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): DXXXXXXX-VY, TYPE-XX, QTY: TBD

6. VICTREX 450G. VIRGIN PEEK RESIN. NO OTHER ADDITIVES.

7. APPROXIMATE WEIGHT = .0005 LBS.

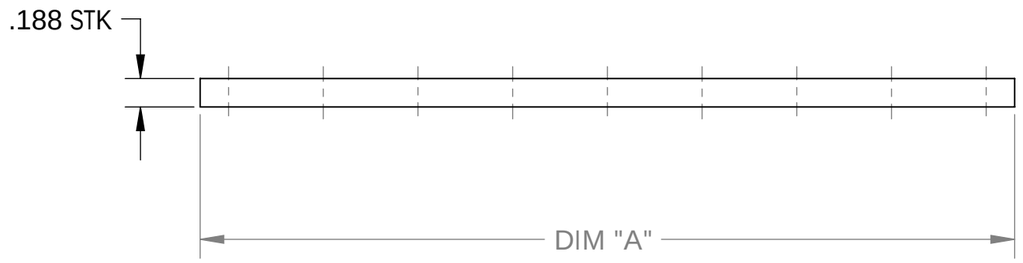
8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

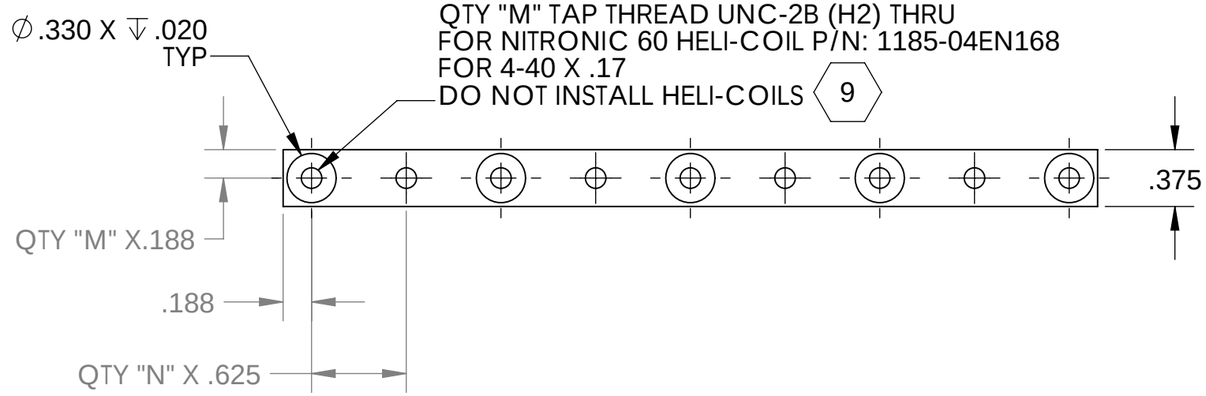
9. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

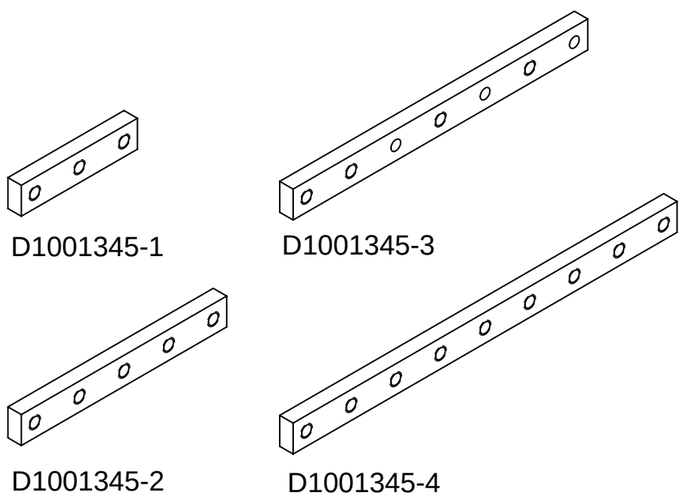
10. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

11. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

REV.	DATE	DCN #	DRAWING TREE #
v2	19 JAN 2011	-	-
v3	09 FEB 2011	E1100099	-
-	-	-	-







PART NUMBER	DIM "A"	QTY "M"	QTY "N"
D1001345-1	1.625	3	2
D1001345-2	2.875	5	4
D1001345-3	4.125	7	6
D1001345-4	5.375	9	8

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .05
.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. MACHINE DRY. NO MACHINING FLUIDS MUST BE USED.

MATERIAL: PEEK 6

FINISH: 125 ⌓inch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM:

SUB-SYSTEM:

NEXT ASSY: D1001346

PART NAME: aLIGO, CABLE BRACKET, NUTPLATE

DESIGNER	J. DAVIS	31 MAY 2010
DRAFTER	J. DAVIS	31 MAY 2010
CHECKER	S.SHANLE	09 FEB 2011
APPROVAL		

SIZE: B — DWG. NO.: D1001345 — REV.: v3

SCALE: 2:1 — PROJECTION: — SHEET 1 OF 1

D1001345 - aLIGO, CABLES HAM TABLE, NUTPLATE, PART PDM REV: X-014, DRAWING PDM REV: X-005