

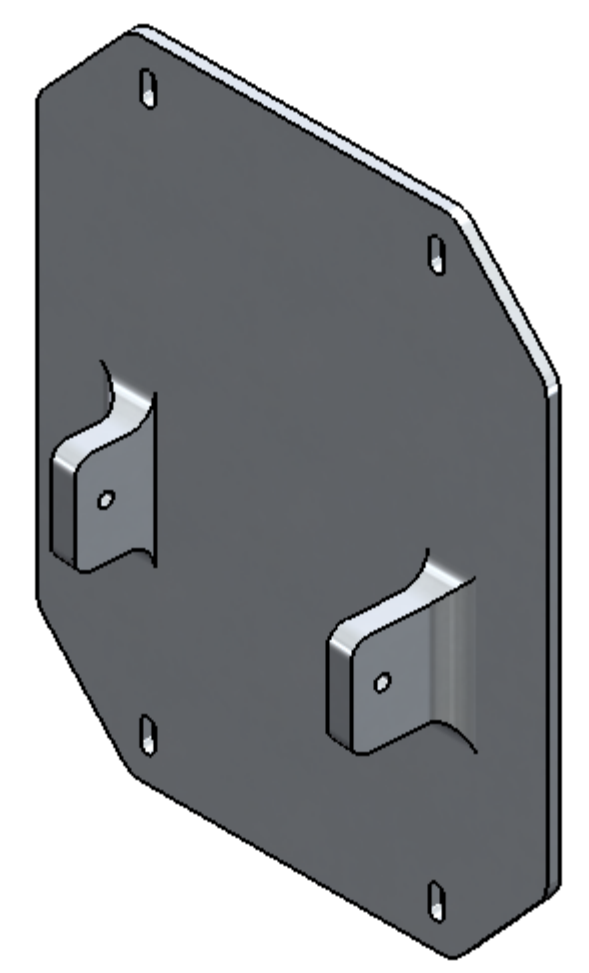
**NOTES CONTINUED:**

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

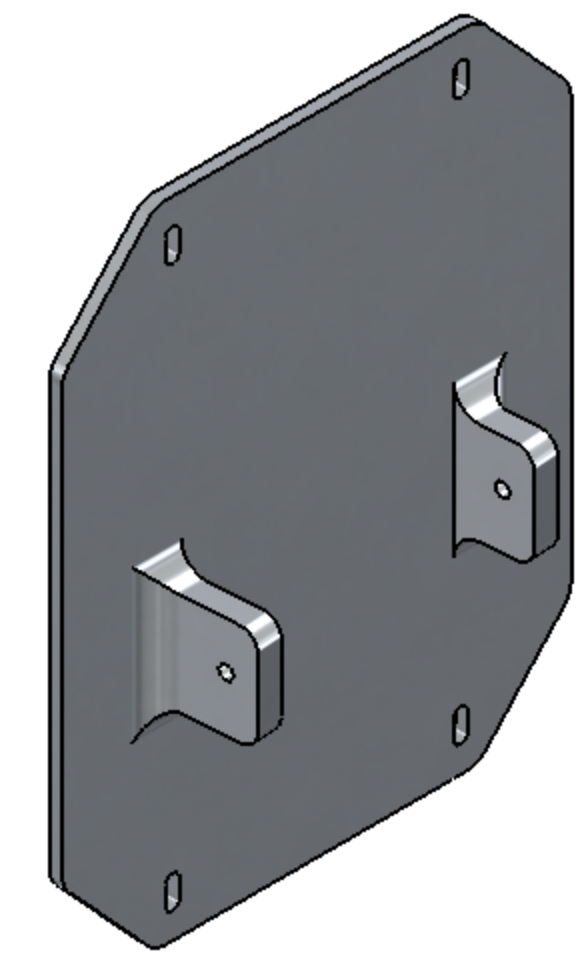
6. APPROXIMATE WEIGHT = 1.099 LB.

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. 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 TO BE VIRGIN MATERIAL. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY THE LIGO LABORATORY. REFER TO LIGO-E0900364

**-01 CONFIGURATION**

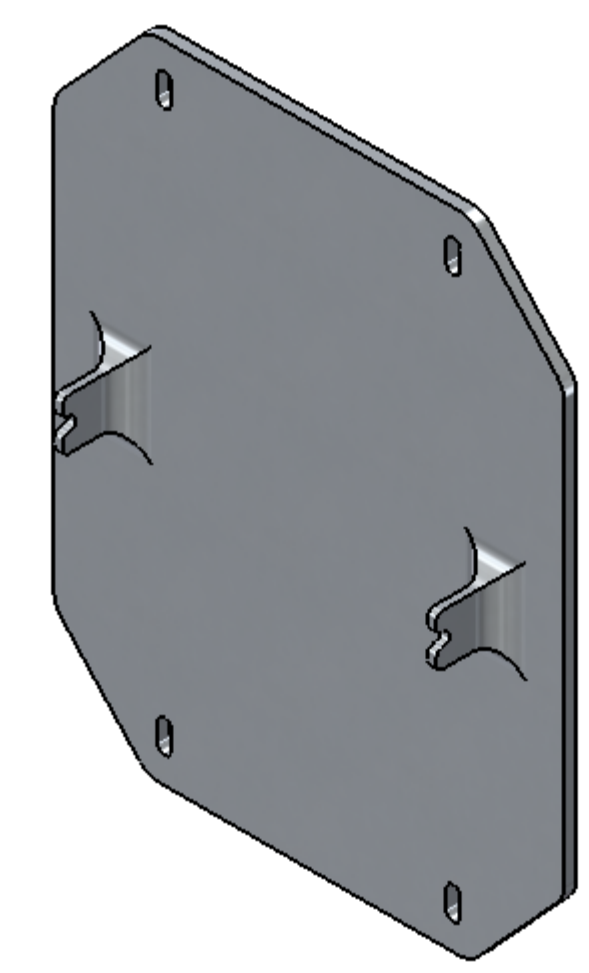


ISO FRONT - RIGHT

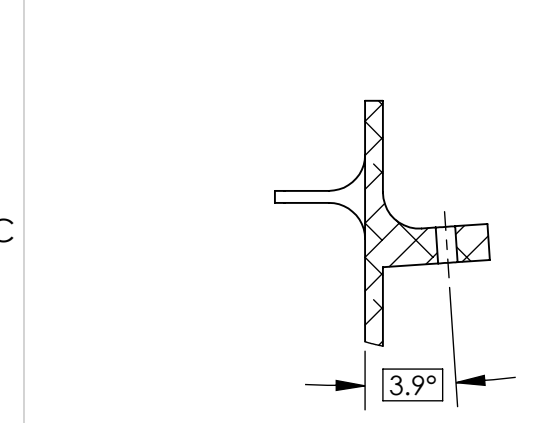
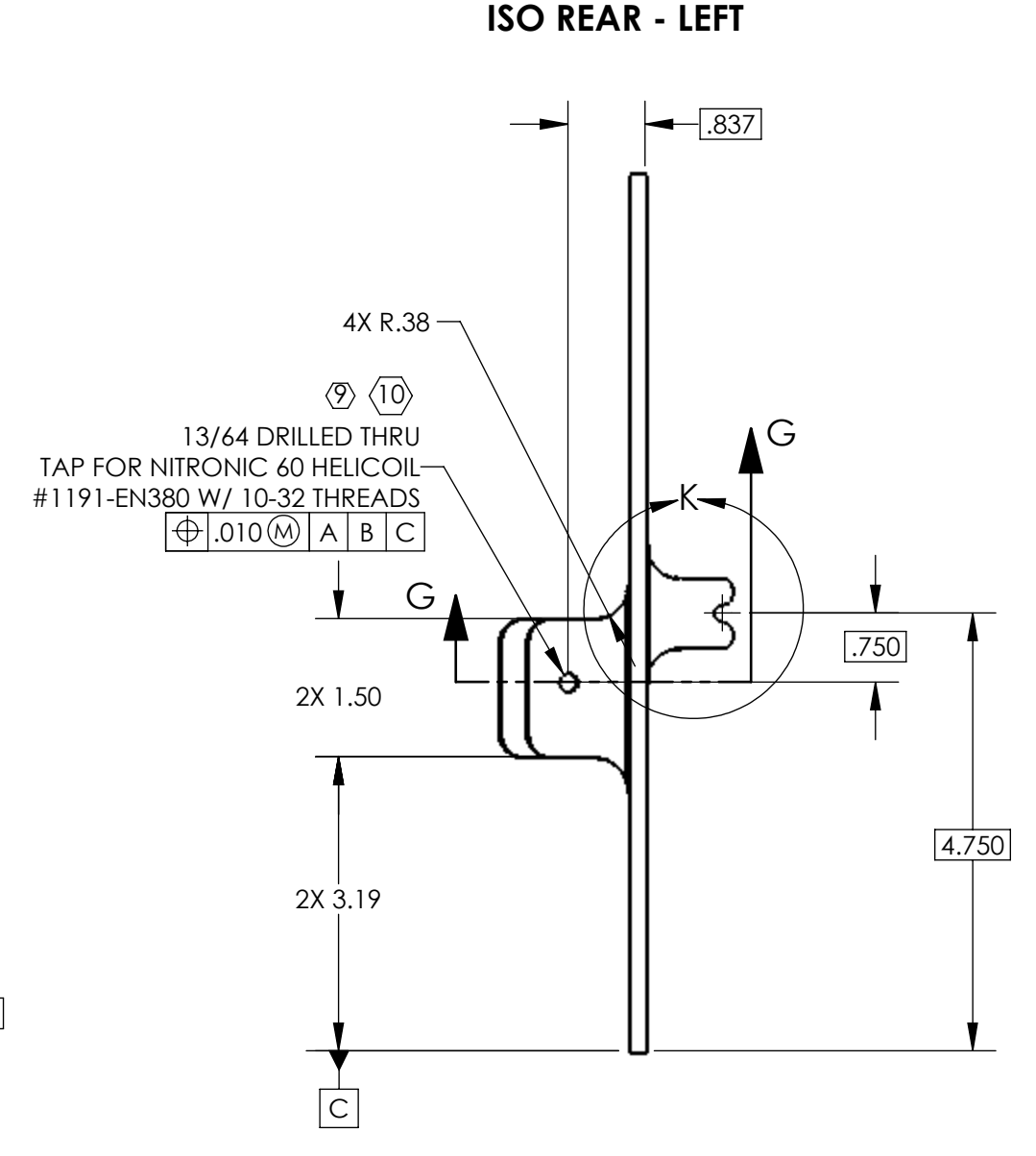
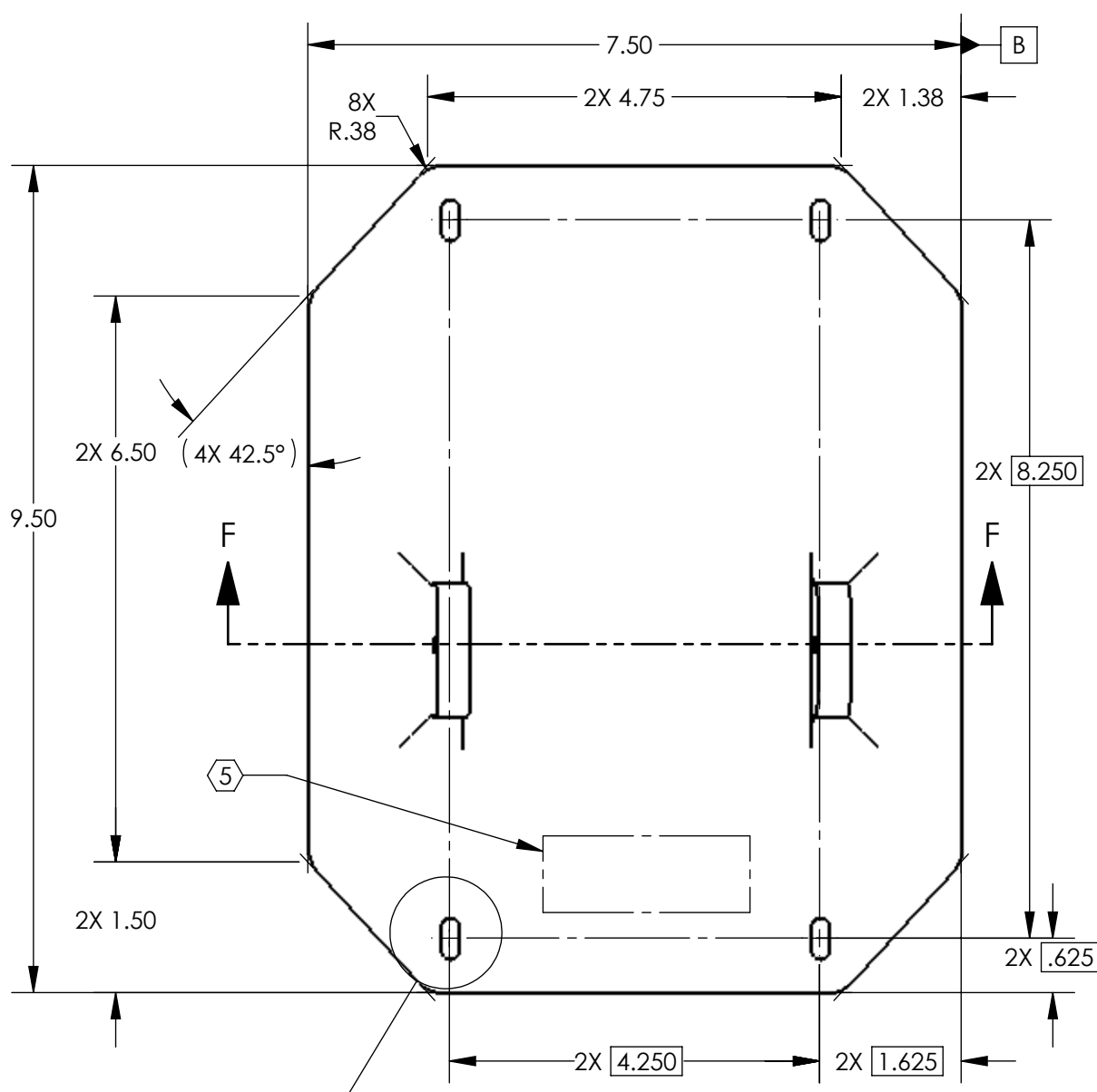
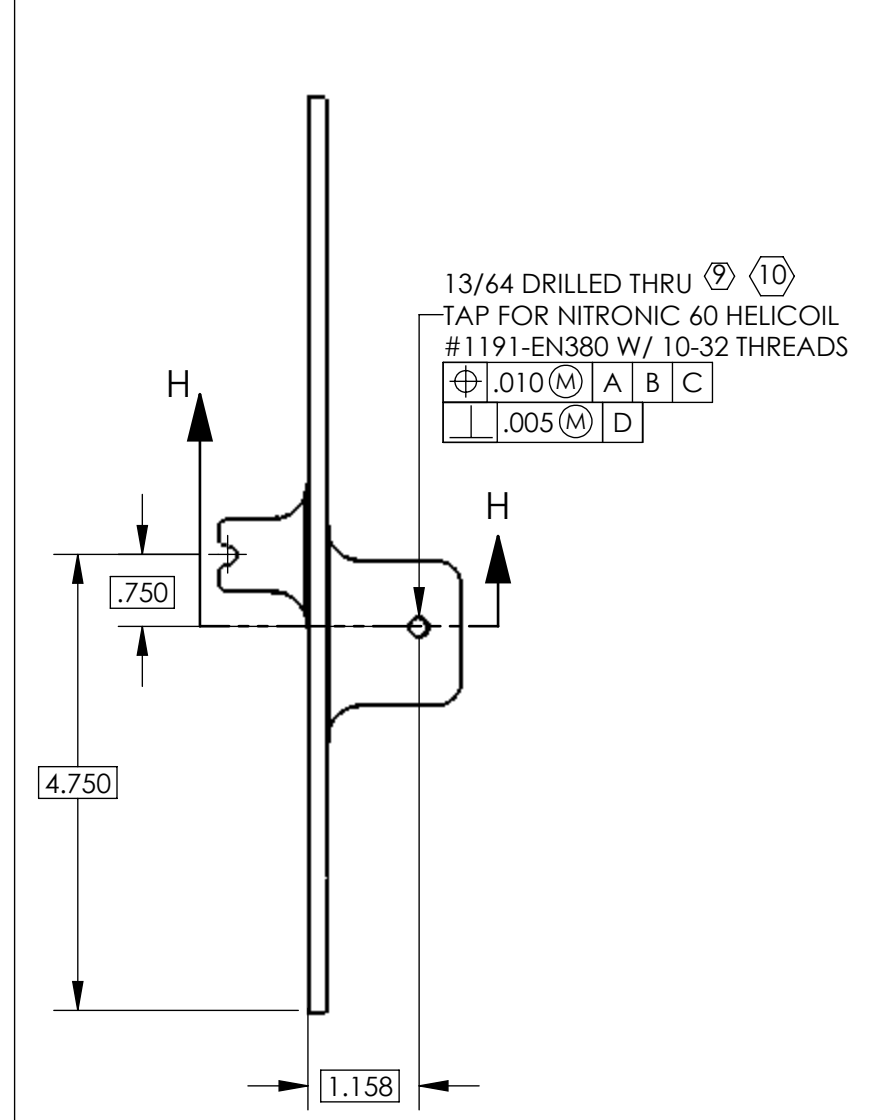
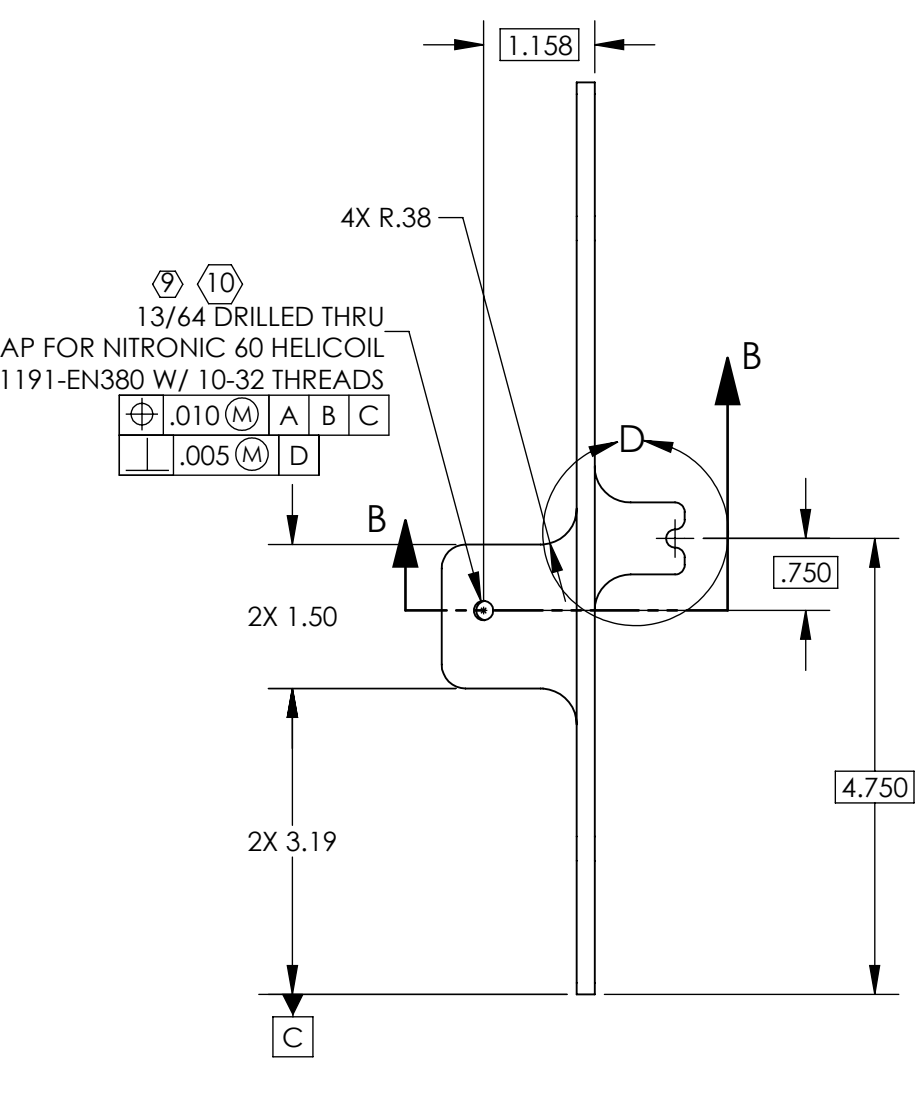
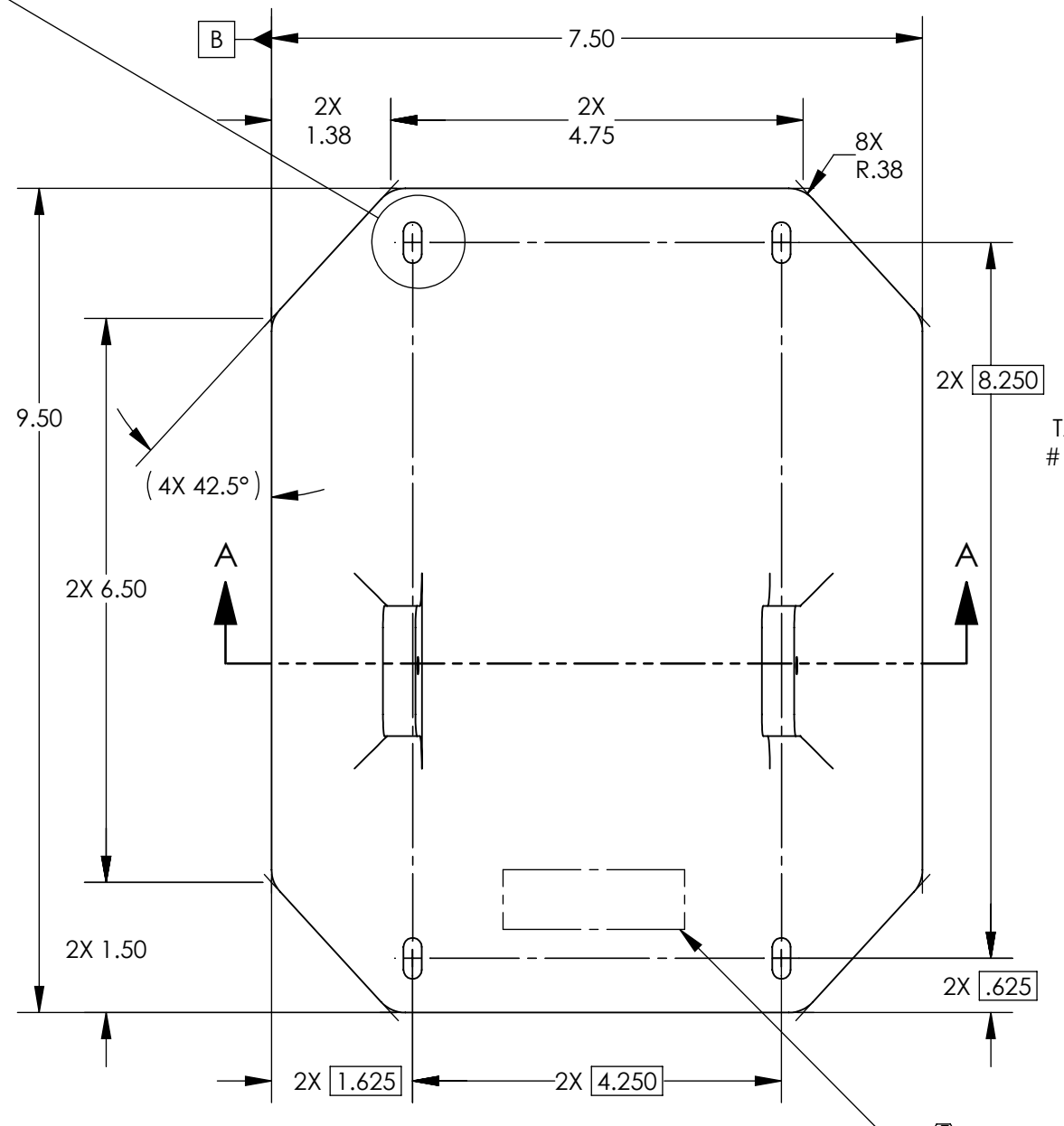
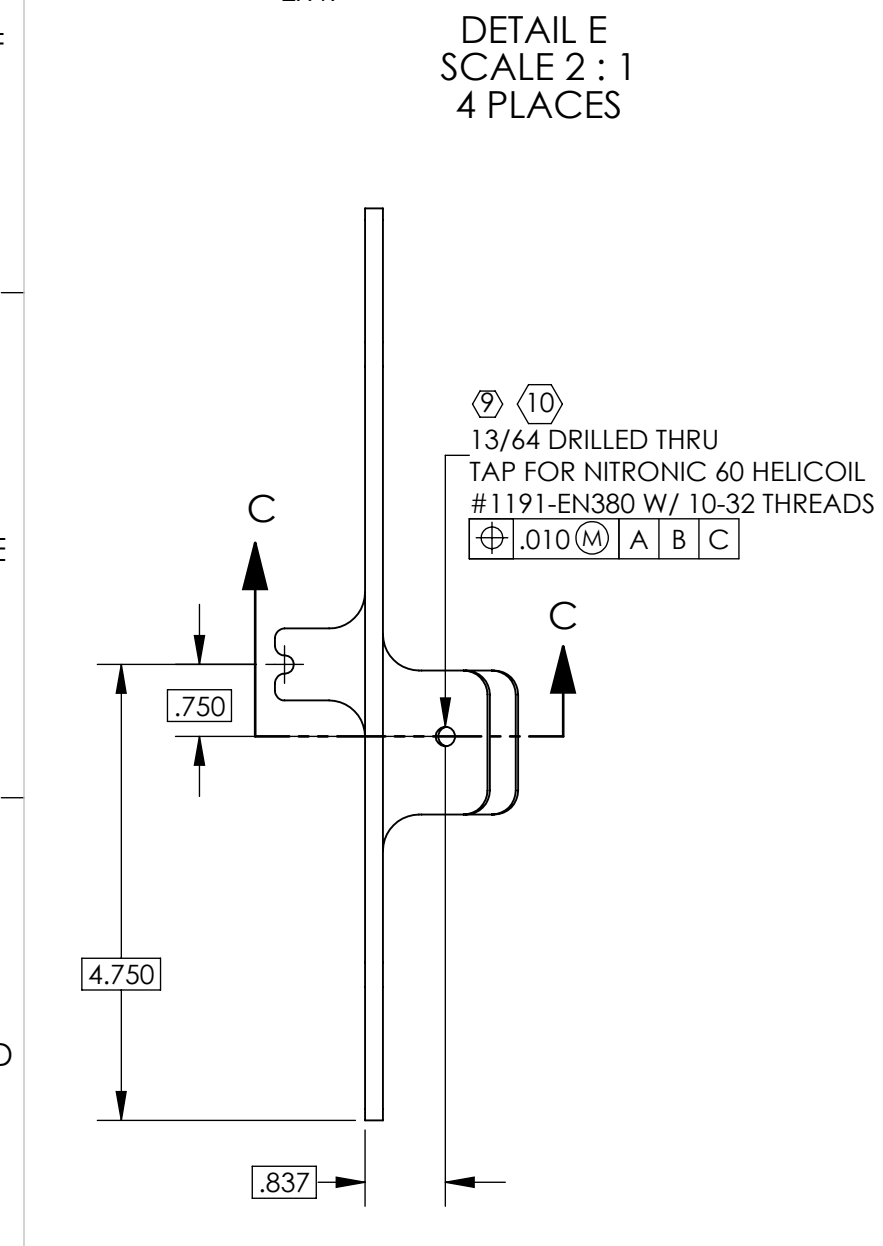
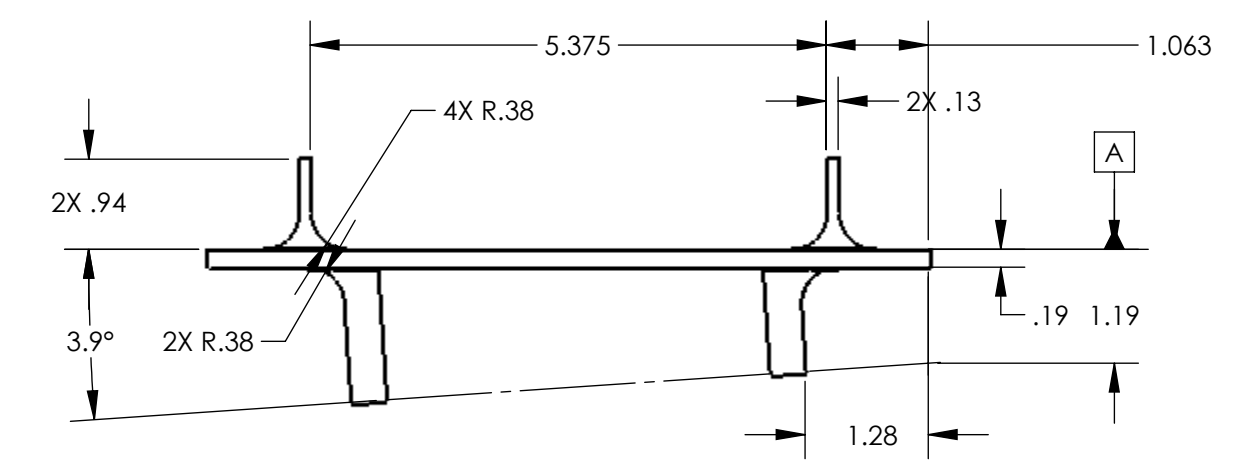
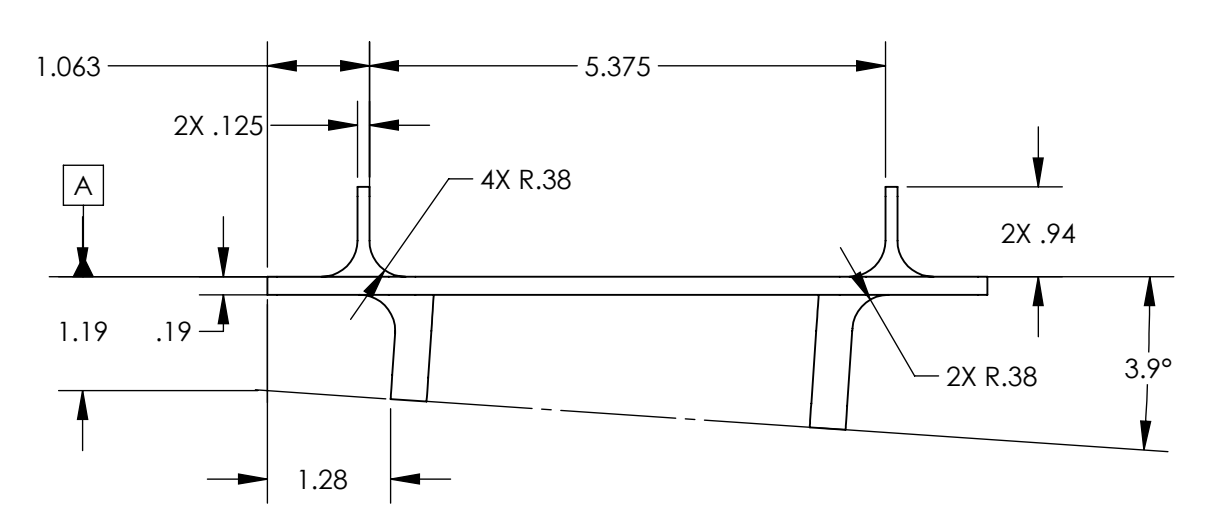
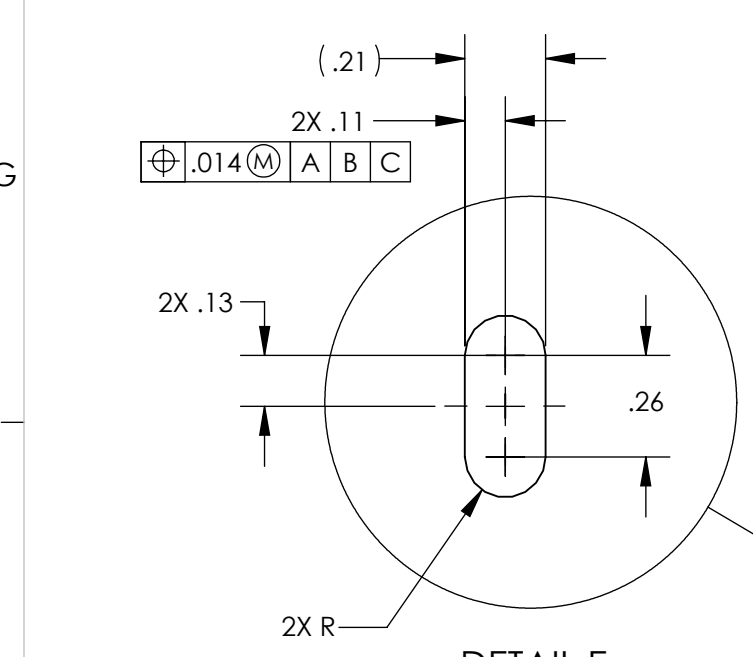


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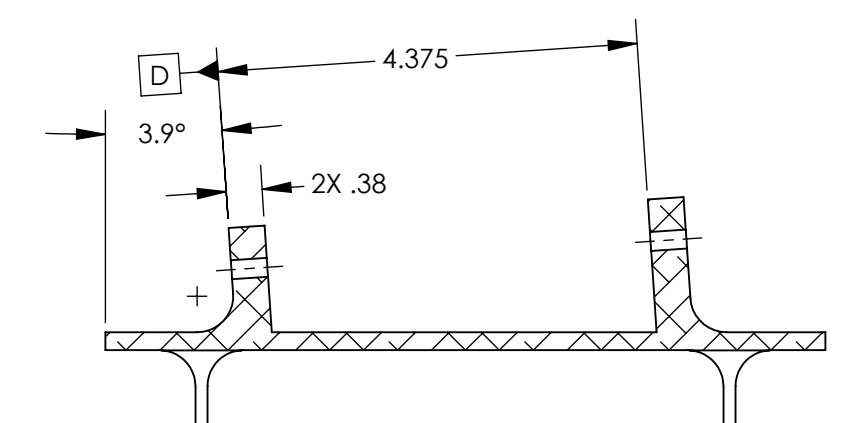
**-02 CONFIGURATION**



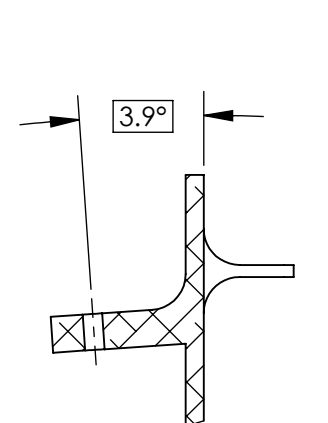
ISO REAR - LEFT



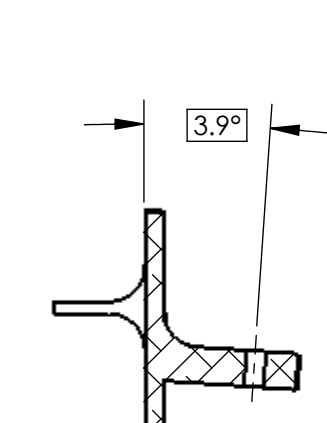
SECTION C-C



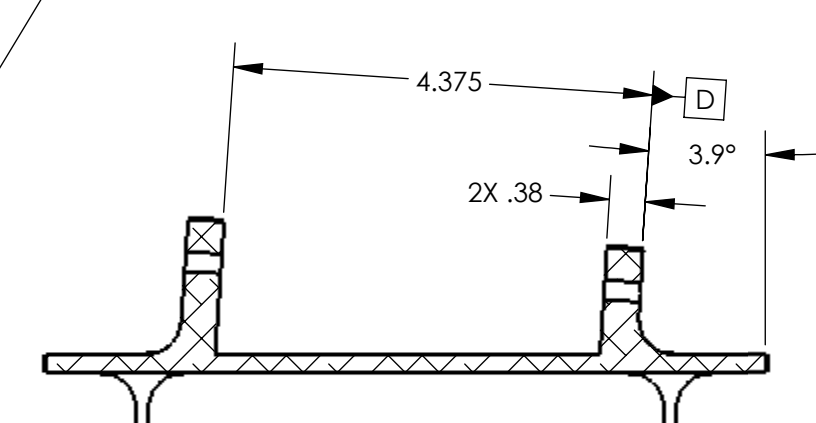
SECTION A-A



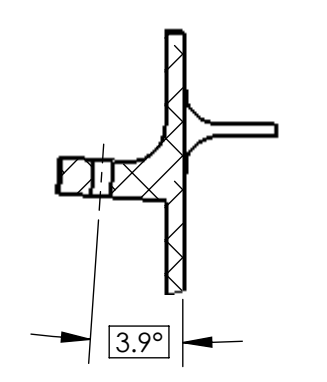
SECTION B-B



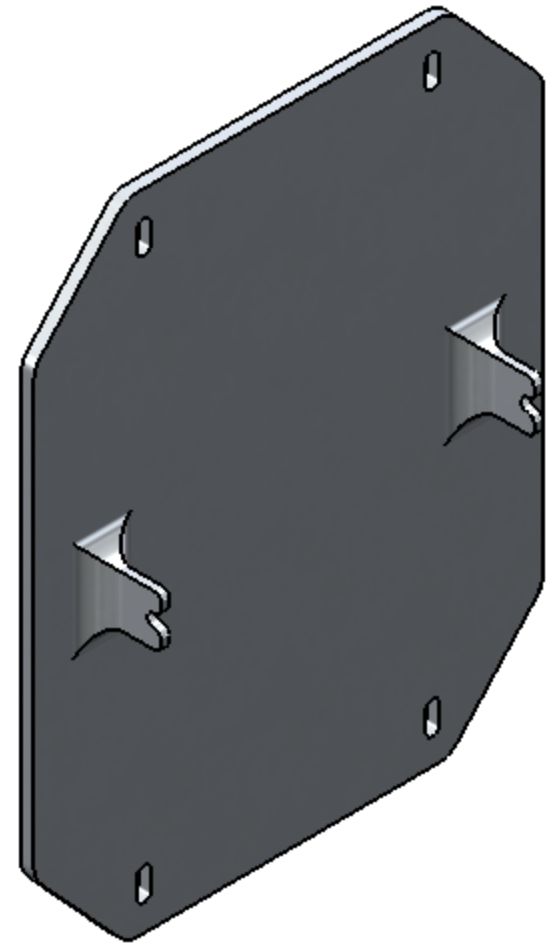
SECTION H-H



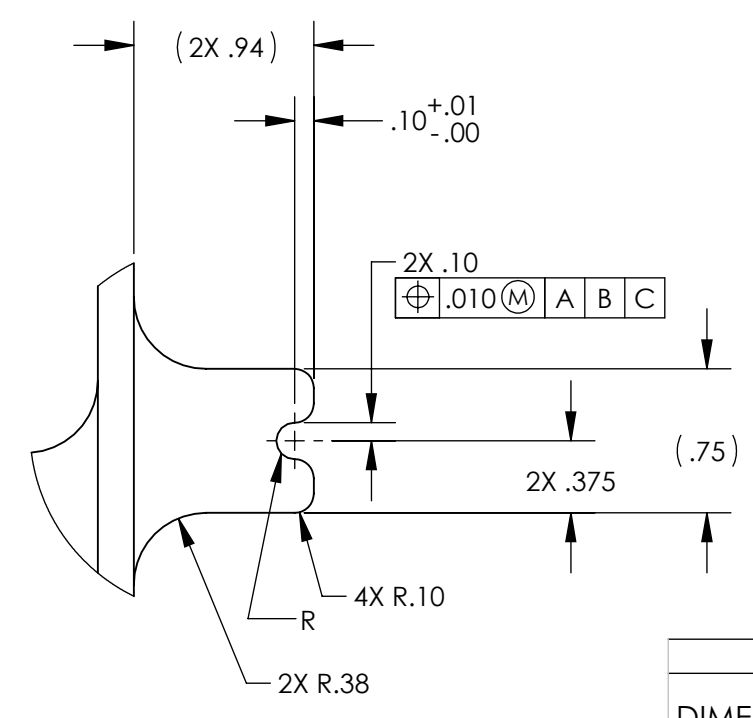
SECTION F-F



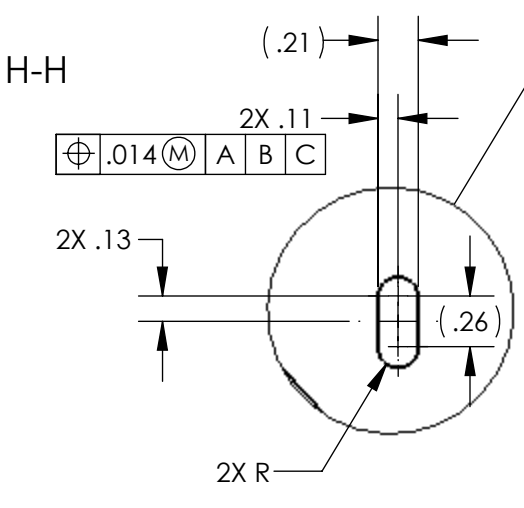
SECTION G-G



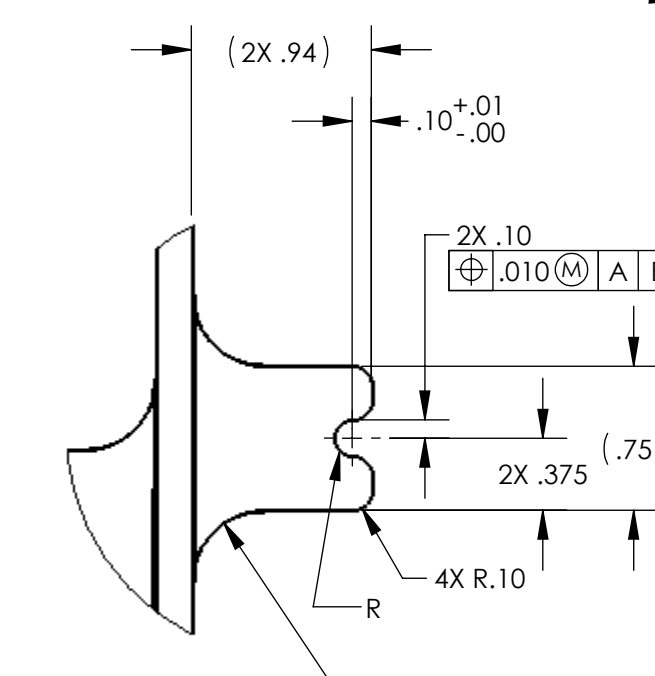
ISO REAR - RIGHT



DETAIL D SCALE 1:1 2 PL.



DETAIL J SCALE 1:1 4 PLACES



DETAIL K SCALE 1:1 2 PL.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
1. INTERPRET DRAWING PER ASME Y14.5-1994.		SYSTEM		ELEVATION SUPPORT PLATE	
2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.		ADVANCED LIGO		DESIGNER M. JACOBSON 20 DEC 2011	
3. DO NOT SCALE FROM DRAWING.		AOS		DRAFTER E. SANCHEZ 27 JAN 2012	
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		NEXT ASSY		CHECKER J. LEWIS 06-MAR-12	
MATERIAL	FINISH	D1101851-1, D1101851-2		APPROVAL A.HEPTONSTAL 05-MAR-12	SIZE DWG. NO.
6061-T6 ALLOY	63 μinch			D	D1102413
DIMENSIONS ARE IN INCHES				SCALE: 1:2	PROJECTION:
TOLERANCES:				SHEET 1 OF 1	
.XX ± .01					
.XXX ± .005					
ANGULAR ± 0.5°					
				REV. v1	