

NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.

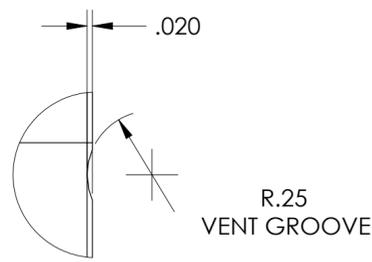
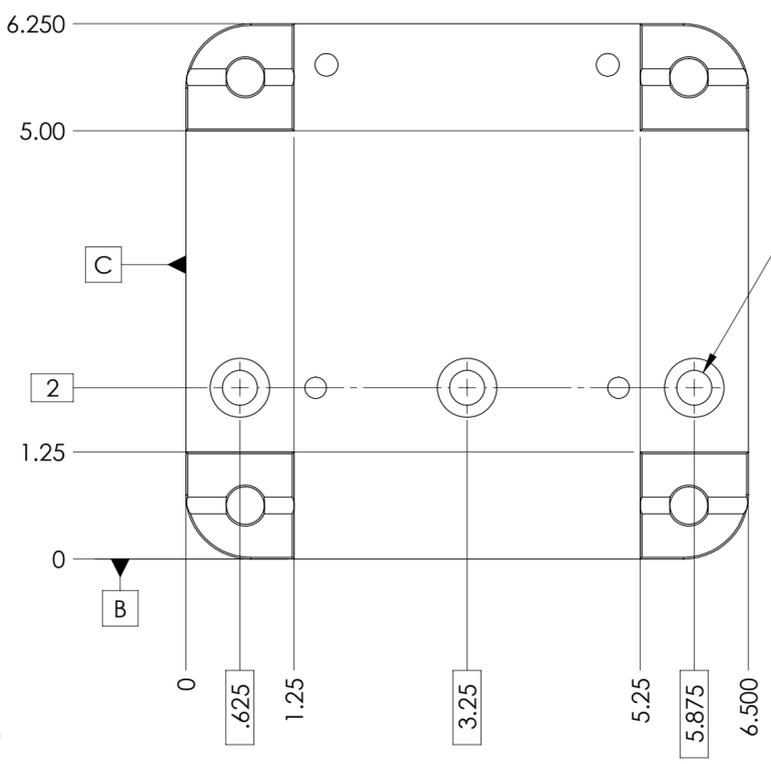
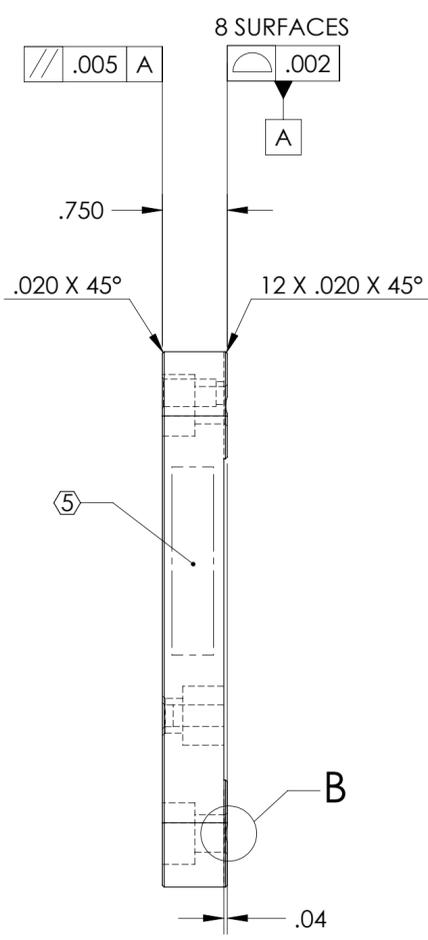
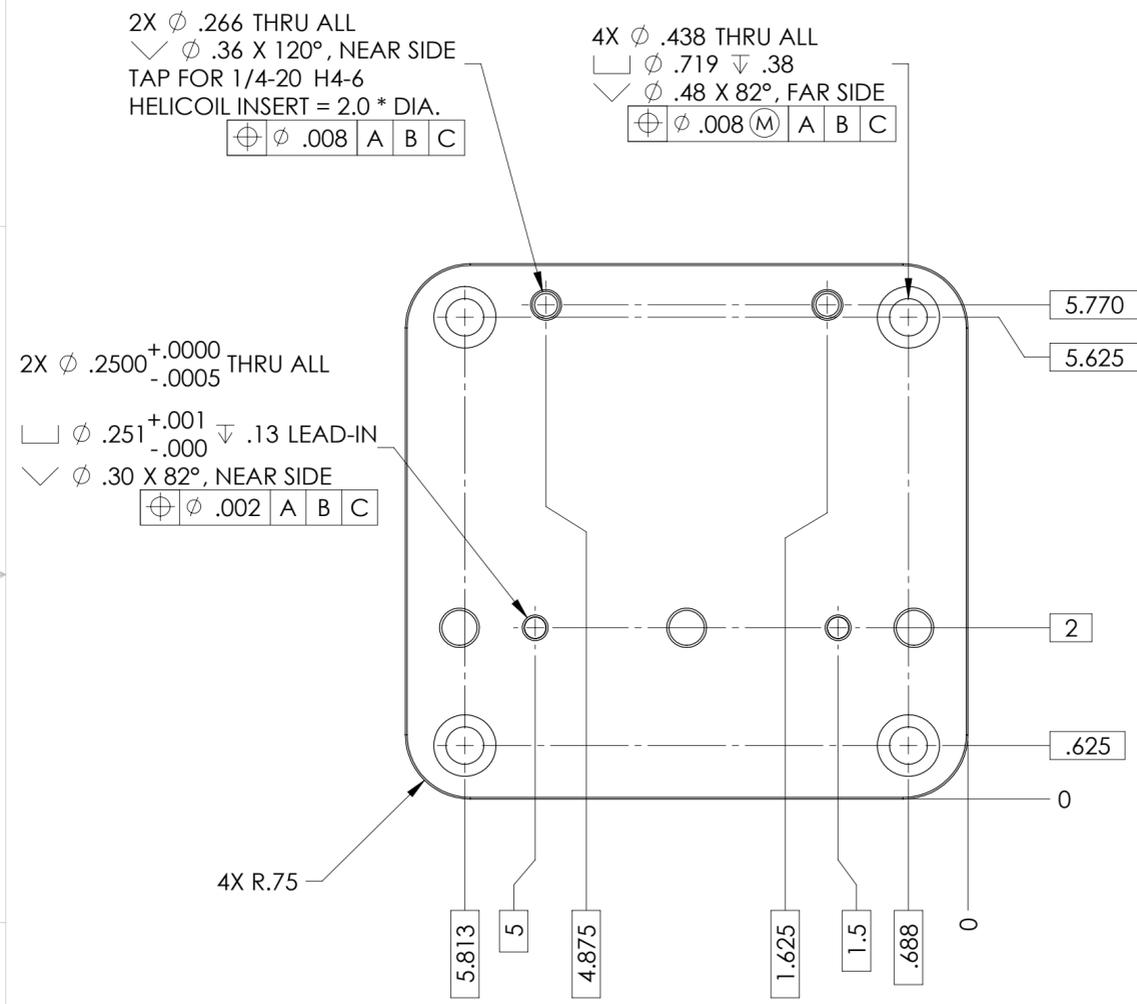
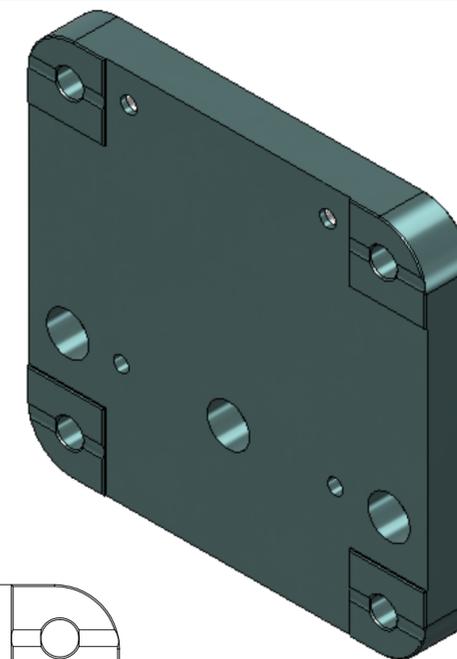
6. DO NOT INSTALL HELI-COILS UNTIL POST-CLEANING.

POST-MANUFACTURING NOTES:

P1. CLEAN TO LIGO STANDARDS, CLASS A (PER E0900047 AND E960022).

P2. INSTALL CLASS-A CLEAN HELI-COILS. BREAK OFF AND REMOVE TANGS. CHECK THAT END OF EACH INSERT REMAINS ENGAGED IN THREAD AFTER TANG REMOVAL.

REV.	DATE	DCN #	DRAWING TREE #
V1	28 Apr 2009		



Mass = 2.6 lbs

HELI-COIL TABLE (See Note 6)				
Item No.	Thread Size	Material	Heli-Coil P/N 1185...	Qty.
1	1/4"-20 x .50"	Nitronic 60	-4EN500	2

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.	
MATERIAL	6061-T6 Al
FINISH	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME			Bracket Base, Horz L4-C, HAM ISI	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	SEI	DESIGNER	astein	04 Apr 2009
NEXT ASSY	D0900317	SCALE	c	DWG. NO.	D0900318	
		CHECKER	astein	27 Apr 2009	REV.	v1
		APPROVAL	astein	27 Apr 2009	SCALE: 2:3	PROJECTION:
						SHEET 1 OF 1