

8 7 6 5 4 3 2 1

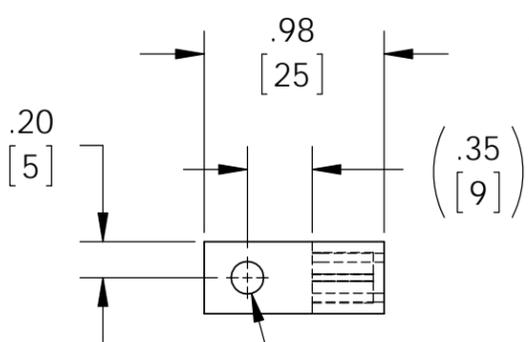
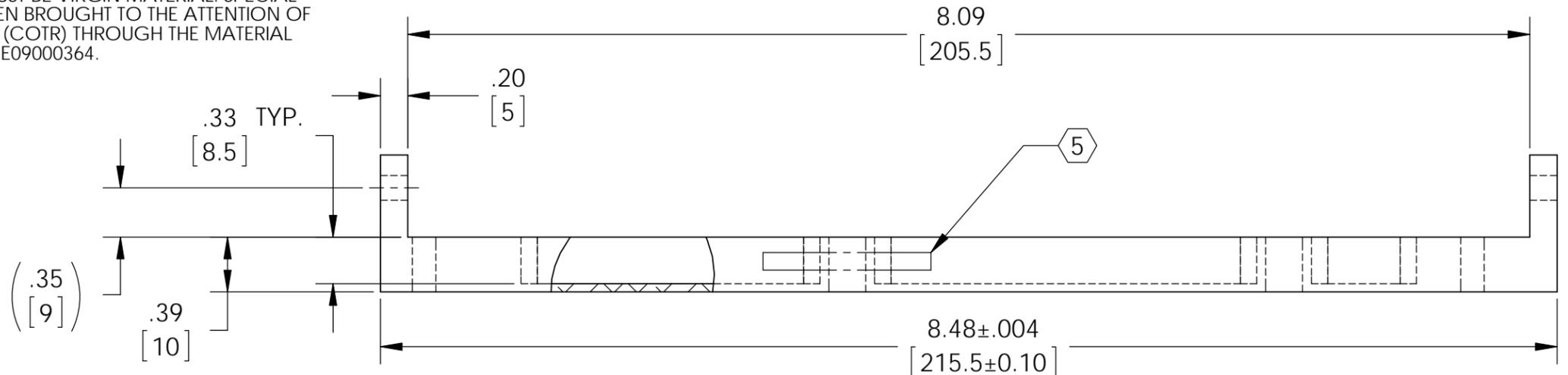
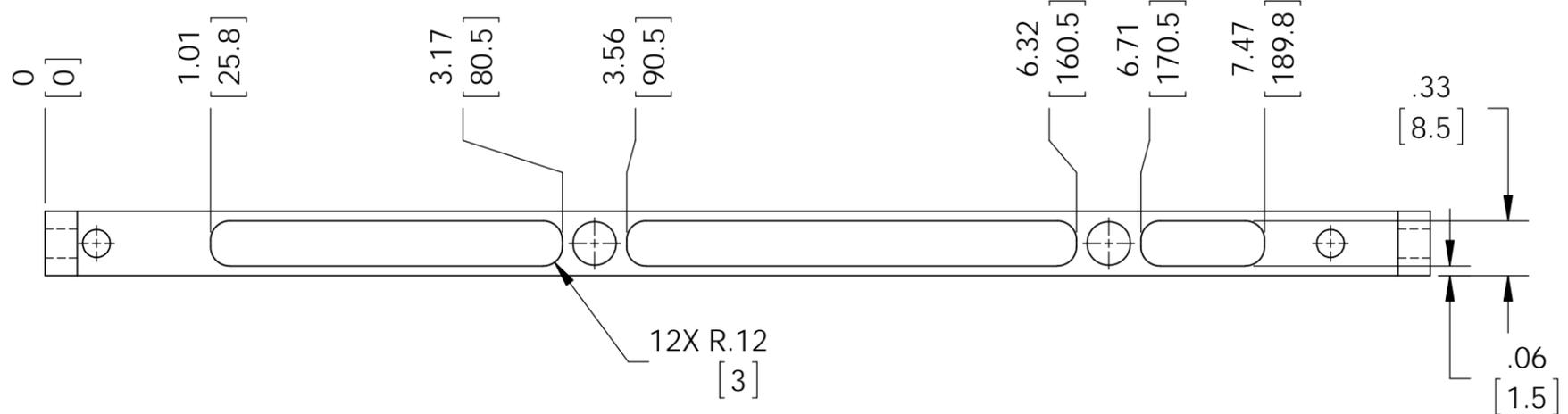
REV.	DATE	DCN #	DRAWING TREE #
v4	04 Jan. 2012	E1200004	E1200005

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 = 0.080 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-E0900364.

D
C
B
A

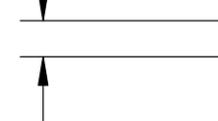
D
C
B
A



2X ϕ .170 [4.3] THRU ALL



2X ϕ .27 [6.8] ∇ .81 [20.5]
TAP FOR 1/4-20 HELICOIL INSERT = 1.5 * DIA.



2X ϕ .18 [4.5] THRU ALL
1 EACH END

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES [MM]		1. INTERPRET DRAWING PER ASME Y14.5-1994.		aLIGO SUS, EARTHQUAKE STOP MOUNTS-LONG, LOWER STRUCTURE	
TOLERANCES: .XX ± .015 .XXX ± .005		2. REMOVE ALL SHARP EDGES, .03 x 45°.		DESIGNER	NJS/FEL 08 June 2008
ANGULAR ± .25°		3. DO NOT SCALE FROM DRAWING.		DRAFTER	M.HILLARD 04 Jan. 2012
MATERIAL	6061-T6 Al	FINISH	63 μ inch	CHECKER	MB 15 Mar 2010
		NEXT ASSY	D060454	APPROVAL	J.ODELL 15 Mar 2010
				SIZE	DWG. NO.
				B	D060475
				REVISION	v4
				SCALE	1:1
				PROJECTION	ASME
				SHEET 1 OF 1	

8 7 6 5 4 3 2 1

D060475, PART PDM REV: X-009, DRAWING PDM REV: X-002