

8 7 6 5 4 3 2 1

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	SEE ECN# D972215-A FOR CHANGE LIST	11-03-97	T. THOMPSON
B	SEE ECN# D972215-B FOR CHANGE LIST	04-15-98	T. THOMPSON
C	SEE ECN# D972215-C FOR CHANGE LIST	07-24-98	T. THOMPSON
D	SEE ECN# D972215-D FOR CHANGE LIST	08-31-98	T. THOMPSON

D

D

C

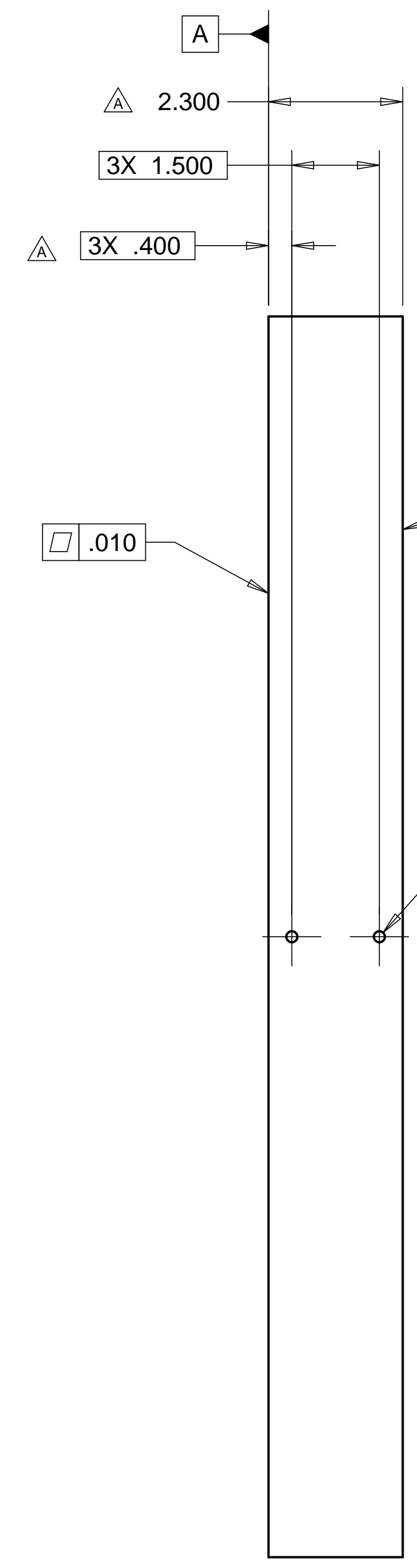
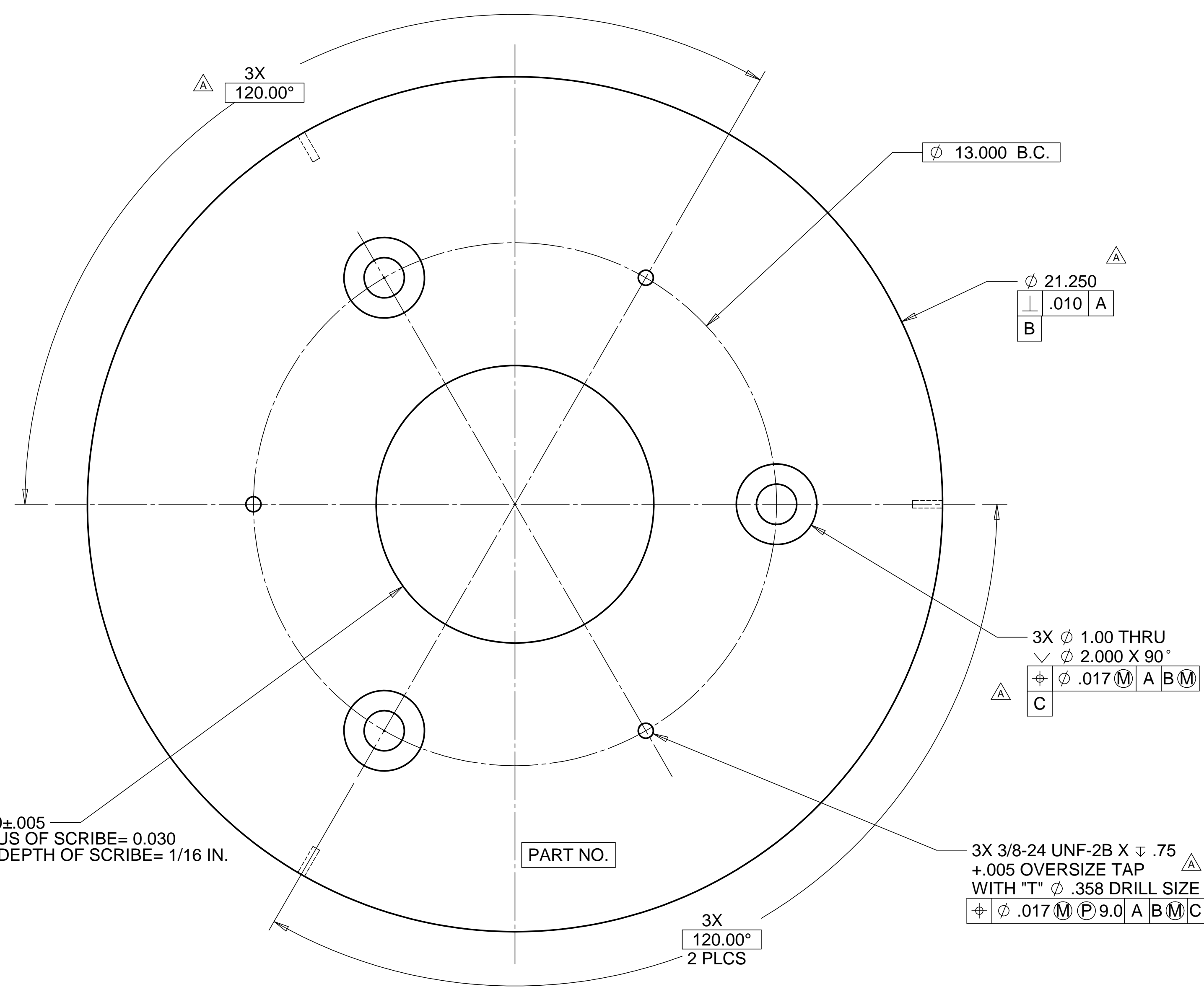
C

B

B

A

A



2X #10-32 UNF-2A X .75
+.005 OVERSIZE TAP
WITH "#16" Ø .177 DRILL SIZE
3X PATTERN ABOUT CIRCUMFERENCE

Ø .10	M	A	B	C	M
Ø .017	M	.50	P	B	

3X Ø 1.00 THRU
∇ Ø 2.000 X 90°
Ø .017 M A B M
C

3X 3/8-24 UNF-2B X .75
+.005 OVERSIZE TAP
WITH "T" Ø .358 DRILL SIZE
Ø .017 M P 9.0 A B M C M

Ø 6.90±.005
RADIUS OF SCRIBE= 0.030
MAX DEPTH OF SCRIBE= 1/16 IN.

PART NO.

3X 120.00°
2 PLCS

NOTES: UNLESS OTHERWISE SPECIFIED

- ALL DIMENSIONS IN INCHES
- DIMENSIONS AND TOLERANCING PER ASME Y14.5M-1994
- SURFACE TEXTURE PER ANSI/ASME B 46.1-1985
- REMOVE ALL BURRS AND BREAK SHARP EDGES TO A MAXIMUM OF .015
- ALL INSIDE CORNERS TO BE .015 RADIUS MAX
- COUNTERSINK 82 DEGREES ALL TAPPED HOLES TO MAJOR DIAMETER
- COUNTERSINK 82 DEGREES APPROXIMATELY .015 DEEP ALL DRILLED HOLES
- PARTS TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT AND CHIPS
- PART NUMBER (DRAWING NO. PLUS DASH NO. PLUS SERIAL NO.) TO BE CLEARLY MARKED ON THE PART ITSELF.
- ALL FABRICATION, CLEANING, AND HANDLING MAINTAINED TO HYTEC SPECIFICATION: LIGO-TS-03 CATEGORY 1.
- NO SULFUR BASED CUTTING FLUIDS ALLOWED. APPROVED STAINLESS STEEL MACHINE LUBRICANT: RELTON A-9, RELTON

MATL: 304 SST
WEIGHT: 233.5 lbs.

PARTS LIST																				
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES -TOLERANCES-	CAD GENERATED DRAWING, DO NOT MANUALLY UPDATE DO NOT SCALE DRAWING		<p>HYTEC, INC</p> <p>TITLE LIGO BSC ISOLATION STACK LEG ELEMENT #3</p>																	
	DECIMALS .X = +/- .1 .XX = +/- .03 .XXX = +/- .010	ANGULAR = +/- .30° SURFACE FINISH = 250		<table border="1"> <tr> <th>FINISH</th> <th>SIGNATURE</th> <th>DATE</th> </tr> <tr> <td>ALL MACHINED SURFACES 64 RMS</td> <td>ROGER L. SMITH</td> <td>5-28-97</td> </tr> <tr> <td></td> <td>ROGER L. SMITH</td> <td>5-28-97</td> </tr> <tr> <td></td> <td>HARRY SALAZAR</td> <td>6-6-97</td> </tr> <tr> <td></td> <td>T. THOMPSON</td> <td>7-10-97</td> </tr> <tr> <td></td> <td>T. THOMPSON</td> <td>7-10-97</td> </tr> </table>	FINISH	SIGNATURE	DATE	ALL MACHINED SURFACES 64 RMS	ROGER L. SMITH	5-28-97		ROGER L. SMITH	5-28-97		HARRY SALAZAR	6-6-97		T. THOMPSON	7-10-97	
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PART NO. D972215-1	DESIGNED	DWG. NO. D972215	SIZE D																	
	CHECKED	SCALE 1/2	SHEET NO. 1 of 1																	
	ENGR.	REVISION	D																	
	APPROVED																			

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