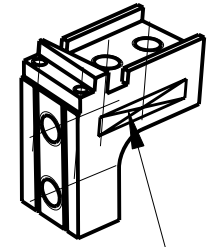
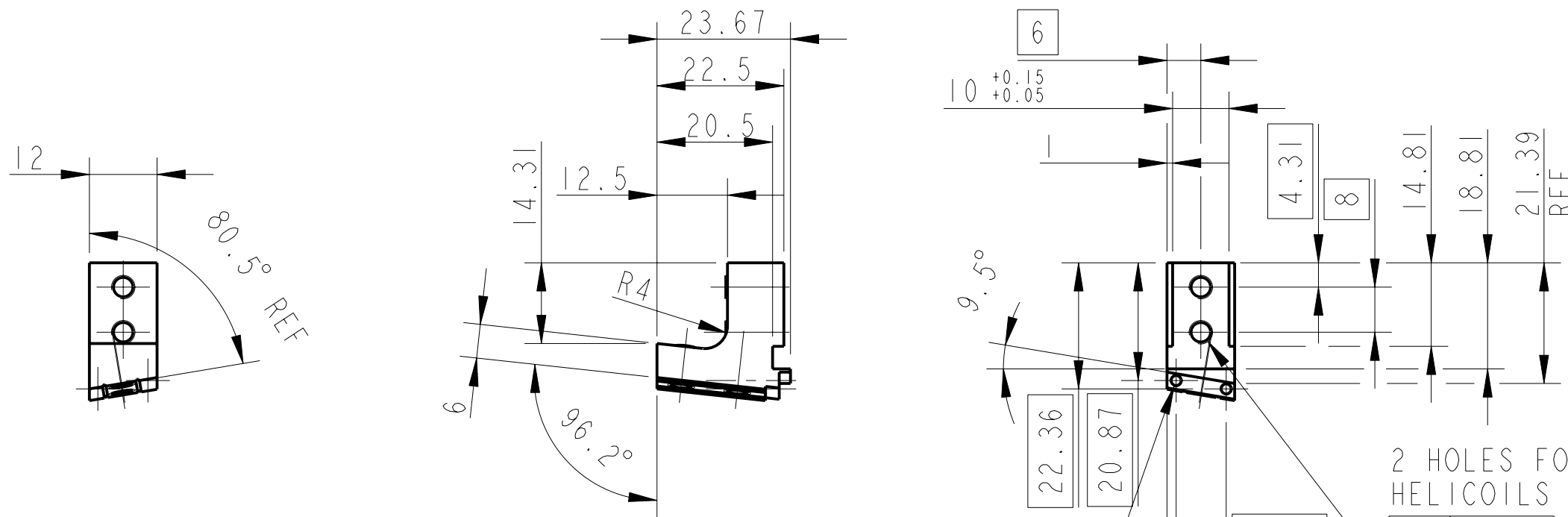


REV.	DATE	DCN #	DRAWING TREE #
A	18/OCT/06	E060247	
B	19/DEC/07	E060247-B	
G	21/JULY/08	E080371	
J	07/JULY/11	E1100648	



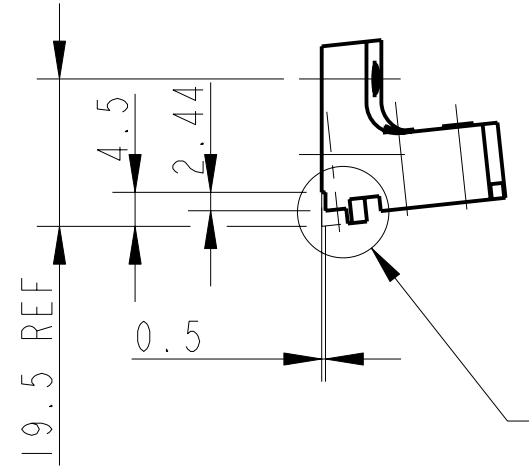
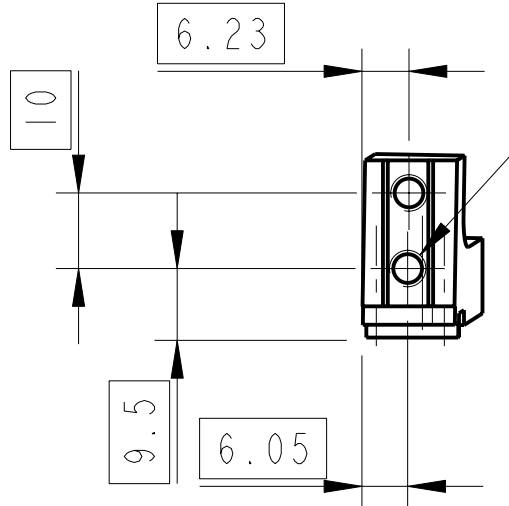
3D VIEW

2 HOLES TAPPED 2-56 UNC X 10DP 0.005 OVERSIZE (ALL RADIAL DIMS OVERSIZE)
 $\text{Ø } 0.2$

PART NO. (SEE NOTES 4&5) TO BE ETCHED OR STAMPED IN APPROX POSITION SHOWN.

2 HOLES FOR 1/4-20 UNC HELICOILS 8 DP, HELICOILS NOT TO BE FITTED
 $\text{Ø } 0.2$

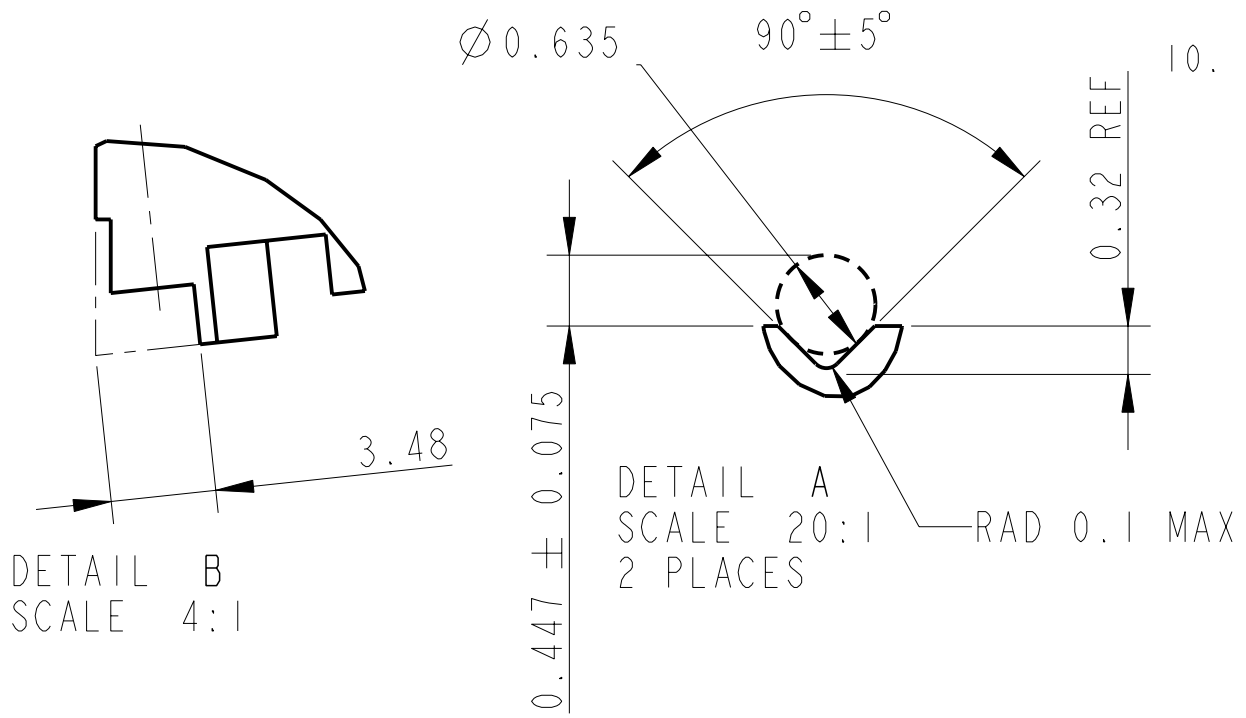
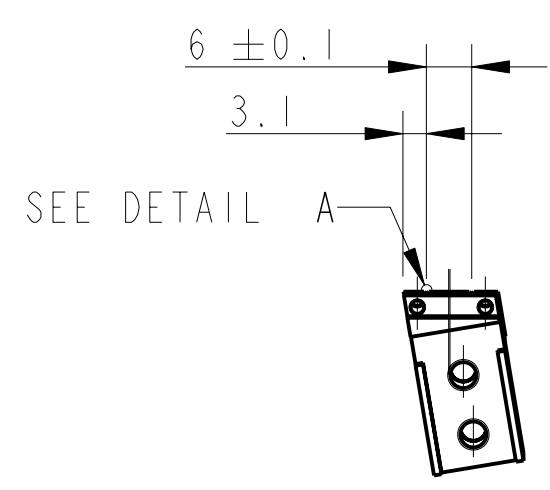
NOTE: THIS HOLE MAY BREAK INTO 8/32 HOLE ON ADJACENT FACE. IF THIS IS THE CASE, REMOVE ANY LOOSE THREADS, AND ENSURE THE BREAK THROUGH IS A CLEAN AND SMOOTH TRANSITION



SEE DETAIL B

ADDITIONAL NOTES:

- START SERIAL NUMBERS FROM 600
- MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- ALL HELICOIL HOLES TO BE PREPARED ACCORDING TO EMHART HELICOIL PRODUCT CATALOG, HC2000, REV 4.
- 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.
- 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 OFFICERS REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.



NOTES: (UNLESS OTHERWISE SPECIFIED)		DIMENSIONS ARE IN mm (INCHES)		TOLERANCES:	
1.	REMOVE ALL SHARP EDGES, R.02 MIN.	X.XX ± mm [INCHES]	ANGULAR ± 0.25°	SYSTEM ADVANCED LIGO	
2.	DO NOT SCALE FROM DRAWING.	MATERIAL: ST. STEEL 304/316	FINISH: CLEAN, GREASE FREE	SUB-SYSTEM SUS	
3.	ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)	Ro = 1.6	SCALE: 1:1	NEXT ASSY QUAD UIM	
4.	SCRIBE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: D020188-001. A VIBRATORY TOOL MAY BE USED.	SCALE: 1:1	PROJECTION:	PART NAME UI MASS WIRE CLAMP BODY	
		DRAWN: J O'DELL 04/JUL/11	CHECKED: J'OD 04/JUL/11	APPROVED: JOD 04/JUL/11	DRG. NO. D060426
					REV J