

NOTES CONTINUED:

5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.

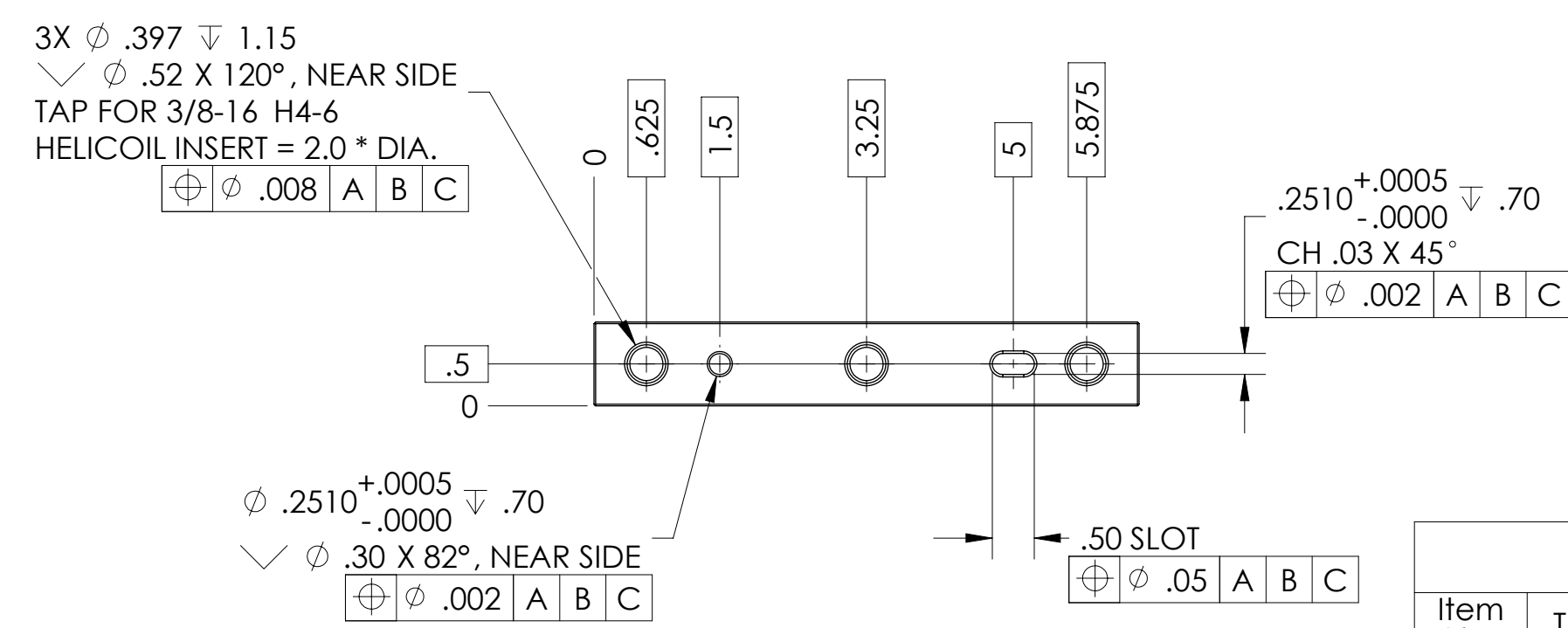
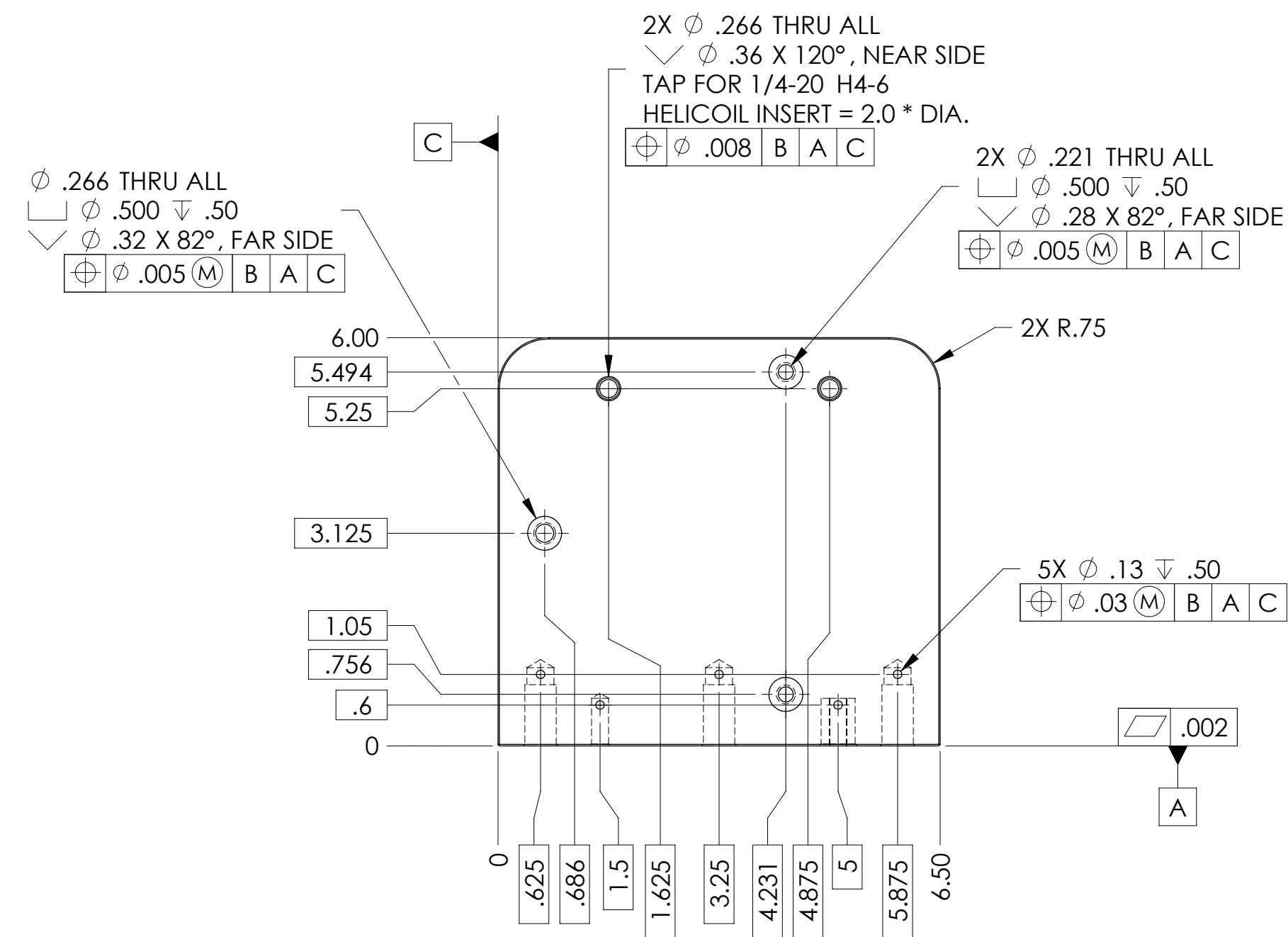
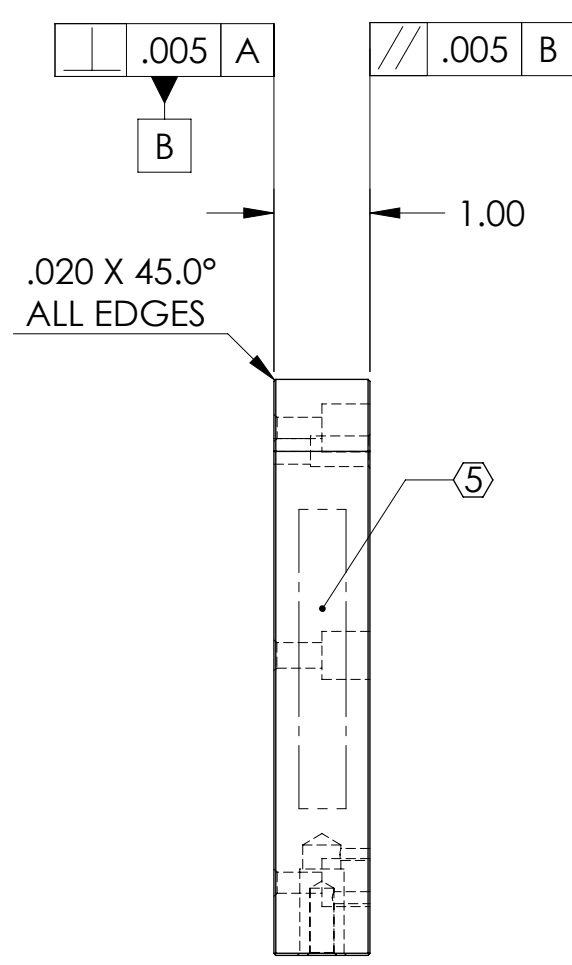
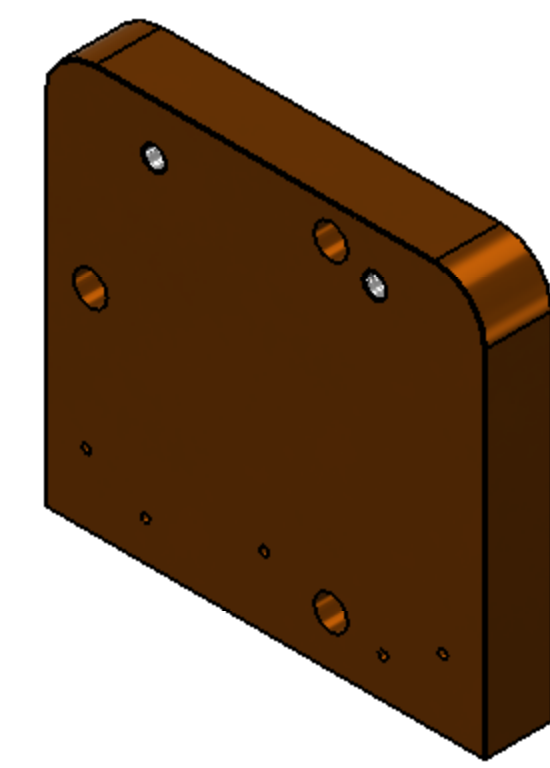
6. DO NOT INSTALL HELI-COILS UNTIL POST-CLEANING.

POST-MANUFACTURING NOTES:

P1. CLEAN TO LIGO STANDARDS, CLASS A (PER E0900047 AND E960022).

P2. INSTALL CLASS-A CLEAN HELI-COILS. BREAK OFF AND REMOVE TANGS. CHECK THAT END OF EACH INSERT REMAINS ENGAGED IN THREAD AFTER TANG REMOVAL.

REV.	DATE	DCN #	DRAWING TREE #
V1	28 Apr 2009		



Mass = 3.7 lbs

Item No.	Thread Size	Material	Heli-Coil P/N 1185...	Qty.
1	1/4"-20 x .50"	Nitronic 60	-4EN500	2
2	3/8"-16 x .75"	Nitronic 60	-6EN750	3

<p>NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)</p> <p>1. INTERPRET DRAWING PER ASME Y14.5-1994.                  2. REMOVE ALL SHARP EDGES, R.02 MIN.                  3. DO NOT SCALE FROM DRAWING.                  4. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.</p>		<p><b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY                  MASSACHUSETTS INSTITUTE OF TECHNOLOGY</p>		<p>PART NAME  <b>Mount Plate, Horz L4-C, HAM ISI</b></p>			
<p>DIMENSIONS ARE IN INCHES</p> <p>TOLERANCES:                  .XX ± .015                  .XXX ± .005</p> <p>ANGULAR ± 0.5°</p>		<p>SYSTEM  <b>ADVANCED LIGO</b></p> <p>SUB-SYSTEM  <b>SEI</b></p> <p>NEXT ASSY  <b>D0900317</b></p>		<p>DESIGNER                  astein 21 Apr 2009</p> <p>DRAFTER                  sbarnum 27 Apr 2009</p> <p>CHECKER                  astein 27 Apr 2009</p> <p>APPROVAL                  astein 27 Apr 2009</p>		<p>SIZE  <b>c</b></p> <p>DWG. NO.  <b>D0900319</b></p> <p>REVISION  <b>v1</b></p>	
<p>MATERIAL  <b>6061-T6 Al</b></p>		<p>FINISH  <b>63 μinch</b></p>		<p>SCALE: 1:2</p>		<p>PROJECTION: </p> <p>SHEET 1 OF 1</p>	