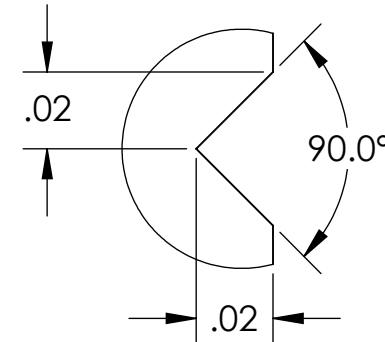
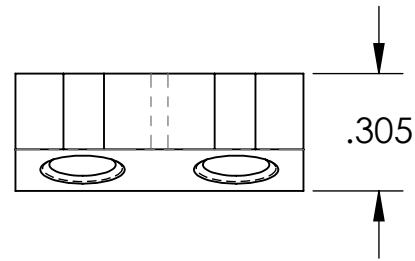


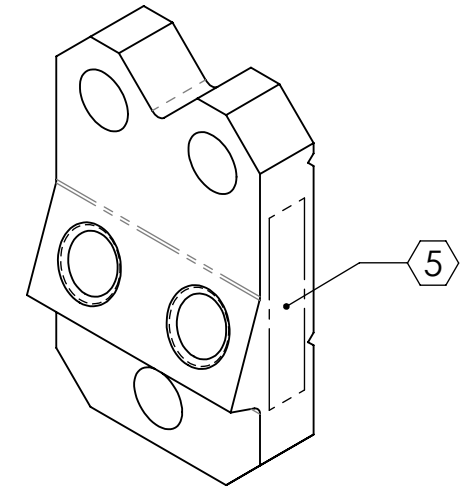
D030149_Advanced_LIGO_SUS_HLTs_Intermediate_Wire_Breakoff_Mass_PART PDM REV: V1-004, DRAWING PDM REV: V1-002

- 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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 - 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - 8. ALL HELICOIL HOLES TO BE PREPARED IN ACCORDANCE WITH EMHART HELICOIL PRODUCT CATALOG, HC2000, REV. 4.
 - 9. ALL HELICOILS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY, CLEANING AND BAKING OF FINISHED PARTS.

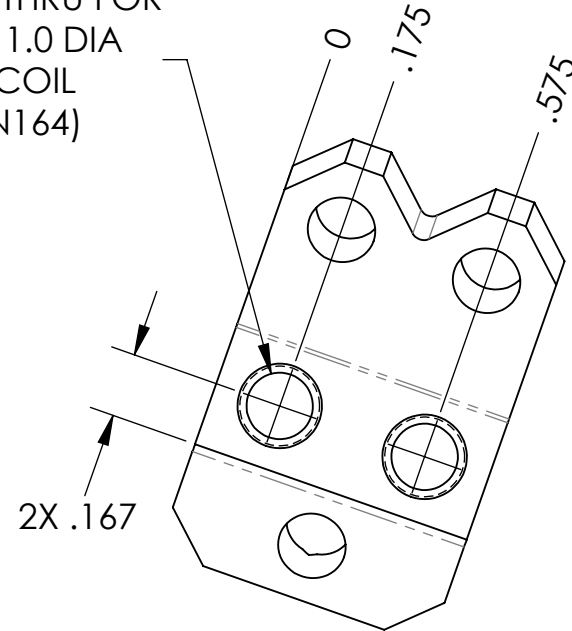
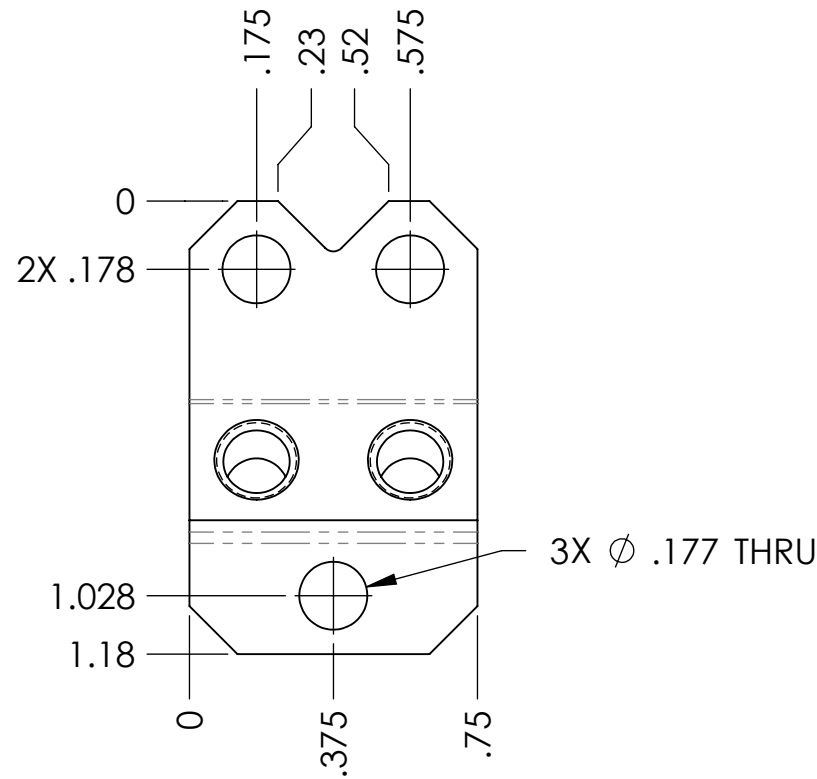
REV.	DATE	DCN #	DRAWING TREE #
v1	30 JUN 2009	E0900184	E080191
v2	28 JUN 2010	E1000236	E080191
-	-	-	-



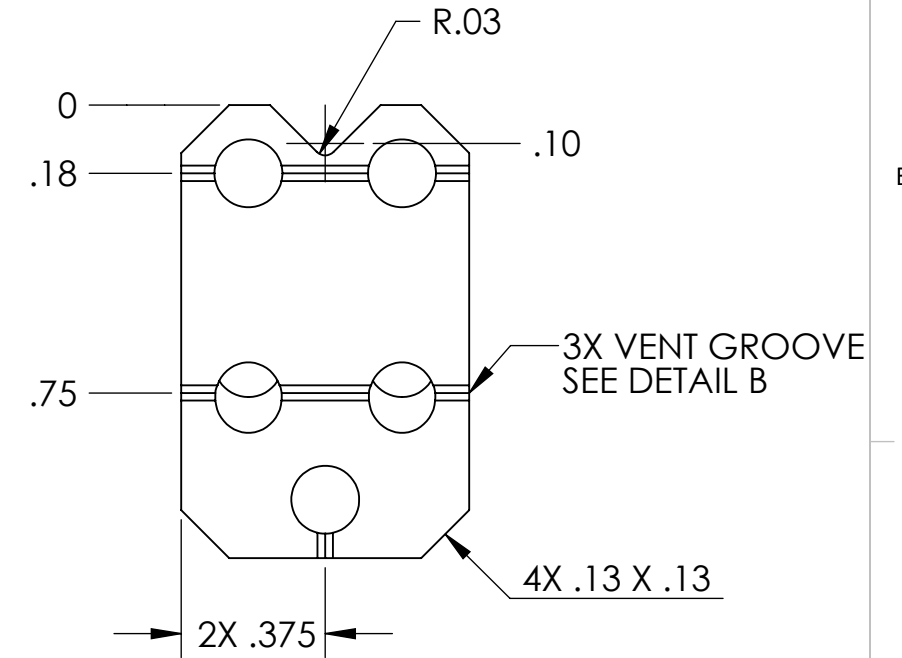
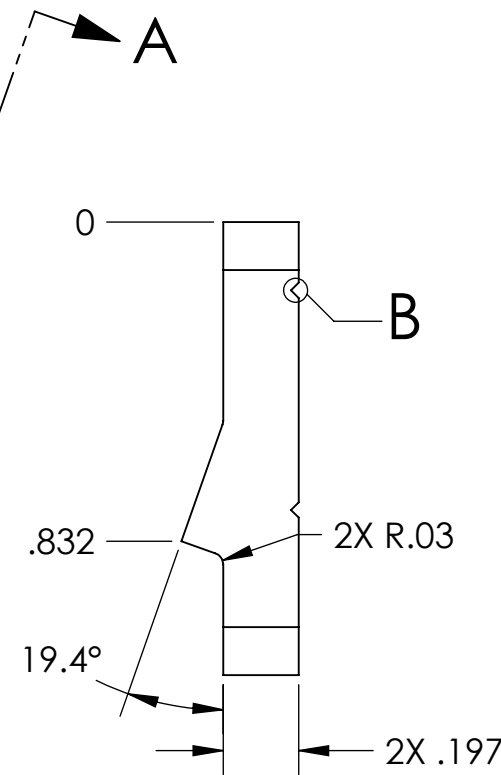
DETAIL B
SCALE 20 : 1



2X DRILL AND TAP THRU FOR
#8-32 UNC-2B X 1.0 DIA
EMHART HELICOIL
(P/N 1185-2EN164)



VIEW A-A



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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 MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± 0.1°

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM ADVANCED LIGO		SUB-SYSTEM SUS	
NEXT ASSY INTERMEDIATE WIRE ASSY		DESIGNER D. BRIDGES	
		DRAFTER R. BIEDENHARN	
		CHECKER D. BRIDGES	
		APPROVAL	

DATE 6 JUL 2009		SIZE DWG. NO. B		REV. v2	
DATE 01 NOV 2010		D030149			
DATE 04 NOV 2010		SCALE: 2:1		PROJECTION:	
		SHEET 1 OF 1			