

**NOTES**

- Material: Magnesium Alloy AZ31B-H24 per AMS 4377 or AZ31B-H26 per AMS 4376.
- 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.
- Key Locking Inserts: Prep all holes as noted on sheet 2 then install item 2. Recess at least .01 inch below surface.
- Verify insert integrity by installing a high strength 10-32 UNF screw in at least 10% of the inserts and torquing to 55 in\*lbF. Use a thick washer to prevent damage to inserts or plate surface.
- All tolerances apply after installation and testing of inserts.
- Surface Treatment: None.
- Cleanliness: Part shall be delivered visibly clean, to the normal unaided eye, of all particulate matter and non-particulate film matter.
- Estimated Mass [lb]: 38.404
- Interfacing Assemblies:
  - 4000744 3U CSD
  - 4000745 6U CSD
  - 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			

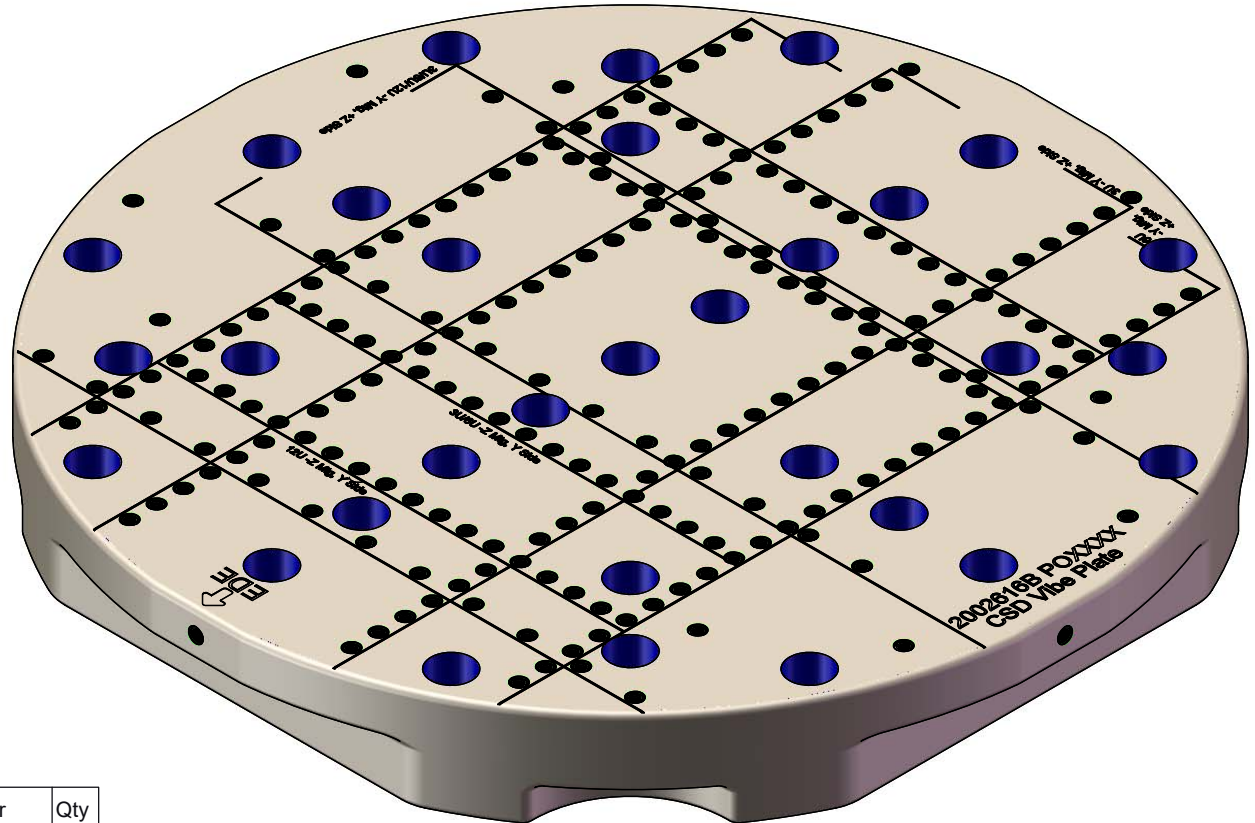


Table 1: BOM

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

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

Tolerances	
.XXXX ±.001	.XXX ±.005
.XX ±.01	.X ±.03
X ±.2	

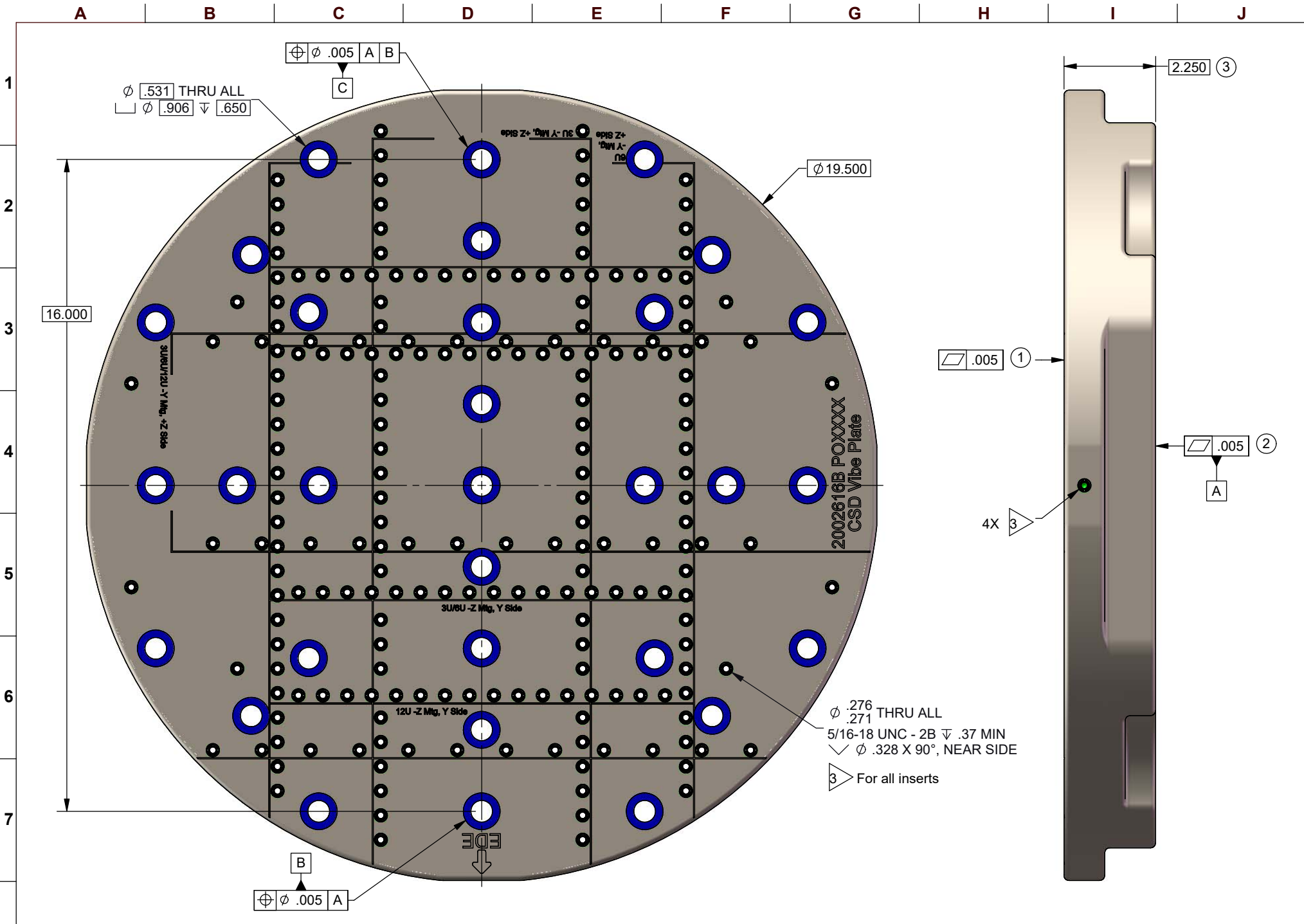
$\overline{\phi}$ .010	A	B	C
$\overline{\phi}$ .010	A	B	C

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	REV <b>B</b>
SIZE <b>A</b>		NUMBER <b>2002616</b>
SCALE 0.33:1		CAGE CODE: 1PHA7 SHEET 1 OF 2



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$\phi$  .531 THRU ALL  
 $\phi$  .906  $\nabla$  .650

$\oplus \phi$  .005 A B  
 C

$\phi$  19.500

16.000

3U/8U - Z Mfg, Y Side

2002616B POXXXX  
 CSD Vibe Plate

3U/8U - Z Mfg, Y Side

12U - Z Mfg, Y Side

$\phi$  .276 THRU ALL  
 $\phi$  .271 THRU ALL  
 5/16-18 UNC - 2B  $\nabla$  .37 MIN  
 $\nabla$   $\phi$  .328 X 90°, NEAR SIDE

3 For all inserts

$\oplus \phi$  .005 A  
 B

2.250 3

$\nabla$  .005 1

$\nabla$  .005 2  
 A

4X 3