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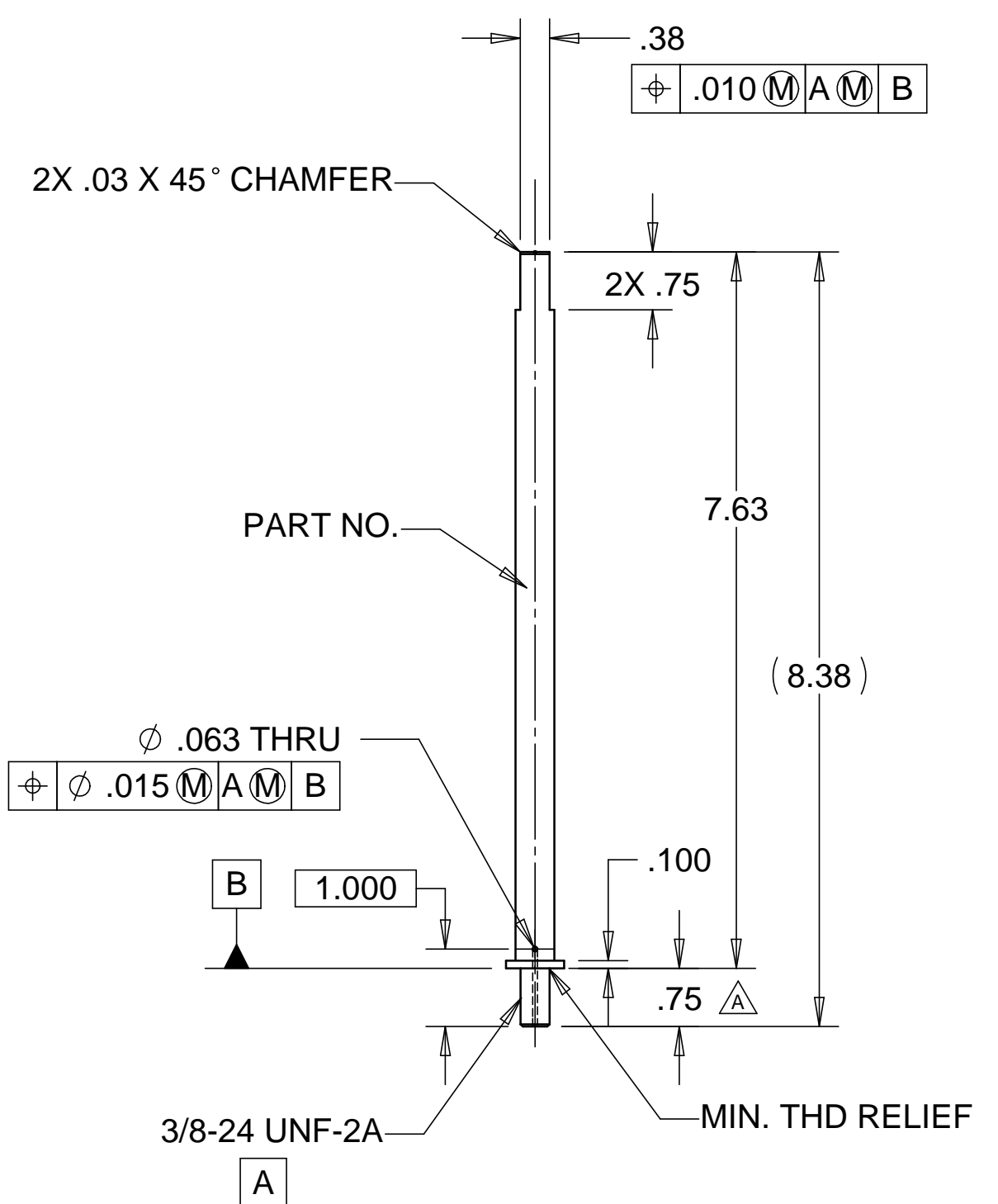
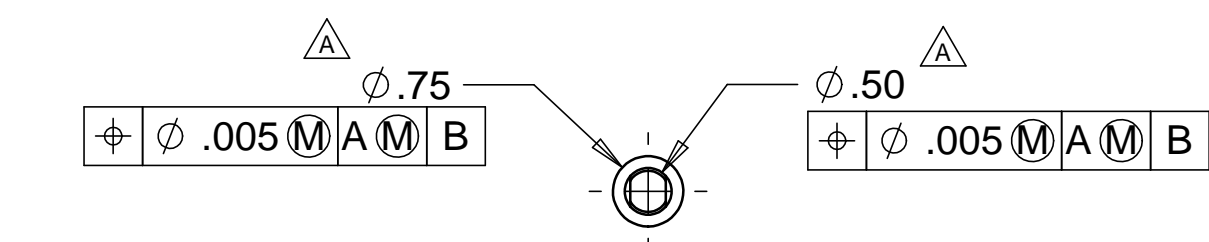
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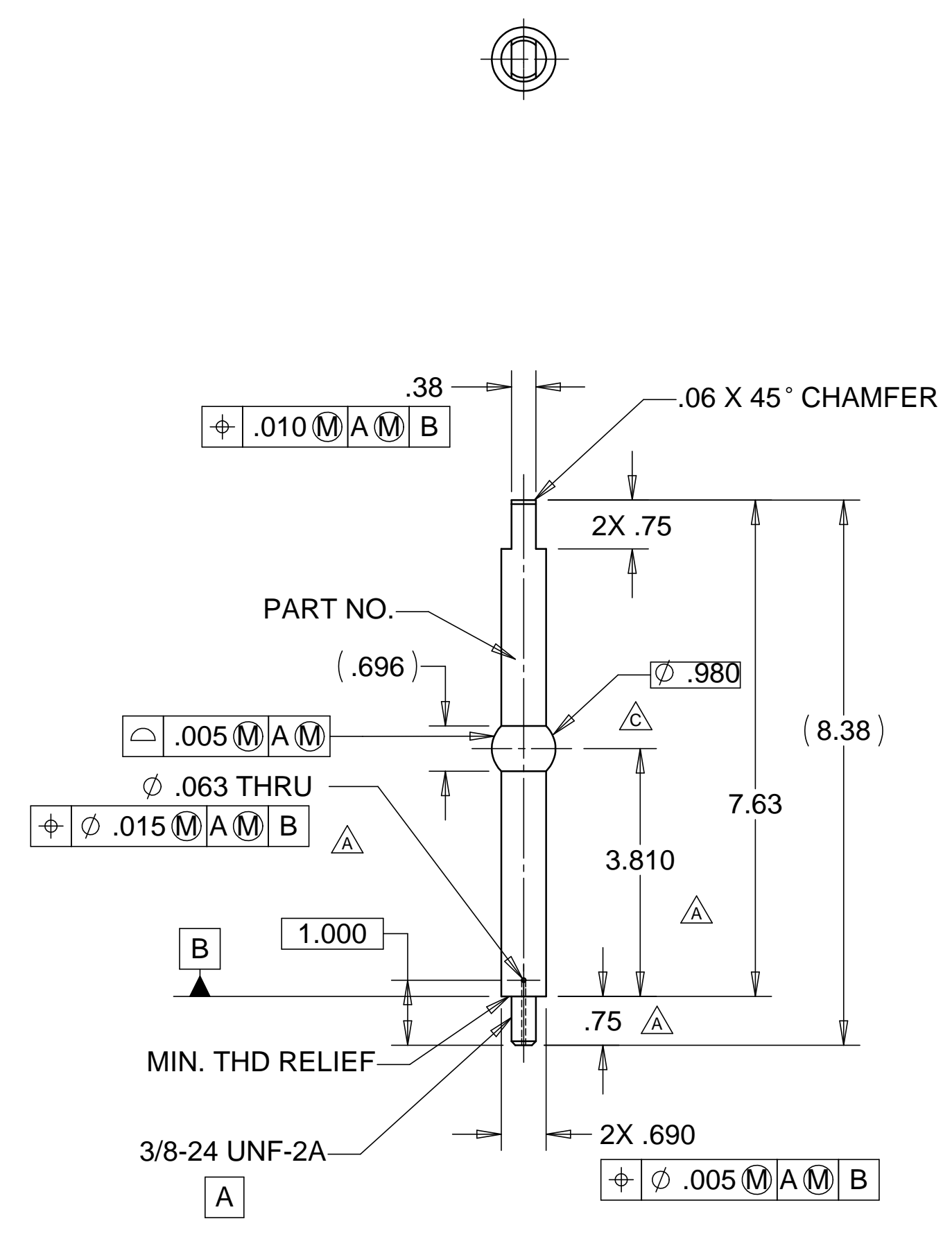
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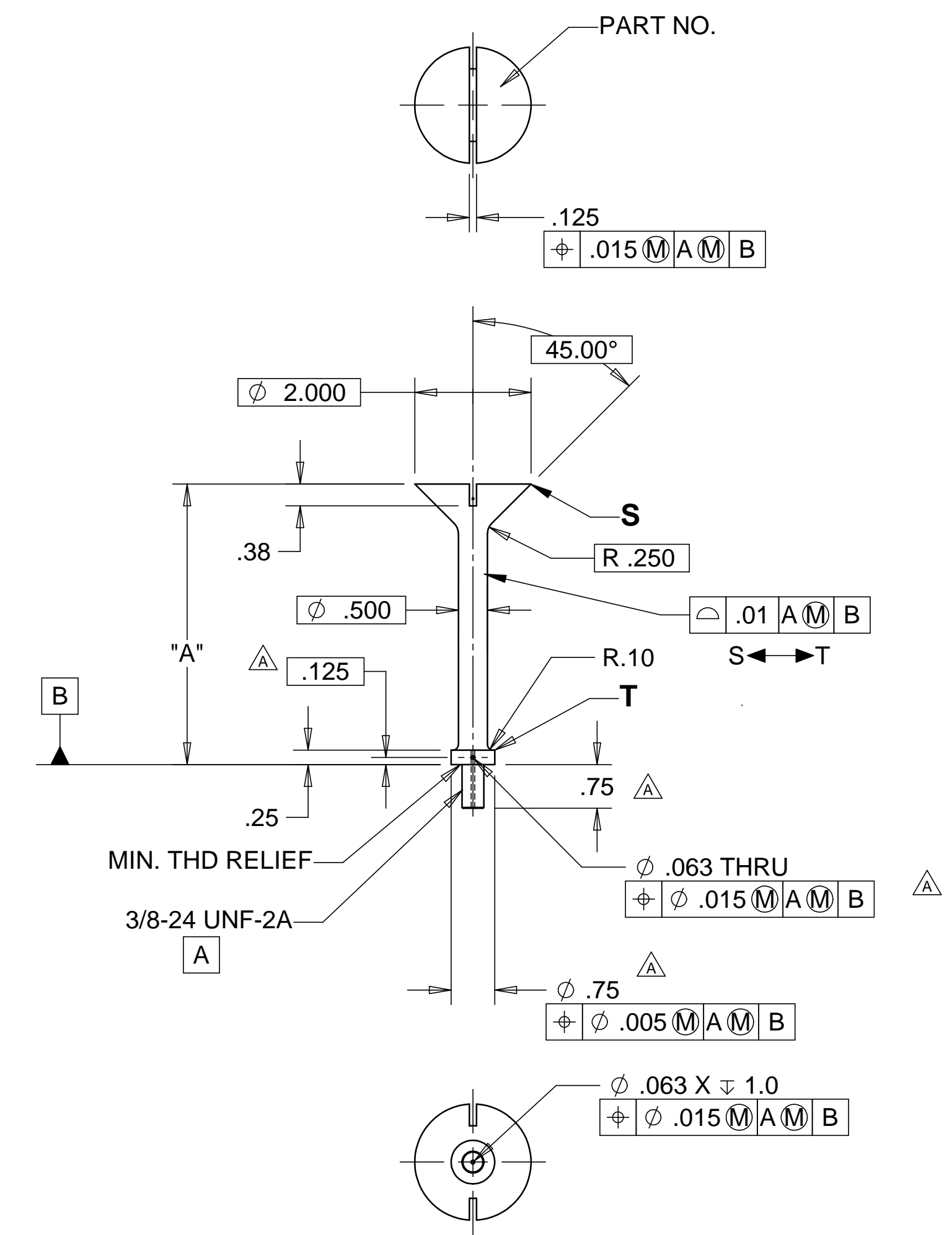
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	SEE ECN# D972715-A FOR CHANGE LIST	11-03-97	T. THOMPSON
B	SEE ECN# D972215-B FOR CHANGE LIST	06-24-98	T. THOMPSON
C	SEE ECN# D972215-C FOR CHANGE LIST	08-31-98	T. THOMPSON



-5 SAFETY PIN
 P.N.: D972715-5
 MATL: 304 SST
 MAGNAPLATE CORP.
 PVD TITANIUM NITRIDE (TiN) COATING
 MAGNAGOLD
 WEIGHT: 0.53 lbs.



-7 LOCATING PIN
 P.N.: D972715-7
 MATL: 10% ALUMINUM BRONZE
 WEIGHT: 0.85 lbs.



PART NO.	DESCRIPTION	"A"	WEIGHT
D972715-1	HAM LEG SCREW 1	3.919	0.51 lbs.
D972715-3	HAM LEG SCREW 2	5.766	0.61 lbs.

MATL: 304 SST
 SILVER COATING

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 .03/.06 DEEP ALL DRILLED HOLES
- PARTS TO BE THOROUGHLY CLEANED TO REMOVE ALL OIL, GREASE, DIRT AND CHIPS
- PART NUMBER (DRAWING NO., DASH NO., REVISION NO., SERIAL NO.) TO BE CLEARLY MARKED EITHER ON THE PART ITSELF, OR ON A TAG ATTACHED TO THE PART OR PACKAGE
- 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

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	<p>HYTEC, INC</p> <p>TITLE: LIGO HAM ISOLATION STACK LEG LOCATION & ASSEMBLY PINS</p>	
FINISH ALL MACHINED SURFACES 64 RMS	DESIGNED ROGER L. SMITH 5-28-97	SIGNATURE ROGER L. SMITH	DATE 5-28-97
PART NO. D972715	CHECKED HARRY SALAZAR 6-6-97	ENGR. T. THOMPSON 7-10-97	DATE 7-10-97
	APPROVED T. THOMPSON 7-10-97	DWG. NO. D972715 SIZE D SHEET NO. 1 of 1	
	SCALE 1/2		REVISION C

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