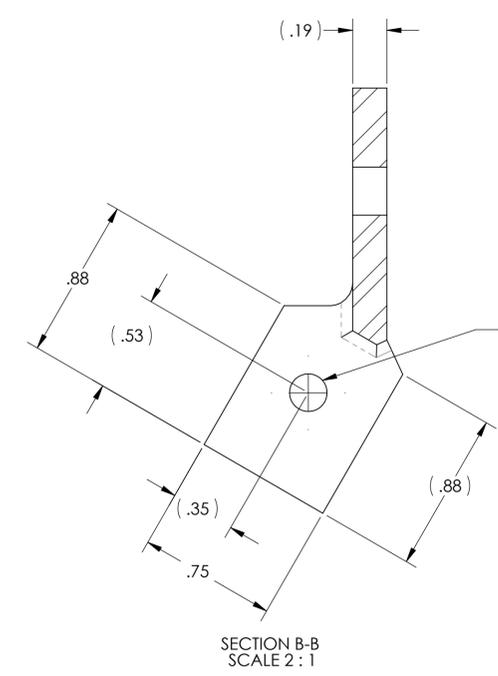
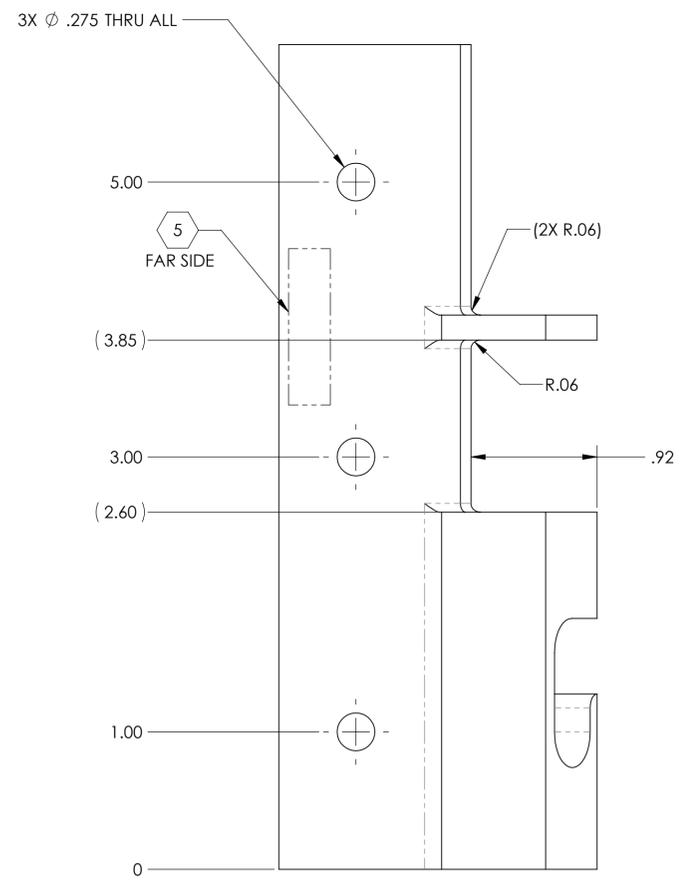
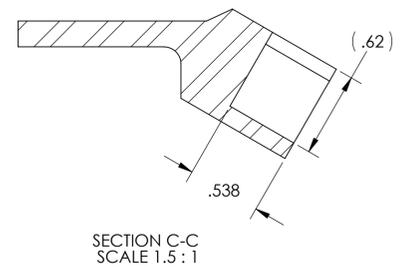
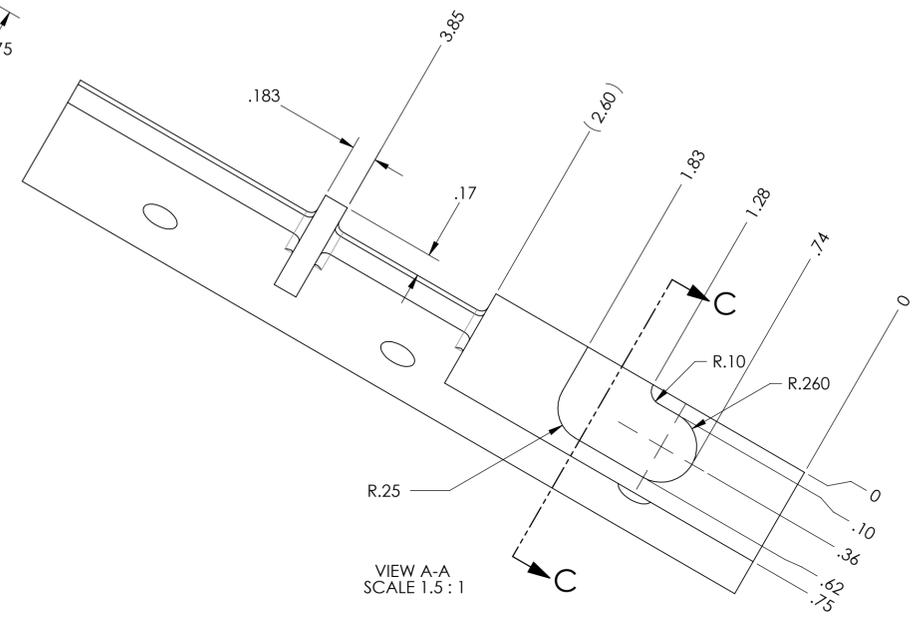
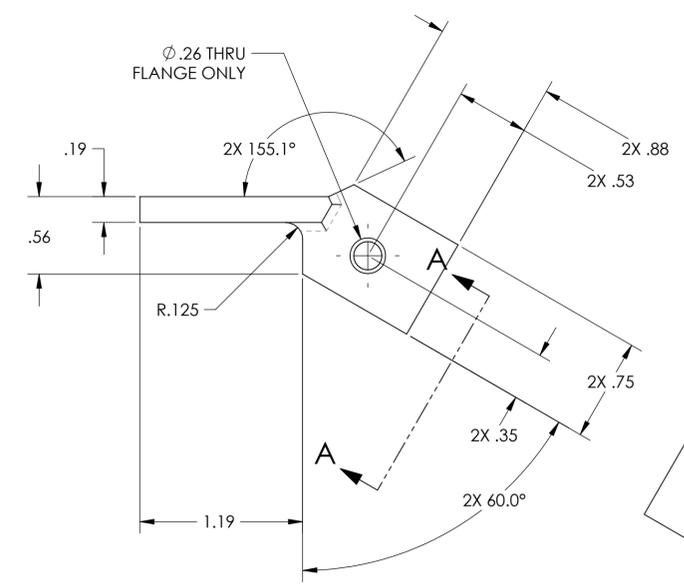
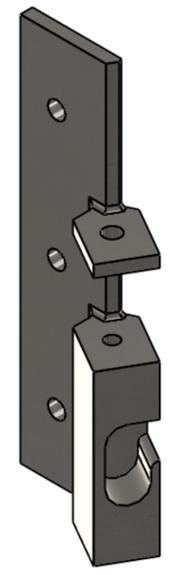
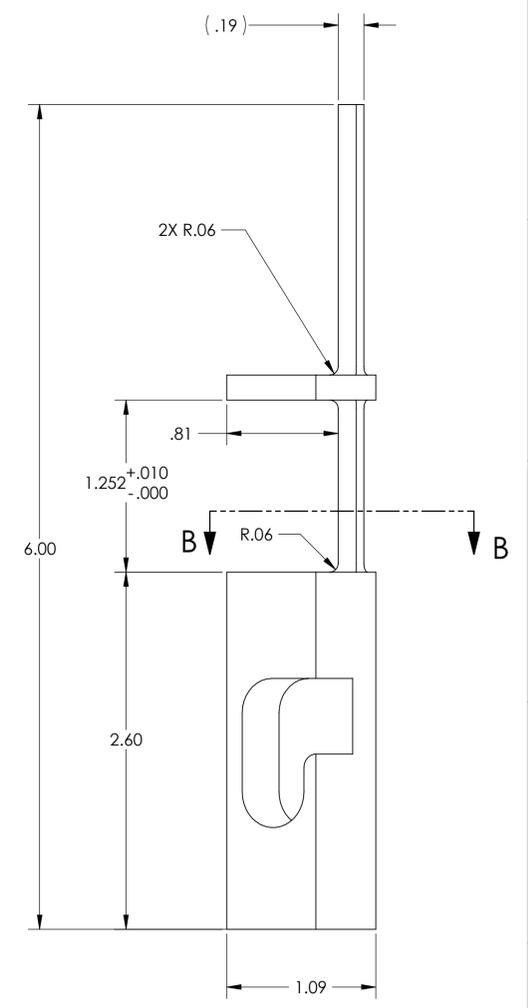


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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 = .913 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	9-AUG-2010	-	-
v2	14-OCT-2010	-	-
v3	23-DEC-2010	E1000883-v1	E1000884-v1



9 10  
 (#5 DRILL) DRILLED  $\nabla$ .51  
 TAP FOR NITRONIC-60 HELI-COIL  
 #1191-EN475 WITH #10-32 THREADS



DIMENSIONS ARE IN INCHES		TOLERANCES:		ANGULAR $\pm$ 0.5°		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		MATERIAL		FINISH		NEXT ASSY		PART NAME		DESIGNER		DRAFTER		CHECKER		APPROVAL	
		.XX $\pm$ .01				1. INTERPRET DRAWING PER ASME Y14.5-1994.		AISI 304		63 $\mu$ inch		D1001742		TCS UHV BRACKET, SHORT SIDE, BSC7		M. JACOBSON		A. COLE		M. JACOBSON		C. TORRIE	
		.XXX $\pm$ .005				2. REMOVE ALL SHARP EDGES, .02 MIN.								ADVANCED LIGO		25-AUG-2010		9-AUG-2010		9-AUG-2010		9-AUG-2010	
						3. DO NOT SCALE FROM DRAWING.								SUB-SYSTEM		SIZE		DWG. NO.		D		D1002315	
						4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.								AOS		SCALE: 1.5:1		PROJECTION:		SHEET 1 OF 1		REV. v3	

D1002315, TCS UHV BRACKET, SHORT SIDE, BSC7, PART FROM REV. X012, DRAWING FROM REV. X-017