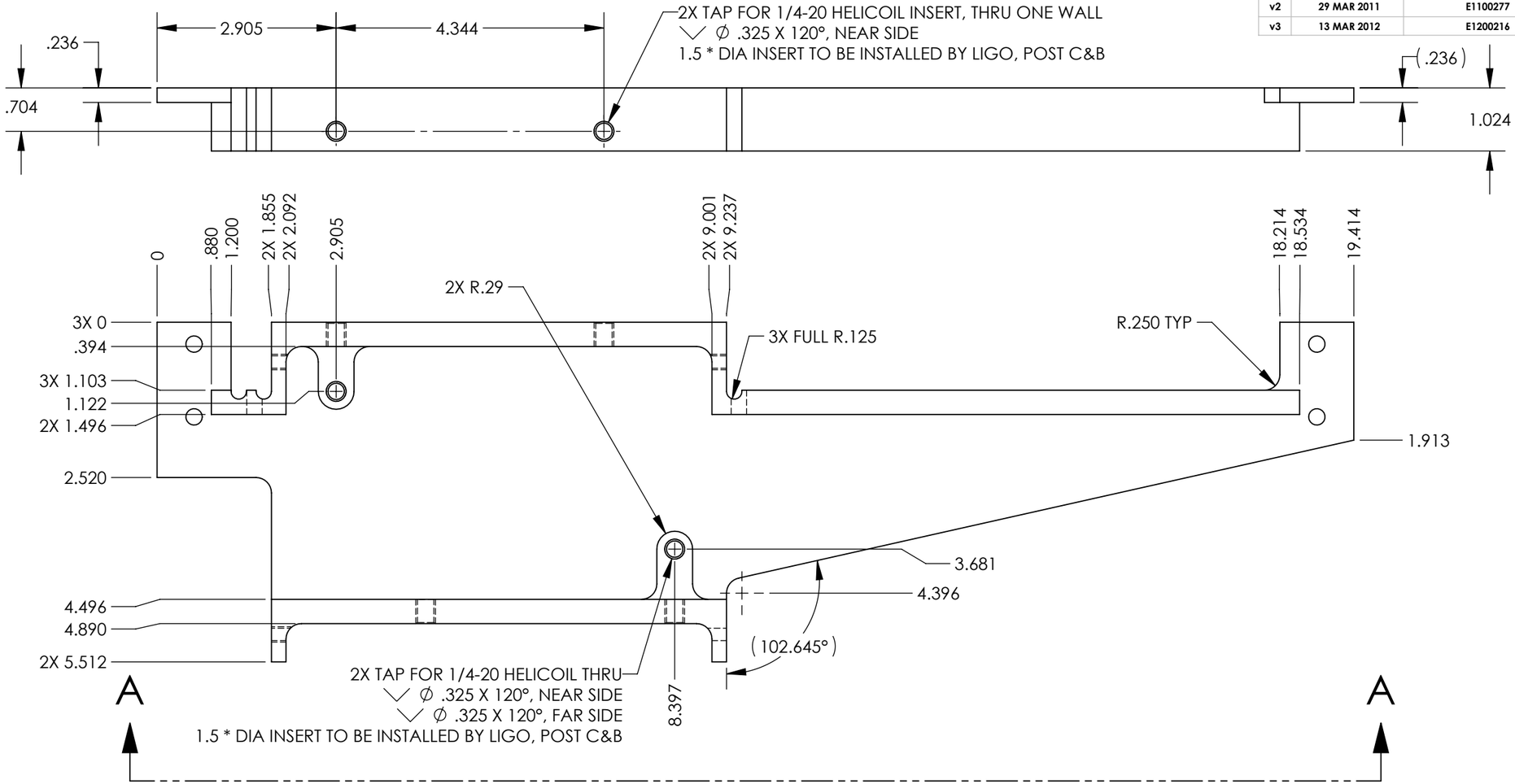
REV.	DATE	DCN #	DRAWING TREE #
v1	29 JUN 2010	E1000234	
v2	29 MAR 2011	E1100277	
v3	13 MAR 2012	E1200216	



NOTES (CONTINUED):

4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE, PER LIGO SPECIFICATION E0900237.

(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. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXXX-VY, TYPE-XX, S/N XXX.

6. MASS: 1.013 KG [2.234 LB].

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364.

8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL HELI-COIL TAPPED HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG HC2000.

10. ALL HELICOIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NOT WELD REPAIRS OR PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING BY LIGO LABBORATORY. REFER TO LIGO-E0900364.

(12) ALL TAPPED HOLES (HELI-COIL EXCLUDED): USE 0.005 OVERSIZE BOTH DRILL & TAP.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± 0.1°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015.
3. DO NOT SCALE FROM DRAWING.

MATERIAL: 6061-T6 Al

FINISH: 63 µinch Ra

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO

SUB-SYSTEM: AOS

NEXT ASSY: D1000549

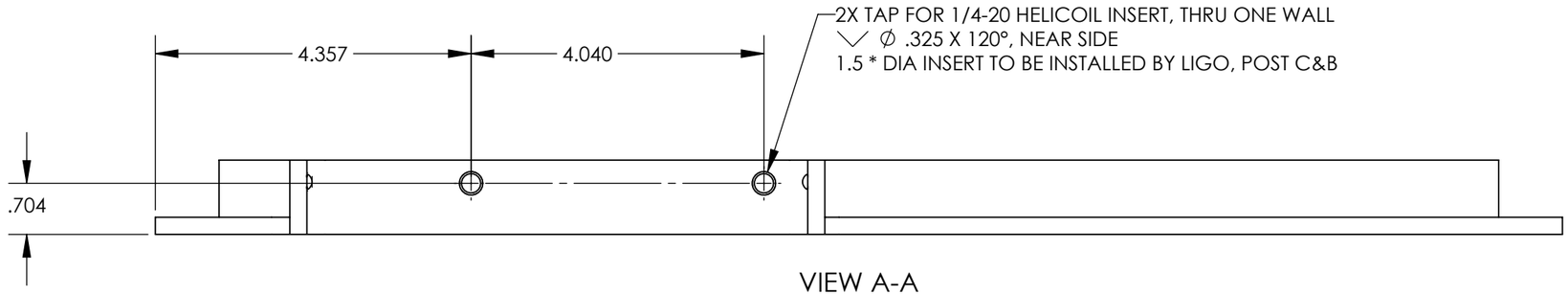
PART NAME: aLIGO OSUMS INTERMIDIATE SUPPORT RIGHT SIDE BRACKET

DESIGNER	K. MAILAND	23 FEB 2010
DRAFTER	I ROMERO	07 JUN 2010
CHECKER	SEE DCN	
APPROVAL	SEE DCN	

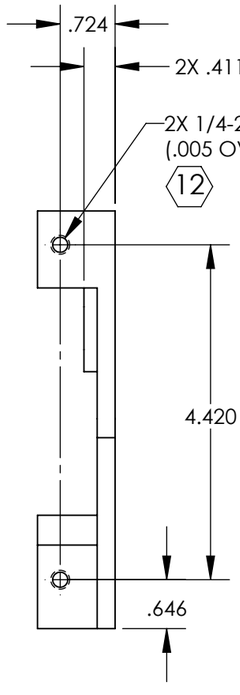
SIZE: B — DWG. NO.: D1000407 — REV.: v3

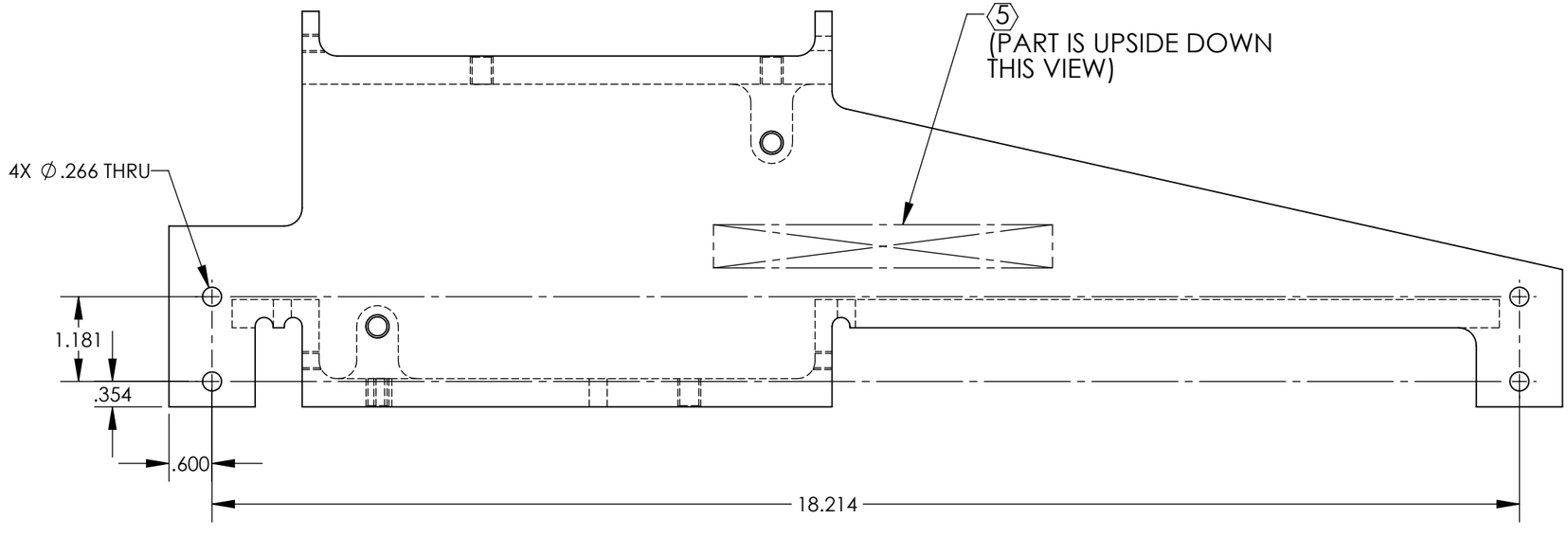
SCALE: NONE — PROJECTION: — SHEET 1 OF 3

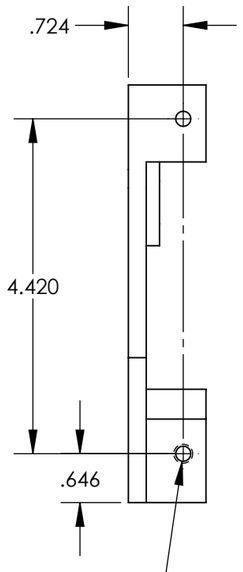
D1000407 aLIGO_OSUMS_INTERMIDIATE_SUPPORT_RIGHT_SIDE_BRACKET, PART PDM REV: X-039, DRAWING PDM REV: X-039



VIEW A-A







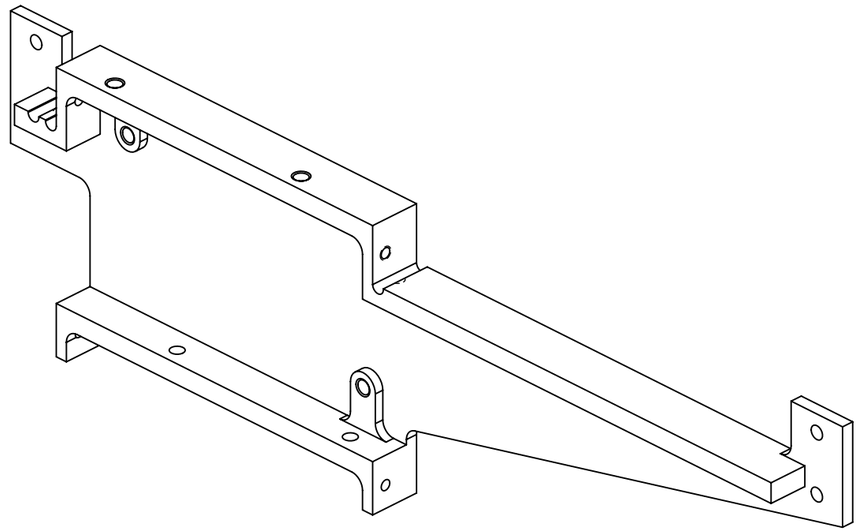
2X 1/4-20 UNC - 2B, H11, THRU NEXT
(.005 OVERSIZE BOTH DRILL & TAP)
12

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

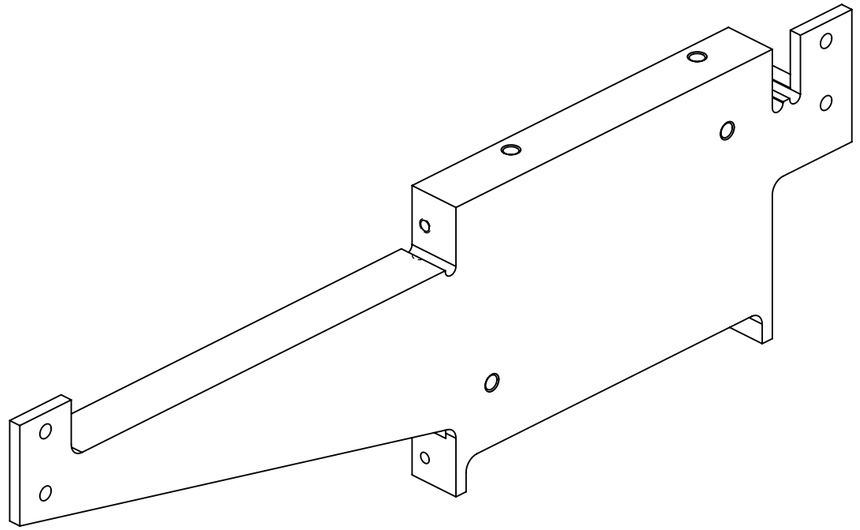
SIZE	DWG. NO.	REV.
B	D1000407	v3

SCALE:NONE PROJECTION: SHEET 2 OF 3

D1000407 GLIGO_OSUMS_INTERMIDIATE_SUPPORT_RIGHT_SIDE_BRACKET, PART PDM REV: X-089, DRAWING PDM REV: X-039



INSIDE ISO VIEW



OUTSIDE ISO VIEW

D1000407 aLIGO_OSUMS_INTERMIDIATE_SUPPORT_RIGHT_SIDE_BRACKET, PART PDM REV: X-089, DRAWING PDM REV: X-039

LIGO	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE B	DWG. NO. D1000407	REV. v3	
SCALE:NONE	PROJECTION:	SHEET 3 OF 3	