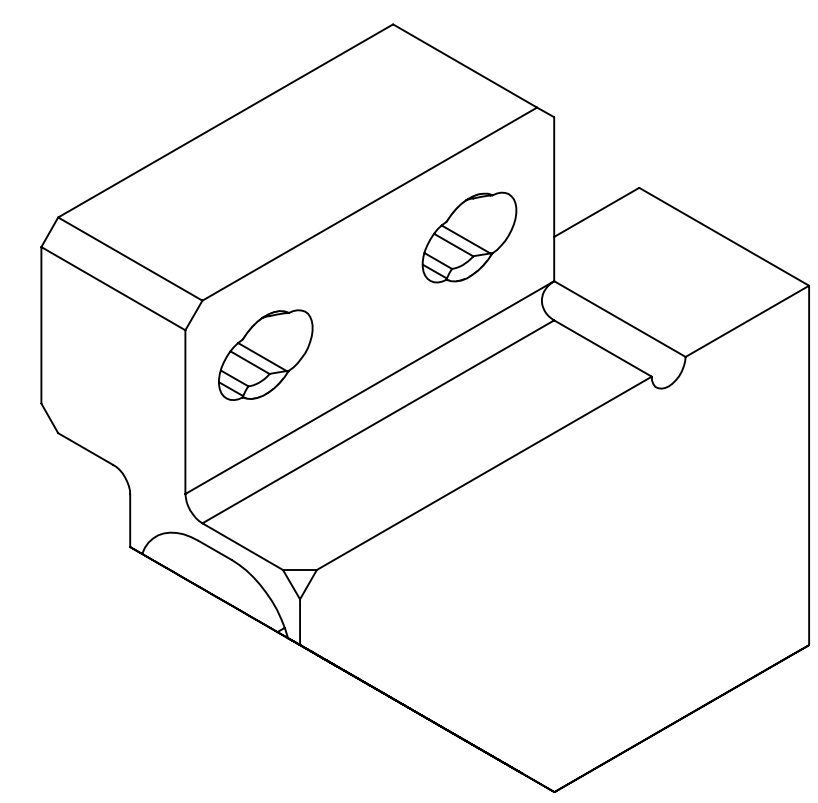


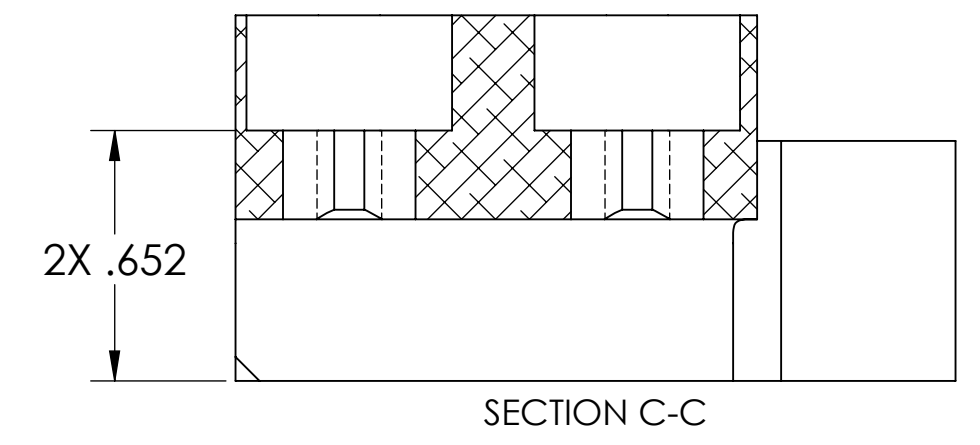
- NOTES CONTINUED:**
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 8. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
 9. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
 10. 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.
 11. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .010 MAX

REV.	DATE	DCN #	DRAWING TREE #
v1	16 NOV 2012	E1201029	-
v2	09 MAR 2015	E1500163-x0	-
v3	17 APR 2015	E1500212-x0	-

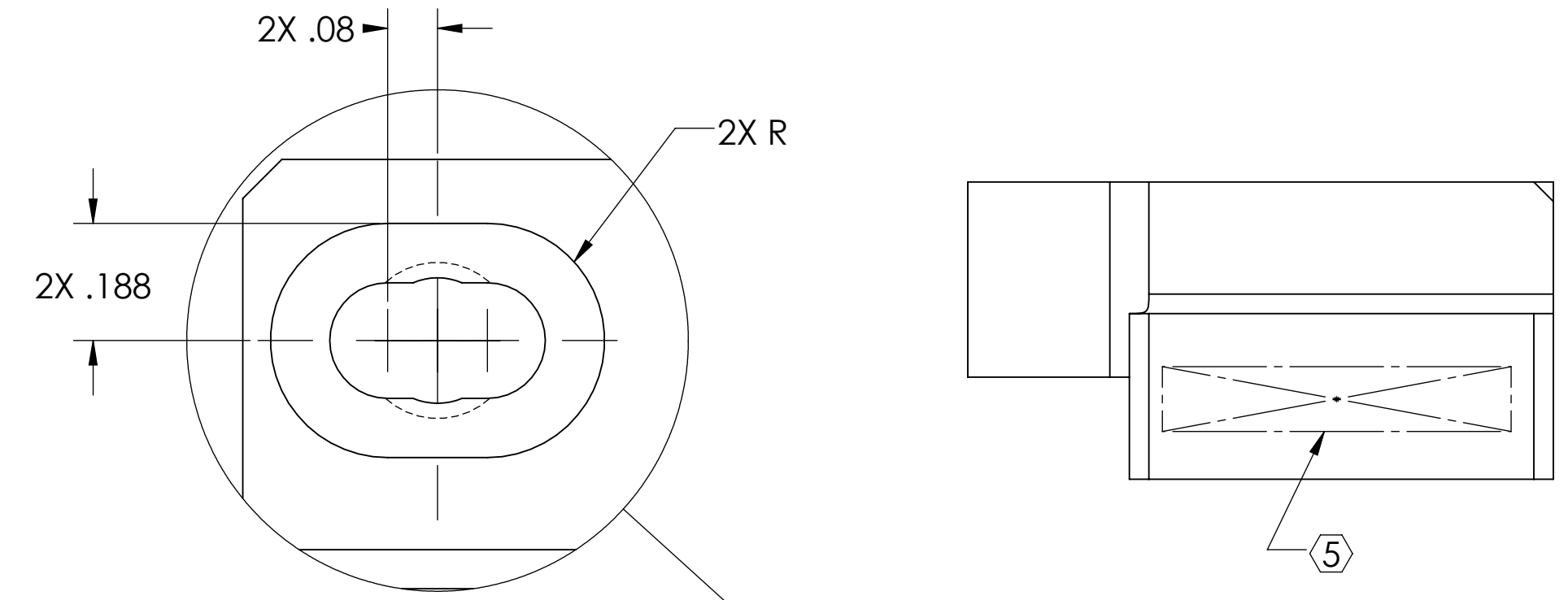
-101 DETAIL



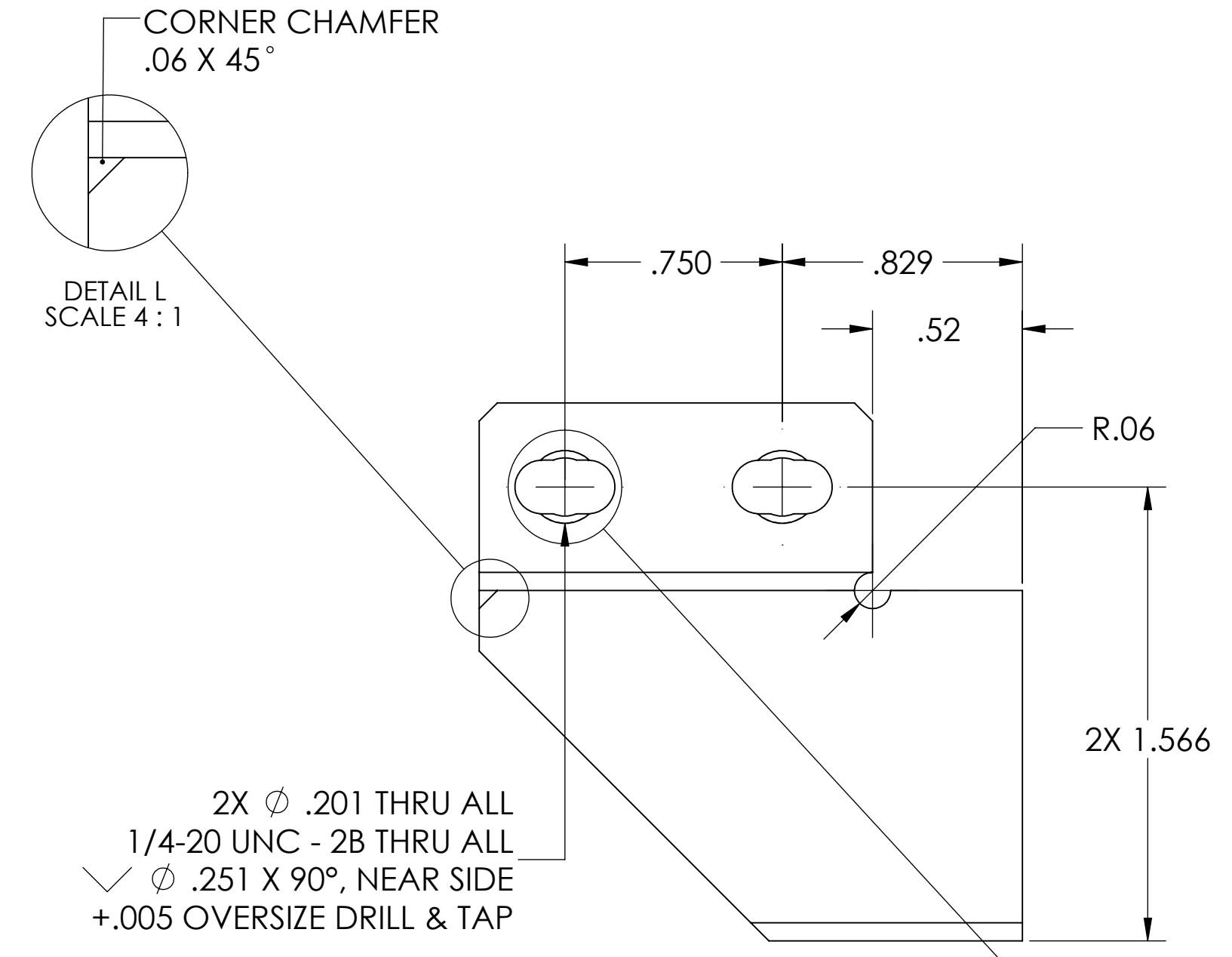
ISO VIEW



SECTION C-C



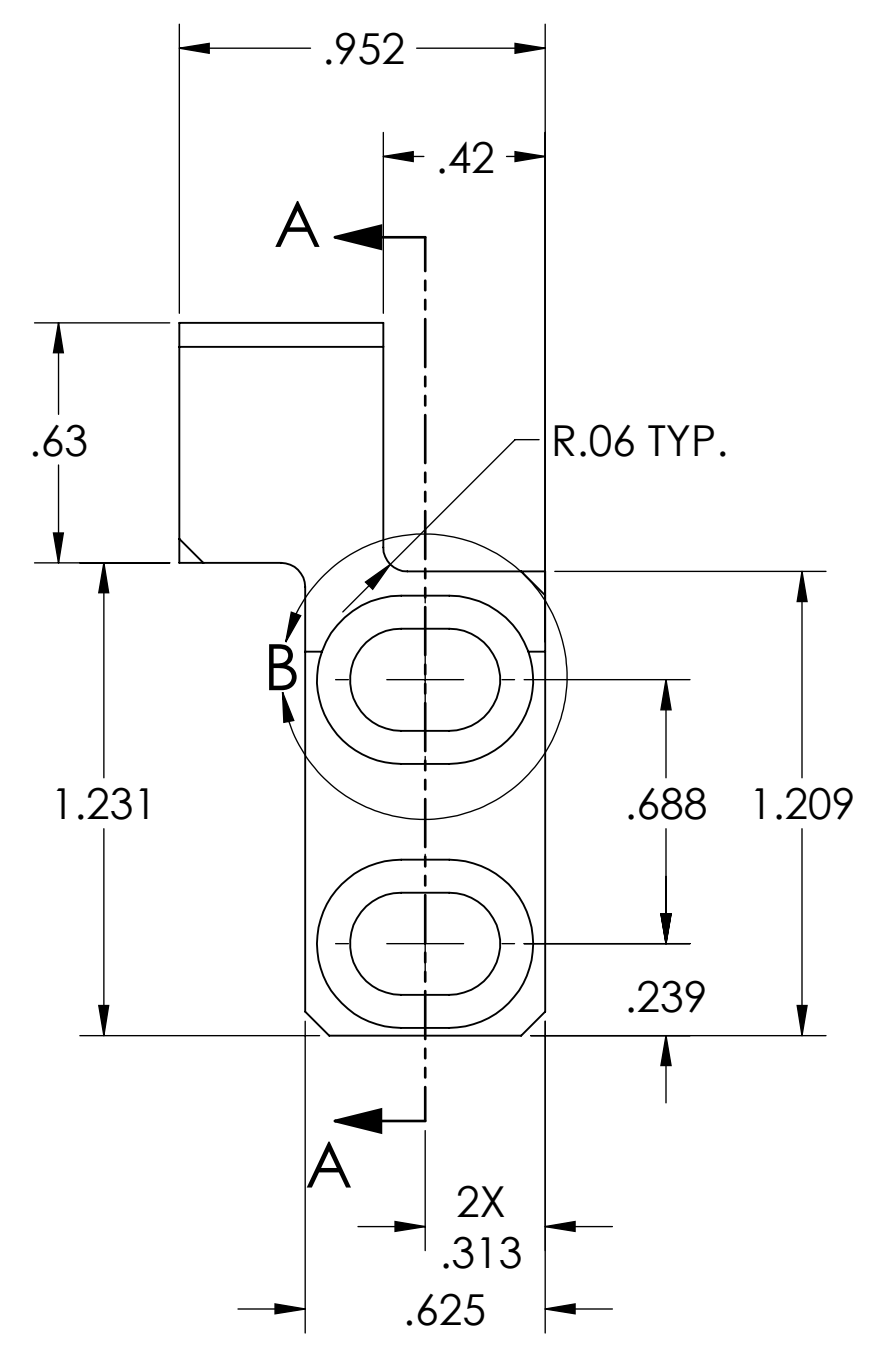
DETAIL E
SCALE 4 : 1
2 PL.



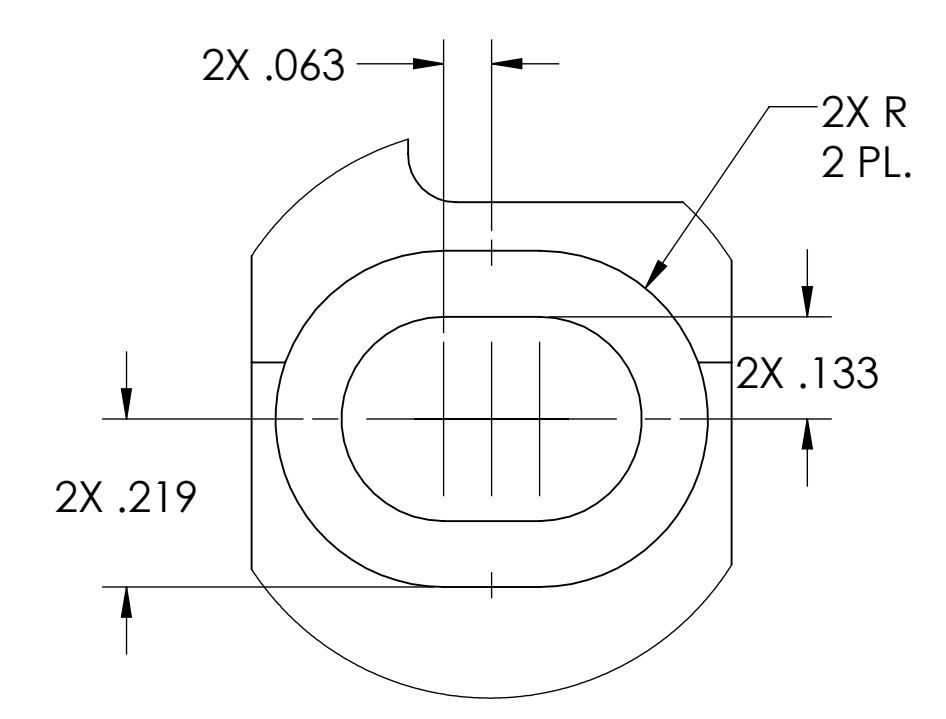
CORNER CHAMFER
.06 X 45°

DETAIL L
SCALE 4 : 1

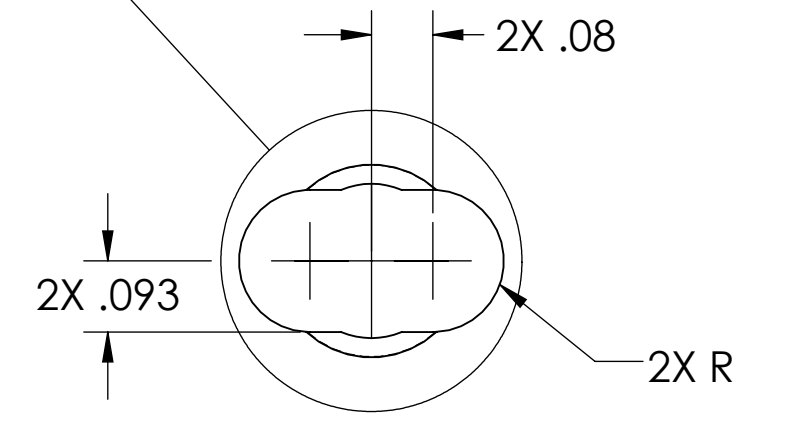
2X ϕ .201 THRU ALL
1/4-20 UNC - 2B THRU ALL
 \checkmark ϕ .251 X 90°, NEAR SIDE
+.005 OVERSIZE DRILL & TAP



SECTION A-A



DETAIL B
SCALE 4 : 1
2 PL.

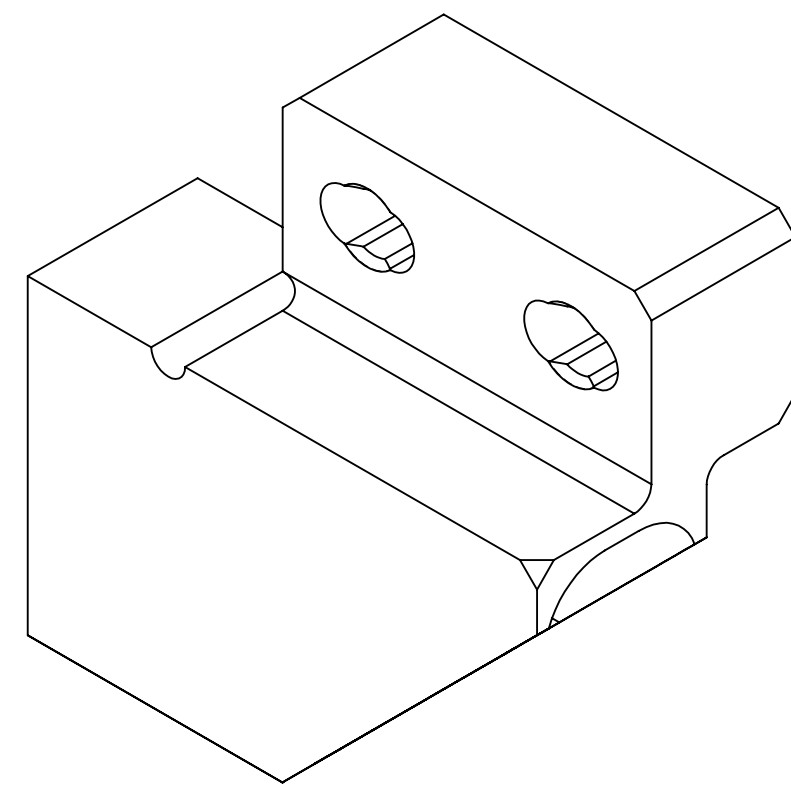


DETAIL D
SCALE 4 : 1
2 PL.

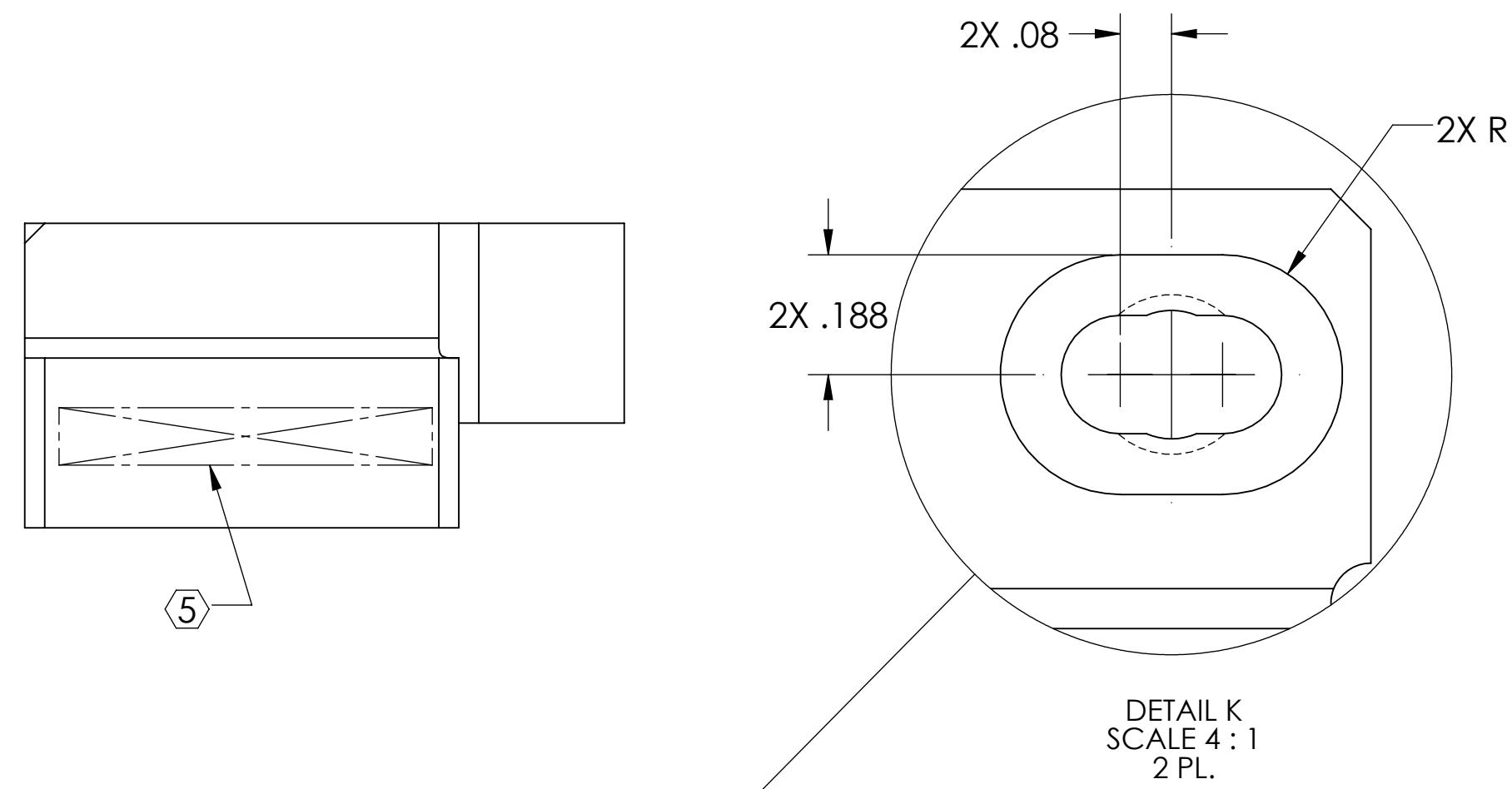
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.				ADVANCED LIGO		HORIZONTAL ADJUST, EQ. STOP, OMC, dLIGO	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± .5°		MATERIAL 6061-T6 Al		FINISH 63 μ inch		DESIGNER SBARNUM	
		NEXT ASSY D1201441		SUB-SYSTEM ISC		DRG. NO. D1201478	
				CHECKER JLEWIS		REV. v3	
				APPROVAL PFRITSHCEL		SHEET 1 OF 2	
				SCALE: 2:1		PROJECTION:	

D1201478 HORIZONTAL ADJUST, EQ STOP, OMC, dLIGO PART PDM REV: X-002, DRAWING PDM REV: X-007

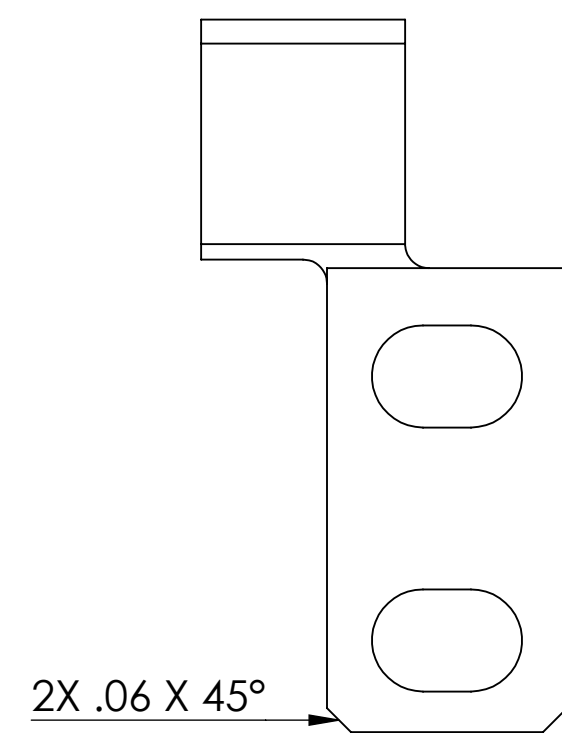
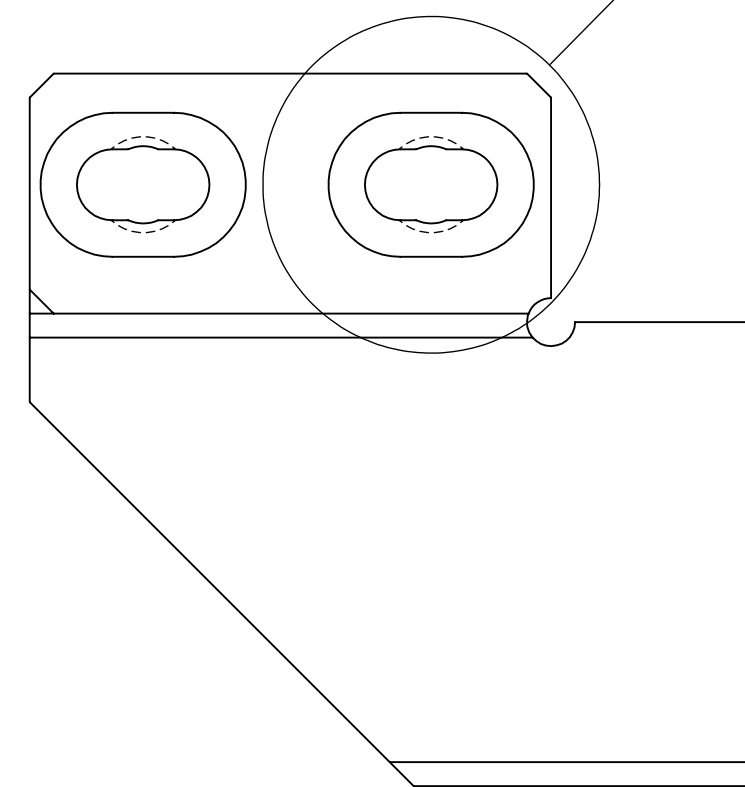
-102 DETAIL



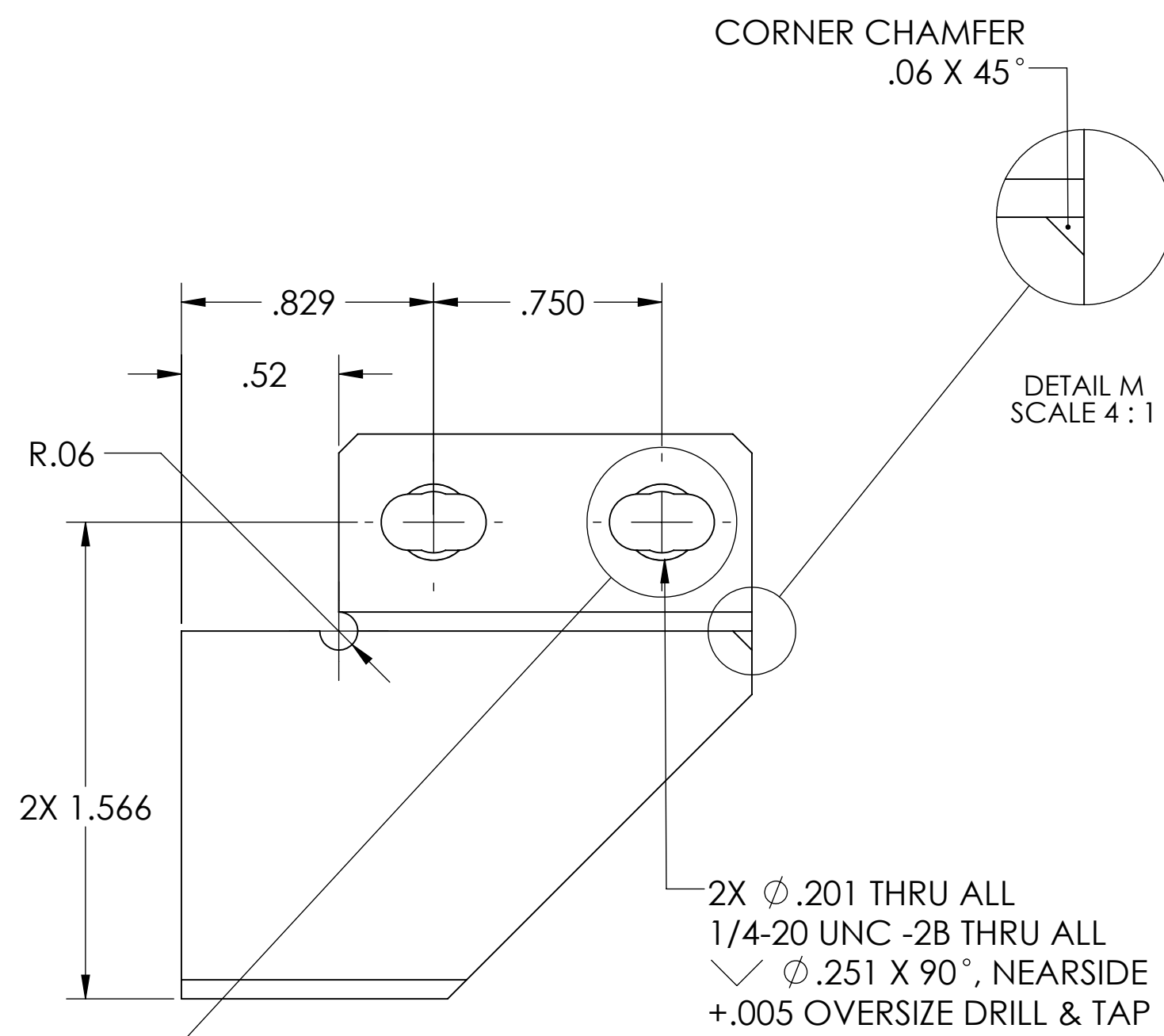
ISO VIEW



DETAIL K
SCALE 4 : 1
2 PL.

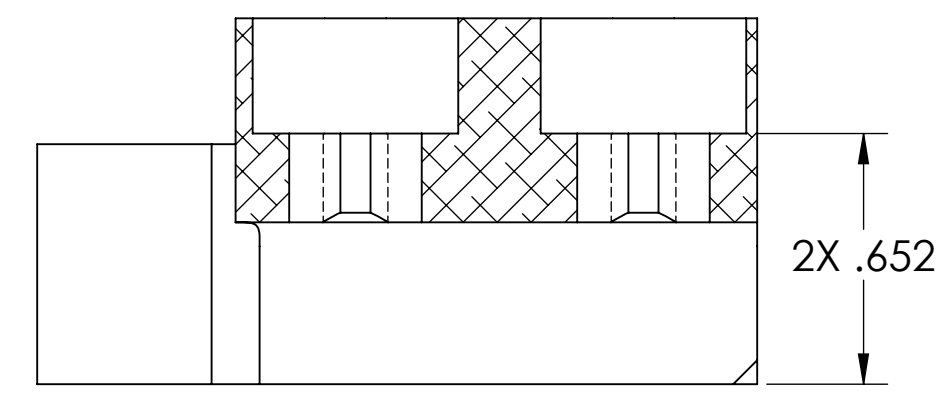


DETAIL J
SCALE 4 : 1
2 PL.

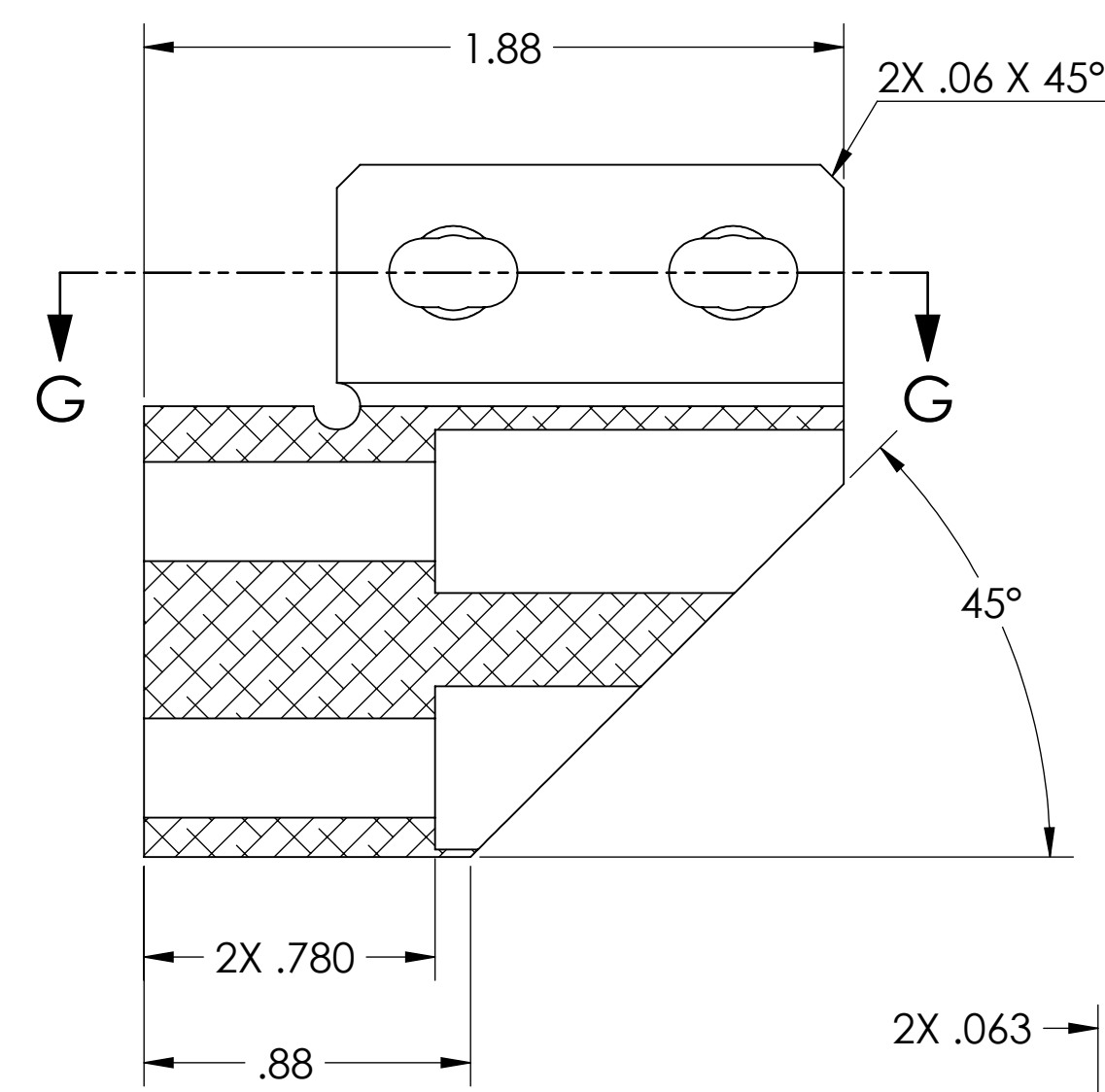


DETAIL M
SCALE 4 : 1

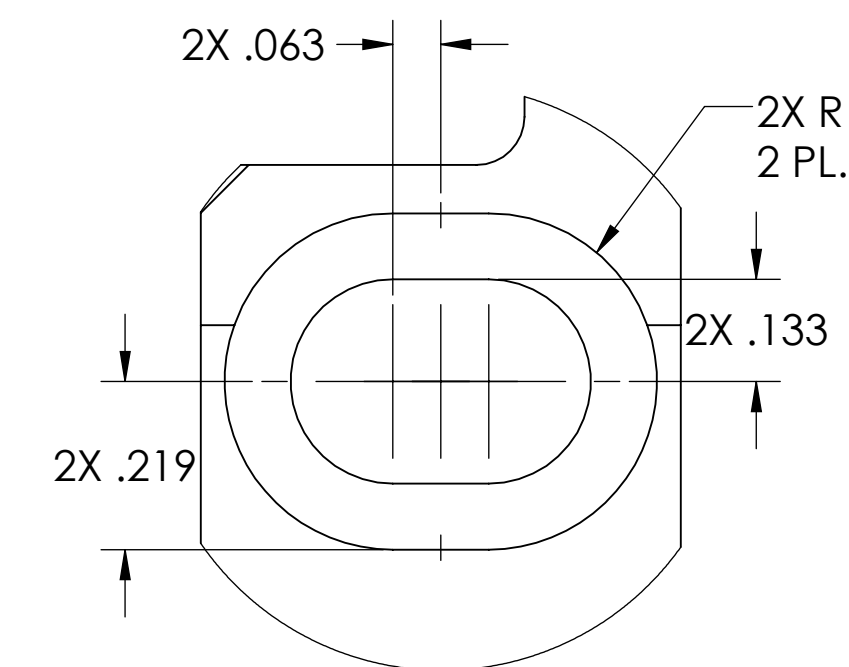
2X ϕ .201 THRU ALL
1/4-20 UNC -2B THRU ALL
 \checkmark ϕ .251 X 90°, NEARSIDE
+.005 OVERSIZE DRILL & TAP



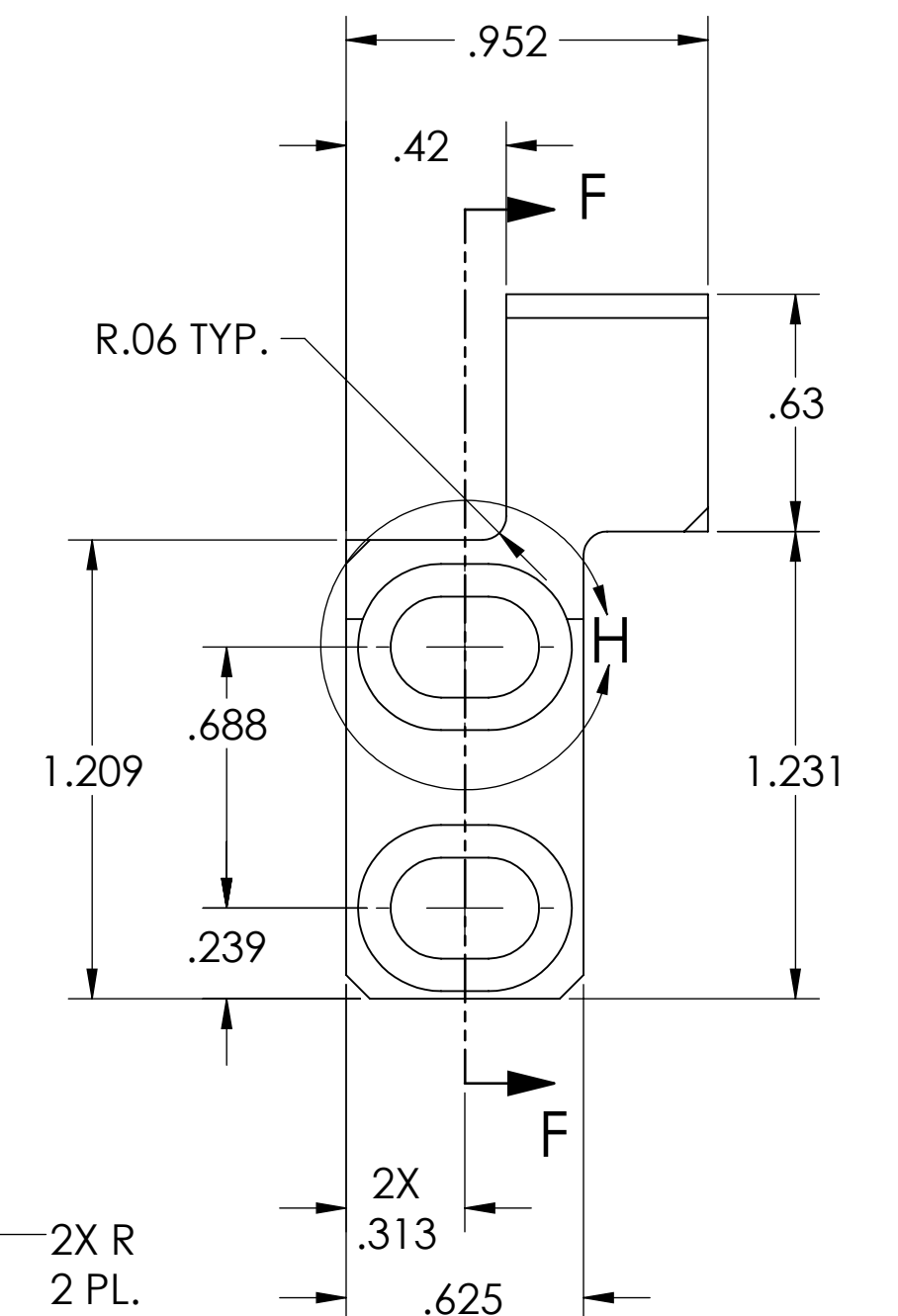
SECTION G-G



SECTION F-F



DETAIL H
SCALE 4 : 1
2 PL.



LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE DWG. NO.	D D1201478-101	v3
SCALE: 2:1	PROJECTION:	SHEET 2 OF 2

D1201478-HORIZONTAL ADJUST, EQ STOP, OMC, LIGO, PART PDM REV: X002, DRAWING PDM REV: X007