

D0901492_Advanced_LIGO_SUS_HLTS_AOSEM_Alignment_Bracket_Intermediate_Mass_Part_PDM_Rev_V2-000_Drawing_PDM_Rev_V2-001

NOTES CONTINUED:

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: DXXXXXX-VY, TYPE-XX, S/N XXX

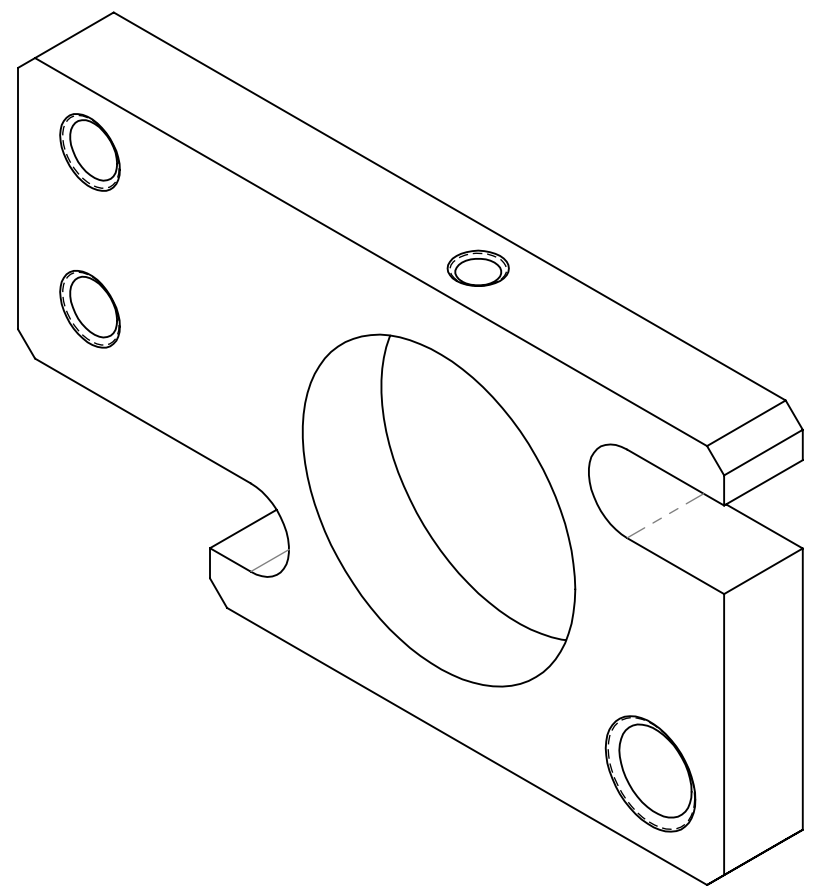
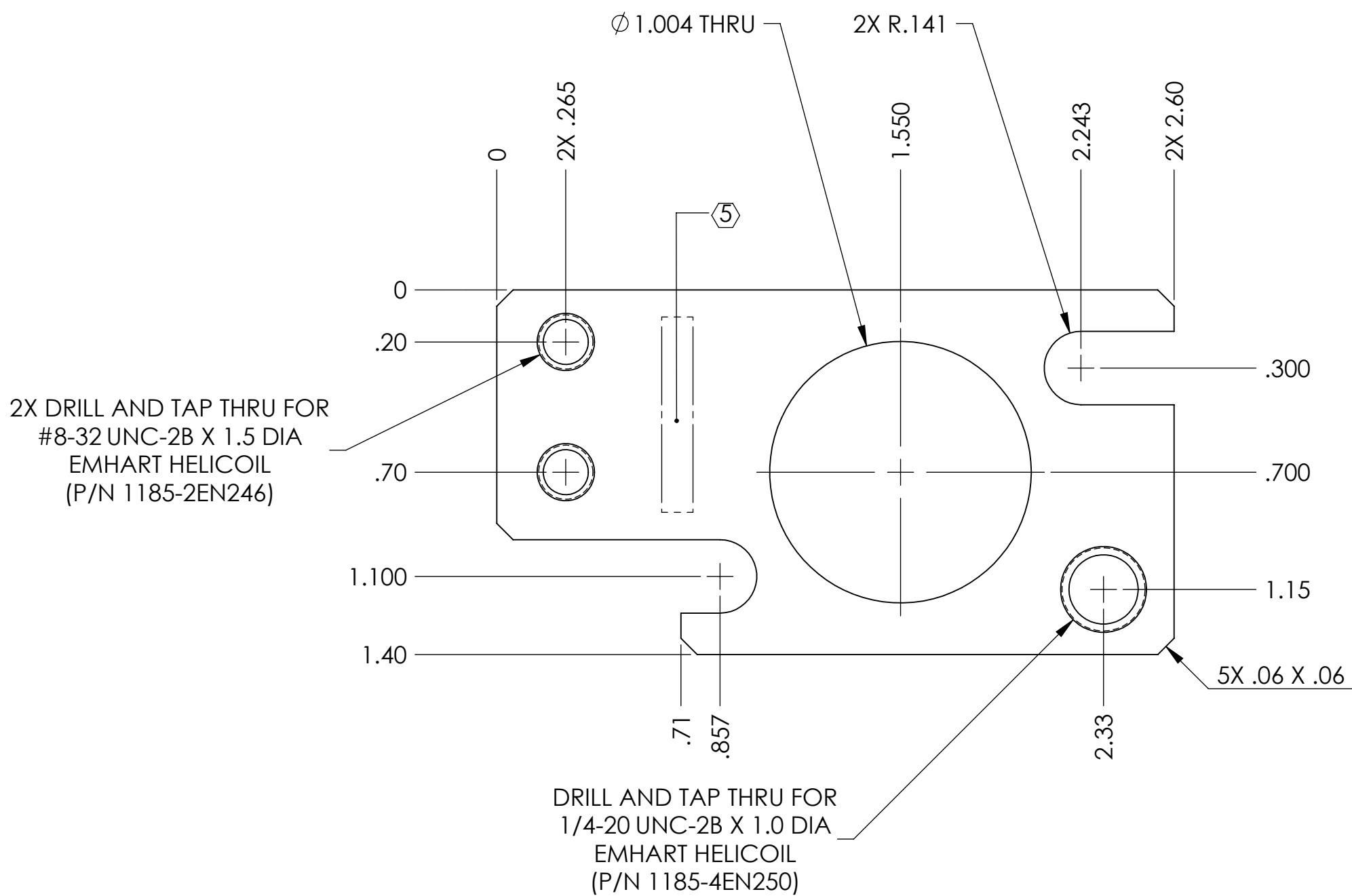
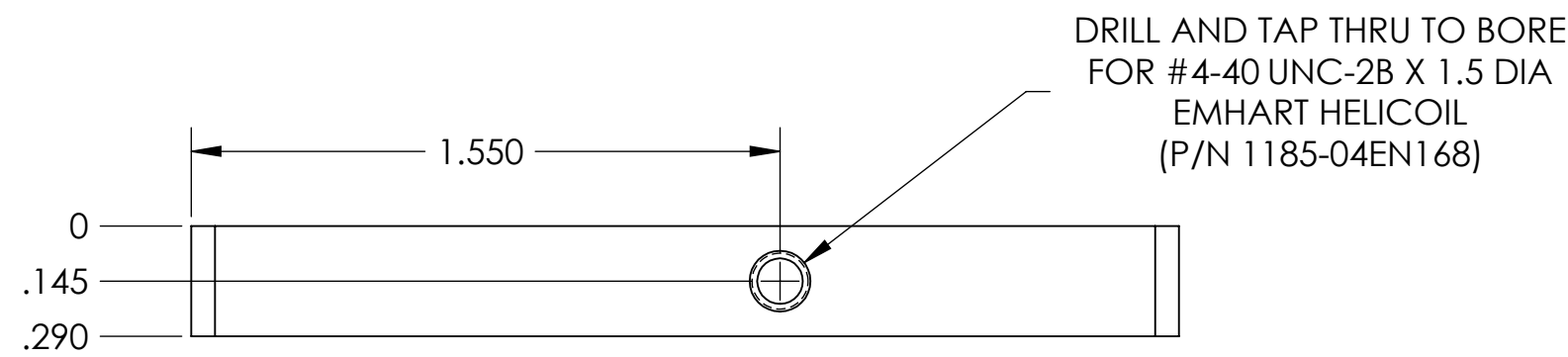
6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

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

8. ALL HELICOIL HOLES TO BE PREPARED IN ACCORDANCE WITH EMHART HELICOIL PRODUCT CATALOG, HC2000, REV. 4.

9. ALL HELICOILS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY, CLEANING AND BAKING OF FINISHED PARTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	17 AUG 2009	E0900243	E080191
v2	10 AUG 2010	E1000301	E080191
v3	05 MAR 2011	E1100228	E080191



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 MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± 0.5°

MATERIAL 6061-T6 Al

FINISH 63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME AOSEM ALIGNMENT BRACKET, INT. MASS	
SYSTEM ADVANCED LIGO	SUB-SYSTEM SUS	DESIGNER D. BRIDGES 08 MAR 2011	SIZE DWG. NO. B D0901492
DRAFTER D. BRIDGES 09 MAR 2011	CHECKER B. MOORE 09 MAR 2011	APPROVAL	REV. v3
NEXT ASSY AOSEM ALIGNMENT ASSY, INT. MASS		SCALE: 2:1	PROJECTION:
			SHEET 1 OF 1