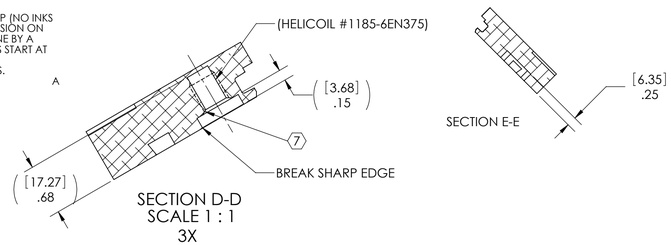
REV.	DATE	DCN #	DRAWING TREE #
v1	23 SEPT 2009	E0900365	
v2	11 NOV 2009	E0900412	
v3	30 NOV 2009	E0900438	

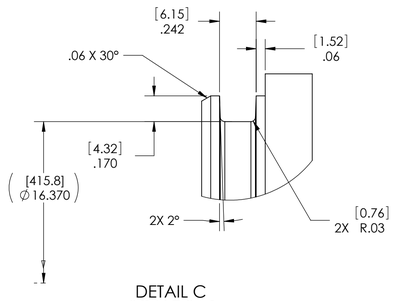
NOTES CONTINUED:

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. VIBRATORY TOOL MAY BE USED.

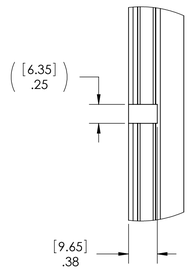
⑥ ENGRAVE "OPTIC ARROW DOWN" 3 PLACES APPROXIMATLEY WHERE SHOWN IN .50 HIGH CHARACTERS.



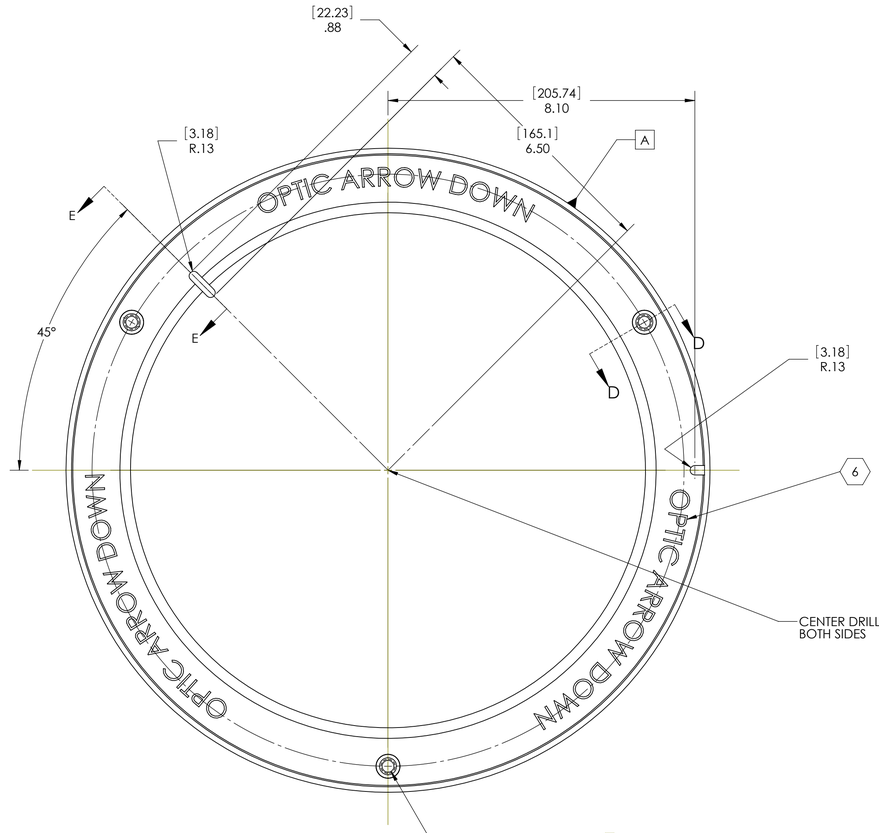
SECTION D-D
SCALE 1 : 1
3X



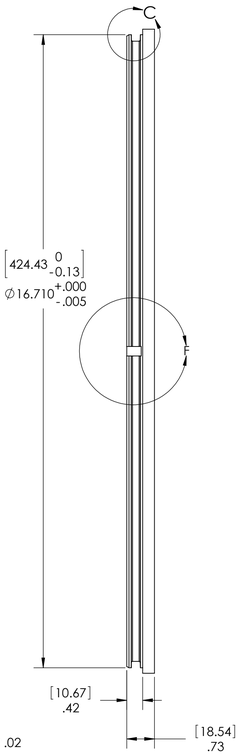
DETAIL C
SCALE 2 : 1

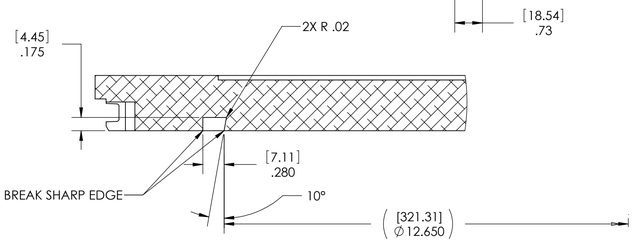


DETAIL F
SCALE 1 : 1

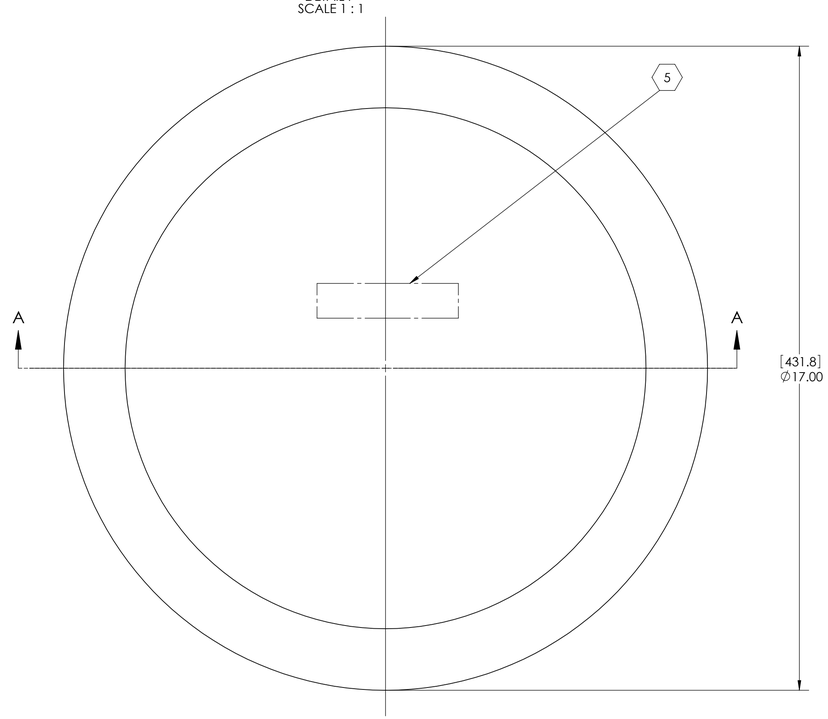


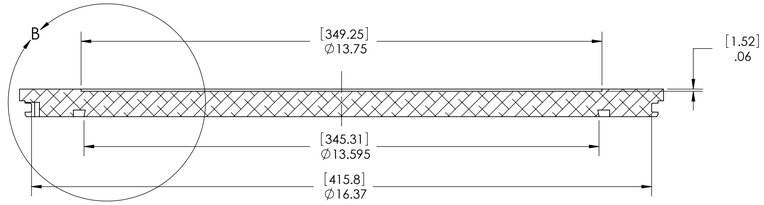
7
3X DRILL ↧ .68
⌴ ∅ .628 ± .003 ↧ .150
TAP FOR 3/8-16 X .440 DEEP FULL THREAD
FOR N60 HELICOIL INSERT #1185-6EN375
EQUALLY SPACED ON A 15.627 ± .005 B.C.
⌖ ∅ .010 A





DETAIL B
SCALE 1 : 1





SECTION A-A

⑦ HELICOIL INSTALLATION:
A) DRILL PILOT HOLE FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELI-COIL PRODUCT CATALOGUE, HC 2000
B) COUNTERSINK HOLE FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELI-COIL PRODUCT
C) TAP HOLE FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELI-COIL PRODUCT CATALOGUE, HC 2000
D) REMOVE ALL CHIPS
E) GAGE THREADS WITH GAGE TOOL FOR INSERT SPECIFIED IN DRAWING, , REFERENCE HELI-COIL PRODUCT CATALOGUE, HC 2000
F) CLEAN THE HOLE, INSERTING TOOL AND HELI-COIL WITH SOAP AND WATER
G) CLEAN THE HELI-COIL AND INSERT TOOL IN ACETONE (IF THE INSERT TOOL HAS ANY PLASTIC USE ISOPROPYL ALCOHOL INSTEAD OF ACETONE TO CLEAN THE INSERT TOOL)
H) CLEAN THE HOLE WITH ACETONE AND A STAINLESS STEEL WIRE BRUSH
I) RINSE THE HELI-COIL, INSERTING TOOL AND THE HOLE WITH DE-IONIZED WATER
J) POWDER FREE LATEX GLOVES MUST BE WORN WHEN INSERTING THE HELI-COILS. (LATEX GLOVES FROM ANSELL EDMONT, ACCUTECH-ULTRA CLEAN 91-300)
K) INSERT THE HELI-COIL WITH TOOL TO ¾ TO 1½ PITCH BELOW SURFACE
L) BREAK OFF AND REMOVE TANG
M) ONCE HELI-COILS HAVE BEEN INSERTED AND FINAL ASSEMBLY IS BEING CARRIED OUT, FOR EXAMPLE, INSERTING THE O-RINGS PLEASE KEEP THE ASSEMBLIES AS CLEAN AS POSSIBLE I.E. FREE FROM OIL, GREASE, DIRT, AND

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)					
DIMENSIONS ARE IN INCHES [MM] TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°	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.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
	MATERIAL: 6061-T6 Al	FINISH: 63 µinch	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: COC	NEXT ASSY: D0902120

PART NAME: BASE PLATE, FM, COC OPTIC CONTAINER					
DESIGNER	K. BUCKLAND	23 SEPT 2009	SIZE: D	DWG. NO.: D0902121	REV.: v3
DRAFTER	K. BUCKLAND	23 SEPT 2009			
CHECKER	K. MAILAND	8 OCT 2009			
APPROVAL	C. TORRIE	8 OCT 2009	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1

D0902121 BASE PLATE, FM, COC CONTAINER, ADVANCED LIGO, PART PDM REV= X-007, DRAWING PDM REV= X-011