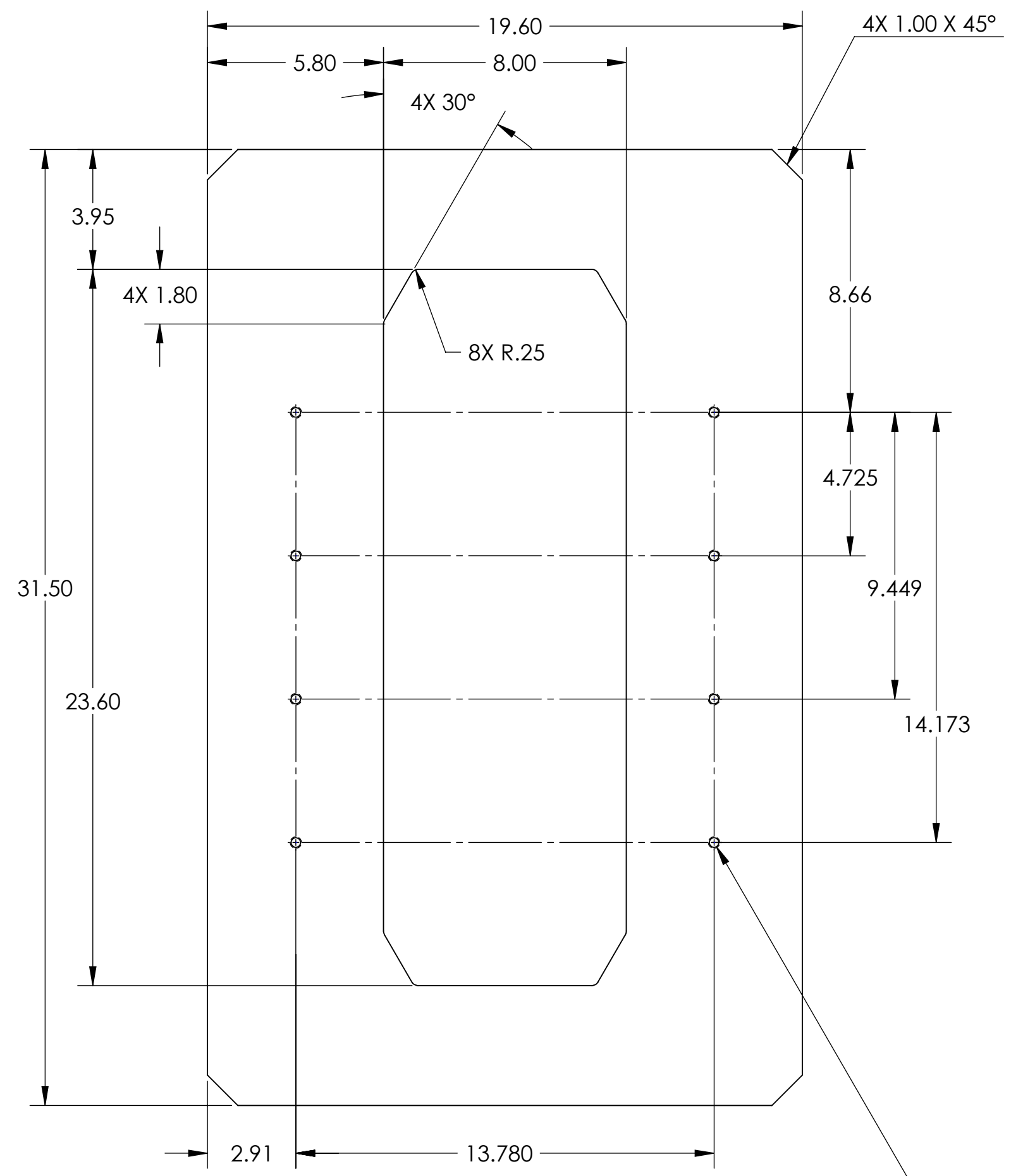


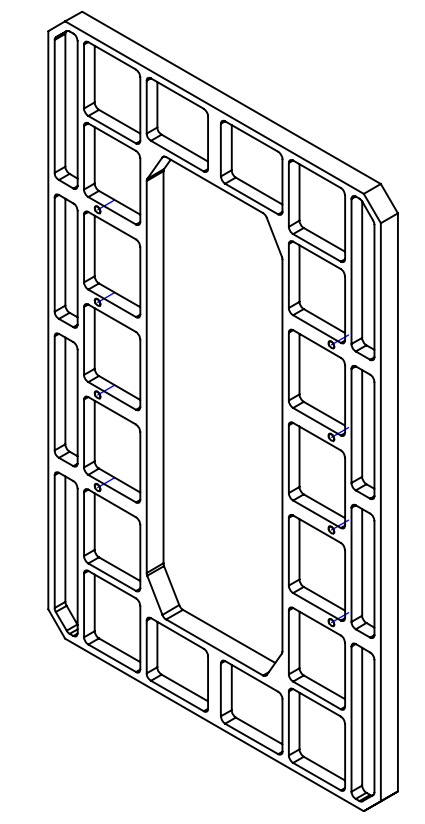
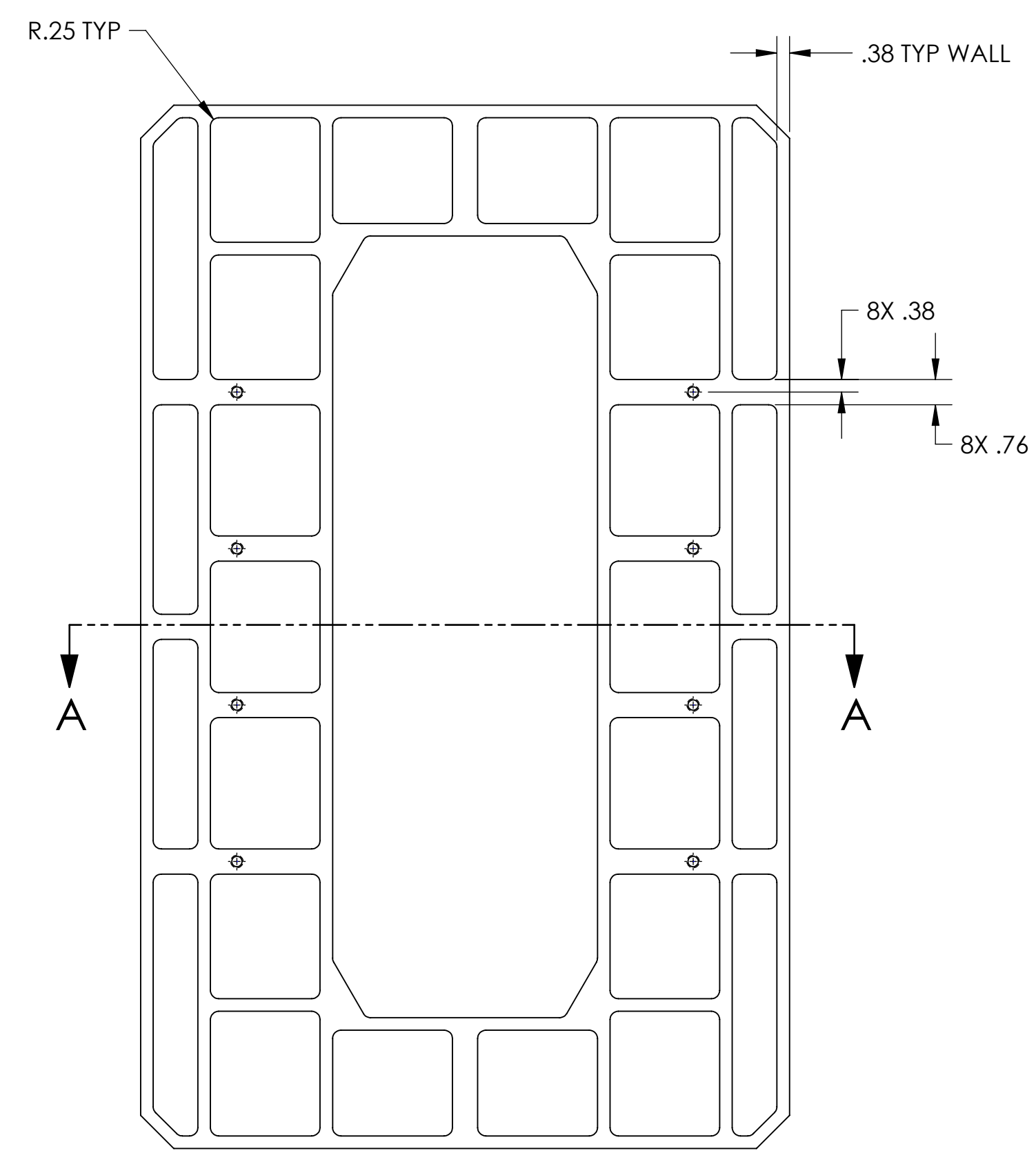
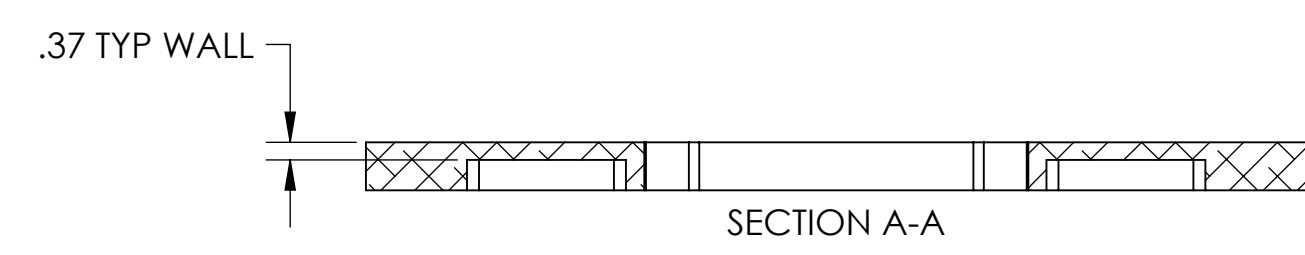
NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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 = 23.8 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 (COR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

REV.	DATE	DCN #	DRAWING TREE #
V1	22 NOV 2010	E1000755	-
-	-	-	-
-	-	-	-



8X DRILL AND TAP FOR 3/8-16
 N60 HELICOIL INSERT #1185-6EN938



DIMENSIONS ARE IN INCHES		TOLERANCES:		ANGULAR ± 0.5°		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		MATERIAL		FINISH		SYSTEM		SUB-SYSTEM		PART NAME		DESIGNER		DRAFTER		CHECKER		APPROVAL		SCALE: 1:4		PROJECTION:		SHEET 1 OF 1	
.XX	± .01	.XXX	± .005			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.	6061-T6 Al	63	µinch	ADVANCED LIGO	SUS	BS-LSAT CONTAINER SUPPORT PLATE	K. BUCKLAND	8 NOV 2010	K. BUCKLAND	19 NOV 2010					D	D1003005	v1					

D1003005.dwg, SUS BS STRUCTURE SUPPORT PLATE, PART PDM REV: X-001, DRAWING PDM REV: X-000