

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

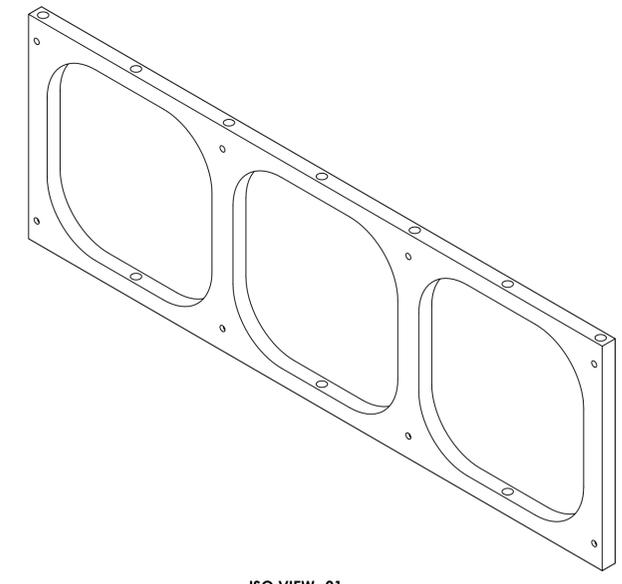
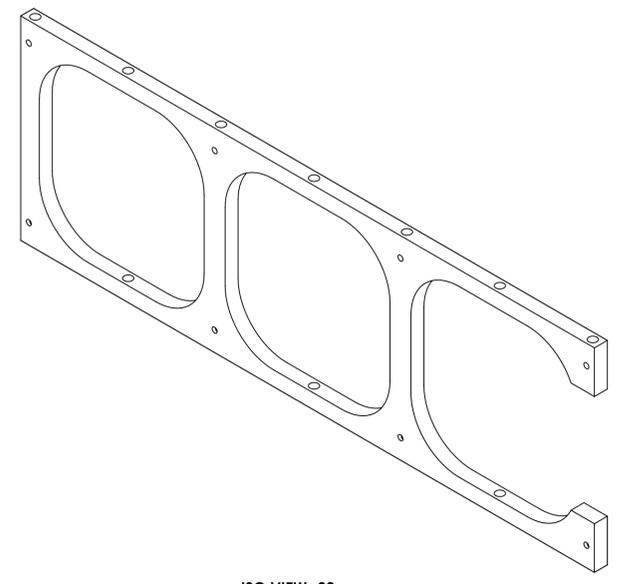
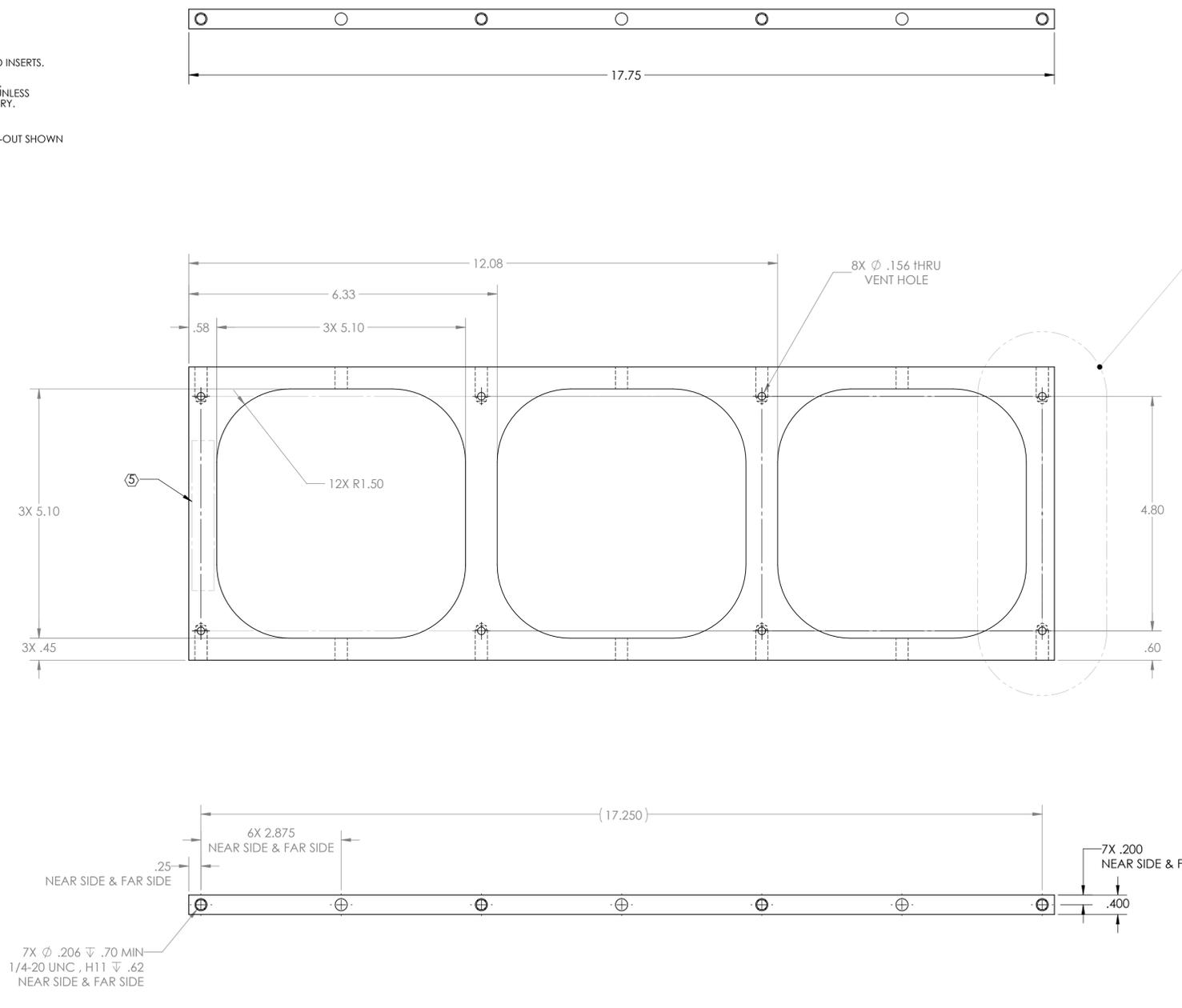
- 6. APPROXIMATE WEIGHT = X.XXX LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

- 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.

12. TYPES -01 AND -02 ARE IDENTICAL WITH THE EXCEPTION OF CUT-OUT SHOWN ON DETAIL 'A'.

TYPE	DESCRIPTION
D1200725-01	PCAL PLATE STRUT (STD.)
D1200725-02	PCAL PLATE STRUT (12 O'CLOCK POS.)

REV.	DATE	DCN #	DRAWING TREE #
V1	26 JUN 2012	E1200700	
V2	13 JUL 2012	E1200700	
V3	13 JUL 2012	E1201028-x0	



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
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.	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .02 .XXX ± .007	
ANGULAR ± 0.5°	
MATERIAL	6061 Alloy
FINISH	63 μinch

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SYSTEM: ADVANCED LIGO
 SUB-SYSTEM: AOS
 NEXT ASSY: D1200174

PART NAME		PCAL PLATE STRUT	
DESIGNER	S. SHANKLE	26 JUN 2012	SIZE DWG. NO.
DRAFTER	S. SHANKLE	26 JUN 2012	D D1200725
CHECKER	S. SHANKLE	26 JUN 2012	
APPROVAL	S. SHANKLE	26 JUN 2012	SCALE: 1:2
		PROJECTION:	SHEET 1 OF 1

D1200725-PCAL Plate Strut PART PDM REV: X-022 DRAWING PDM REV: X-010