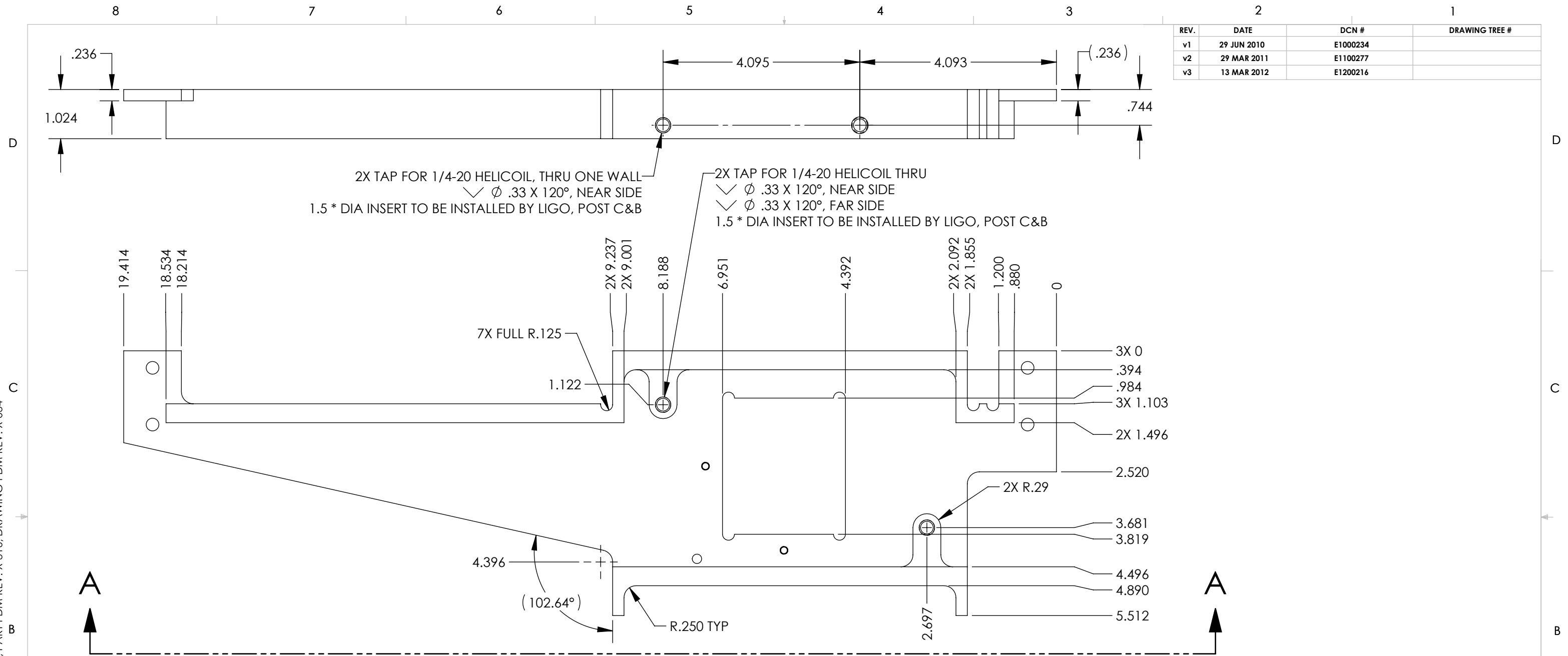


D1000408 qLIGO_OSUMS_INTERMEDIATE_SUPPORT_LEFT_SIDE_BRACKET, PART PDM REV: X-316, DRAWING PDM REV: X-034

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: 0.886 KG [1.953 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 LABORATORY. REFER TO LIGO-E0900364.
12. ALL TAPPED HOLES (HELI-COIL EXCLUDED): USE 0.005 OVERSIZE BOTH DRILL & TAP.

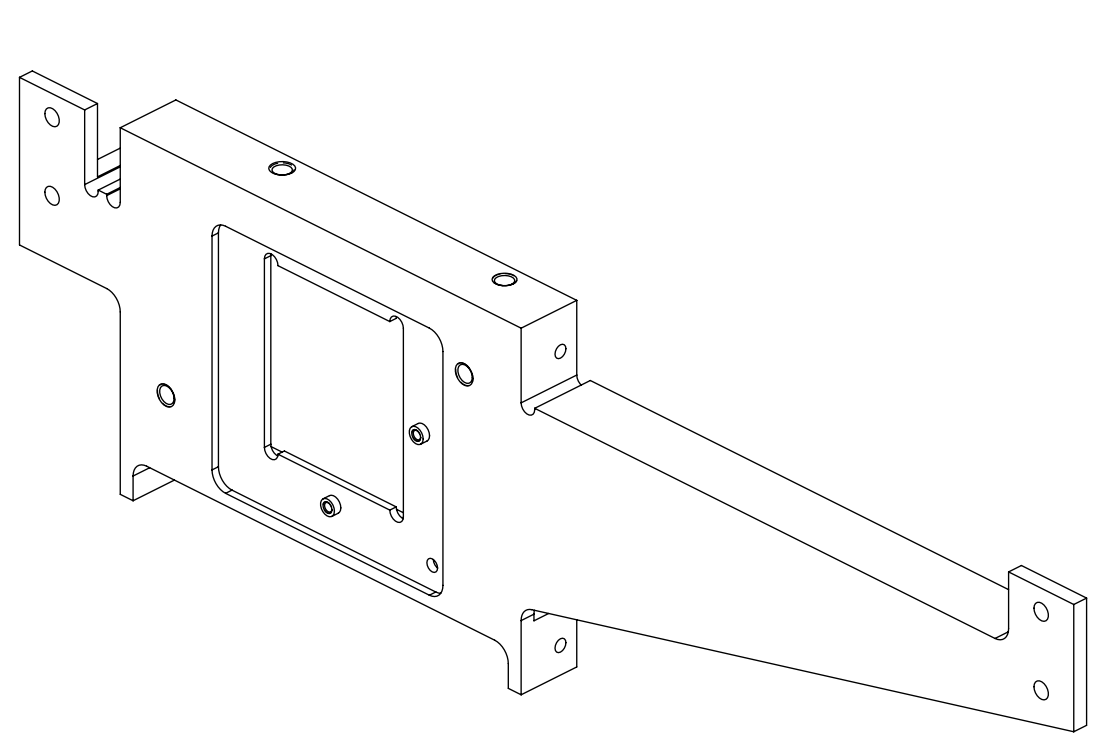
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		
DIMENSIONS ARE IN INCHES		
TOLERANCES: .XX ± .01 .XXX ± .005		
ANGULAR ± 1.0°		
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. 3. DO NOT SCALE FROM DRAWING.		
MATERIAL	6061-T6 Al	FINISH 63 µinch Ra

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME qLIGO OSUMS INTERMEDIATE SUPPORT LEFT SIDE BRACKET	
SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS	DESIGNER K. MAILLAND	23 FEB 2010
CHECKER SEE DCN	APPROVAL SEE DCN	SIZE B	DWG. NO. D1000408
NEXT ASSY D1000549		SCALE: NONE	PROJECTION:
		REV. v3	SHEET 1 OF 3

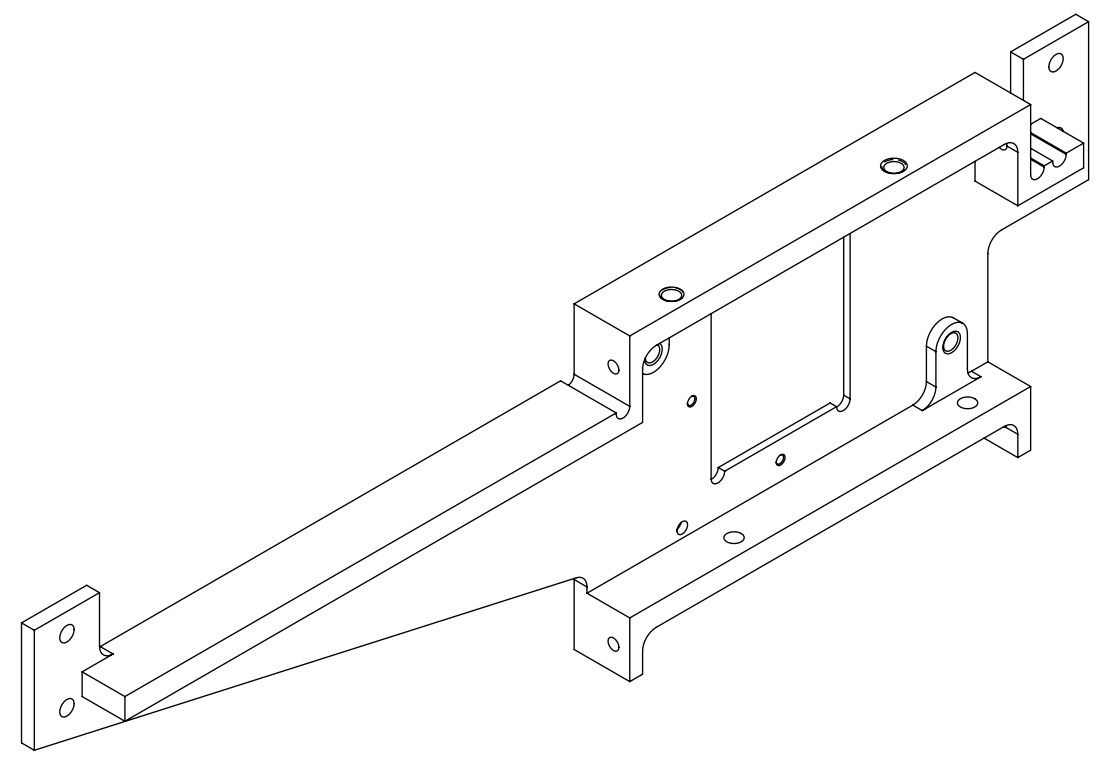
D1000408 dLIGO_OSUMS_INTERMEDIATE_SUPPORT_LEFT_SIDE_BRACKET, PART PDM REV: X-316, DRAWING PDM REV: X-034

8 7 6 5 4 3 2 1

D
C
B
A





INSIDE ISO VIEW



OUTSIDE ISO VIEW

8 7 6 5 4 3 2 1

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE B	DWG. NO. D1000408	REV. v3
SCALE: 1:8	PROJECTION: 	SHEET 3 OF 3