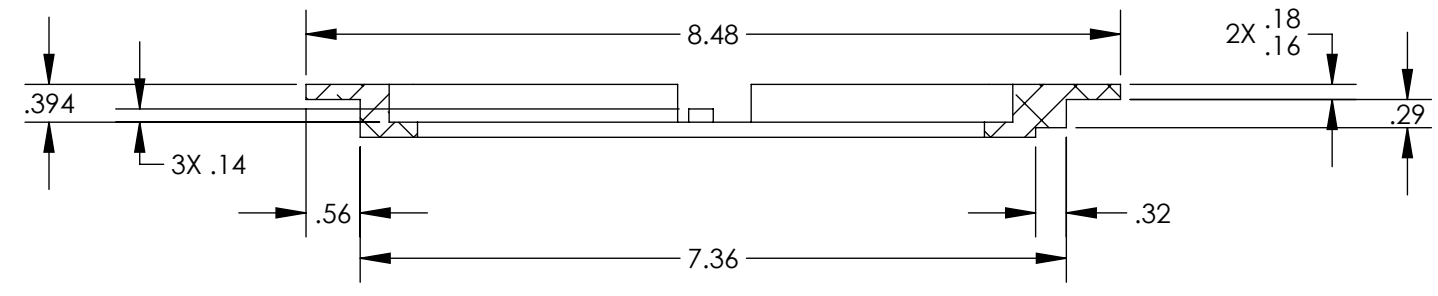
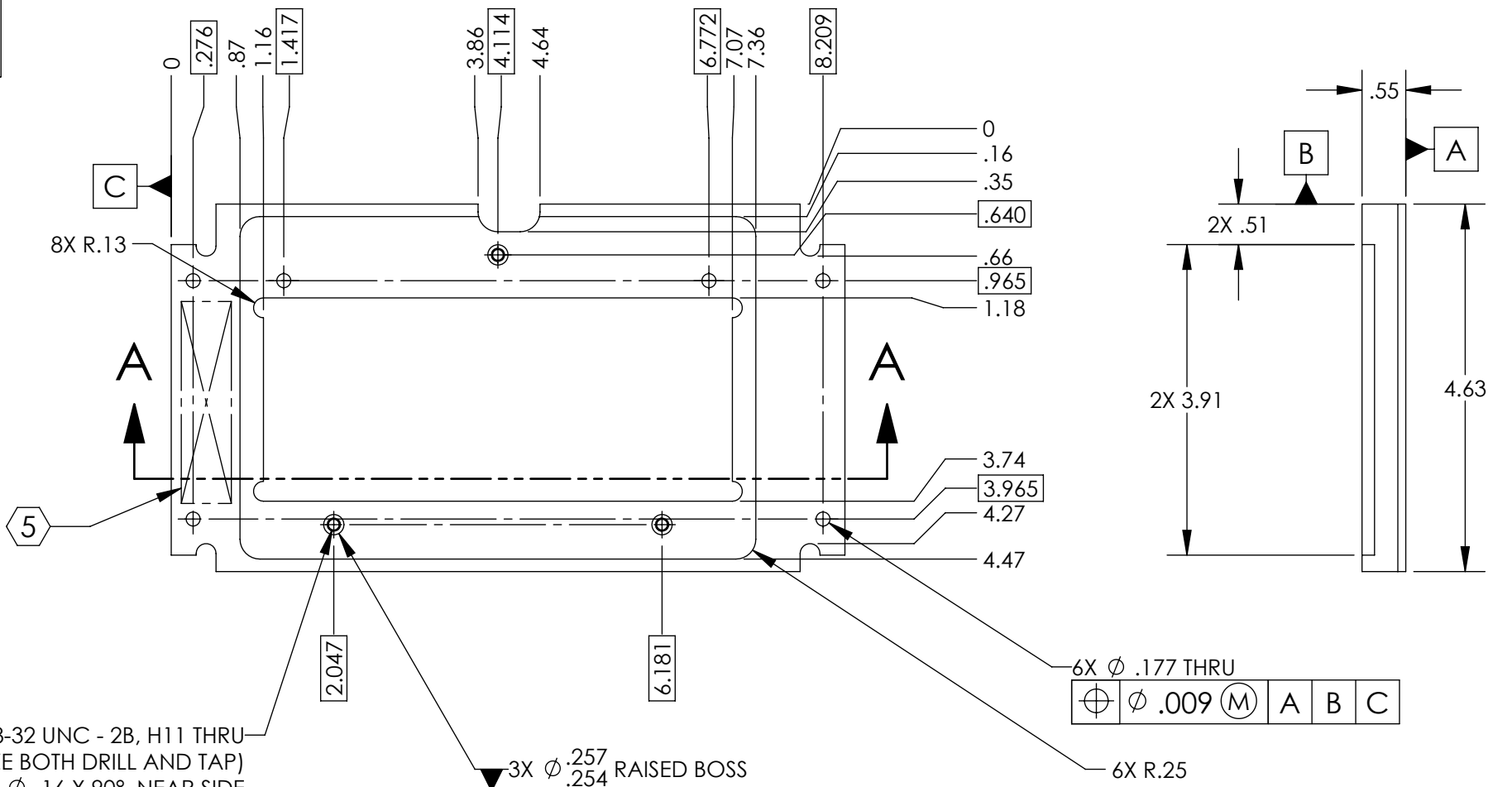
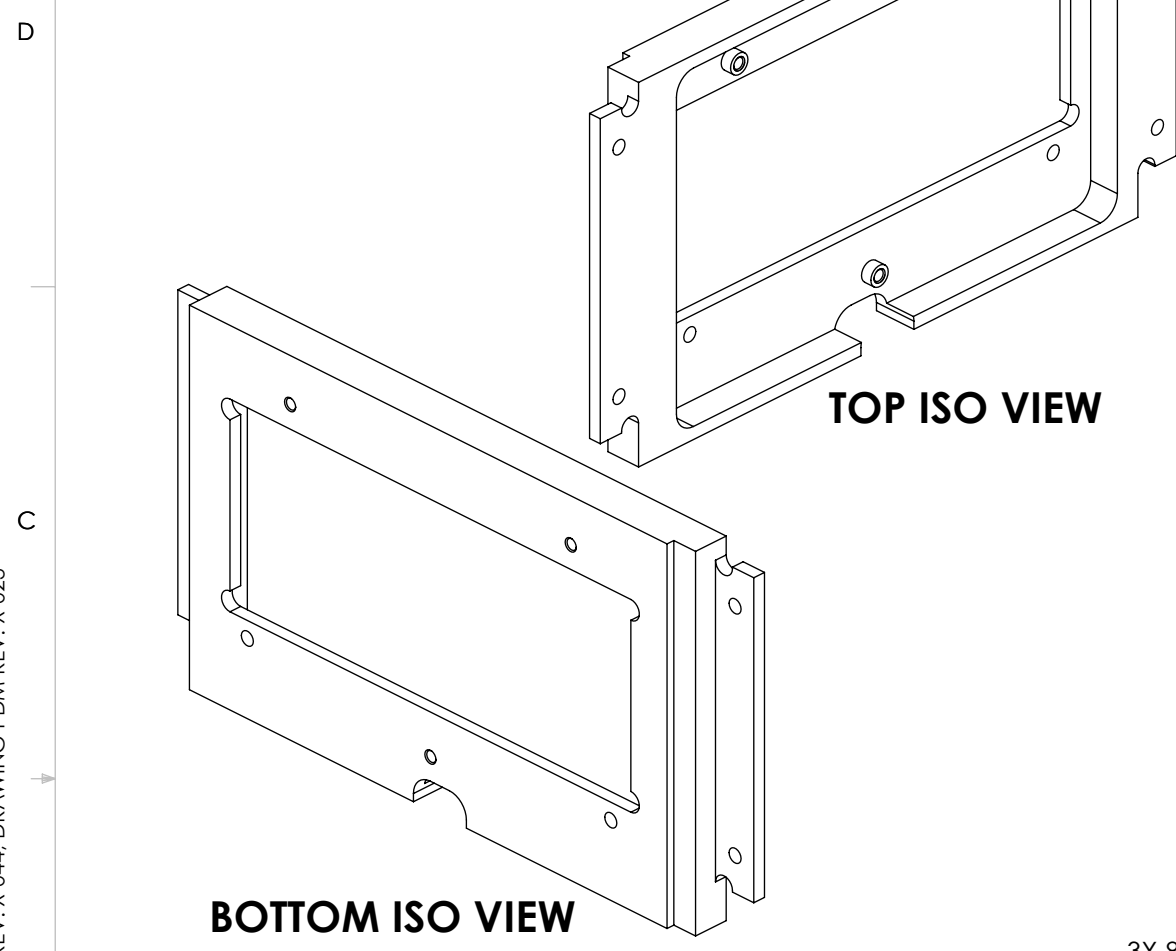


D1000409 aLIGO\_OSUMS\_INTERMEDIATE\_SUPPORT\_RIGHT\_SIDE\_TRAY, PART PDM REV: X-044, DRAWING PDM REV: X-023

REV.	DATE	DCN #	DRAWING TREE #
v1	29 JUN 2010	E1000234	
v2	31 MAR 2011	E1100277	
v3	13 MAR 2012	E1200216	



- NOTES (CONTINUED):**
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE, PER LIGO SPECIFICATION E0900237.
  - 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. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXXX-VY, TYPE-XX, S/N XXX.
  - MASS: 256 G [0.564 LB].
  - MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364.
  - ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
  - ALL HELI-COIL TAPPED HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG HC2000.
  - ALL HELICOIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.
  - ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NOT WELD REPAIRS OR PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING BY LIGO LABORATORY. REFER TO LIGO-E0900364.
  - ALL TAPPED HOLES: 0.005" OVERSIZE, BOTH DRILL AND TAP.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				1. INTERPRET DRAWING PER ASME Y14.5-1994.		aLIGO OSUMS INTERMEDIATE SUPPORT RIGHT SIDE TRAY	
TOLERANCES: .XX ± .01 .XXX ± .005				2. REMOVE ALL SHARP EDGES, .005-.015.		DESIGNER K. MAILAND 23 FEB 2010	
ANGULAR ± 1.0°				3. DO NOT SCALE FROM DRAWING.		DRAFTER I ROMERO 24 OCT 2010	
MATERIAL 6061-T6 Al		FINISH 63 µinch Ra		SYSTEM ADVANCED LIGO SUB-SYSTEM AOS		SIZE DWG. NO. B D1000409	
NEXT ASSY D1000549				CHECKER SEE DCN		REV. v3	
				APPROVAL SEE DCN		SCALE: NOTE PROJECTION: SHEET 1 OF 1	