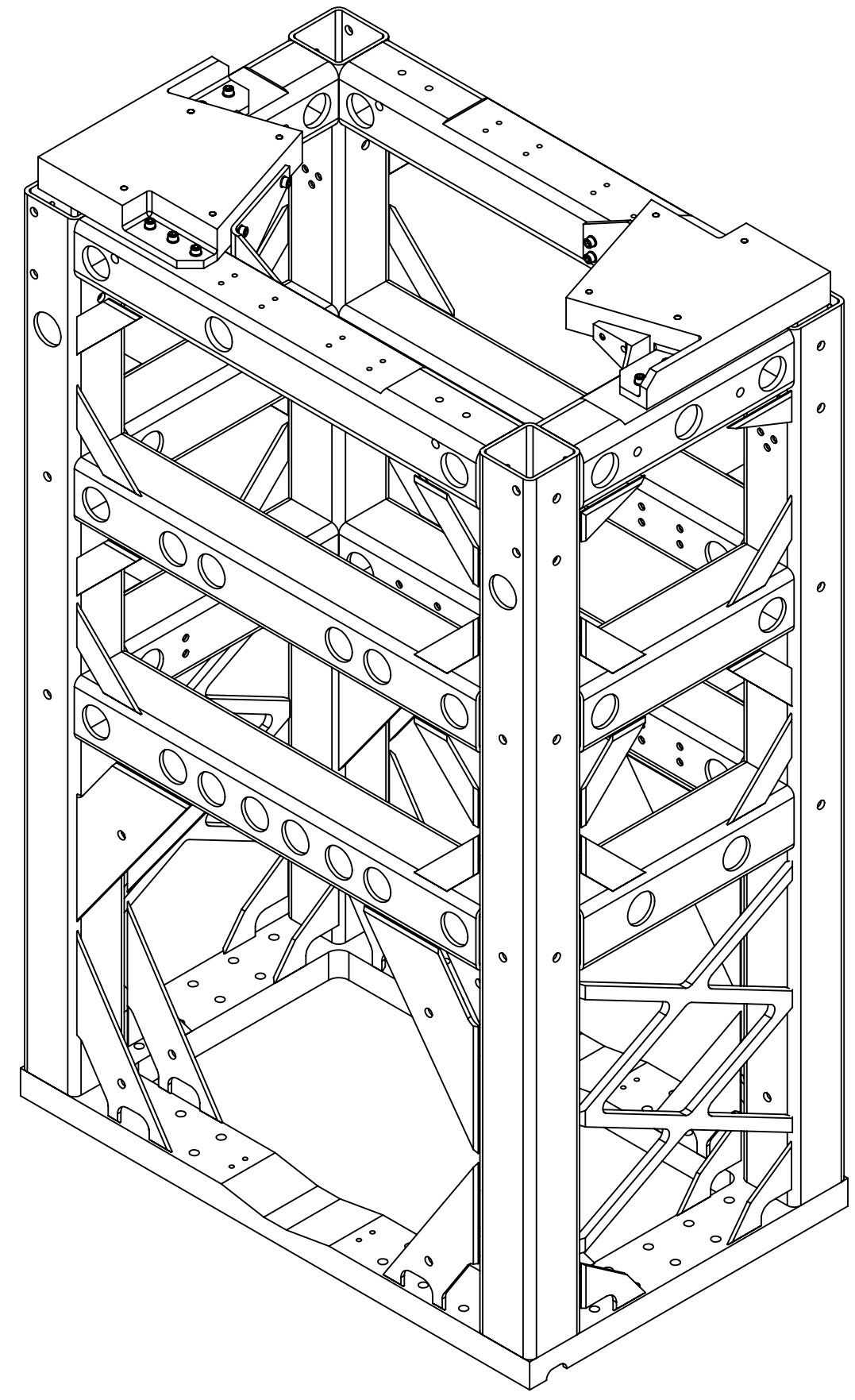


REV.	DATE	DCN #	DRAWING TREE #
V1	3 MAR 2009	E0900066	E080191
-	-	-	-
-	-	-	-



ITEM NO.	REQ	SPARE	TOTAL	PART NUMBER	DESCRIPTION	MATERIAL
6	8	2	10	1185-2EN246	HELICOIL, #8-32 X 0.246 LONG (6)	NITRONIC 60
5	18	4	22	-	WASHER, FLAT, #8 (NAS 620-C8 OR EQUIVALENT)	300 SSSL
4	18	4	22	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 0.5 LONG	Ag-PLATED 300 SSSL
3	2	0	2	D0900626	MOUNTING PAD ASSEMBLY	N/A
2	60	12	72	PENN ENGINEERING SP-832-2 (STAMPED)	SELF CLINCHING NUT, #8-32, LONG SHANK (5)	A286 SSSL
1	1	0	1	D070442	HLTS STRUCTURAL WELDMENT	N/A

NOTES: (UNLESS OTHERWISE SPECIFIED)  
 1. REMOVE ALL SHARP EDGES, R.02 MIN.  
 2. DO NOT SCALE FROM DRAWING.  
 3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.  
 4. FLY CUT INDICATED SURFACES TO ACHIEVE DESIRED PARALLELISM AND FLATNESS.  
 5. INSTALL SELF-CLINCHING NUTS AS DESCRIBED IN "FASTENERS FOR USE IN STAINLESS STEEL SHEETS" BULLETIN BY PENN ENGINEERING. SELF-CLINCHING NUTS AND CORRESPONDING HOLES TO BE CLEANED WITH METHANOL PRIOR TO INSTALLATION. SELF-CLINCHING NUTS TO BE INSTALLED ON INNER WALL OF TUBE AS SHOWN.  
 6. HELICOILS TO BE INSTALLED BY LIGO AFTER FLY CUTTING AND CLEAN AND BAKE OF ALL PARTS.

DIMENSIONS ARE IN INCHES  
 TOLERANCES:  
 .XX ± .01  
 .XXX ± .005  
 ANGULAR ± 0.1°

MATERIAL: N/A  
 FINISH: N/A μinch

DESIGNER	D. BRIDGES	14 APR 2009
DRAWN	D. BRIDGES	14 APR 2009
CHECKED	J. ROMIE	6 MAY 2009

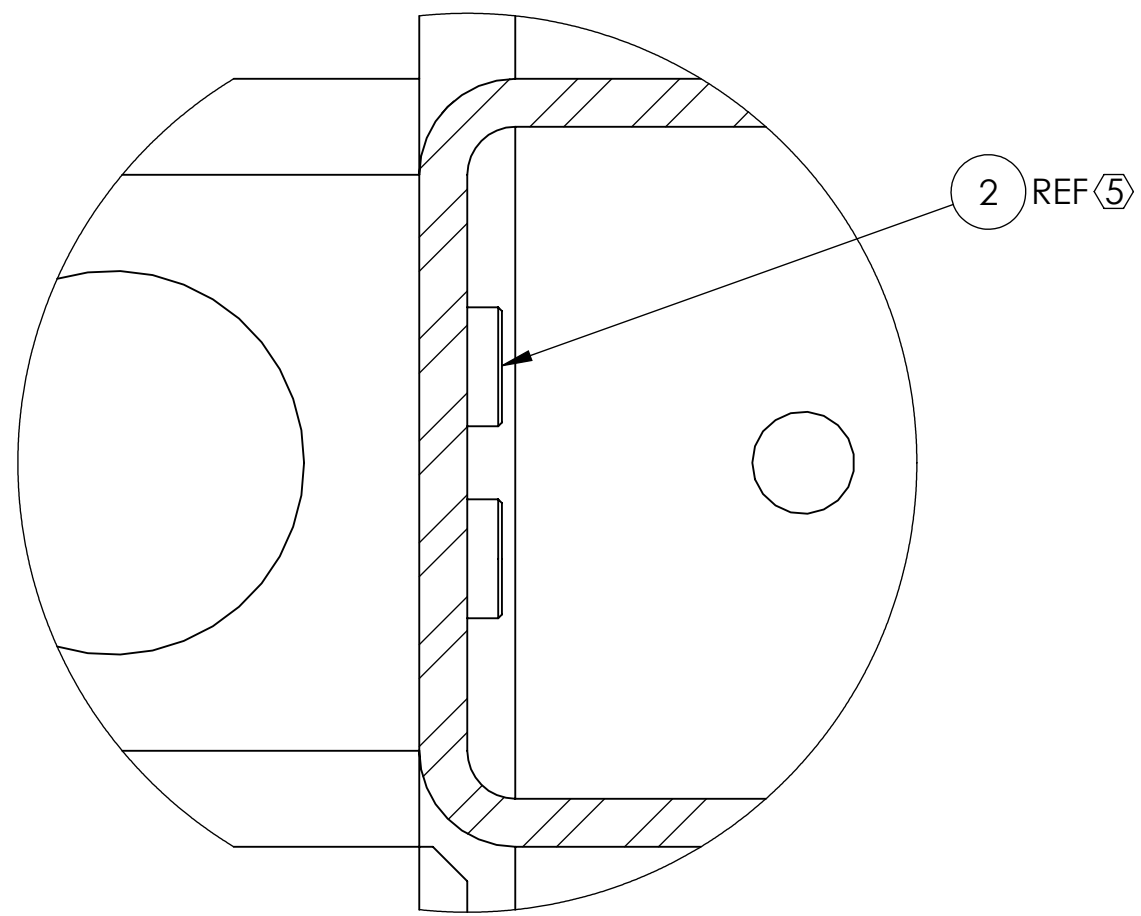
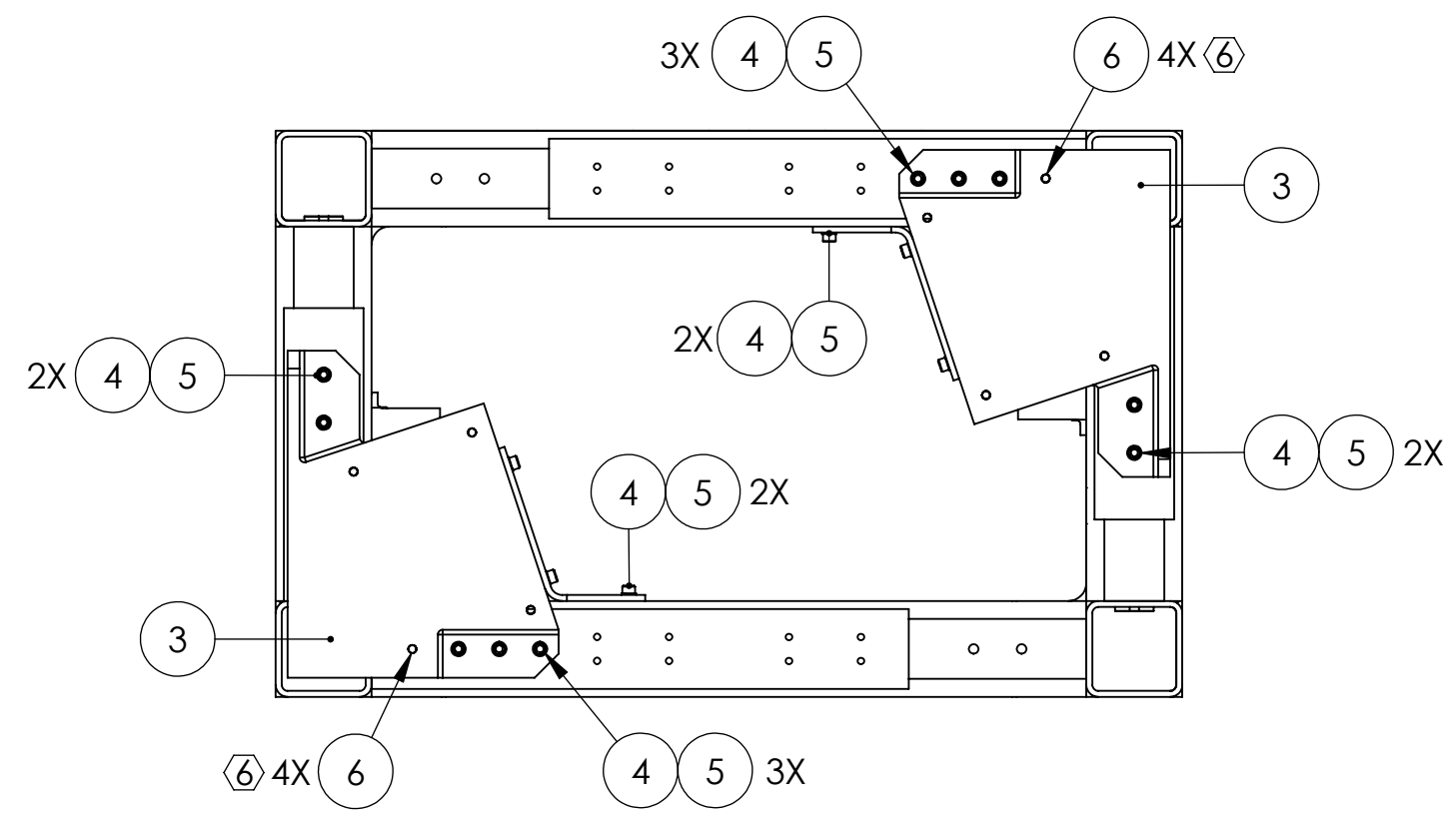
SCALE: 1:4 PROJECTION: SHEET 1 OF 2

SYSTEM: ADVANCED LIGO  
 SUB-SYSTEM: SUS  
 NEXT ASSY: HLTS OVERALL ASSY  
 PART NAME: HLTS STRUCTURE

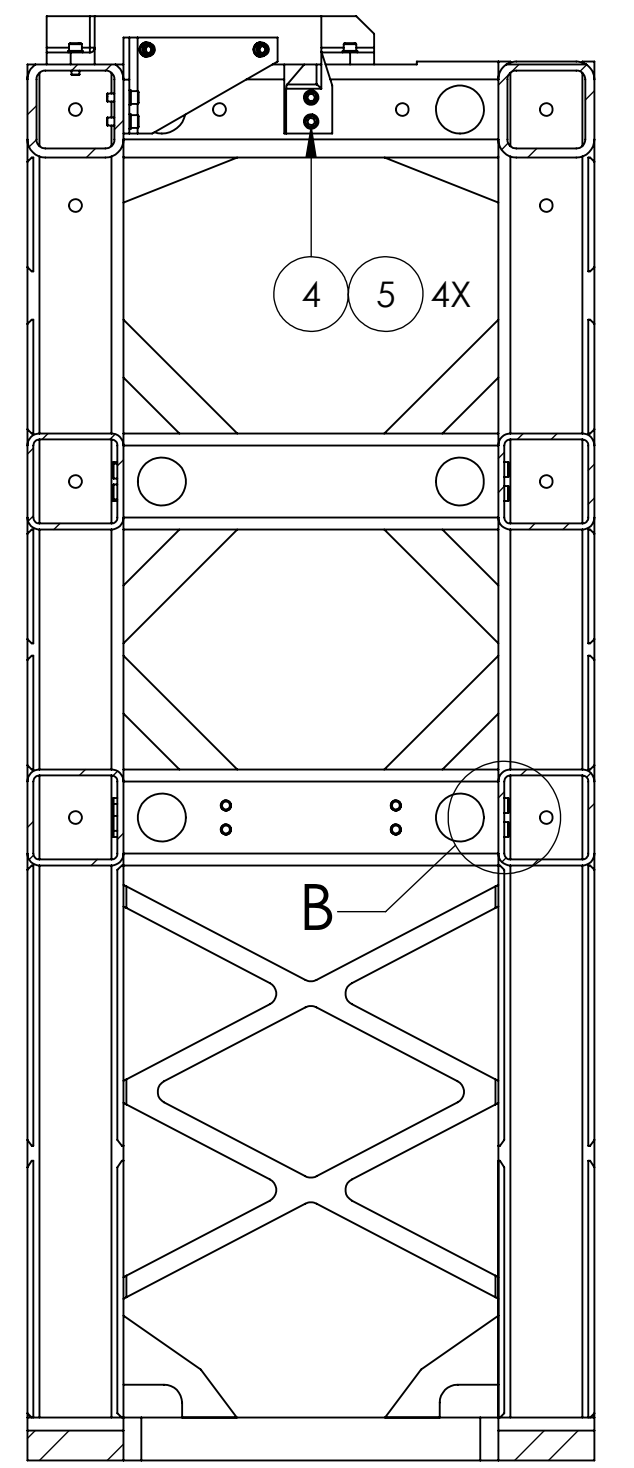
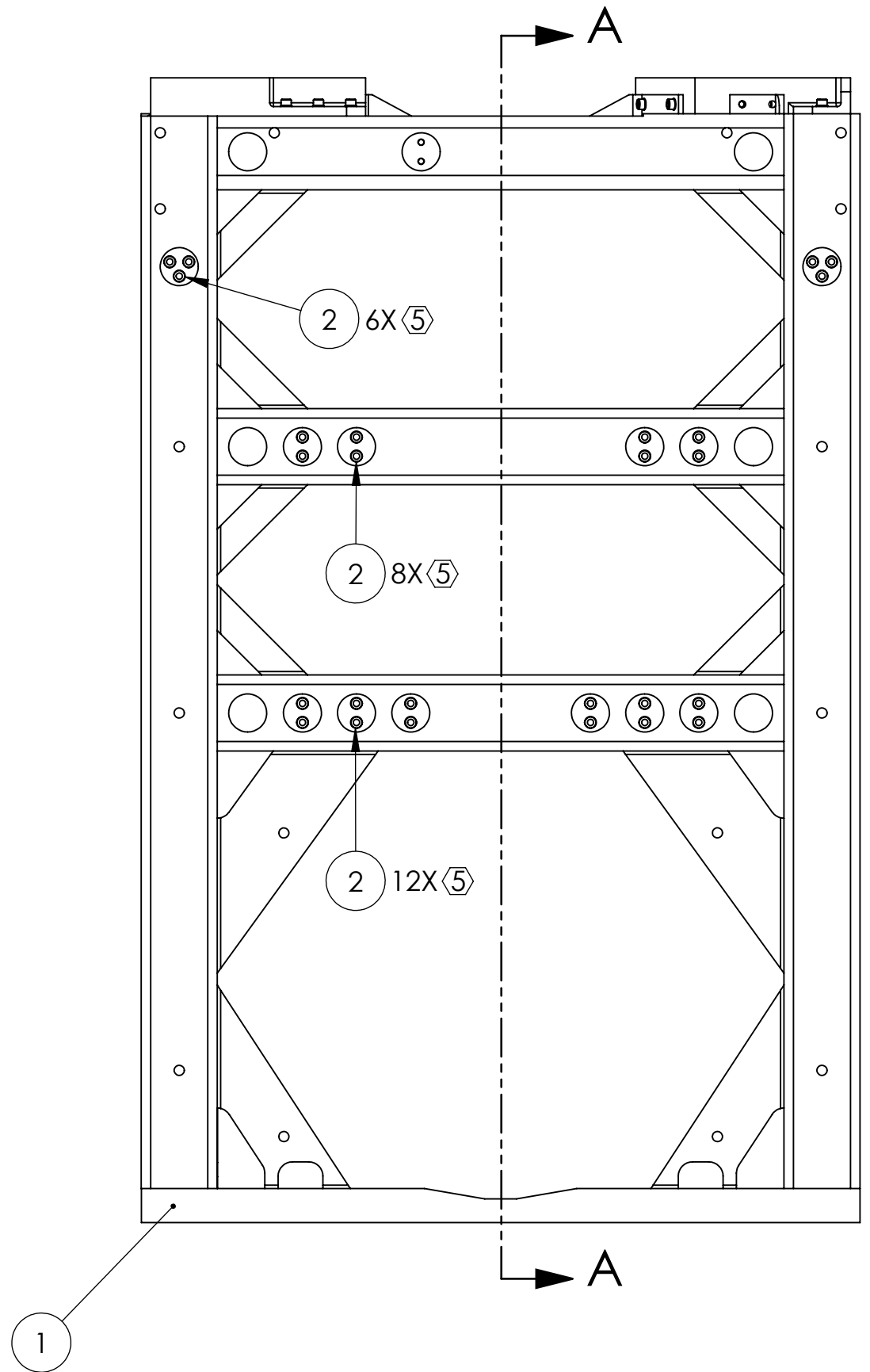
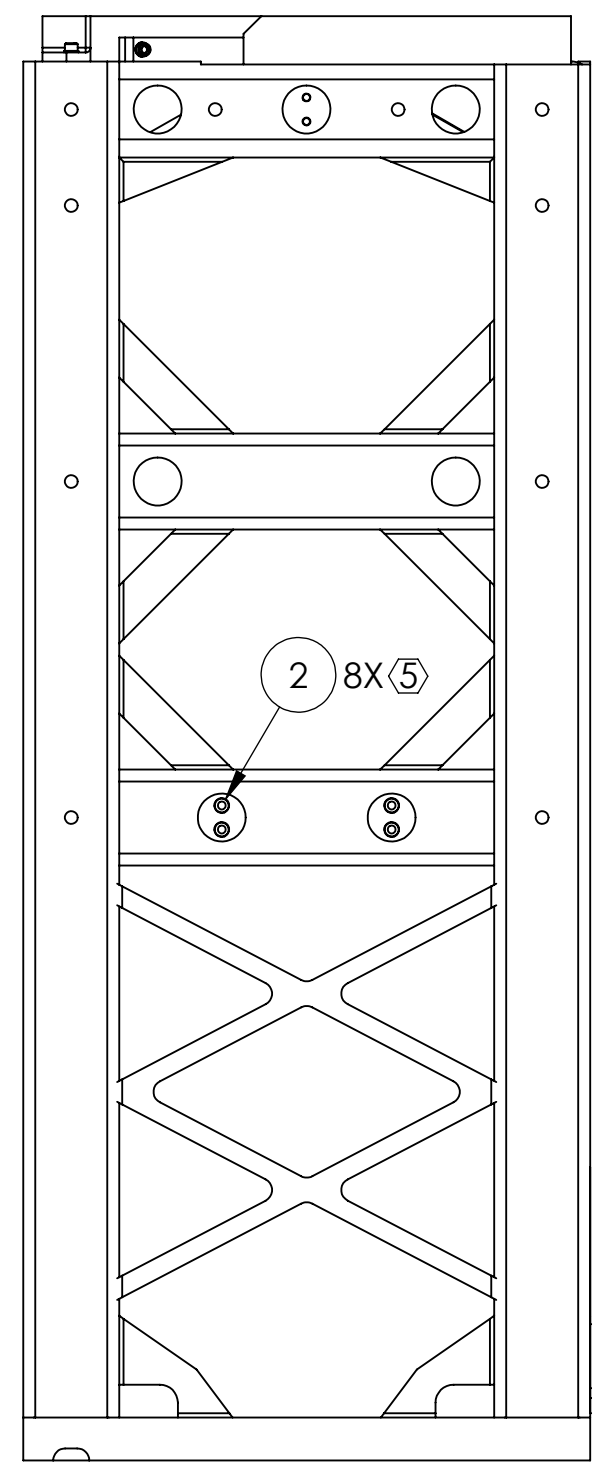
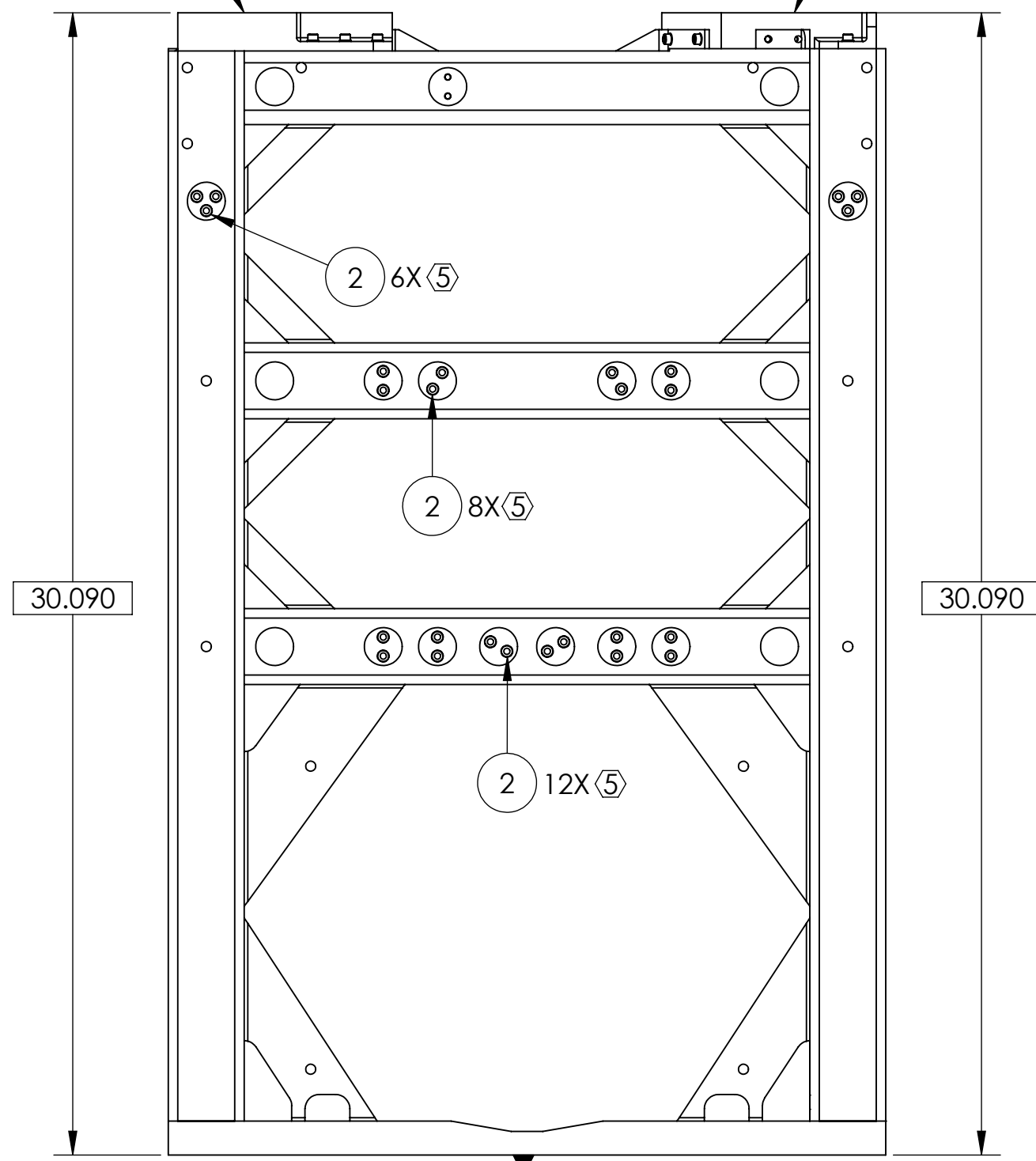
SIZE DWG. NO. D070537 REV. V1

8 7 6 5 4 3 2 1

F  
E  
D  
C  
B  
A



DETAIL B  
SCALE 2 : 1  
TYPICAL



SECTION A-A

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE DWG. NO. REV.  
C D070537 v1

SCALE: 1:4 PROJECTION: SHEET 2 OF 2