

NOTES CONTINUED:

5. SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) REVISION NUMBER ON EACH PART. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. EXAMPLE (PART): 001-v1 EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD

6. ALL HOLES TO BE 100% GAGED WITH EMHART TOOL: 1442-6 OR 1440-6

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

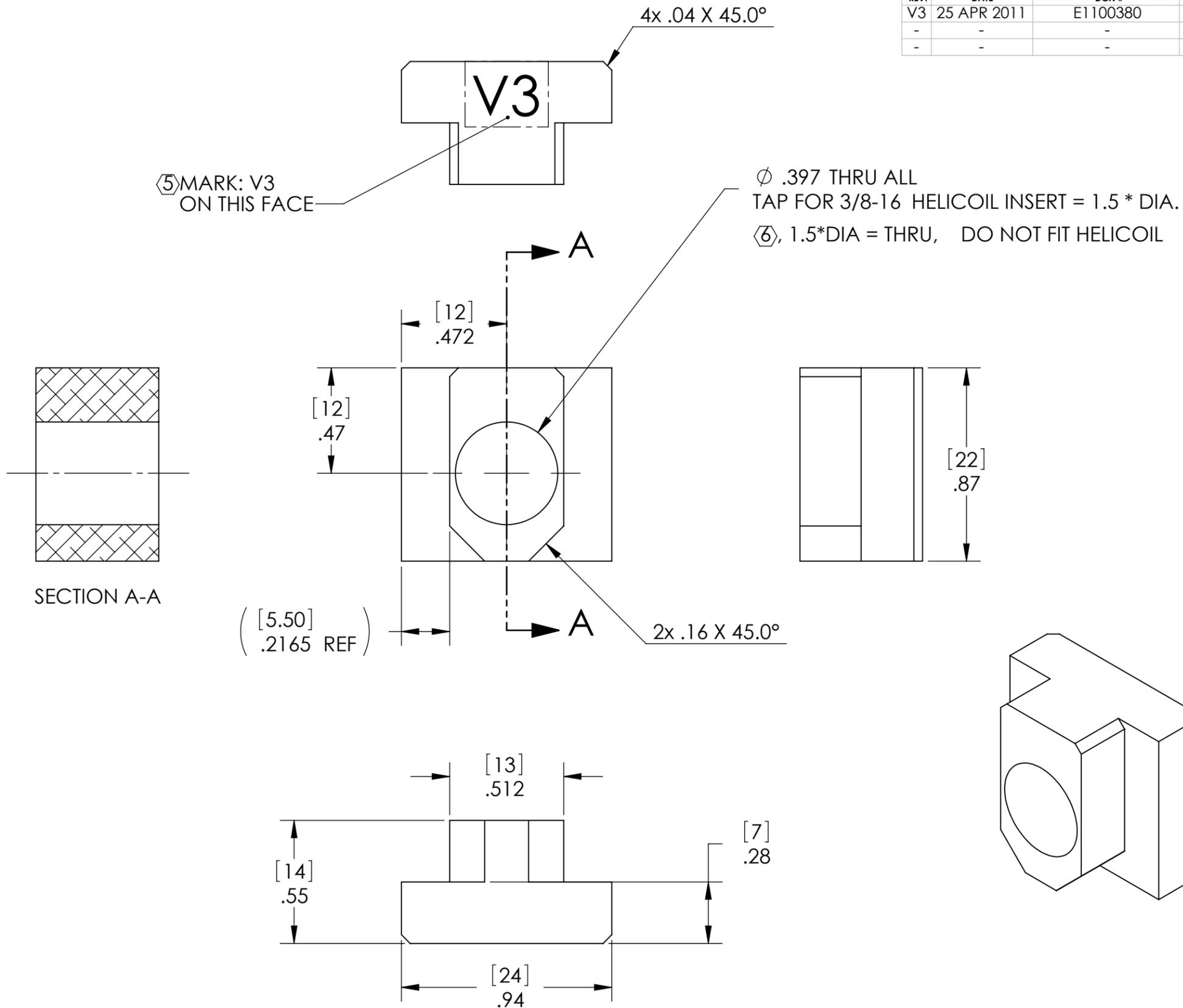
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

REV.	DATE	DCN #	DRAWING TREE #
V3	25 APR 2011	E1100380	-
-	-	-	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES [MM]	
TOLERANCES: .XX ± .008 .XXX ± .004 ANGULAR ± 0.3°	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
MATERIAL	FINISH
304 SSSL	32 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
ADVANCED LIGO		aLIGO, SUS, Quad N-P Top Stage, 3/8-16 UNC T-NUT	
DESIGNER	DRFTER	DATE	SIZE
Joe Odell	SBARNUM	22 April 2011	DWG. NO.
CHECKER	APPROVAL	25 Apr 2011	B
CTORRIE			D060328
NEXT ASSY		REV.	
D060324		v3	
SCALE: 2:1		PROJECTION:	
		SHEET 1 OF 1	

D060328 aLIGO, SUS, Quad N-P Top Stage, 3/8-16 UNC T-NUT, PART PDM REV: , DRAWING PDM REV: