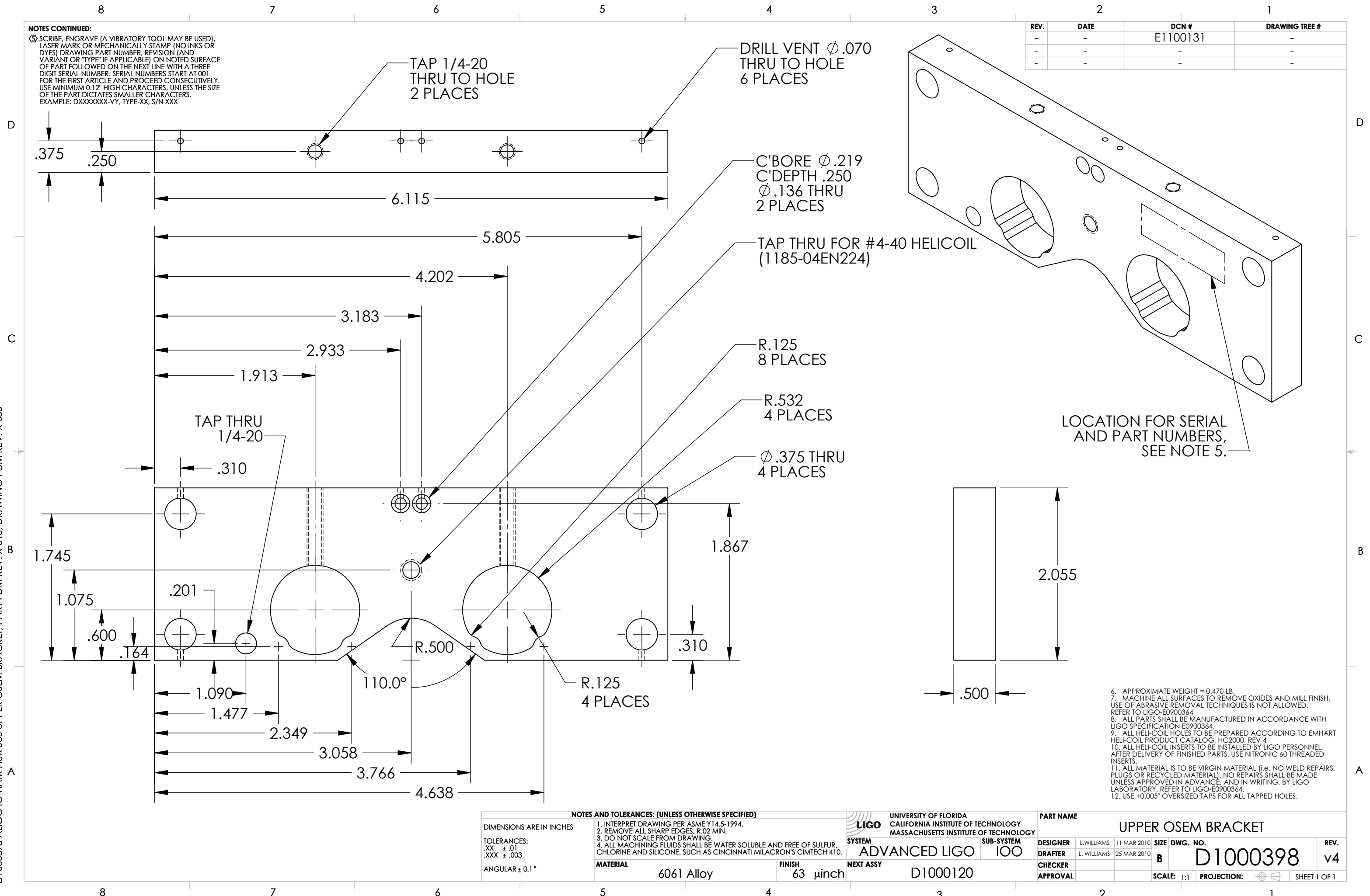


NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

REV.	DATE	DCN #	DRAWING TREE #
-	-	E1100131	-
-	-	-	-
-	-	-	-



- 6. APPROXIMATE WEIGHT = 0.470 LB.
- 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.
- 12. USE +0.005" OVERSIZED TAPS FOR ALL TAPPED HOLES.

DIMENSIONS ARE IN INCHES	
TOLERANCES:	.XX \pm .01
	.XXX \pm .003
ANGULAR \pm 0.1°	

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 SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.

MATERIAL	FINISH
6061 Alloy	63 μ inch

UNIVERSITY OF FLORIDA CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	PART NAME		UPPER OSEM BRACKET	
	SYSTEM ADVANCED LIGO	SUB-SYSTEM 100	DESIGNER	L.WILLIAMS
NEXT ASSY D1000120	DATE 11 MAR 2010	SIZE B	DWG. NO. D1000398	REV. v4
	DRAFTER L.WILLIAMS	DATE 25 MAR 2010	SCALE: 1:1	PROJECTION:
	CHECKER		SHEET 1 OF 1	

D1000398 ALIGO IO HAM AUX SUS UPPER OSEM BRACKET, PART PDM REV: X-016, DRAWING PDM REV: X-005