

NOTES CONTINUED:

5. SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
 EXAMPLE (PART): 001-v1
 EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD

6. APPROXIMATE WEIGHT = X.XXX LB.

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

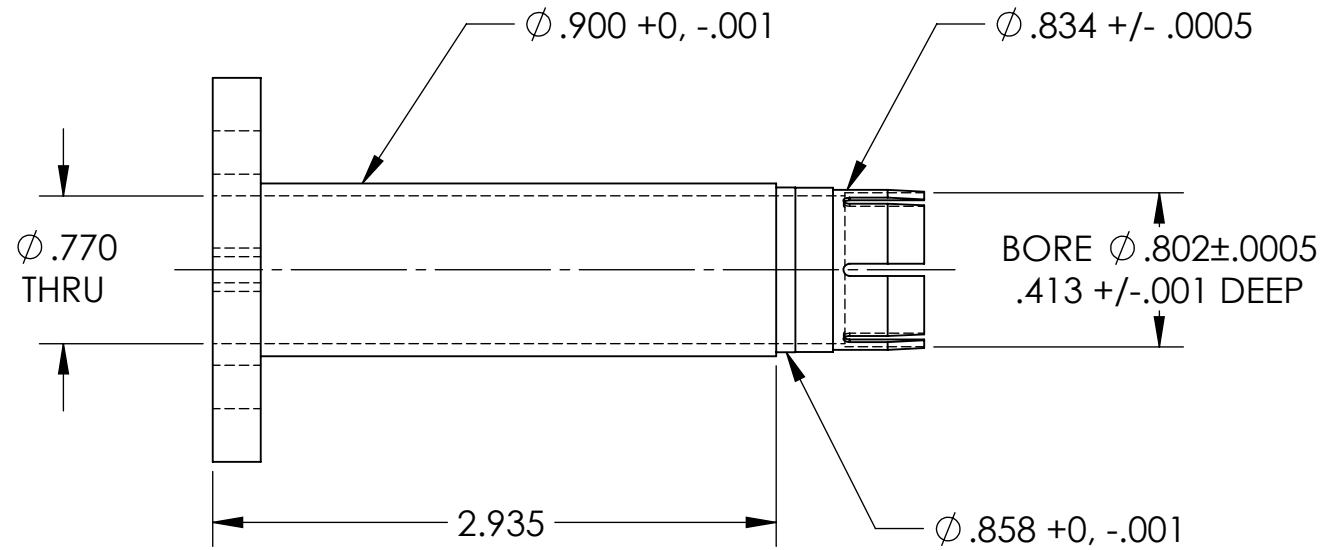
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

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

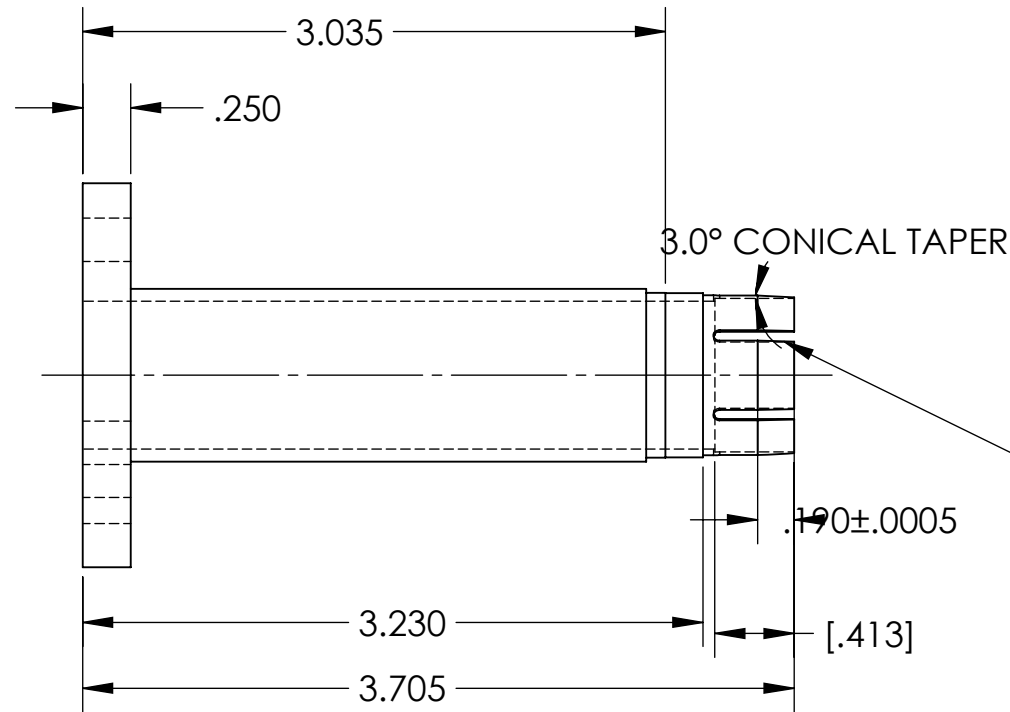
10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

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.

REV.	DATE	DCN #	DRAWING TREE #
-	-	-	-
-	-	-	-
-	-	-	-



INTERNAL THREAD 40 TPI THRU
 MAJOR DIAMETER .250
 MINOR DIAMETER .226
 3 PLACES 120° APART
 ON $\phi 1.410$ CIRCLE
 LOOSE THREADS



$\phi 2.000^{+.002}_{-.002}$

SLOT .063 WIDE
 .420 LONG
 6 PLACES
 EACH 60° APART

TAP #8-32 THRU
 ON SAME CIRCLE
 60° APART
 LOOSE THREADS

D1101666_ALIGO_IO_FL_FR_TGG HOLDER, PART PDM REV: X-003, DRAWING PDM REV:

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 0.1°

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 6061 Alloy FINISH 32 μ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM 100
 NEXT ASSY

PART NAME				REV.	
FI FR TGG HOLDER				v1	
DESIGNER	L.WILLIAMS	13 AUG 2013	SIZE	DWG. NO.	
DRAFTER	L.WILLIAMS	13 AUG 2013	B	D1101666	
CHECKER			SCALE:	1:1	PROJECTION:
APPROVAL					SHEET 1 OF 1