

**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: DXXXXXX-VY, TYPE-XX, S/N XXX

6. APPROXIMATE WEIGHT = 2.314 LB.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

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

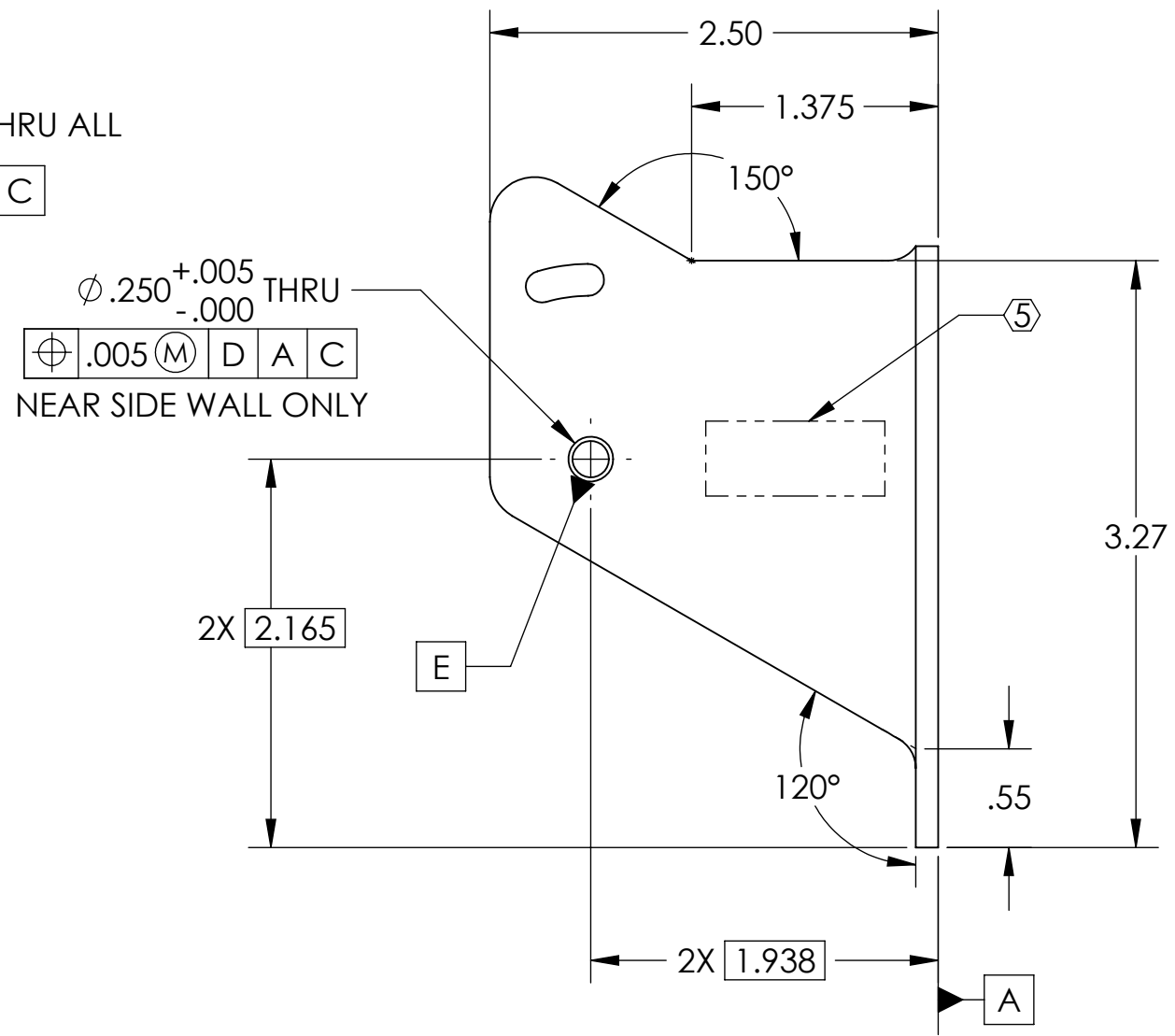
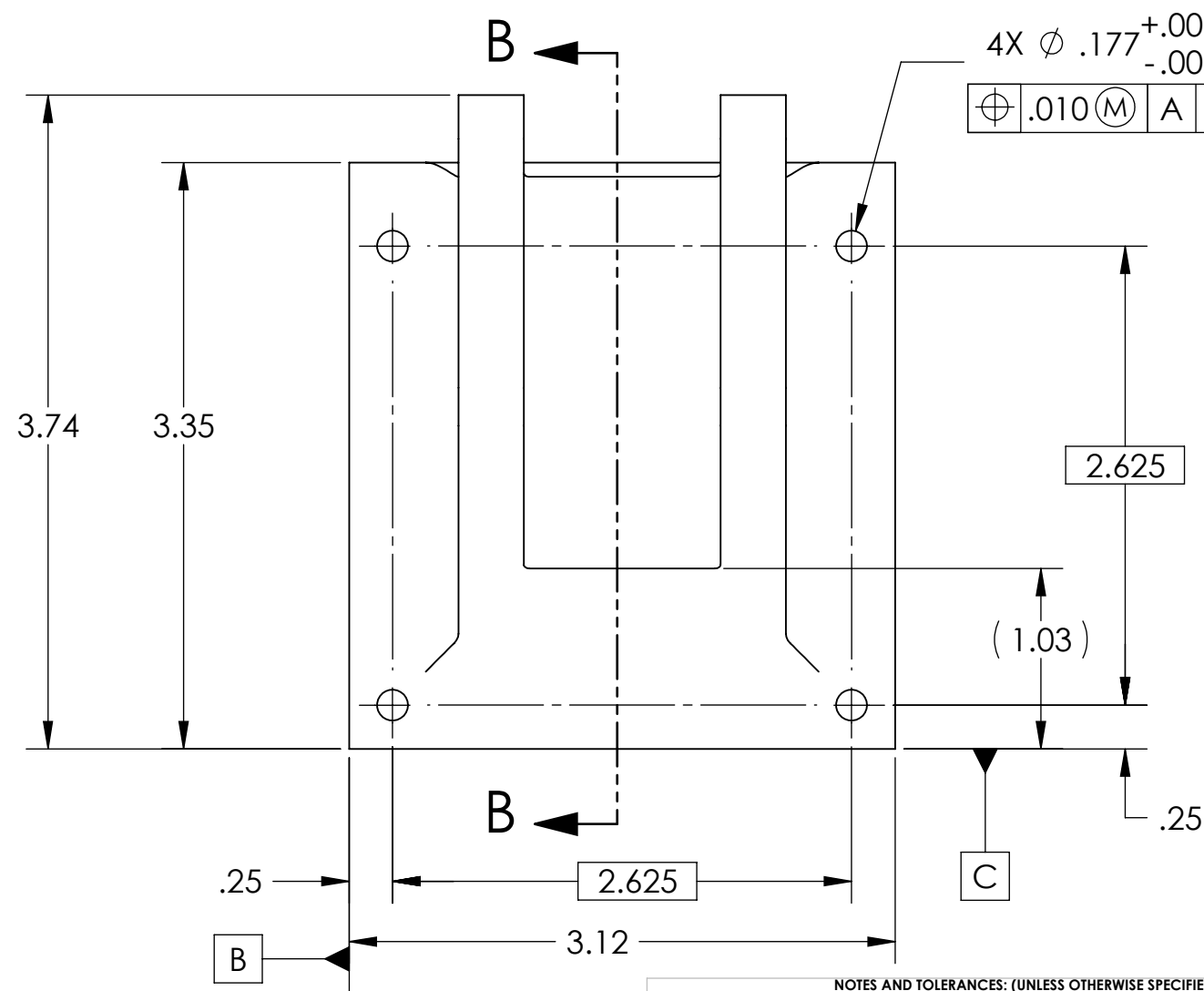
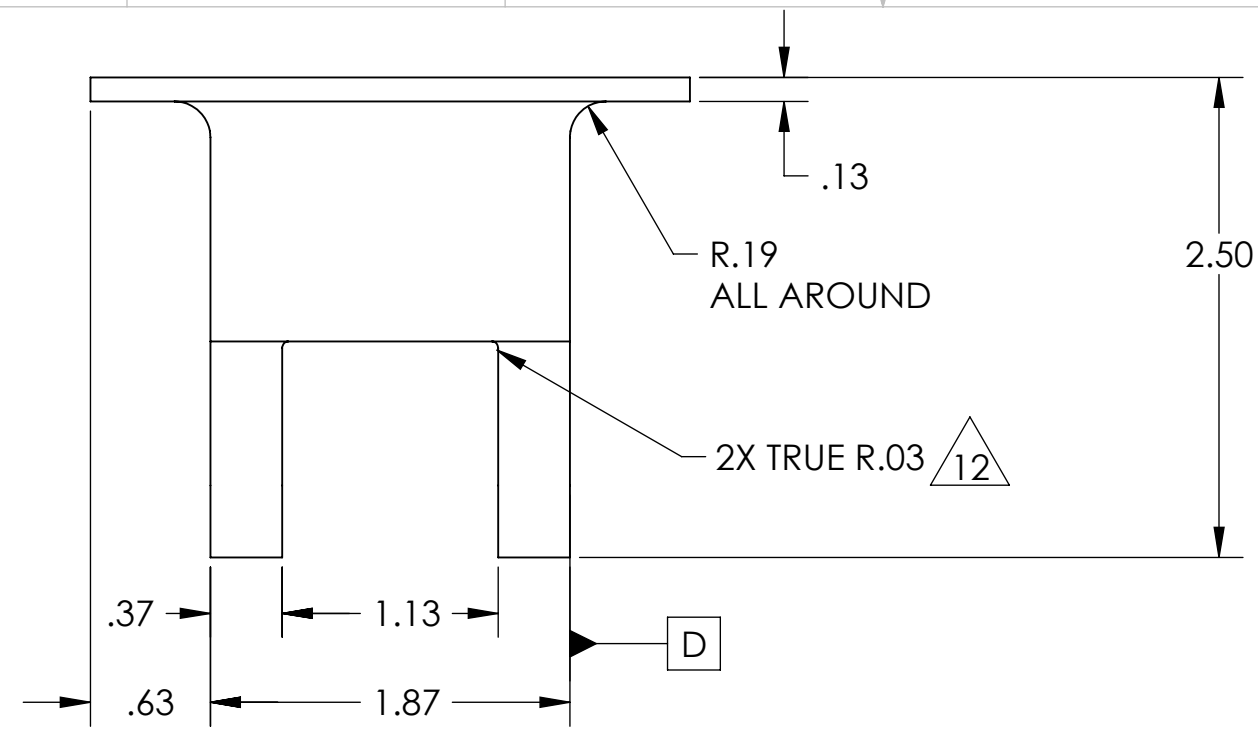
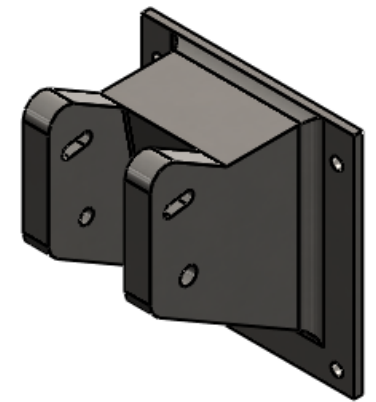
9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

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. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

12. MAKE FROM EXISTING PART (-v1)

REV.	DATE	DCN #	DRAWING TREE #
v1	05-MAR-12	E1101043-v1	E1101044-v1
v2	12-SEPT-2012	E1200830-v1	E1101044-v2
-	-	-	-



D1101292\_H1-L1 SM1 AZ SUPPORT BRKT, PART PDM REV: X-031, DRAWING PDM REV: X-016

**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

DIMENSIONS ARE IN INCHES

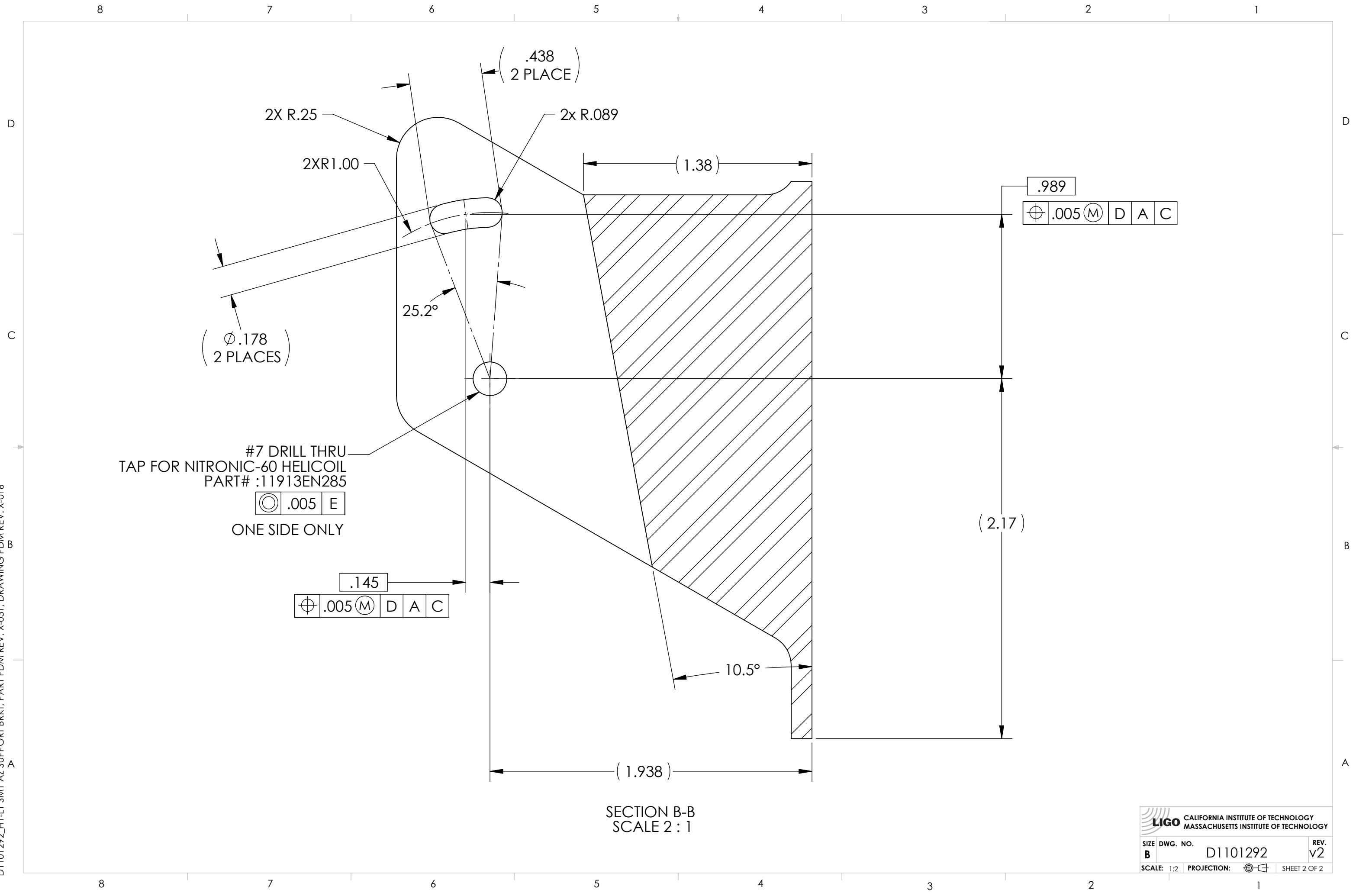
TOLERANCES:  
 .XX ± .10  
 .XXX ± .005  
 ANGULAR ± 1.0°

1. INTERPRET DRAWING PER ASME Y14.5-1994.  
 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.  
 3. DO NOT SCALE FROM DRAWING.  
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

**MATERIAL** AISI 304      **FINISH** 63 μinch

<b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		<b>PART NAME</b> H1-L1 SM1 AZ SUPPORT BRKT	
<b>SYSTEM</b> ADVANCED LIGO	<b>SUB-SYSTEM</b> AOS	<b>DESIGNER</b> M. JACOBSON 07 JUL 2011 <b>DRAFTER</b> A. COLE 12-OCT-11 <b>CHECKER</b> G. GRABEEL 11-SEPT-12 <b>APPROVAL</b> M. JACOBSON 12-SEPT-12	<b>SIZE DWG. NO.</b> B D1101292 <b>SCALE:</b> 1:2 <b>PROJECTION:</b>
<b>NEXT ASSY</b> D1102078	<b>REV.</b> v2	SHEET 1 OF 2	

D1101292\_H1-L1\_SMI\_AZ\_SUPPORT\_BRKT, PART PDM REV: X-031, DRAWING PDM REV: X-016



SECTION B-B  
SCALE 2 : 1

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
B	D1101292	v2
SCALE: 1:2	PROJECTION:	SHEET 2 OF 2