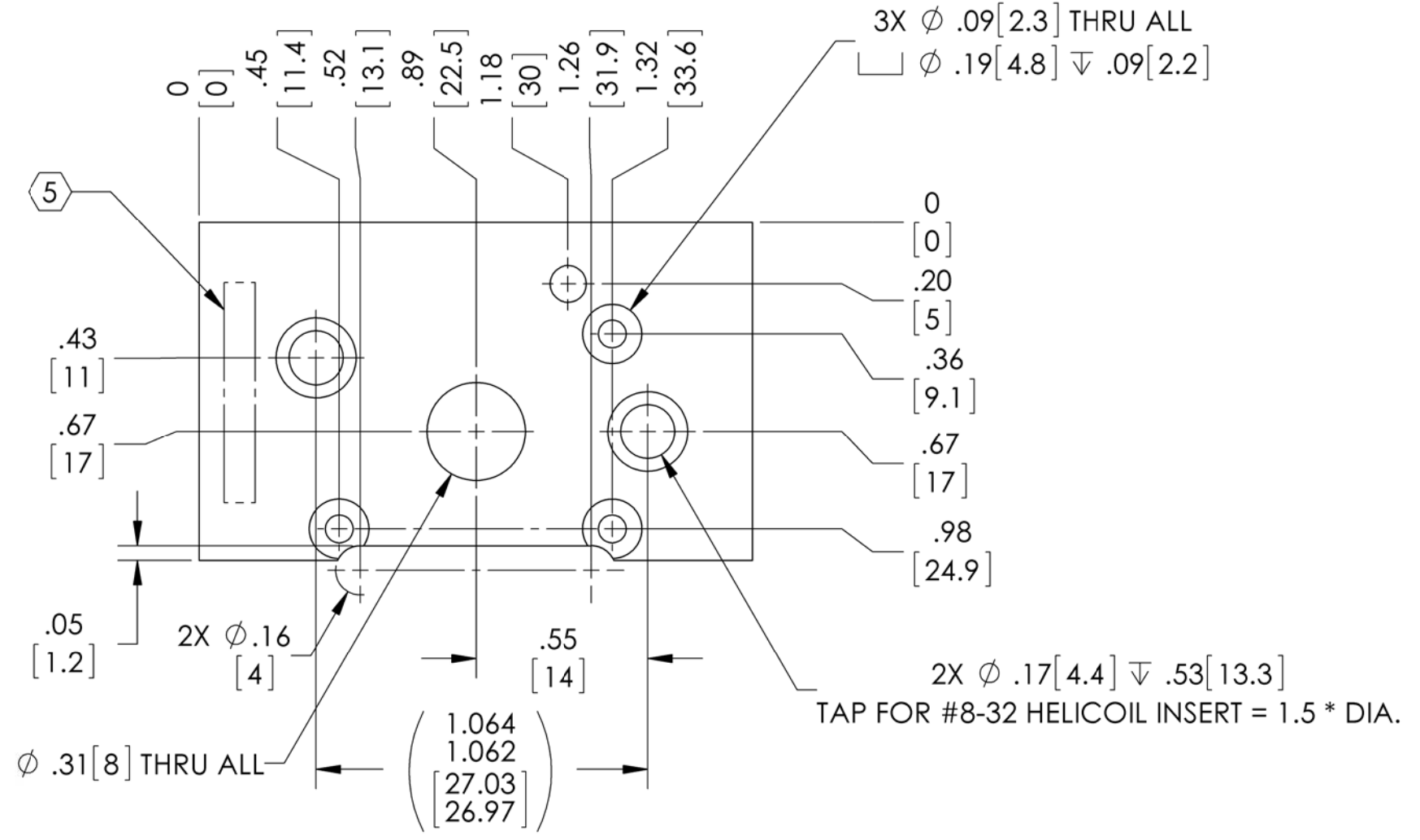
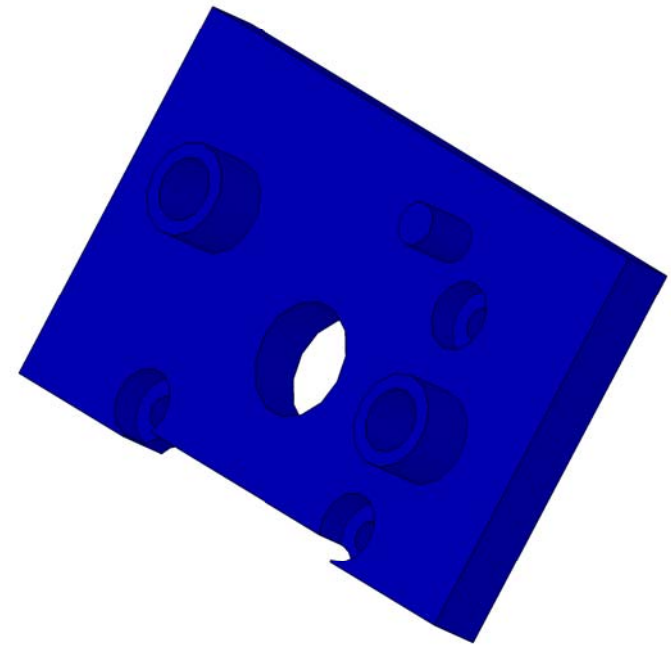
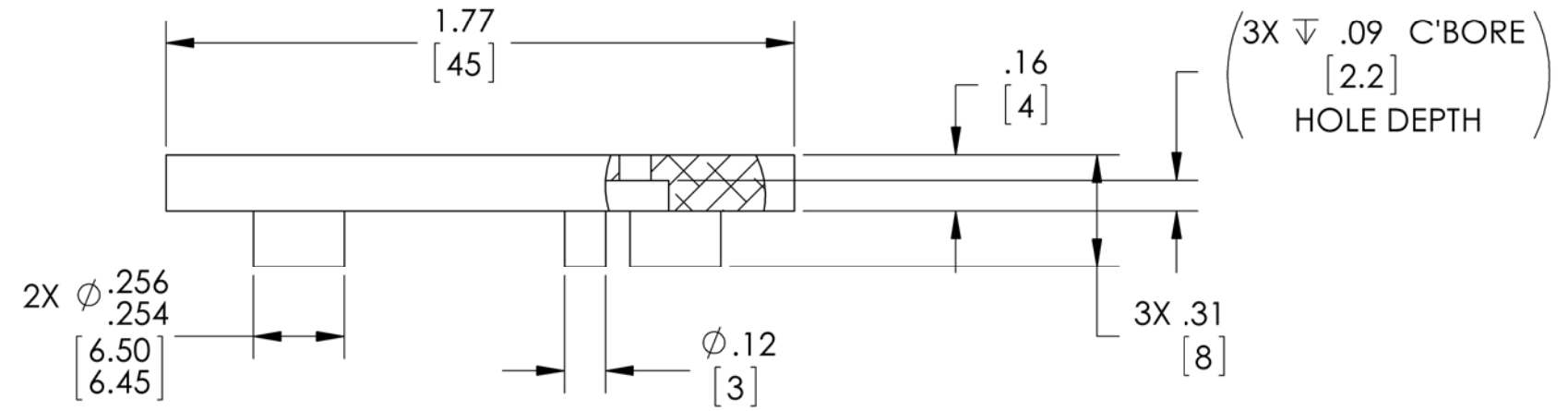


REV.	DATE	DCN #	DRAWING TREE #
v3	23 Jan 2012	E1200057	E1200069

NOTES CONTINUED:

4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12 HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXXX-VY, TYPE-XX, S/N XXX.
6. APPROXIMATE WEIGHT = 0.027 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES (INCLUDING SANDING OR SCOURING FOR MATTE FINISH) IS NOT ALLOWED. USE OF SCOTCH-BRITE OR SIMILAR PRODUCTS IS FORBIDDEN.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
10. ALL HELI-COIL TAPPED HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG HC2000 CURRENT REV.
11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NOT WELD REPAIRS OR PLUGS) UNLESS APPROVED IN ADVANCE AND IN WRITING BY LIGO, REFER TO LIGO-E0900364.
12. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE. THE MATERIAL USED MUST BE VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF AND WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH THE MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E09000364.



d060389, PART PDM REV: X-012, DRAWING PDM REV: X-005

DIMENSIONS ARE IN INCHES [MM]		TOLERANCES: .XX ± .015 .XXX ± .005		ANGULAR ± .5°		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		PART NAME		REV.	
1. INTERPRET DRAWING PER ASME Y14.5-1994.		2. REMOVE ALL SHARP EDGES, .03 x 45°.		3. DO NOT SCALE FROM DRAWING.		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		ADVANCED LIGO		SUB-SYSTEM SUS	
MATERIAL 6061-T6 Al		FINISH 63 μinch		NEXT ASSY D060387		DESIGNER J. ODELL		10 Aug. 2009		SIZE DWG. NO. B D060389	
						DRAFTER M.HILLARD		24 Jan 2012		SHEET 1 OF 1	
						CHECKER MB		15 Mar 2010			
						APPROVAL J.ODELL		15 Mar 2010			