NOTES CONTINUED:

Ⓢ 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. APPROXIMATE WEIGHT = 2.00 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.

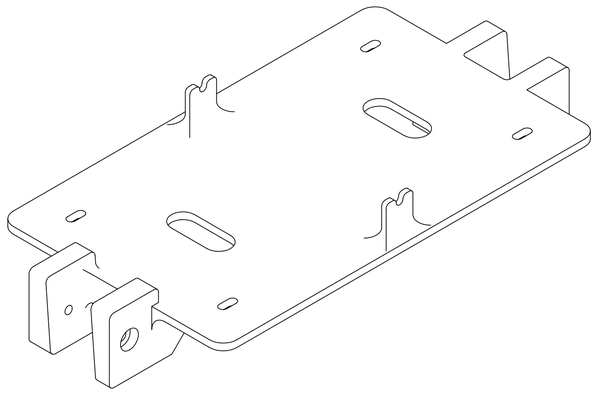
Ⓥ ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC200, REV 4.

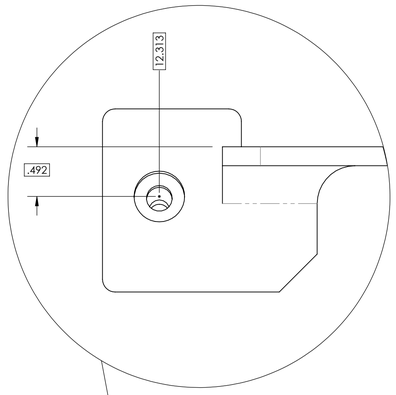
⑩ ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

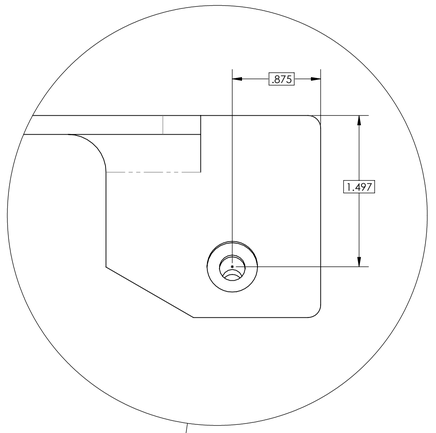
11. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .015-.030.
12. ALL MATERIAL IS TO BE VIRGIN PMATERIAL. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY THE LIGO LABORATORY. REFER TO LIGO-E0900364

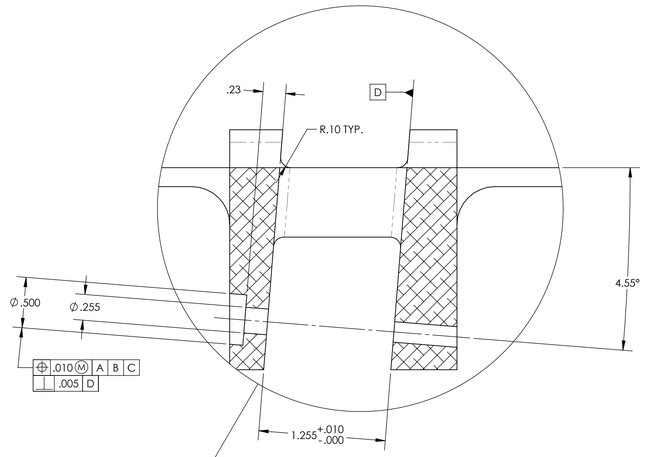
-01 CONFIGURATION

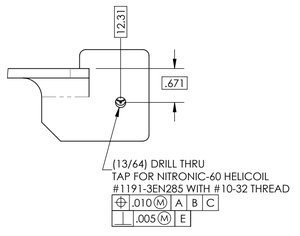
REV.	DATE	DCN #	DRAWING TREE #
v1	06-MAR-12	E1200002-v1	E1200003-v1

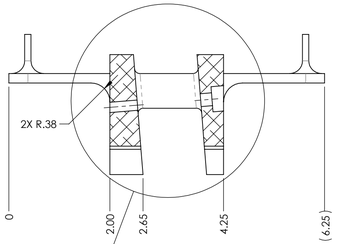




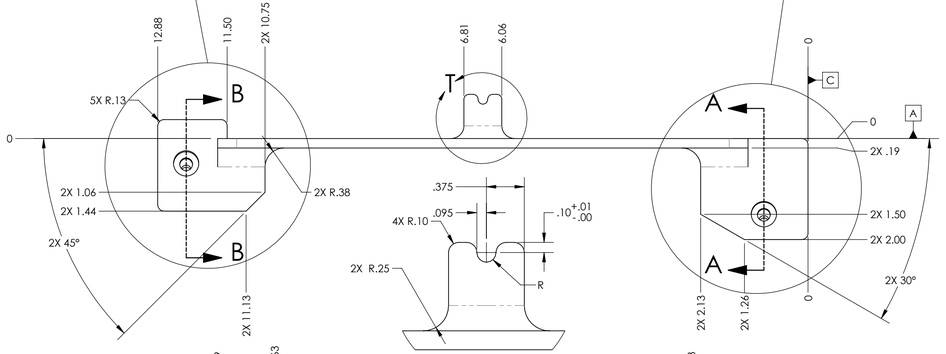




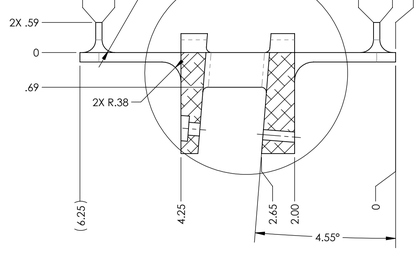




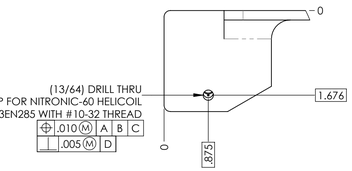
SECTION B-B
SCALE 1 : 1.5

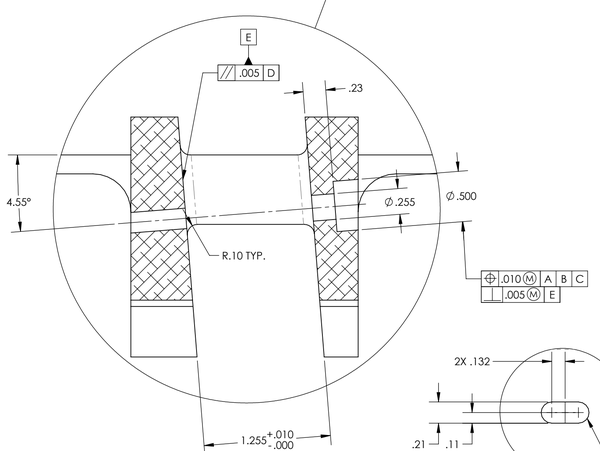


DETAIL T
SCALE 2 : 1.5
2 PL.

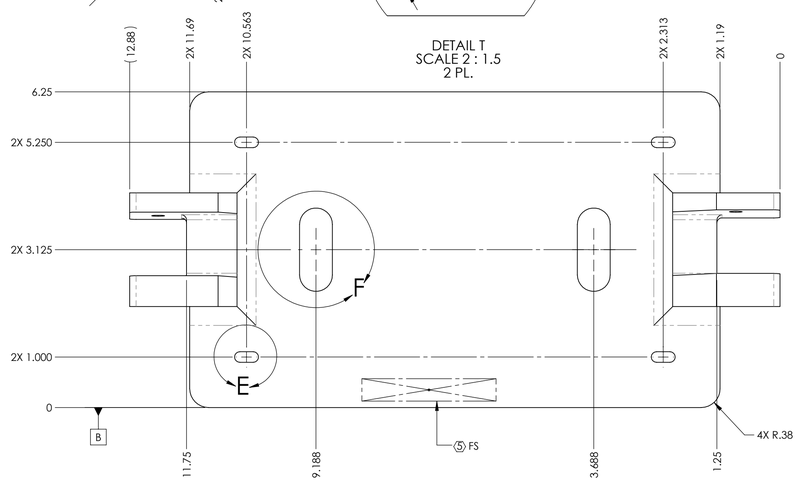


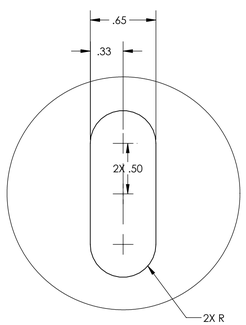
SECTION A-A
SCALE 1 : 1.5



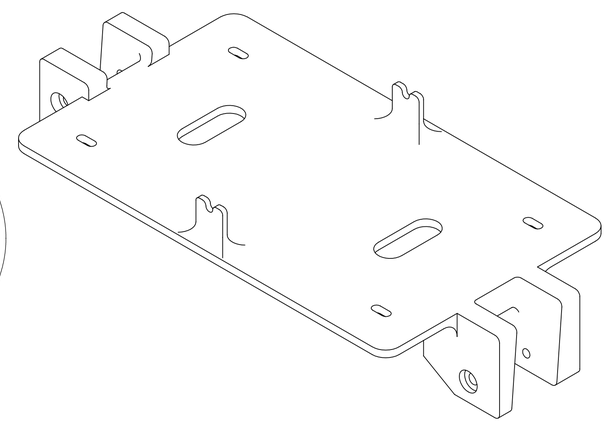


DETAIL E
SCALE 2 : 1.5
4 PL.





DETAIL F
SCALE 2 : 1.5
2 PL.



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATLEY 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-T6 Al		FINISH: 63 µinch			

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS

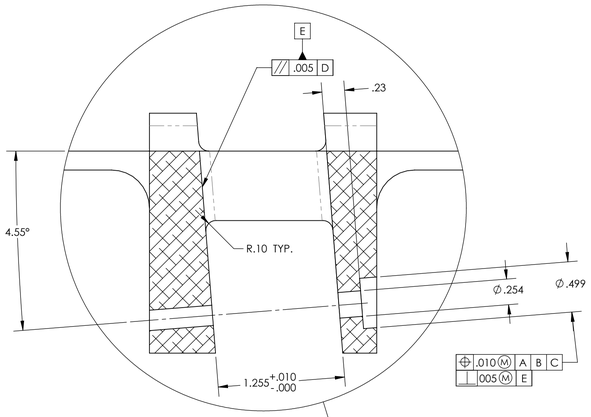
NEXT ASSY: D1101851-1, D1101851-2

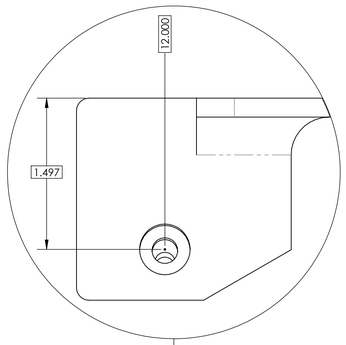
PART NAME: AZIMUTH SUPPORT PLATE

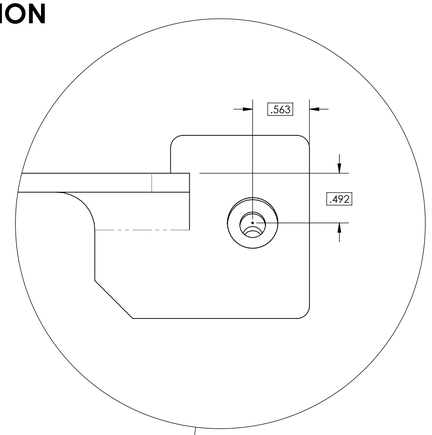
DESIGNER	M. JACOBSON	08 NOV 2011	SIZE	DWG. NO.	REV.
DRAFTER	M. JACOBSON	03 JAN 2012	D	D1102176	v1
CHECKER	J. LEWIS	06-MAR-12			
APPROVAL	A. HEPTONSTALL	05-MAR-12	SCALE: 1:4	PROJECTION:	SHEET 1 OF 2

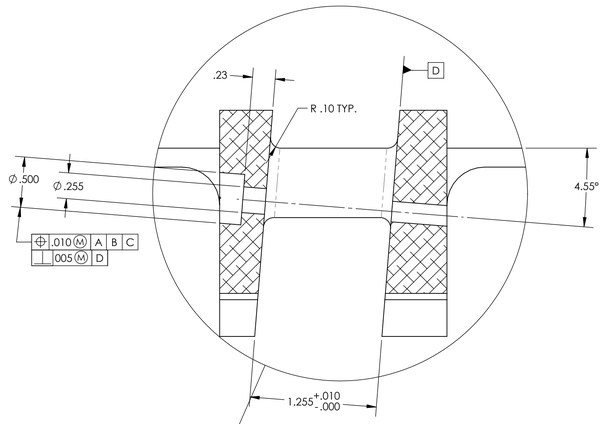
D1102176_AZIMUTH SUPPORT PLATE_CODP SM2, H1-L1, PART PDM REV: X-031, DRAWING PDM REV: X-010

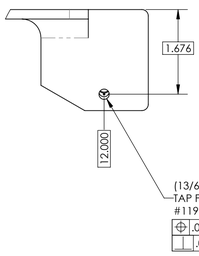
-02 CONFIGURATION

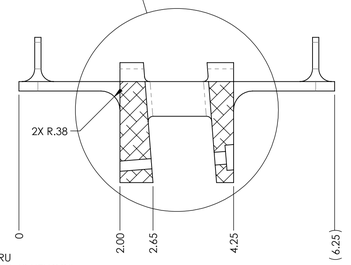




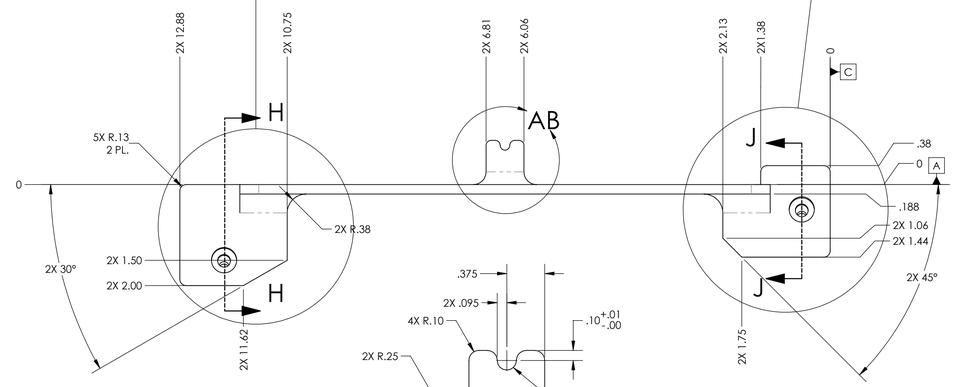




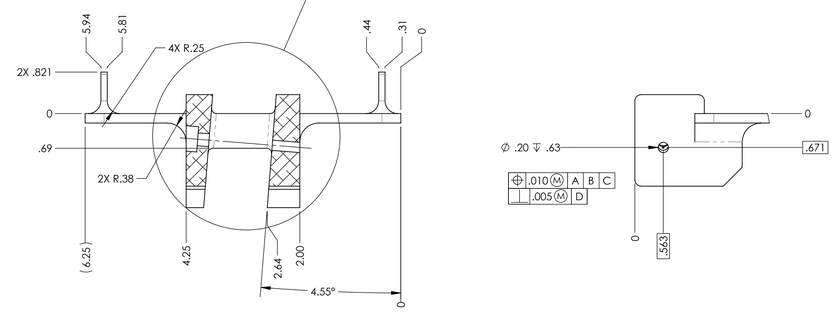




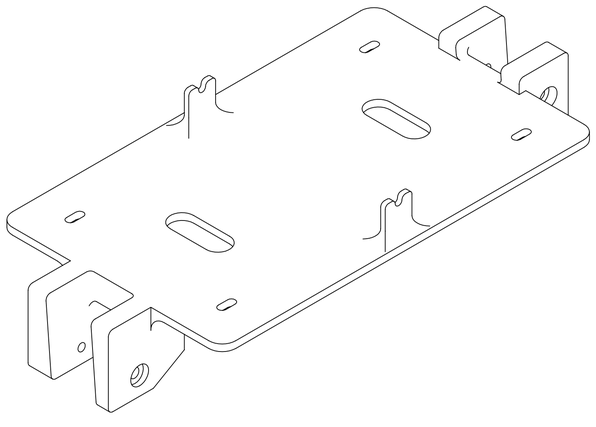
SECTION H-H
SCALE 1 : 1.5

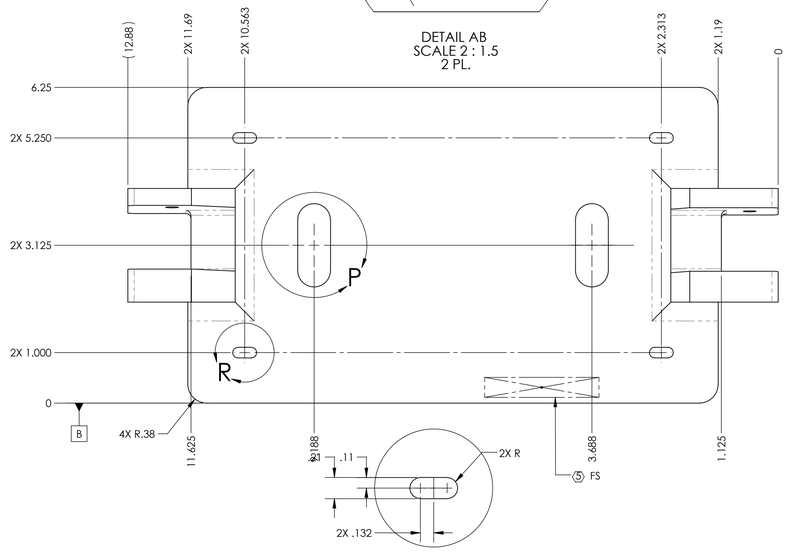


DETAIL AB
SCALE 2 : 1.5
2 PL.

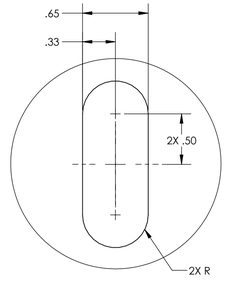


SECTION J-J
SCALE 1 : 1.5

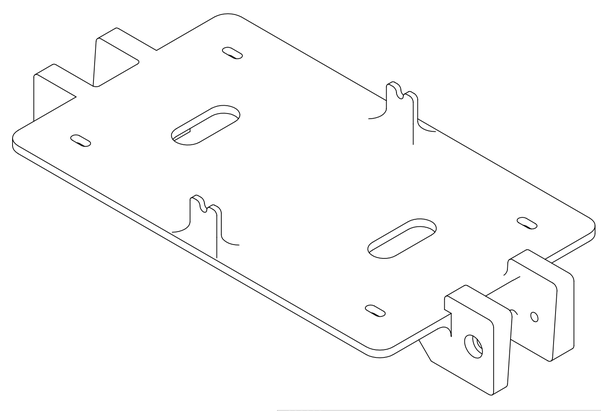




DETAIL R
SCALE 2 : 1.5
4 PL.



DETAIL P
SCALE 2 : 1.5
2 PL.



LIGO	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE: D	DWG. NO.: D1102176	REV.: v1
SCALE: 1:4	PROJECTION:	SHEET 2 OF 2

D1102176_AZIMUTH SUPPORT PLATE_CODP SM2_H1-L1_PART PDM REV:_X-001_DRAWING PDM REV:_X-010