

D1000539_ALIGO_IO_HAM_AUX_SUS_EARTHQUAKE_STOP_LOWER_LEFT, PART PDM REV: X-010, DRAWING PDM REV: X-010

NOTES CONTINUED:

5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
 EXAMPLE (PART): 001-v1
 EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD

6. APPROXIMATE WEIGHT = 0.108 LB.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

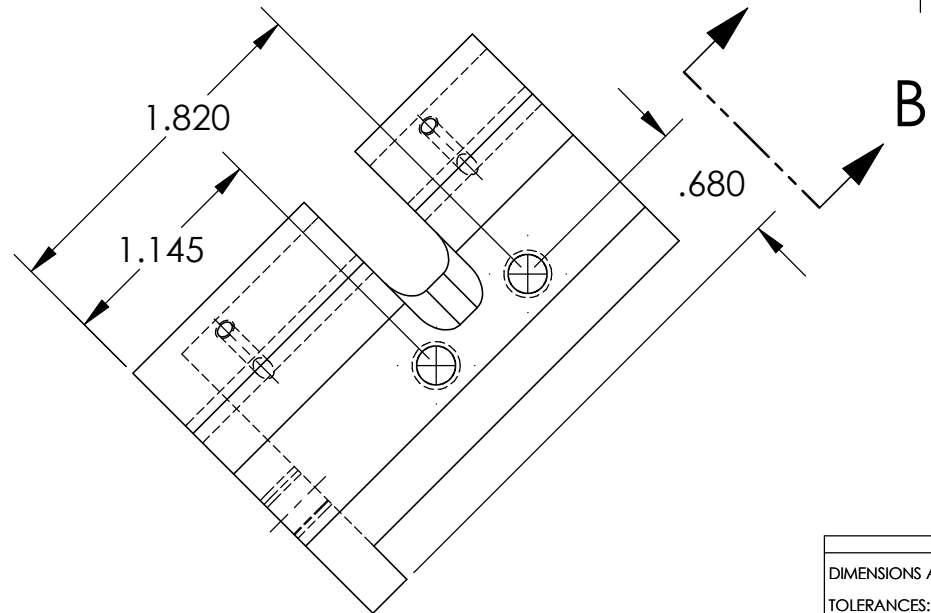
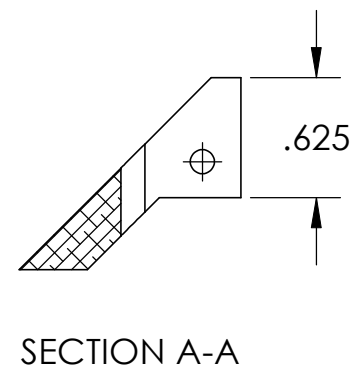
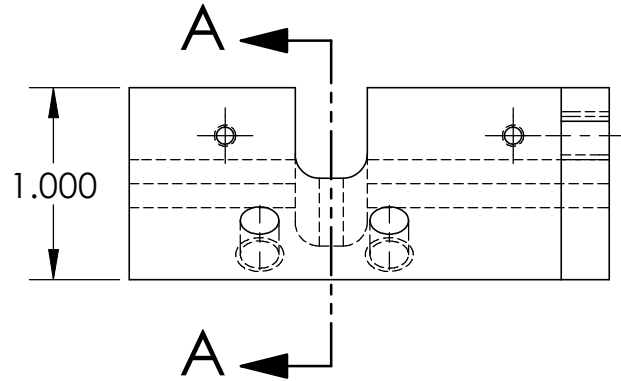
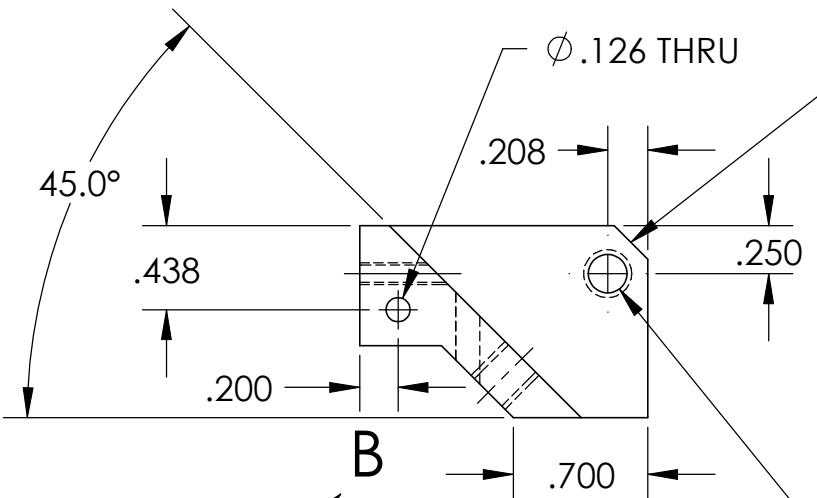
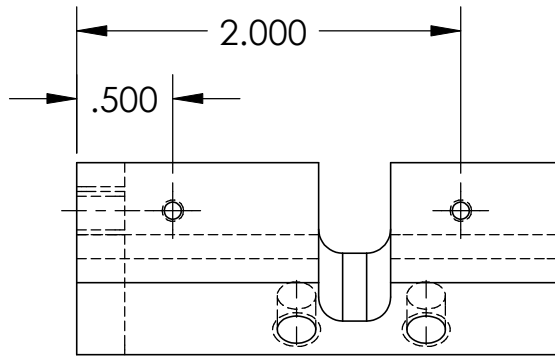
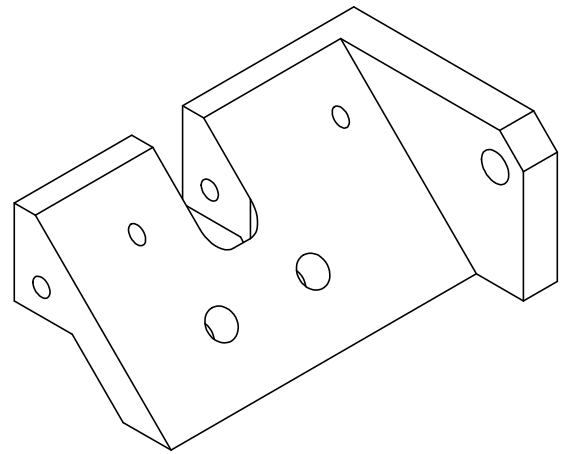
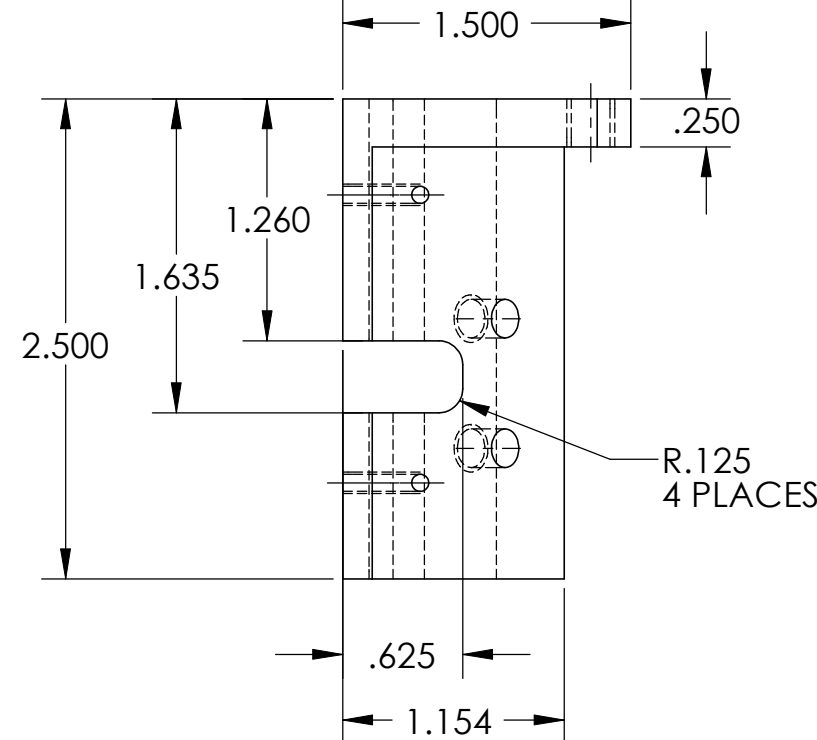
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

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.

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



TAP THRU FOR #4-40 HELICOIL (1185-04EN224)
5 PLACES

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				UNIVERSITY OF FLORIDA CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .003 ANGULAR ± 0.1°				LIGO SYSTEM ADVANCED LIGO		EARTHQUAKE STOP LOWER LEFT	
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.				SUB-SYSTEM 100		DESIGNER L.WILLIAMS 11 MAR 2010 DRAFTER L.WILLIAMS 25 MAR 2010 CHECKER APPROVAL	
MATERIAL 6061 Alloy				FINISH 63 μinch		NEXT ASSY D1000120	
				SIZE DWG. NO. B D1000539		REV. v6	
				SCALE: 1:1 PROJECTION:		SHEET 1 OF 1	

VIEW B-B

8 7 6 5 4 3 2 1