REV.	DATE	DCN #	DRAWING TREE #
A	07/JUN/11	E1100449	.

3D VIEW

80
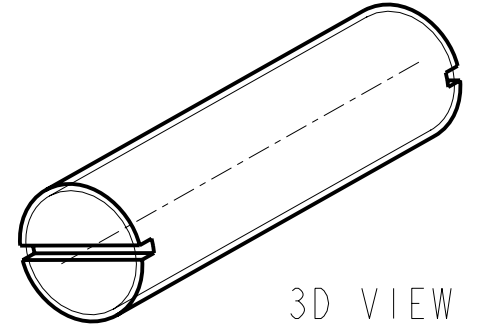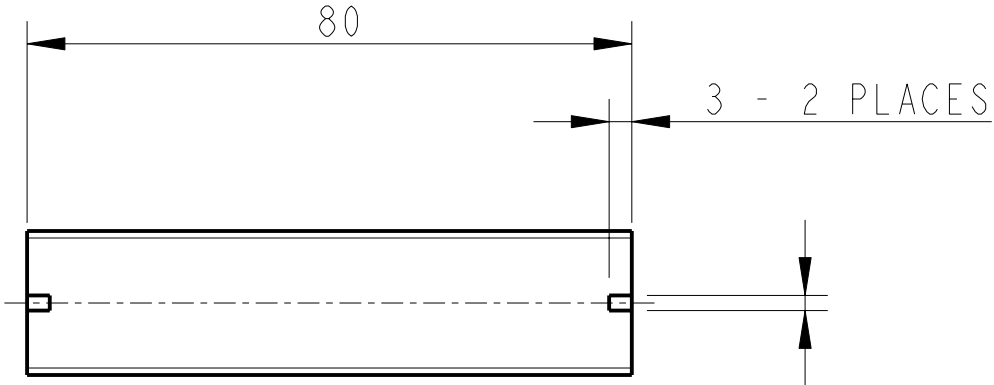
3 - 2 PLACES

2 - 2 PLACES
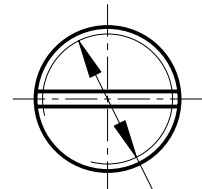
3/4 - 10 UNC THREAD

ADDITIONAL NOTES:

5. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

7. ALL HELICOIL HOLES TO BE PREPARED ACCORDING TO EMHART HELICOIL PRODUCT CATALOG, HC2000, REV 4.

8. 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.

9. 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 BROUGH TO THE ATTENTION OF LIGO CONTRACTING OFFICERS REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

NOTES: (UNLESS OTHERWISE SPECIFIED)

1. REMOVE ALL SHARP EDGES, R.02 MIN.
2. DO NOT SCALE FROM DRAWING.
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)
4. SCRIBE, ENGRAVE OR STAMP DRAWING PARTNUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: D020188- 001. A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN mm [INCHES]
TOLERANCES:

X.XX ±0.2 mm
ANGULAR ±0.25 °

MATERIAL: ST. STEEL 304/316

FINISH: CLEAN, GREASE FREE
√µm [µin] Ra = 1.6

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
IGR, GLASGOW UNIVERSITY GEO 600 GROUP
RUTHERFORD APPLETON LABORATORIES

SYSTEM **ADVANCED LIGO**

SUB-SYSTEM **SUS**

NEXT ASSY **QUAD UIM**

PART NAME **PITCH ADJUSTER QUAD UIM**

	NAME	DATE
DRAWN	J O'DELL	07/JUN/11
CHECKED	J'OD	07/JUN/11
APPROVED	JOD	07/JUN/11

SIZE **A**

DRG. NO. **D1101080**

REV **A.**

SCALE 1:1 | PROJECTION: | SHEET 1 OF 1