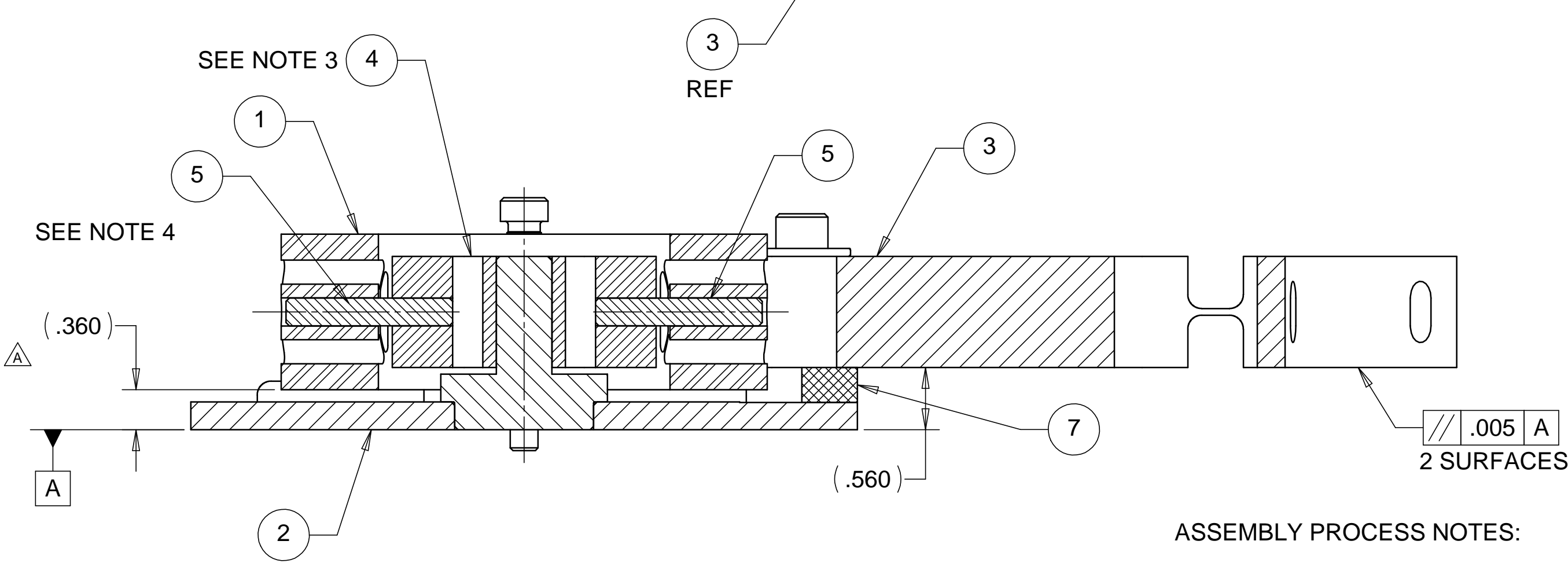
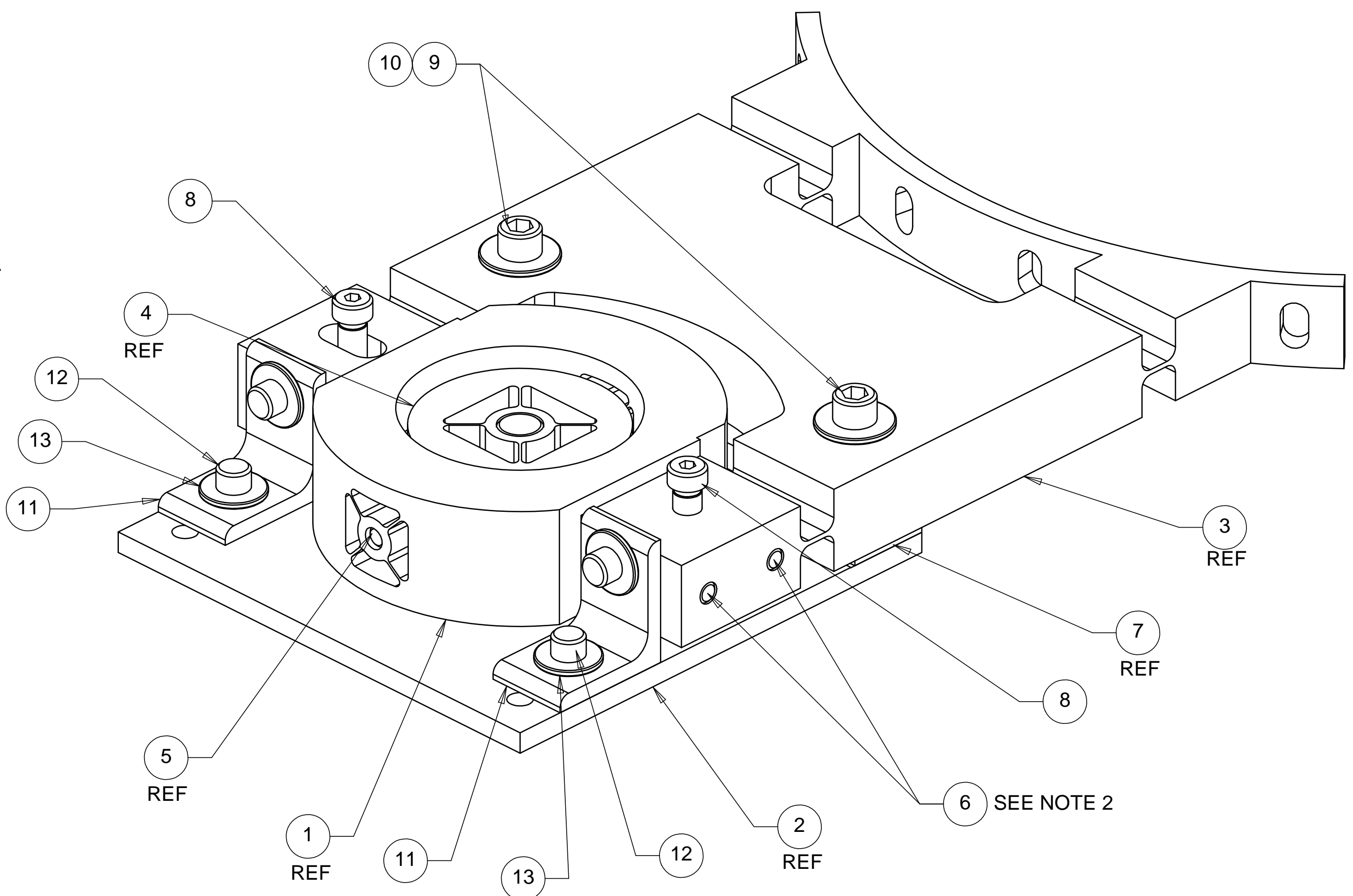
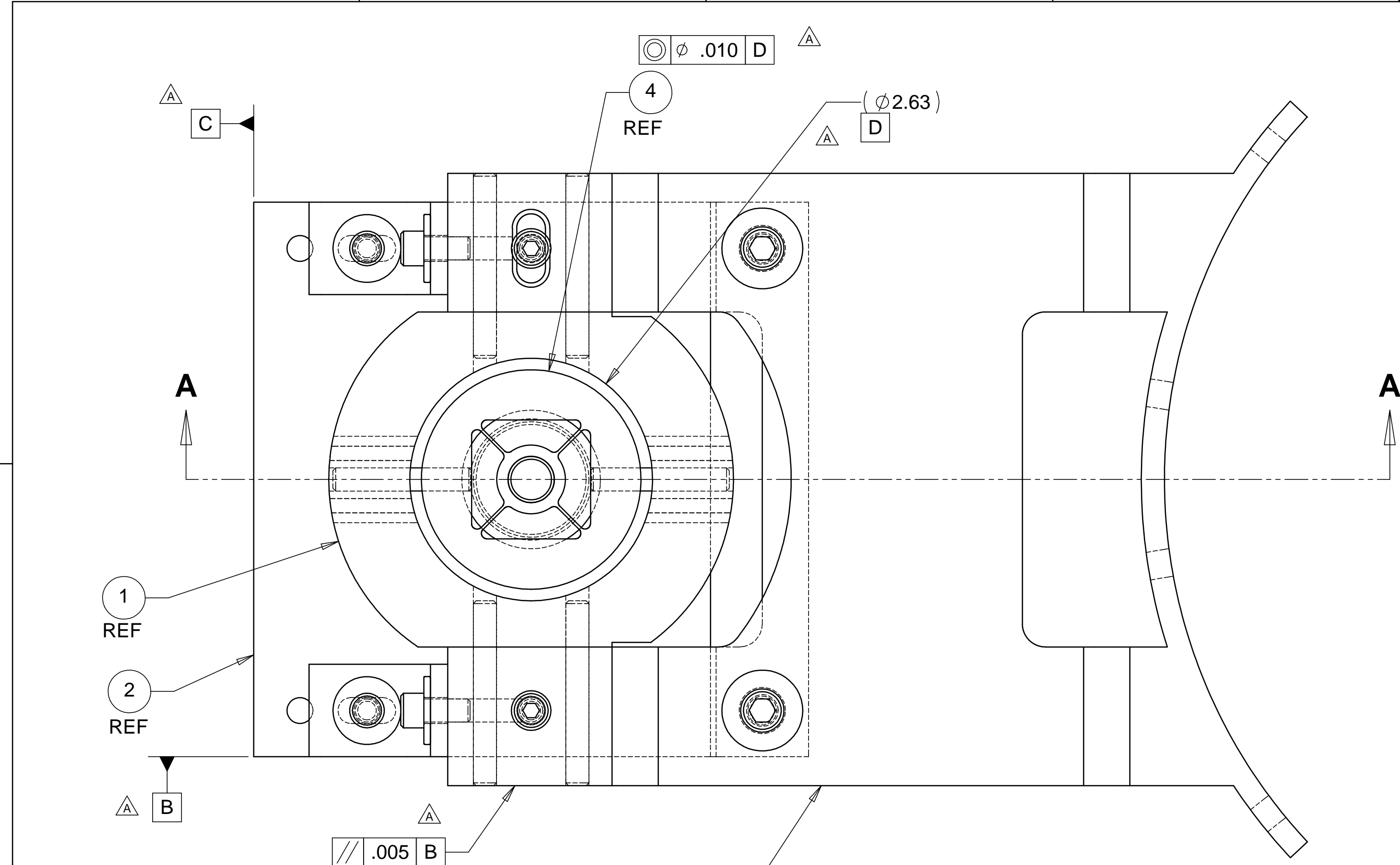


REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	SEE ECN# D972141-A FOR CHANGE LIST	05-13-98	T. THOMPSON



WEIGHT: 15.5 lbs.

ITEMS 7, 8, 9, 10 & 11 ARE USED ONLY FOR ASSEMBLY HANDLING & SHIPPING. TO BE REMOVED UPON INSTALLATION IN NEXT ASSEMBLY.

- ASSEMBLY PROCESS NOTES:
1. COMPLETE MACHINE OPERATIONS
 2. PRESS-FIT PIN ITEM #6 INTO ITEMS #3 & 1
 3. BRAZE ITEM #2 CENTER POST INTO ITEM #4 FLUSH WITH TOP OF ITEM #4. USE A HIGH TEMPERATURE BRAZE - 1200°F (REMOVE EXTERNAL BRAZE RESIDUES)
 4. BRAZE ITEMS #5 INTO ITEMS #1 & 4 AS SHOWN. USE A HIGH TEMPERATURE BRAZE - 1200°F (REMOVE EXTERNAL BRAZE RESIDUES)
 5. FASTEN ITEM #11 (2 PLACES TO ASSEMBLY)
 6. HANDLE WITH GLOVES ONLY - STEPS 6 TO 10
 7. DEGREASE ASSY PRIOR TO HEAT TREAT
 8. STRESS RELIEVE AND HEAT TREAT TO CONDITION - H900.
 9. ELECTRO POLISH ENTIRE ASSEMBLY
 10. BAG PART IN PLASTIC

- NOTES: UNLESS OTHERWISE SPECIFIED
1. ALL DIMENSIONS IN INCHES
 2. DIMENSIONS AND TOLERANCING PER ANASI Y14.5M-1994
 3. SURFACE TEXTURE PER ANI/ASME B 46.1-1985
 4. REMOVE ALL BURRS AND BREAK SHARP EDGES TO A MAXIMUM OF .015
 5. ALL INSIDE CORNERS TO BE .015 RADIUS MAX
 6. COUNTERSINK 82 DEGREES ALL TAPPED HOLES TO MAJOR DIAMETER
 7. COUNTERSINK 82 DEGREES APPROXIMATELY .03/.06 DEEP ALL DRILLED HOLES
 8. PARTS TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT AND CHIPS
 9. PART NUMBER (DRAWING NO. PLUS DASH NO. PLUS SERIAL NO.) TO BE CLEARLY MARKED ON THE PART ITSELF.

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	D972137-1	ROLL PIVOT
2	1	D972138-1	FLEXURE BASE
3	1	D972139-1	PITCH FLEXURE ARM
4	1	D972140-1	YAW PIVOT
5	2		DOWEL PIN, .2500 DIAM. X 1.50 LG.
6	4		DOWEL PIN, .2500 DIAM. X 2.00 LG.
7	1	972147-1	HANDLING SUPPORT BAR
8	2		SOC HD SHOULDER BOLT, 1/4-20 UNC-2A X 1.63 LG. SHOULDER
9	2		SOC HD SCREW, 5/16-24 UNF-2A X 1.63 LG.
10	2		FLAT WASHER 5/16
11	2	D972149-1	HANDLING SUPPORT ANGLE
12	2		SOC HD SCREW, 1/4-20 UNC-2A X 0.50 LG.
13	2		FLAT WASHER, 1/4

PARTS LIST			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-		CAD GENERATED DRAWING. DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING	
DECIMALS X = +/- .1 XX = +/- .03 XXX = +/- .010	ANGULAR = +/- .30° SURFACE FINISH = 250	SIGNATURE ROGER L. SMITH	DATE 11-17-97
FINISH		DRAWN ROGER L. SMITH	11-17-97
		CHECKED HARRY SALAZAR	11-24-97
		ENGR. ERIK SWENSEN	11-17-97
		APPROVED T. THOMPSON	11-17-97
PART NO. D972141-1		TITLE HYTEC, INC LIGO COARSE X-Y TRANSLATION FLEXURAL PIVOT ASSEMBLY	
		DWG. NO. D972141	SIZE SHEET NO. D 1 of 1
		SCALE 1/1	REVISION A