

D1001755\_dLIGO TCS RH, Lower Custom 25D Connector Bracket, PART PDM REV: X-010, DRAWING PDM REV: X-009

- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE, 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: DXXXXXX-VY, TYPE-XX, S/N XXX
  - 6. APPROXIMATE WEIGHT = X.XXX 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.
  - 11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.
  - 12. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	8-NOV-2010	E1000700	E1000699
v2	25-OCT-2011	E1100950	E1000699
-	-	-	-

D

C

B

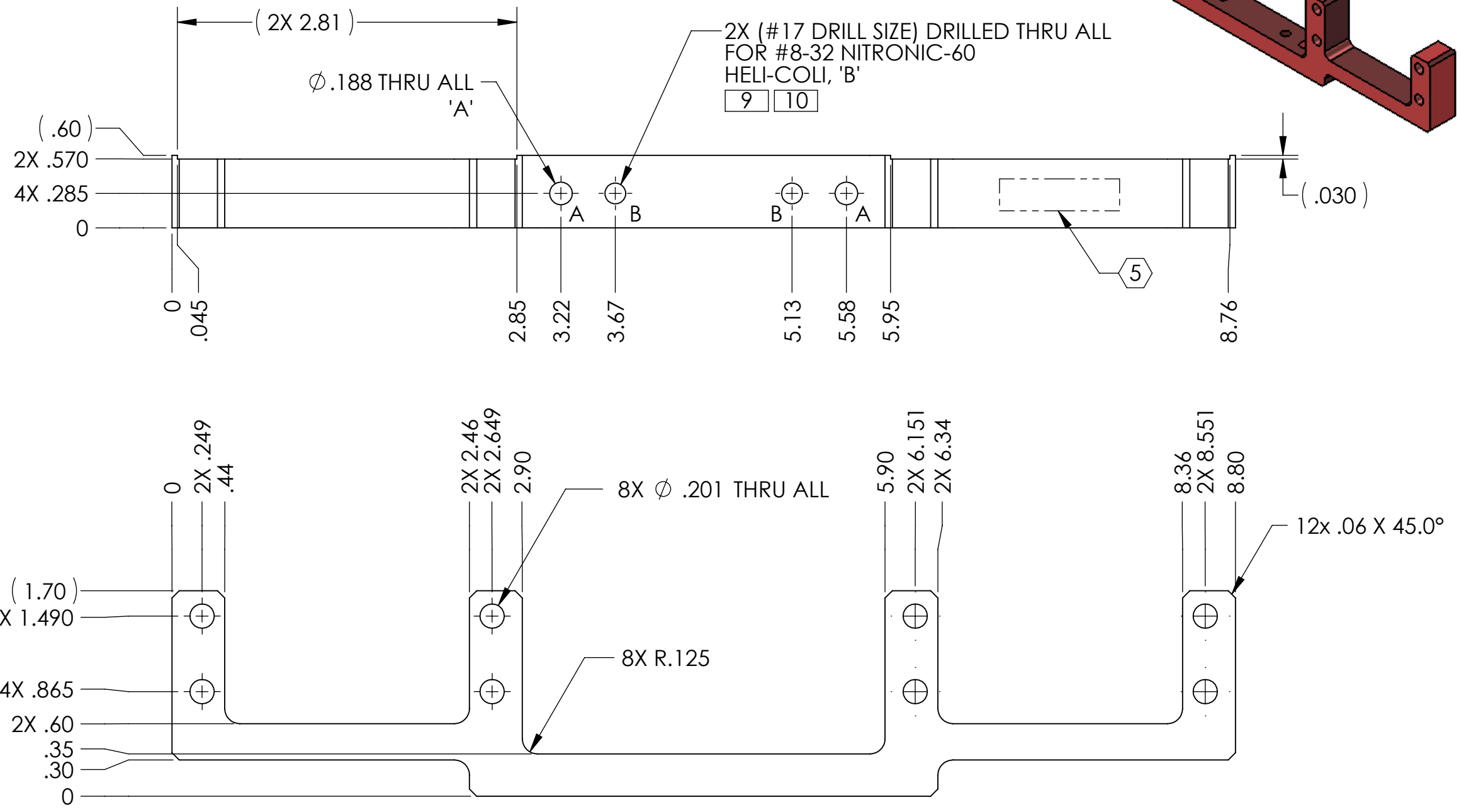
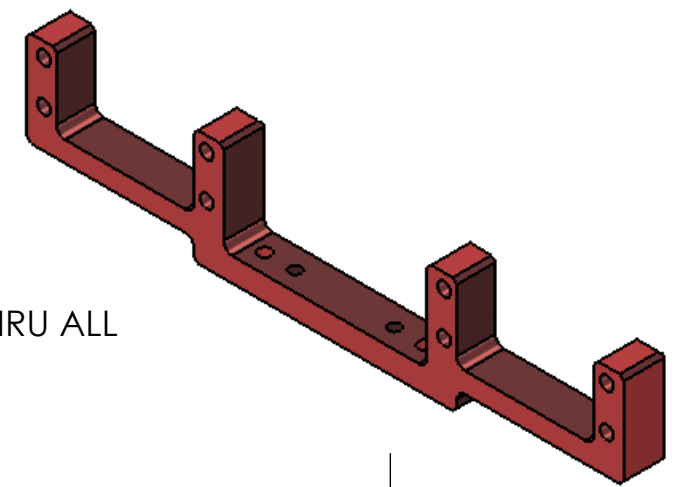
A

D

C

B

A



DIMENSIONS ARE IN INCHES		TOLERANCES:		ANGULAR ± 0.1°		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		MATERIAL		FINISH		SYSTEM		SUB-SYSTEM		PART NAME		DESIGNER		DRAFTER		CHECKER		APPROVAL		SIZE DWG. NO.		REV.	
		.XX ± .01				1. INTERPRET DRAWING PER ASME Y14.5-1994.		6061-T6 (SS)		63 μinch		ADVANCED LIGO		AOS		aLIGO TCS RH, LOWER CUSTOM 25D CON BRKT		A.COLE		A.COLE		M.JACOBSON		B		D1001755		v2	
		.XXX ± .005				2. REMOVE ALL SHARP EDGES, R.02 MIN.						CALIFORNIA INSTITUTE OF TECHNOLOGY				13-AUG-2010		8-NOV-2010		8-NOV-2010		8-NOV-2010		SCALE: 1:2		SHEET 1 OF 1			
						3. DO NOT SCALE FROM DRAWING.						MASSACHUSETTS INSTITUTE OF TECHNOLOGY				8-NOV-2010		8-NOV-2010		8-NOV-2010		8-NOV-2010		PROJECTION:					
						4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.						NEXT ASSY		D1001520															