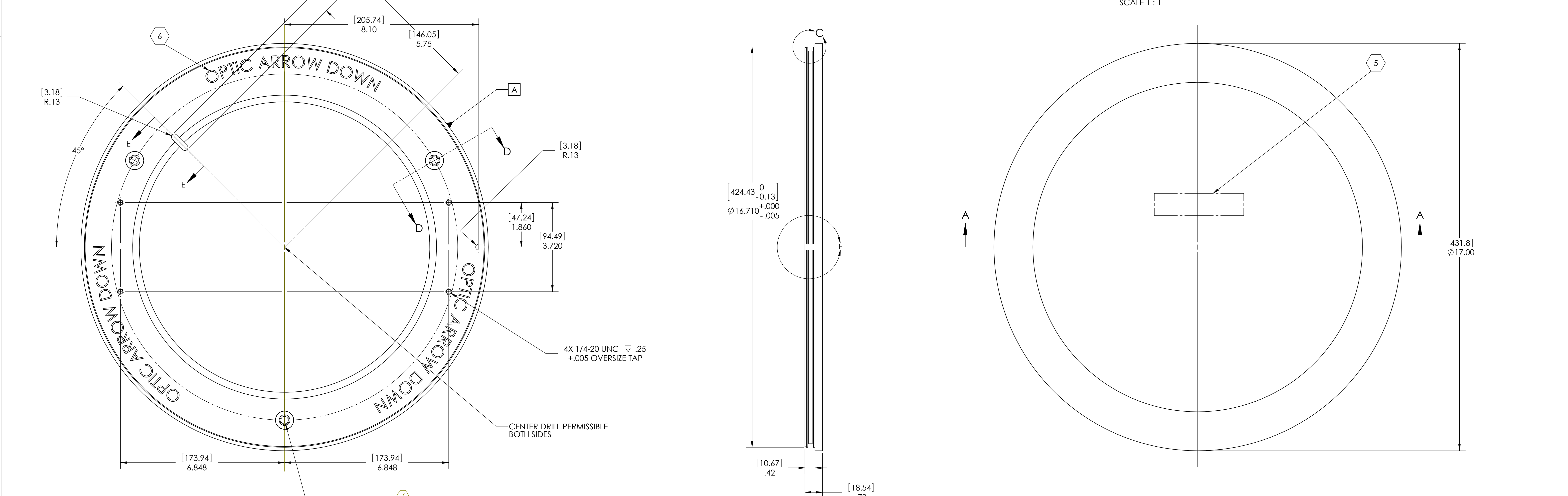
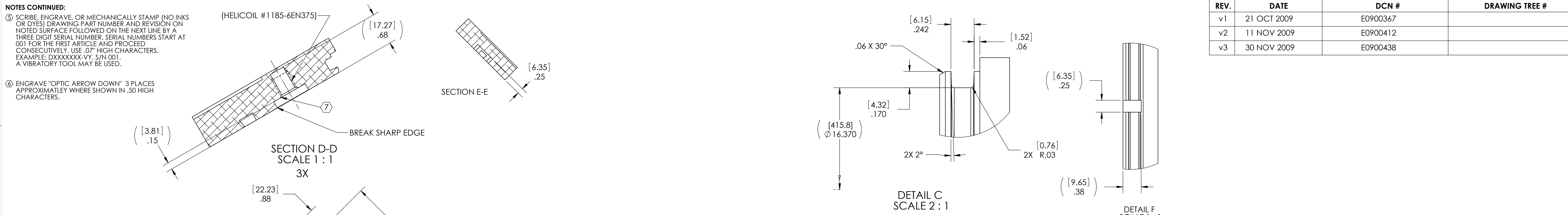


NOTES CONTINUED:
 5) SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.

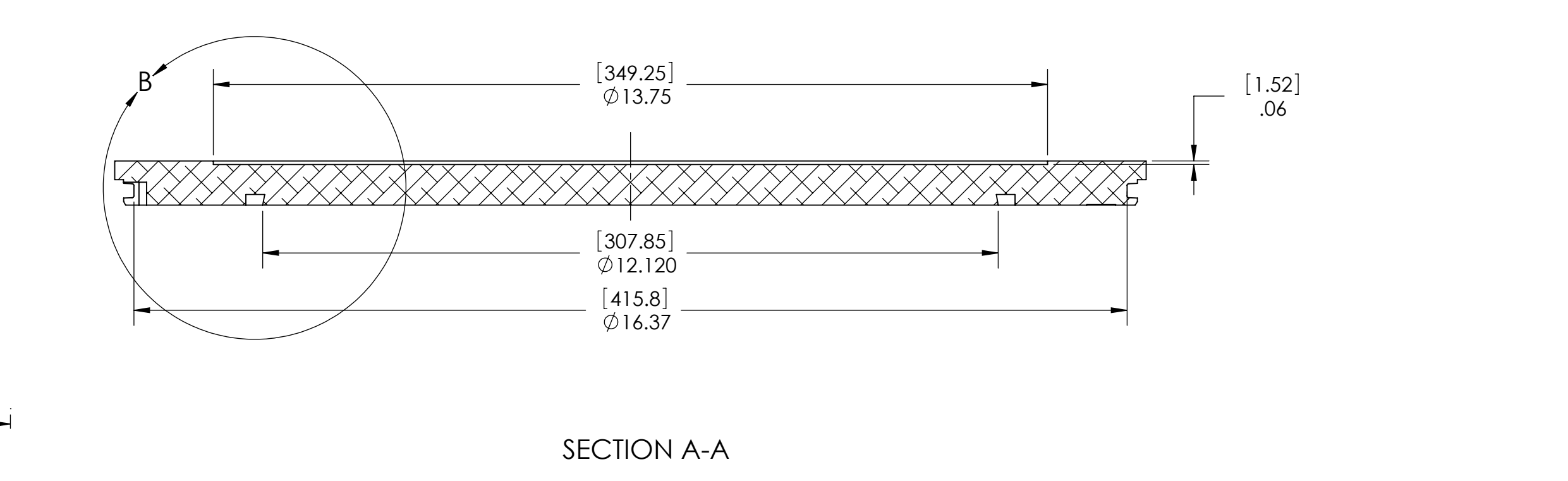
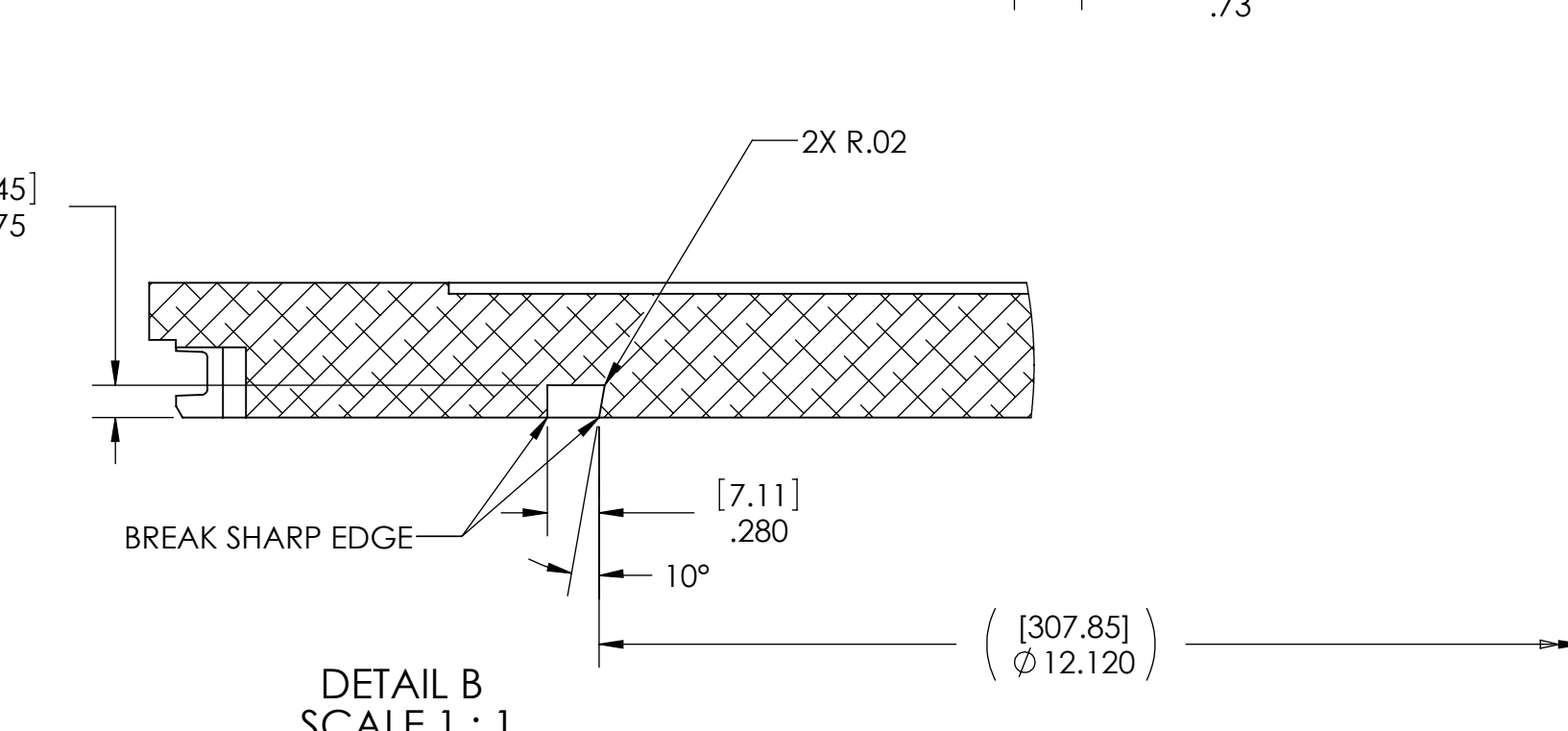
6) ENGRAVE "OPTIC ARROW DOWN" 3 PLACES APPROXIMATELY WHERE SHOWN IN .50 HIGH CHARACTERS.

REV.	DATE	DCN #	DRAWING TREE #
v1	21 OCT 2009	E0900367	
v2	11 NOV 2009	E0900412	
v3	30 NOV 2009	E0900438	



7) HELICOIL INSTALLATION:
 A) DRILL PILOT HOLE FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELI-COIL PRODUCT CATALOGUE, HC 2000
 B) COUNTERSINK HOLE FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELI-COIL PRODUCT CATALOGUE, HC 2000
 C) TAP HOLE FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELI-COIL PRODUCT CATALOGUE, HC 2000
 D) REMOVE ALL CHIPS
 E) GAGE THREADS WITH GAGE TOOL FOR INSERT SPECIFIED IN DRAWING, REFERENCE HELI-COIL PRODUCT CATALOGUE, HC 2000
 F) CLEAN THE HOLE, INSERTING TOOL AND HELI-COIL WITH SOAP AND WATER
 G) CLEAN THE HELI-COIL AND INSERT TOOL IN ACETONE (IF THE INSERT TOOL HAS ANY PLASTIC USE ISOPROPYL ALCOHOL INSTEAD OF ACETONE TO CLEAN THE INSERT TOOL)
 H) CLEAN THE HOLE WITH ACETONE AND A STAINLESS STEEL WIRE BRUSH
 I) RINSE THE HELI-COIL, INSERTING TOOL AND THE HOLE WITH DE-IONIZED WATER
 J) POWDER FREE LATEX GLOVES MUST BE WORN WHEN INSERTING THE HELI-COILS. (LATEX GLOVES FROM ANSELL EDMONT, ACCUTECH-ULTRA CLEAN 91-300)
 K) INSERT THE HELI-COIL WITH TOOL TO 3/4 TO 1 1/2 PITCH BELOW SURFACE
 L) BREAK OFF AND REMOVE TANG
 M) ONCE HELI-COILS HAVE BEEN INSERTED AND FINAL ASSEMBLY IS BEING CARRIED OUT, FOR EXAMPLE, INSERTING THE O-RINGS PLEASE KEEP THE ASSEMBLIES AS CLEAN AS POSSIBLE I.E. FREE FROM OIL, GREASE, DIRT, AND CHIPS OR

3X DRILL ∇ .68
 ∇ Ø.755 ± .003 ∇ .150
 TAP FOR 3/8-16 X .440 DEEP FULL THREAD FOR N60 HELICOIL INSERT #1185-6EN375 EQUALLY SPACED ON A 14.446 ± .005 B.C.
 ∇ Ø.010 | A



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
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.		ADVANCED LIGO		BASE PLATE, ETM, COC OPTIC CONTAINER	
DIMENSIONS ARE IN INCHES [MM] TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°		SYSTEM ADVANCED LIGO		SUB-SYSTEM COC	
MATERIAL 6061-T6 Al		FINISH 63 µinch		DESIGNER K. BUCKLAND 29 SEPT 2009	
NEXT ASSY D0902146		CHECKER K. MAILAND 8 OCT 2009		SIZE DWG. NO. D D0902147	
		APPROVAL C. TORRIE 8 OCT 2009		REV. v3	
		SCALE: 1:2		PROJECTION:	
		SHEET 1 OF 1			

D0902147 BASE PLATE, ETM, COC CONTAINER, ADVANCED LIGO, PART PDM REV: X.005, DRAWING PDM REV: X.008