

**NOTES**

1. Material: Magnesium Alloy AZ31B-H24 per AMS 4377 or AZ31B-H26 per AMS 4376.
2. Engraving: Engrave all text and lines shown in model. Replace PO 'XXXX' with actual PO number. Acceptable for 90deg corners to have fillets from cutter path.
3. Key Locking Inserts: Prep all holes as noted on sheet 2 then install item 2. Recess at least .01 inch below surface.
4. Verify insert integrity by installing a high strength 10-32 UNF screw in at least 10% of the inserts and torquing to 55 in\*lb. Use a thick washer to prevent damage to inserts or plate surface.
5. All tolerances apply after installation and testing of inserts.
6. Surface Treatment: None.
7. Cleanliness: Part shall be delivered visibly clean, to the normal unaided eye, of all particulate matter and non-particulate film matter.
8. Estimated Mass [lb]: 38.404
9. Interfacing Assemblies:
  1. 4000744 3U CSD
  2. 4000745 6U CSD
  3. 4000746 12U CSD

REVISIONS						
Rev	Changes			Date	By	Chk
	Description	Sht	Zone			
-	Initial Revision	-	-	12Sep14	CF	FA
A	Removed 1/4-28 inserts for +Z mounting plate. Moved and added numerous 10-32 inserts. Removed X face mounting inserts. Plate only accomodates -Y and -Z. Added -Y patterns rotated 90 deg. Moved alignment lines. Changed datums.	All	All	23Nov16	RH	CF
B	Added key inserts to model	All	All	27Feb17	CF	RH
	Made all insert holes the same in the solid model.	All	All			
	Added Table 1:BOM	1	A7			
	Updated revision in PN engraving.	2	G4			

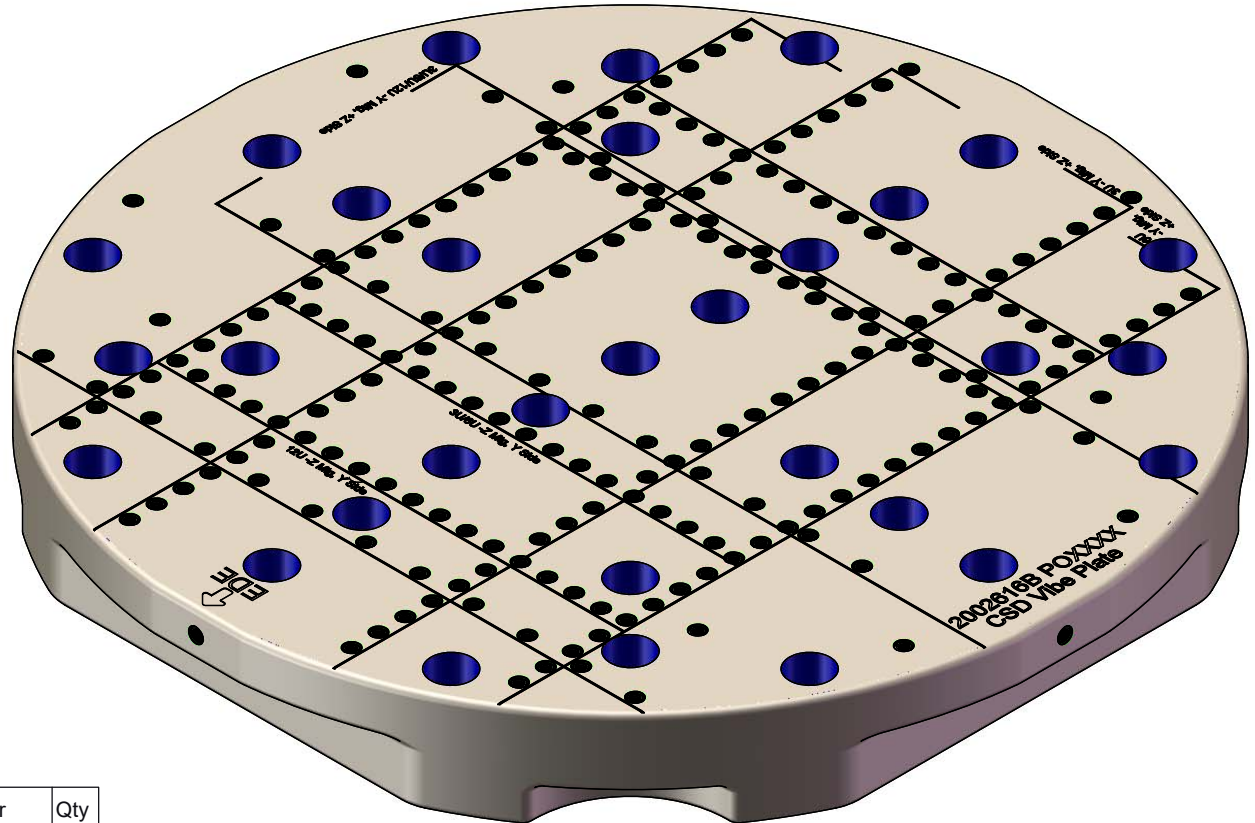


Table 1: BOM

Item	Number & Description	Rev	Vendor	Qty
1	2002616 CSD Vibe Plate	B	PSC	1
2	92070A240, .190-32 insert, .313-18 tap size	-	McMaster-Carr	216

Unless Otherwise Specified

1. All dimensions are in inches  
 2. Interpret per ASME Y14.5-2009  
 3. Dimensions apply AFTER all surface treatments  
 4. Remove all burrs and sharp edges, R.01 max  
 5. Internal sharp edges may have R.01 max  
 6. Thread depths are a minimum  
 7. Inspect all numbered dimensions.

Tolerances

.XXXX ±.001	.XXX ±.005	.XX ±.01	.X ±.03	X ±.2
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Hole diameters ±.005

<input checked="" type="checkbox"/> N7/ Max surface roughness	Material: see Note 1	TITLE <b>CSD Vibe Plate</b>
Third Angle Projection	Do not scale from drawing	SIZE <b>A</b> NUMBER <b>2002616</b> REV <b>B</b>
SCALE 0.33:1		CAGE CODE: 1PHA7 SHEET 1 OF 2

