

NOTES CONTINUED:

5 SCRIBE, ENGRAVE, LASER MARK 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 = .006 LB.

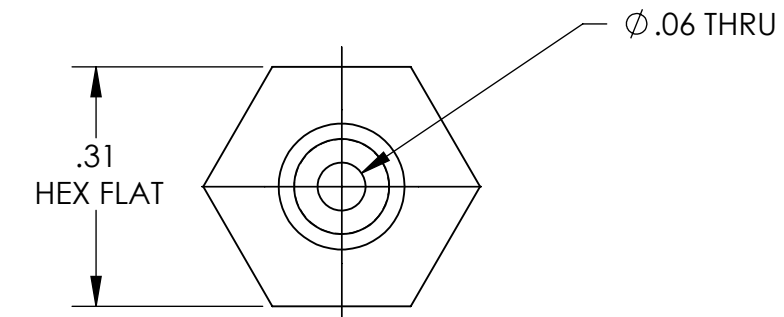
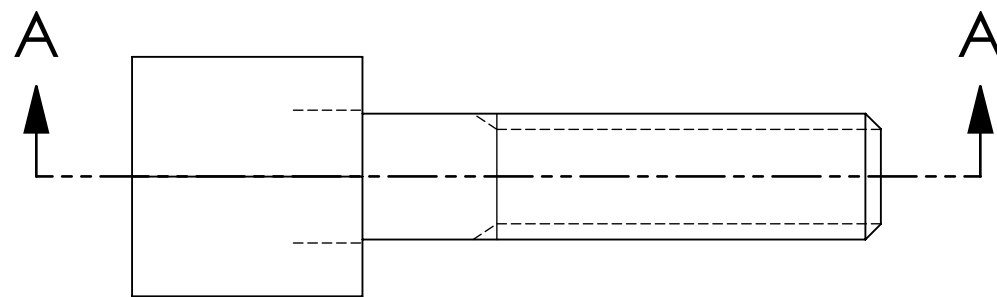
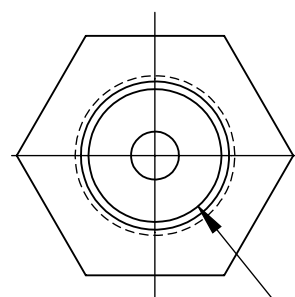
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

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

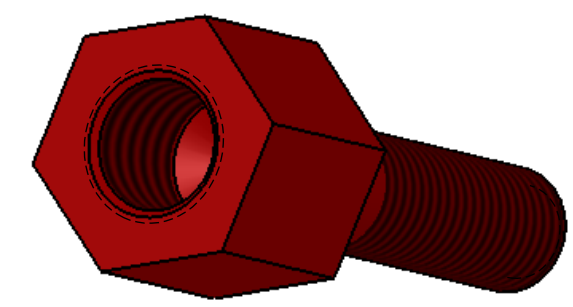
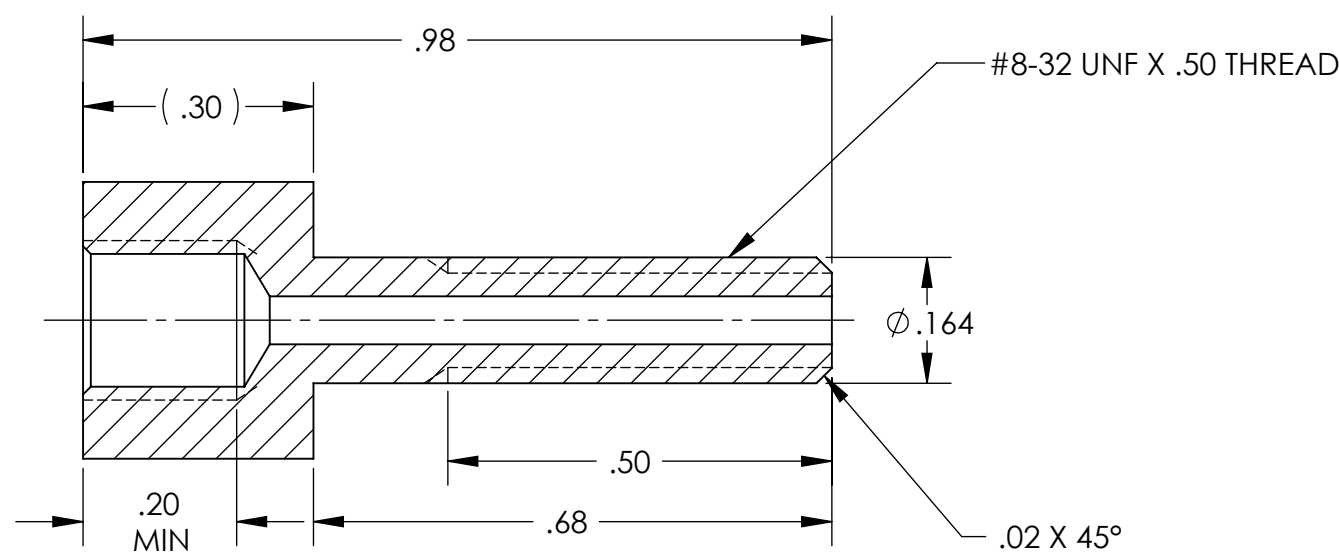
9 ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

10 ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	20 OCT 2011	E1000406	-
-	-	-	-
-	-	-	-



DRILL AND TAP FOR #8-32 N60 HELICOIL INSERT #1185-2EN 164 HELI-COIL=1 DIA.  
9 10



GENERAL VIEW FOR REFERENCE ONLY NO SCALY

SECTION A-A SCALE 4:1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± 0.5°	
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.	
MATERIAL	304 SSTL
FINISH	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	AOS
NEXT ASSY	D1000429

PART NAME				SLC FM ELLIPTICAL STANDOFF ADAPTER #8-32			
DESIGNER	N. Nguyen	20 AUG 2010	SIZE	DWG. NO.		REV.	
DRAFTER	N. Nguyen	15 Sep 2010	B	D1001049		v1	
CHECKER	M. Smith	20 Sep 2010	SCALE:	1:1	PROJECTION:	SHEET 1 OF 1	
APPROVAL	C. Torrie	30 Sep 2010					

D1001049\_AdlIGO\_slc\_fm\_Elliptical Standoff Adapter #8-32, PART PDM REV: X-015, DRAWING PDM REV: X-015