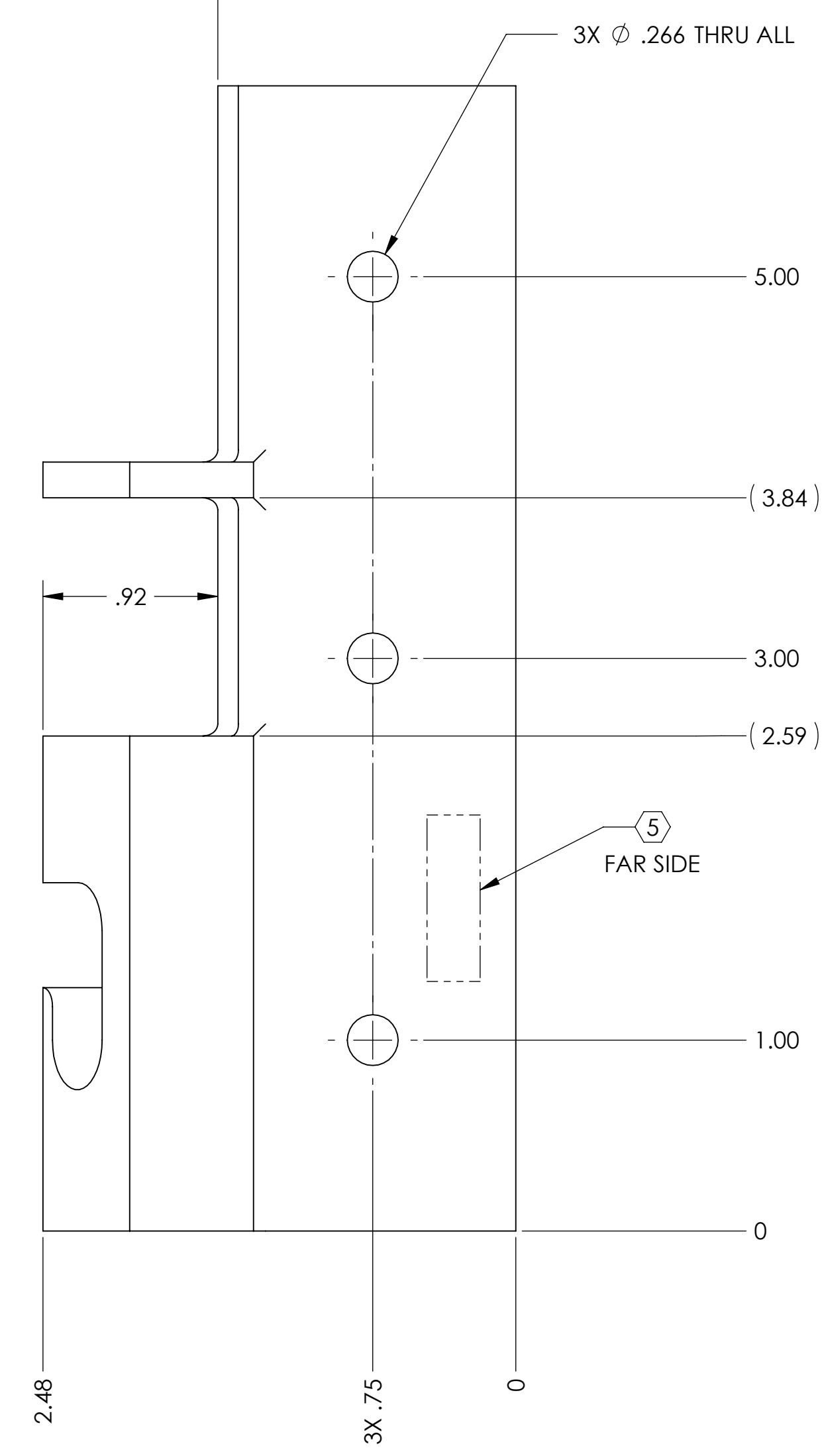
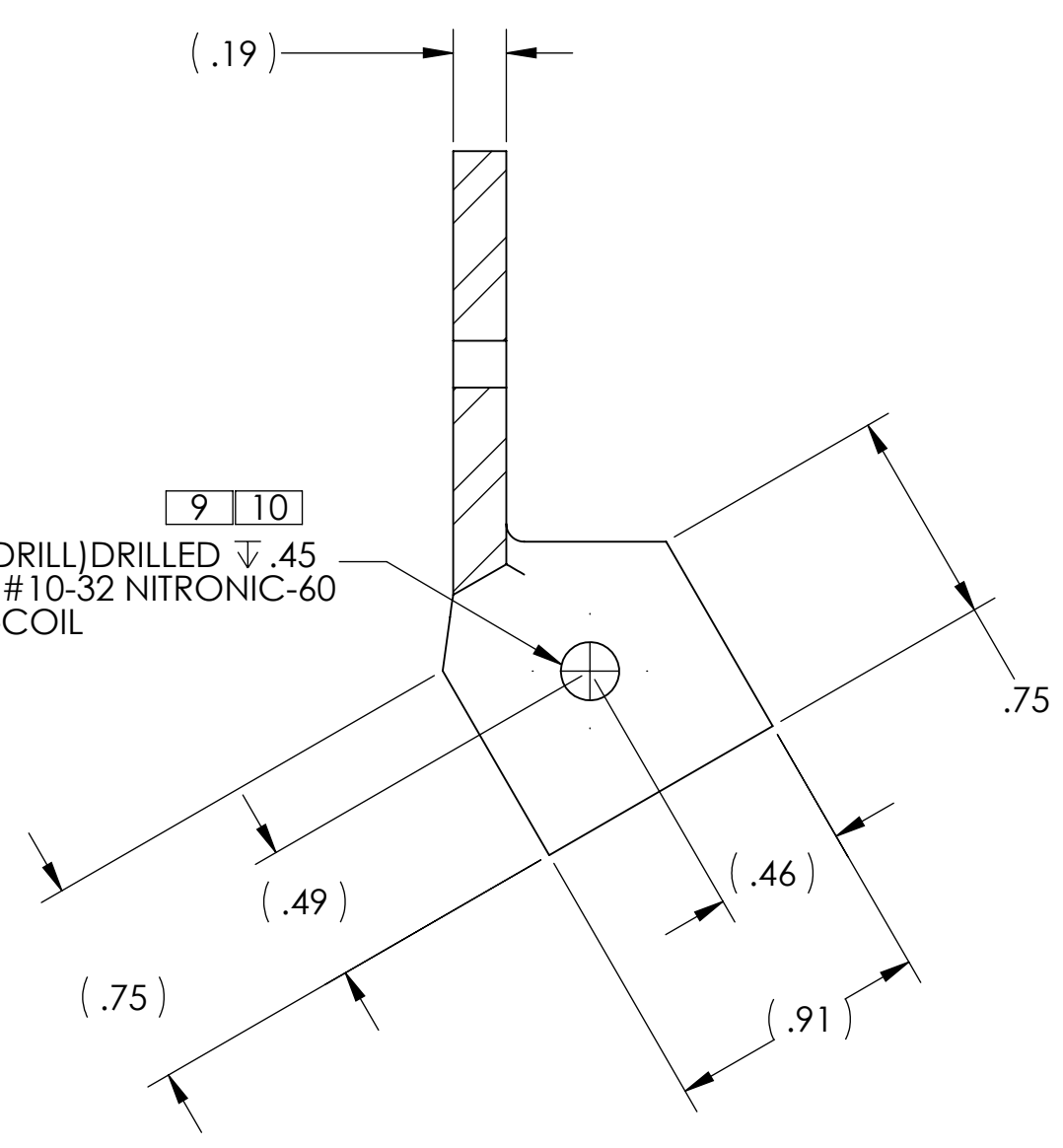
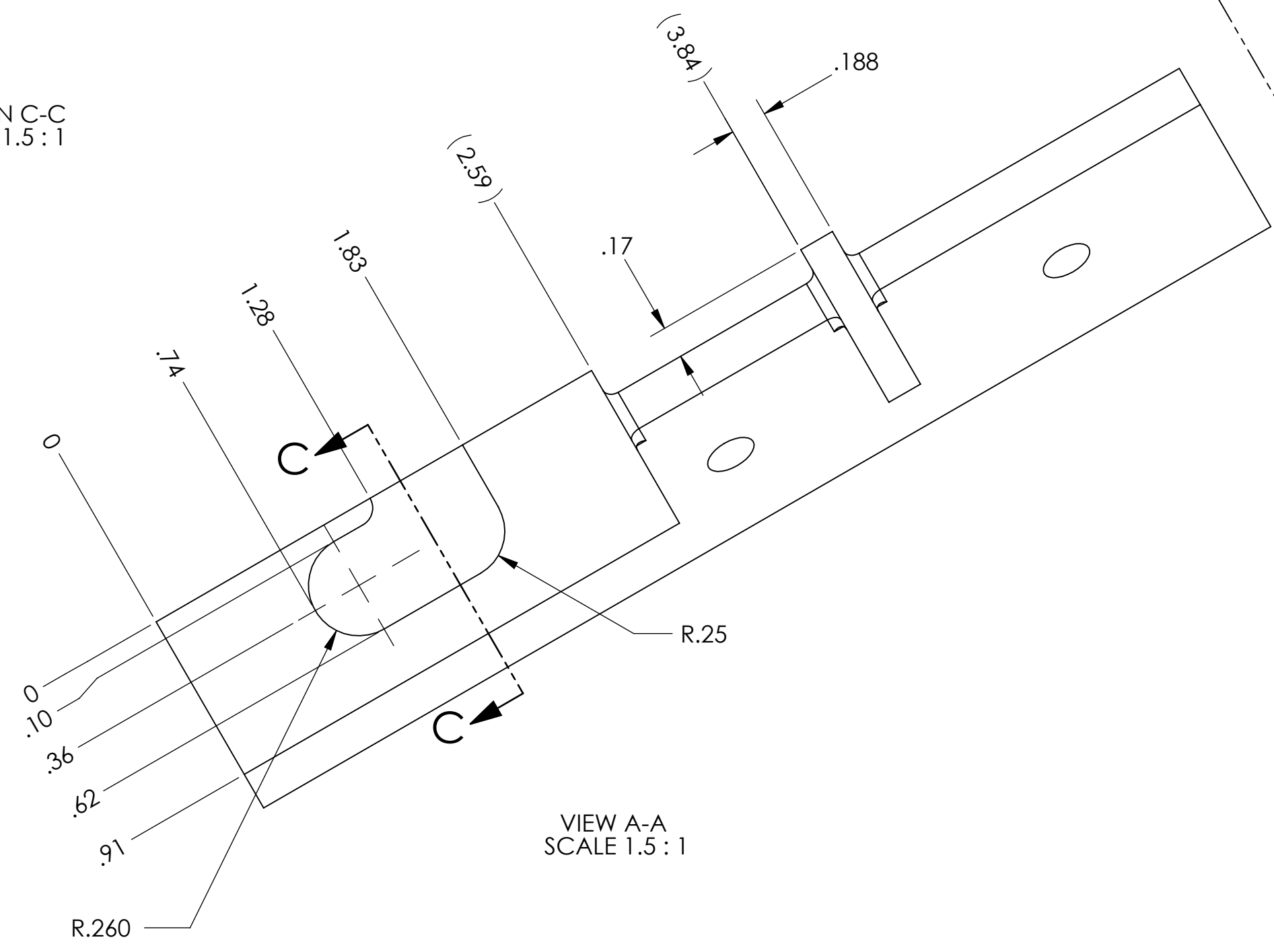
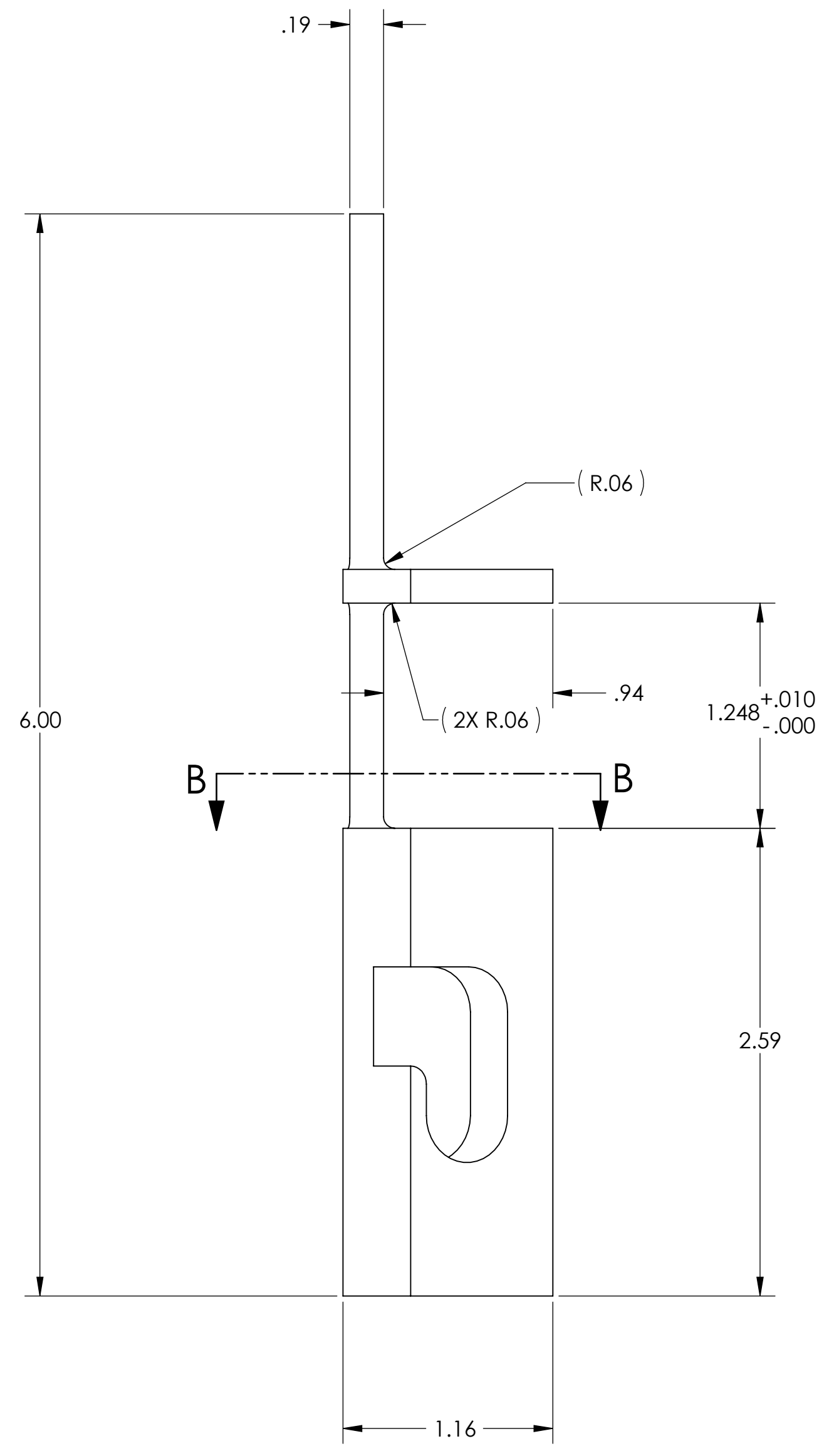
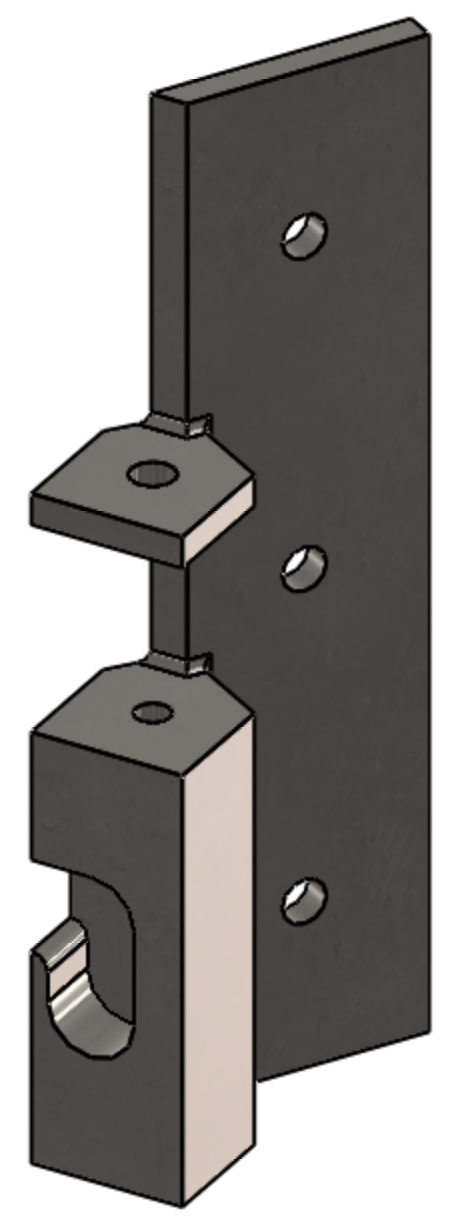
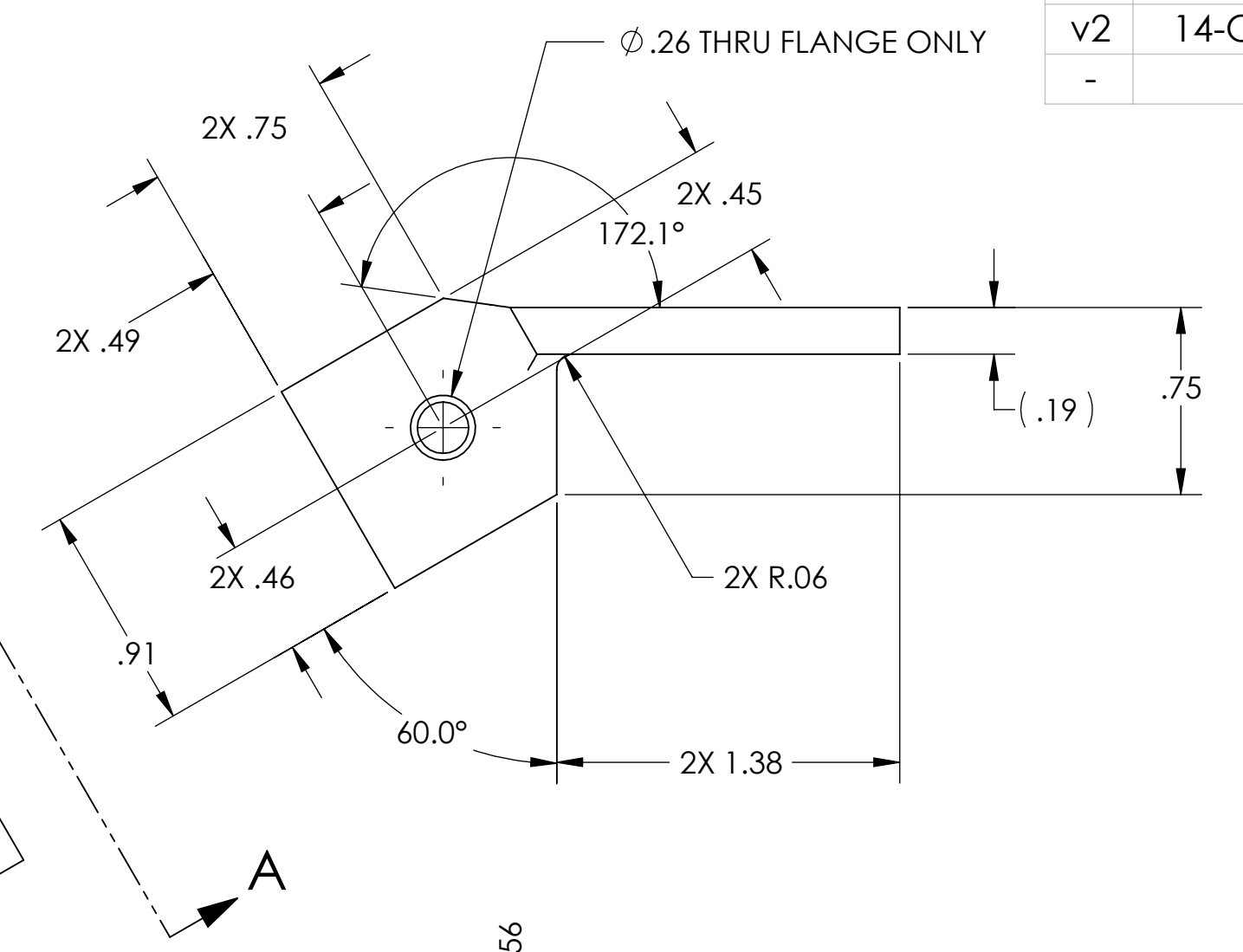
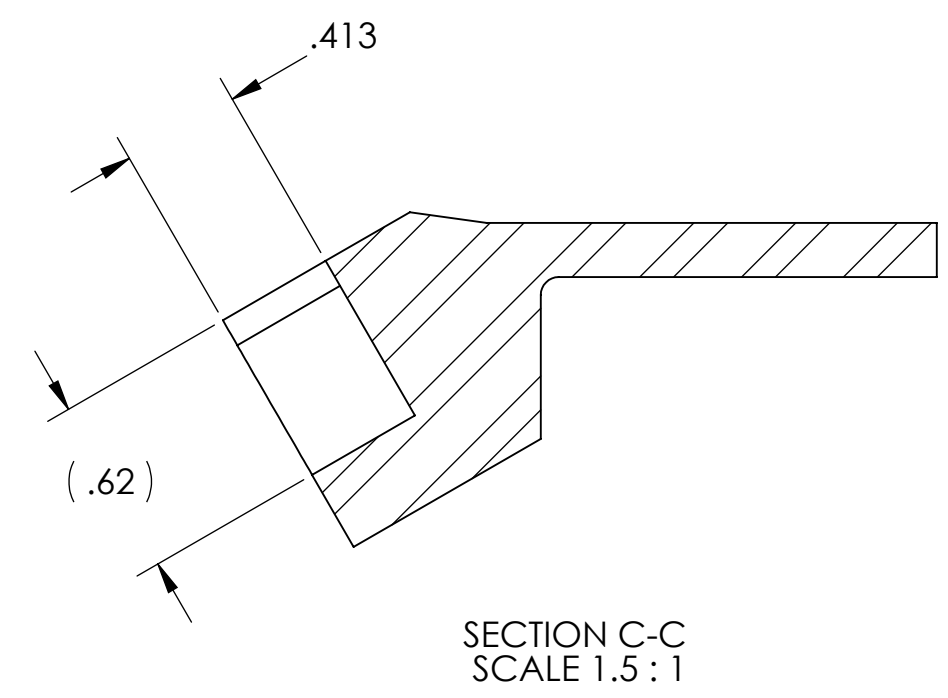


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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 = 1.028 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   | 10-AUG-2010 | -     | -              |
| v2   | 14-OCT-2010 | -     | -              |
| -    | -           | -     | -              |



| DIMENSIONS ARE IN INCHES                |  | NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)   |  | LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY |  | PART NAME                       |  |                                  |  |
|---|--|--|--|---|--|---------------------------------|--|----------------------------------|--|
| TOLERANCES:<br>.XX ± .01<br>.XXX ± .005 |  | 1. INTERPRET DRAWING PER ASME Y14.5-1994.<br>2. REMOVE ALL SHARP EDGES, R.02 MIN.<br>3. DO NOT SCALE FROM DRAWING.<br>4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. |  | SYSTEM ADVANCED LIGO  |  | SUB-SYSTEM AOS                  |  | TCS UHV BRACKET, LONG SIDE, BSC7 |  |
| ANGULAR ± 0.1°                          |  | MATERIAL AISI 304  |  | FINISH 32 μinch   |  | NEXT ASSY D1001742              |  | DESIGNER M. JACOBSON 25-AUG-2010 |  |
|   |  |  |  |   |  | SIZE DWG. NO. D D1002287        |  | REV. v2                          |  |
|   |  |  |  |   |  | CHECKER M. JACOBSON 10-AUG-2010 |  | APPROVAL C. TORRIE 10-AUG-2010   |  |
|   |  |  |  |   |  | SCALE: 1.5:1                    |  | PROJECTION:                      |  |
|   |  |  |  |   |  | SHEET 1 OF 1                    |  |                                  |  |

D1002287\_TCS\_UHV\_BRACKET\_LONG\_SIDE\_BSC7\_PART\_PDM\_REV\_X-006\_DRAWING\_PDM\_REV\_X-006