

NOTES CONTINUED:

⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

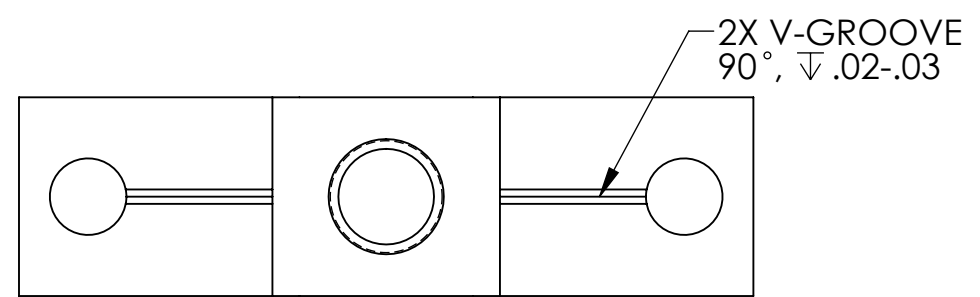
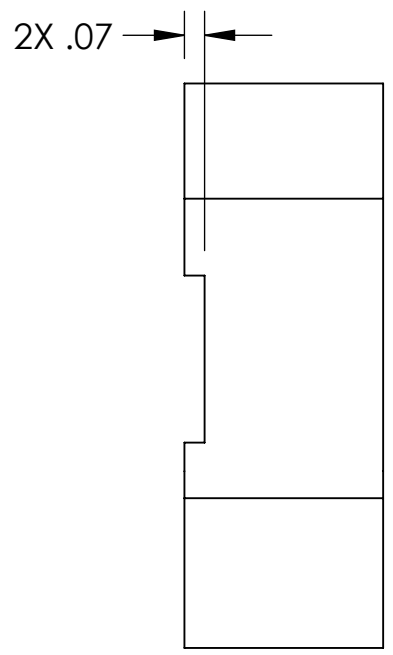
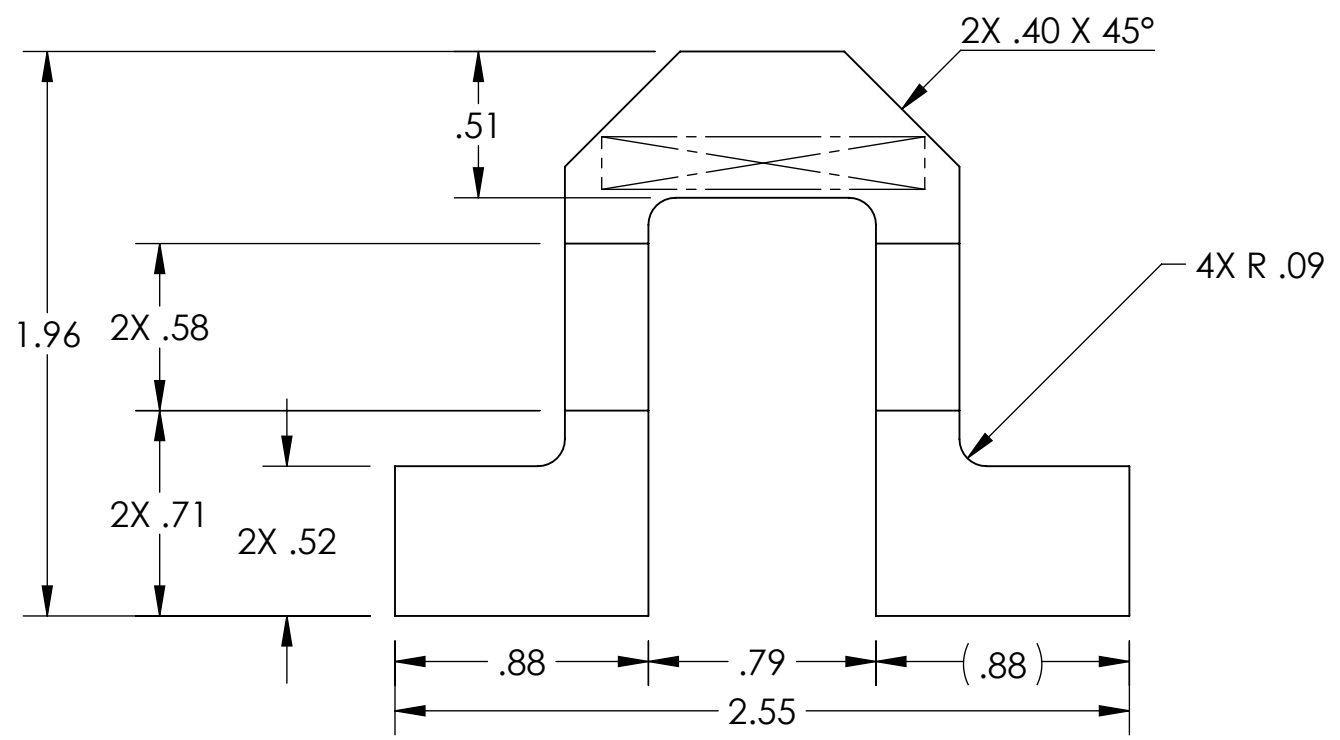
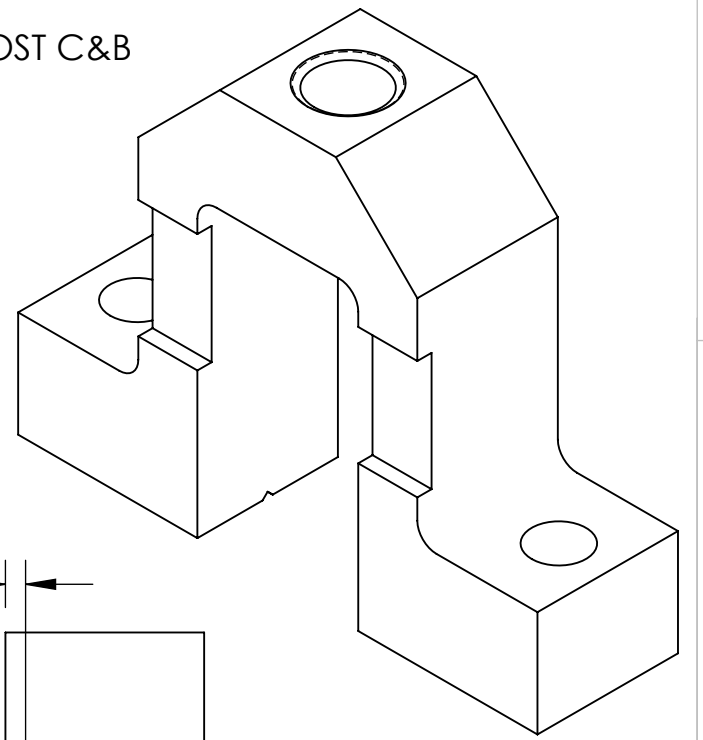
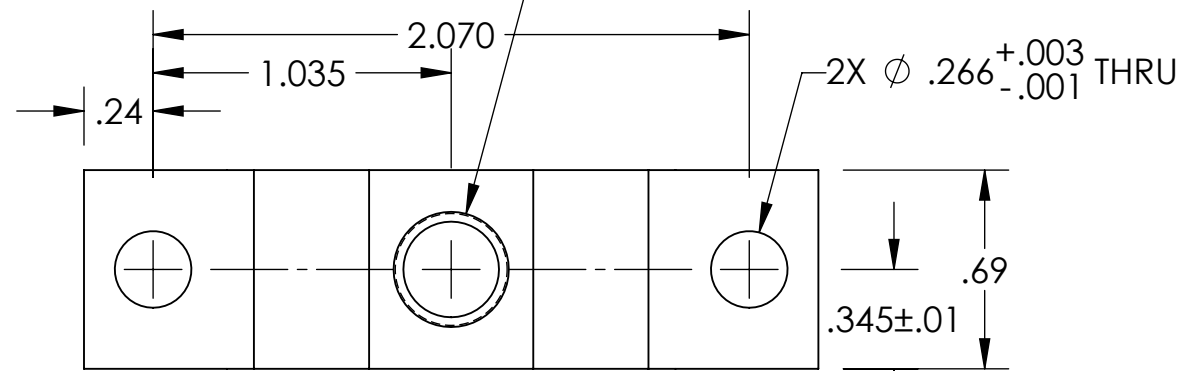
- 6. MASS: 51.4 G [0.113 LB].
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL, WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE PART 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.

⑩ PREPARE HELICOIL TAPPED HOLE ACCORDING TO EMHART HELICOIL PRODUCT CATALOG HC2000. DO NOT INSTALL HELICOILS.

⑪ INTERNAL NOTE: HELICOIL TO BE INSTALLED BY LIGO, POST C&B. USE ONLY NITRONIC 60 HELICOILS.

REV.	DATE	DCN #	DRAWING TREE #
v1	11 APR 2012	E1101214	-
-	-	-	-
-	-	-	-

TAP FOR 5/16-18 HELICOIL INSERT THRU
 ✓ ϕ .40 X 120°, NEAR SIDE
 ✓ ϕ .40 X 120°, FAR SIDE
 1.5 * DIA INSERT TO BE INSTALLED BY LIGO, POST C&B
 ⑩ ⑪



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				LIGO		aLIGO SUS TOP MASS STOP BRIDGE	
TOLERANCES: .XX ± .01 .XXX ± .005				SYSTEM ADVANCED LIGO		DESIGNER C. CONLEY	
ANGULAR ± 1.0°				SUB-SYSTEM AOS		DRAFTER J. TERRAZAS	
MATERIAL 6061-T6 Al				NEXT ASSY D1200525		CHECKER SEE DCN	
FINISH 63 μinch Ra				APPROVAL SEE DCN		DATE 21 FEB 2012	
				SCALE: NONE		PROJECTION:	
				SIZE DWG. NO. B D1101273		REV. v1	
				SHEET 1 OF 1			

D1101273_alIGO SUS TOP MASS STOP BRIDGE, PART PDM REV: X-023, DRAWING PDM REV: X-007