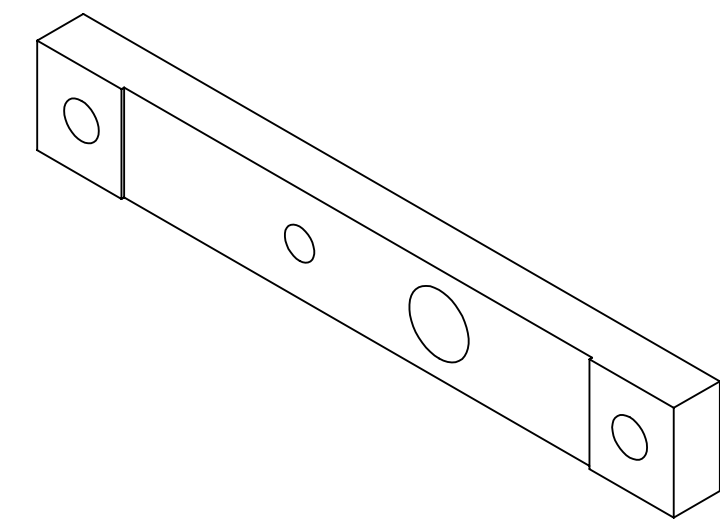
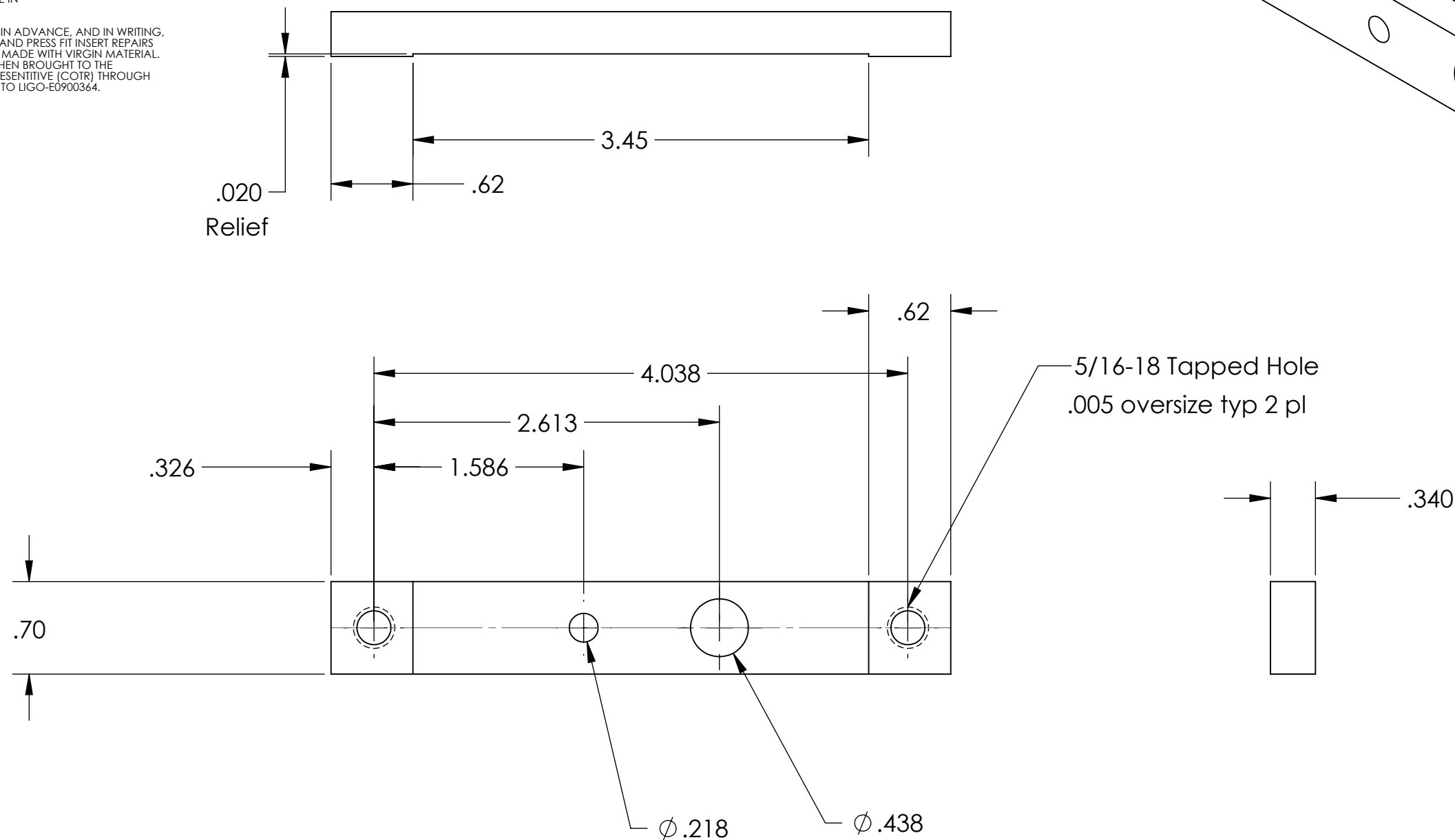


NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED.
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. APPROXIMATE WEIGHT = 0.100 (.046KG) 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, 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. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO. REFER TO LIGO-E0900364.
- 12. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE. THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS. REFER TO LIGO-E0900364.

REV.	DATE	DCN #	DRAWING TREE #
V1	22 MAY 2012	E1100351	-
v2	1 JUN 2012	E1100351	-
-	-	-	-

D C B A



D C B A

D1200752-v1 aLigo Nut Plate - Structure Tube, PART PDM REV: X-000, DRAWING PDM REV: X-003

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		aLigo Nut Plate - Structure Tube	
TOLERANCES: .XX ± .02 .XXX ± .005				SUB-SYSTEM AOS		DESIGNER K MAILAND 18 05 2012	SIZE DWG. NO. B
ANGULAR ± 1.0°				MATERIAL 6061-T6 (SS)		DRAFTER K MAILAND 05-22-2012	D1200752
				FINISH 63 μinch		CHECKER K MAILAND 05-22-2012	REV. v2
				NEXT ASSY D0901880		APPROVAL	SCALE: 1:1 PROJECTION: SHEET 1 OF 1