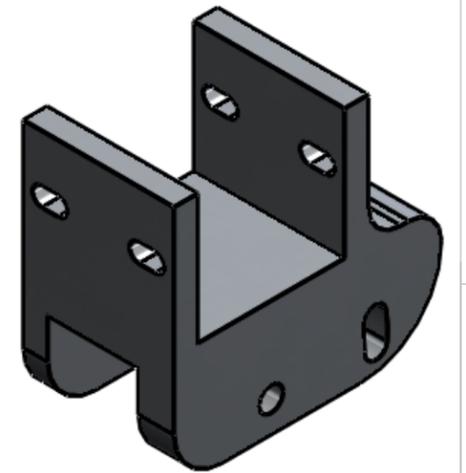
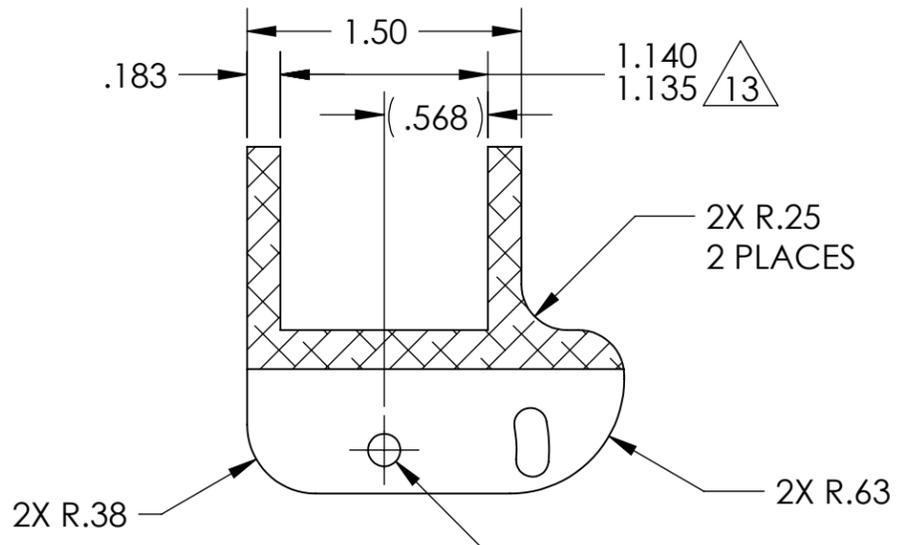


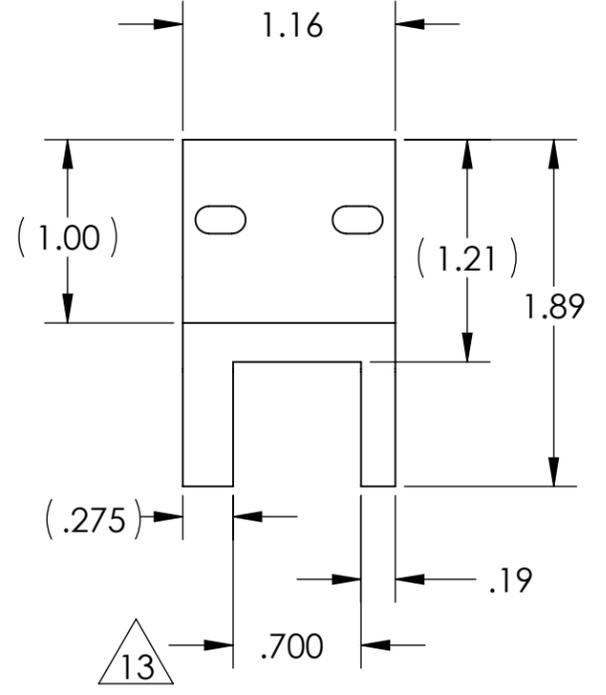
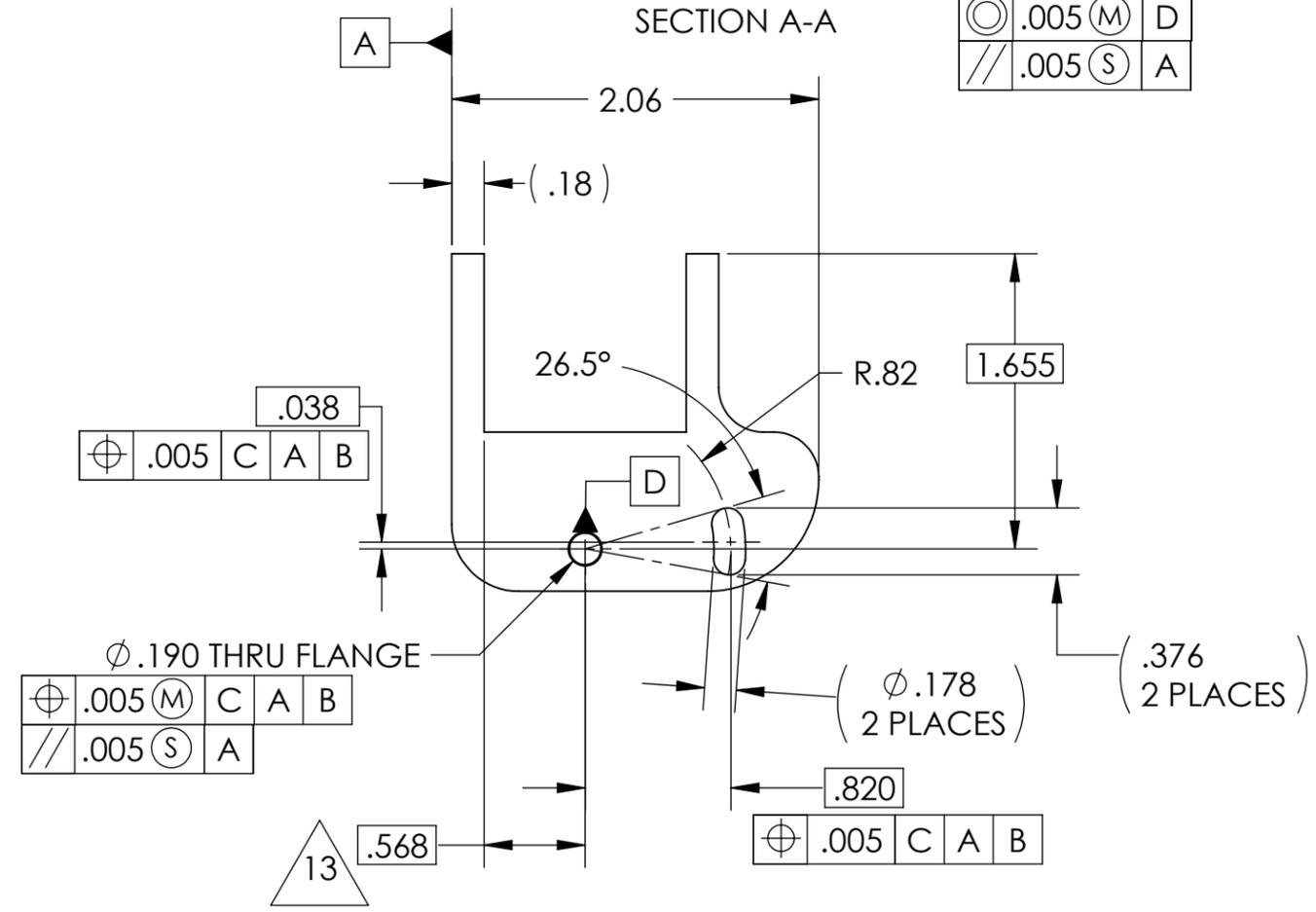
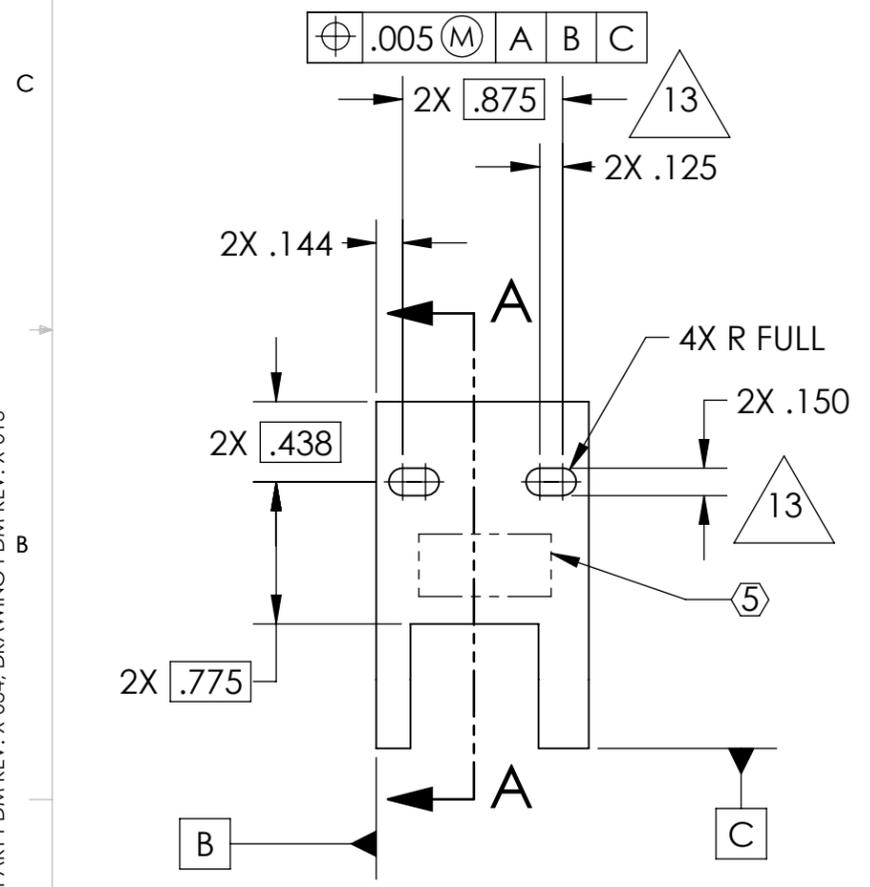
- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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 = 0.15 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. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
13. MODIFY FROM EXISTING PART (-v2)

REV.	DATE	DCN #	DRAWING TREE #
v1	12-OCT-2011	E1101043-v1	E1101044-v1
v2	12-SEPT-2012	E1200830-v1	E1101044-v2
v3	10-DEC-2012	E1201098-x0	E1200917-v3



(#16 DRILL) DRILLED THRU TAP FOR NITRONIC-60 HELI-COIL PART #:1185-2EN164

⊙	.005 (M)	D
∥	.005 (S)	A



⊙	.005 (M)	C	A	B
∥	.005 (S)	A		

⊙	.005 (M)	C	A	B
∥	.005 (S)	A		

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

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

MATERIAL: 6061 Alloy

FINISH: 63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
 SUB-SYSTEM: AOS

NEXT ASSY: D1102029

PART NAME: H1-L1 STEER M1 AZ BRACKET

DESIGNER	M. JACOBSON	13 JUN 2011	SIZE	DWG. NO.	REV.
DRAFTER	M. JACOBSON	10-DEC-2012	B	D1101294	v3
CHECKER	C. GUIDO	10-DEC-2012	SCALE	1:1	PROJECTION
APPROVAL	M. JACOBSON	10-DEC-2012	SHEET	1 OF 1	

D1101294_H1-L1 STEER M1 AZ BRACKET, PART PDM REV: X-034, DRAWING PDM REV: X-013