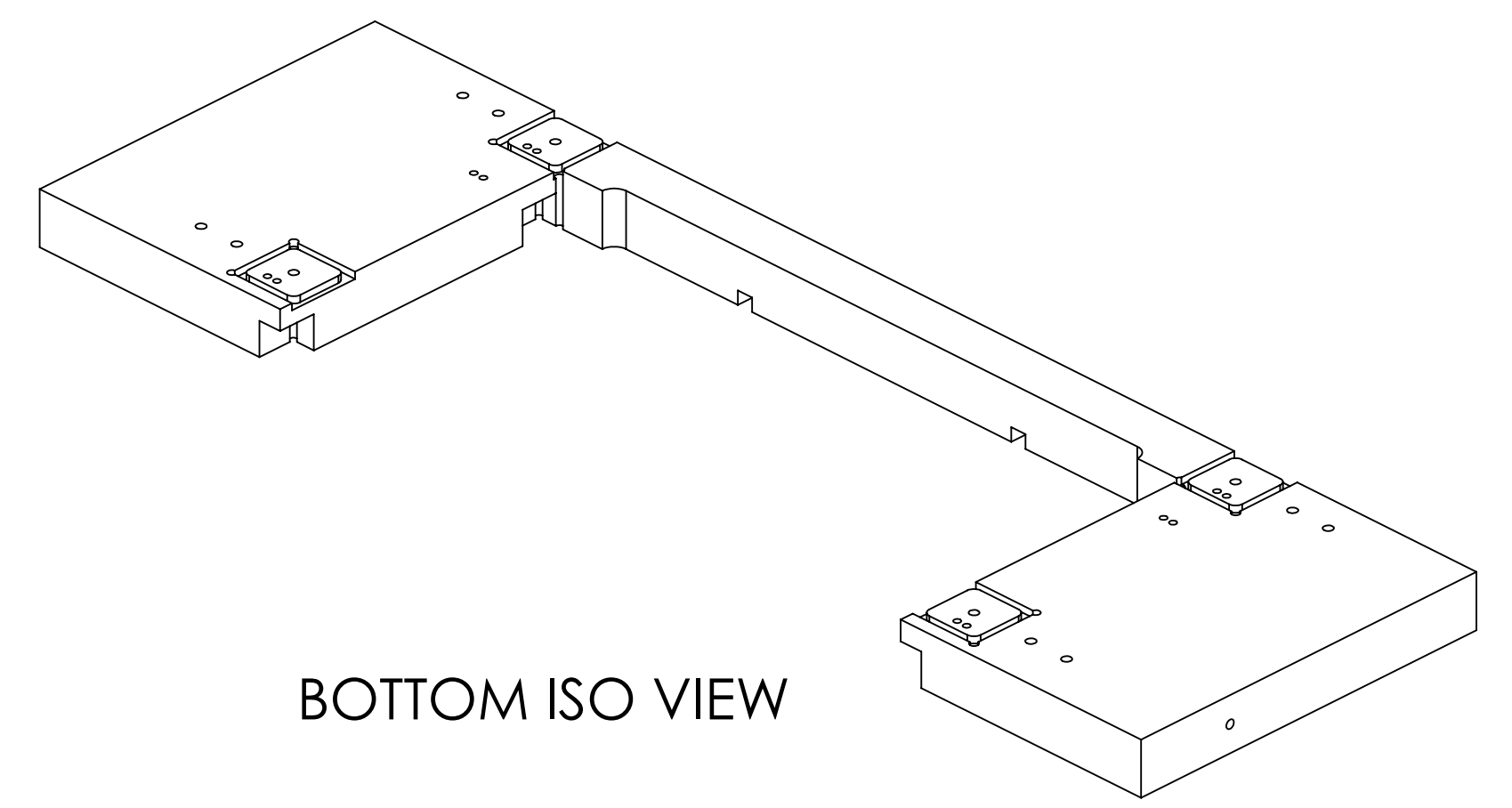
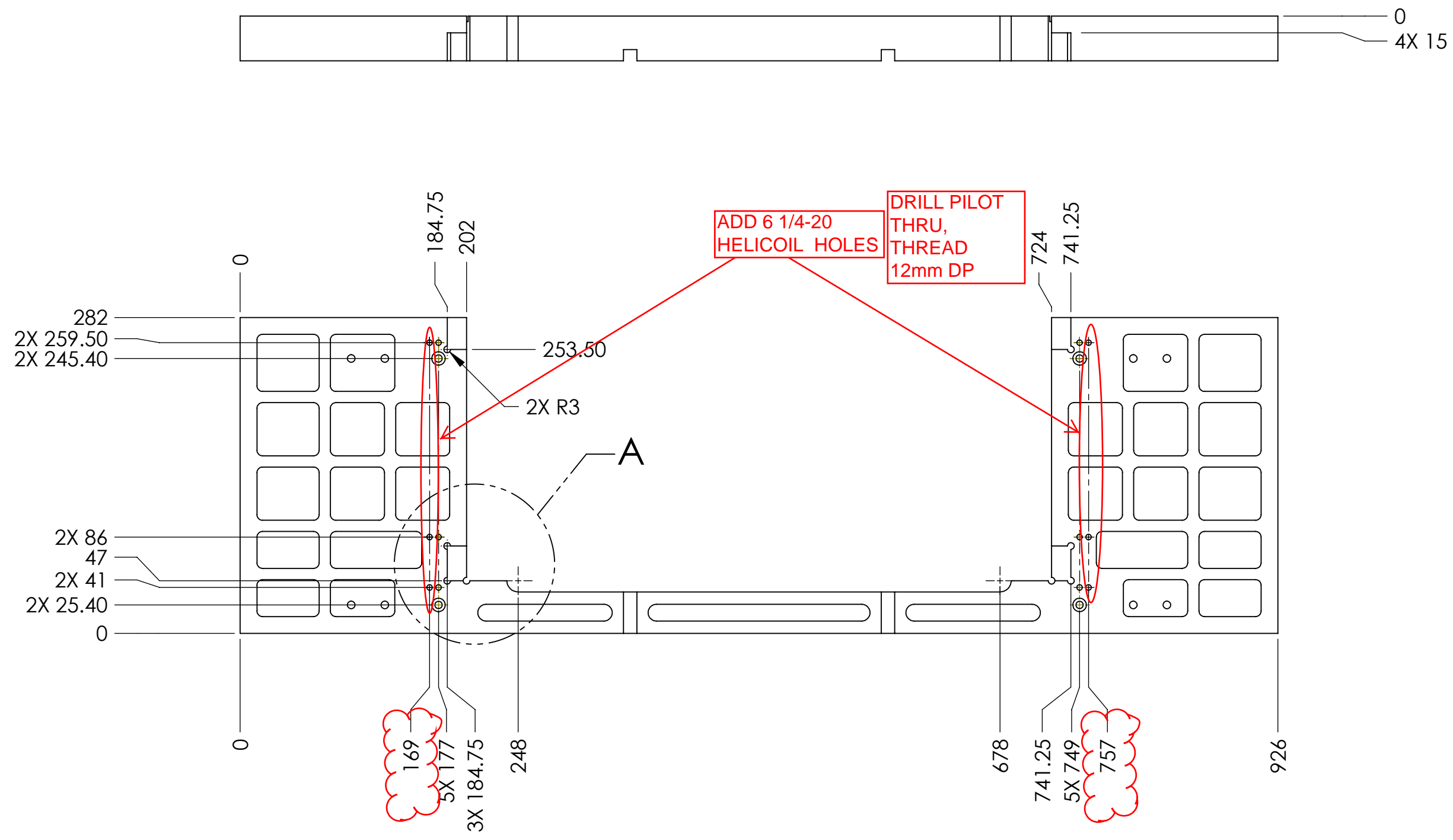
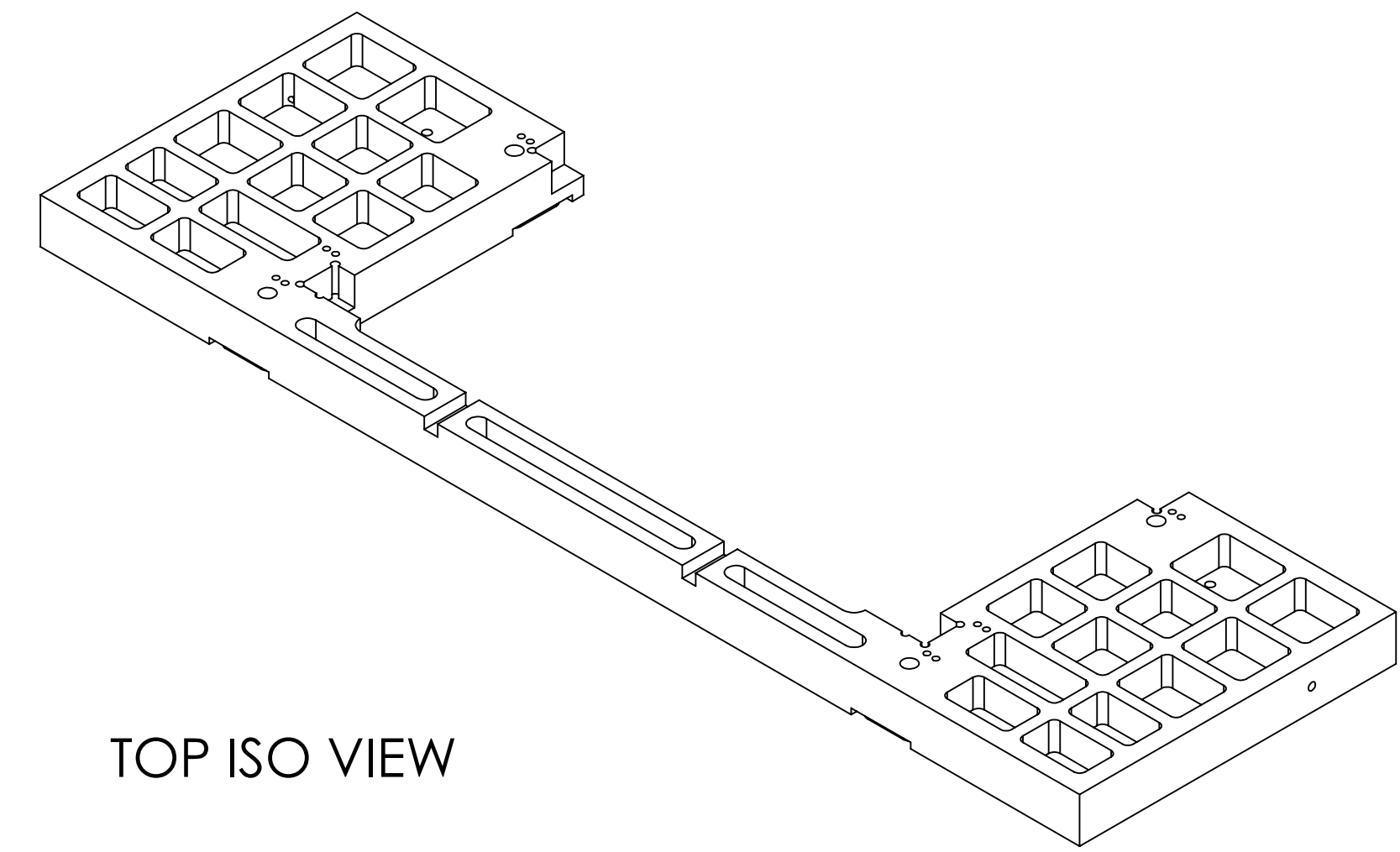
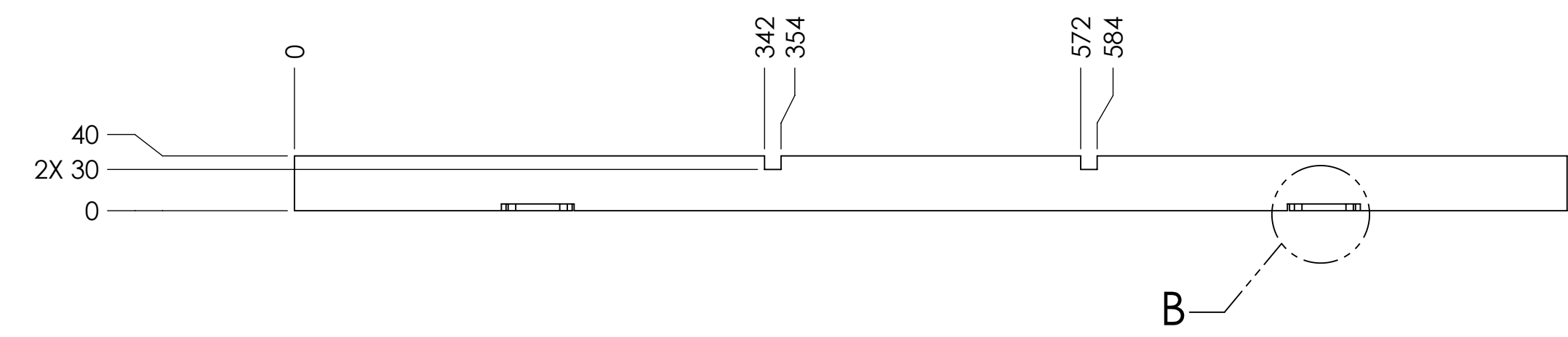


- NOTES CONTINUED:
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
 6. APPROXIMATE WEIGHT = 21.91 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 HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
 10. ALL HELI-COIL 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. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
 12. UNDIMENSIONED FEATURES ARE CONTROLLED BY THE SOLIDWORKS MODEL AND HAVE A TOLERANCE OF $\pm .25\text{mm}$.

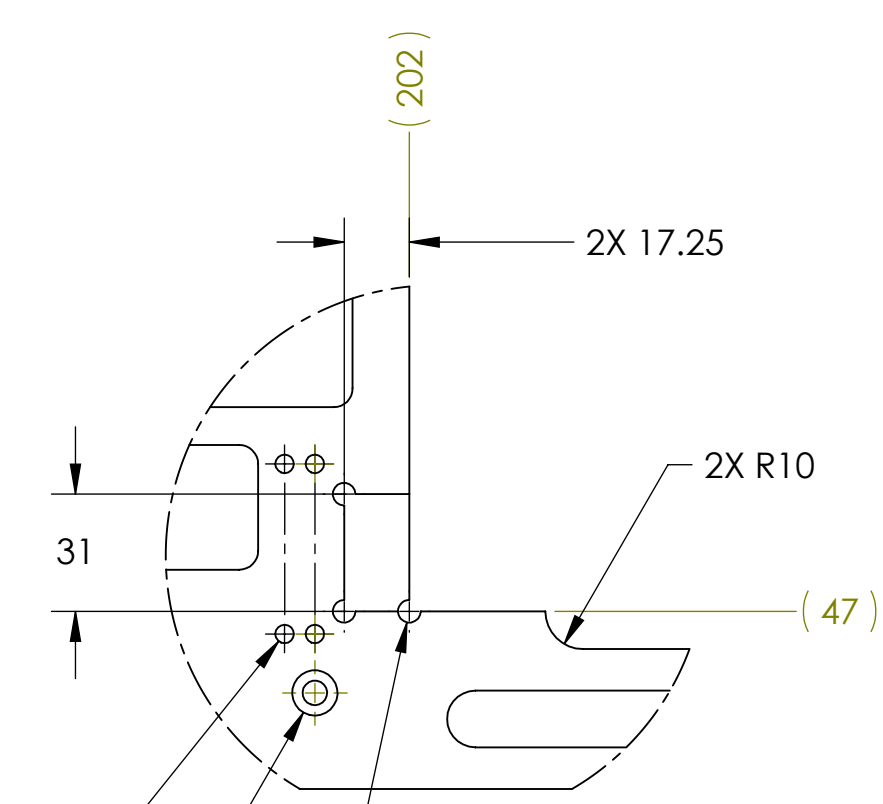
REV.	DATE	DCN #	DRAWING TREE #
v1	24 MAY 2010		
v2	16 JUL 2010		
v3	17 OCT 2011	E1101036	



BOTTOM ISO VIEW



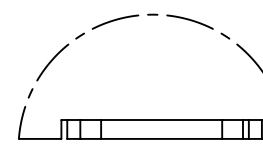
TOP ISO VIEW



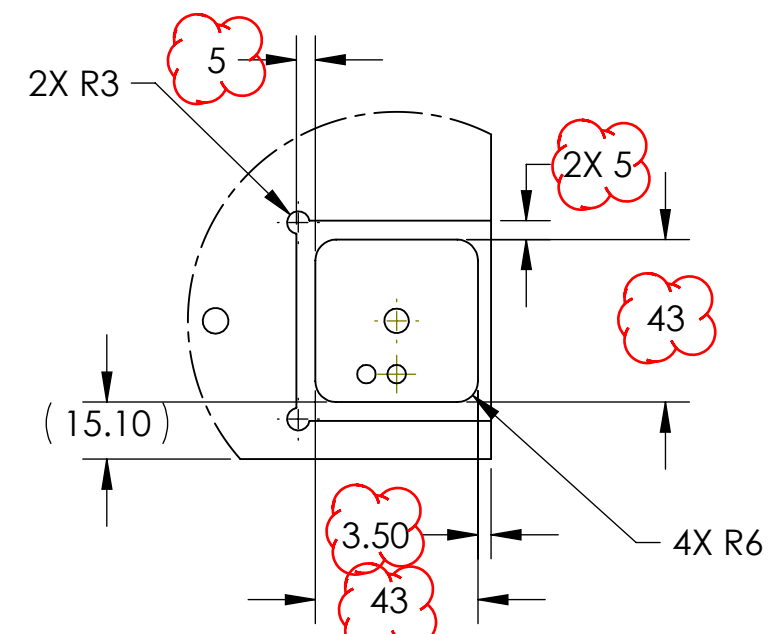
12X DRILL AND TAP FOR 1/4-20 N60 HELICOIL INSERT #1185-4EN500

DETAIL A SCALE 1 : 2 2 PLACES

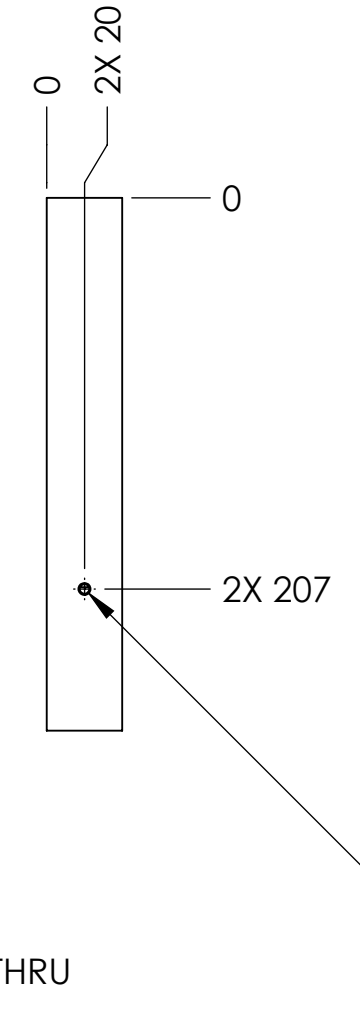
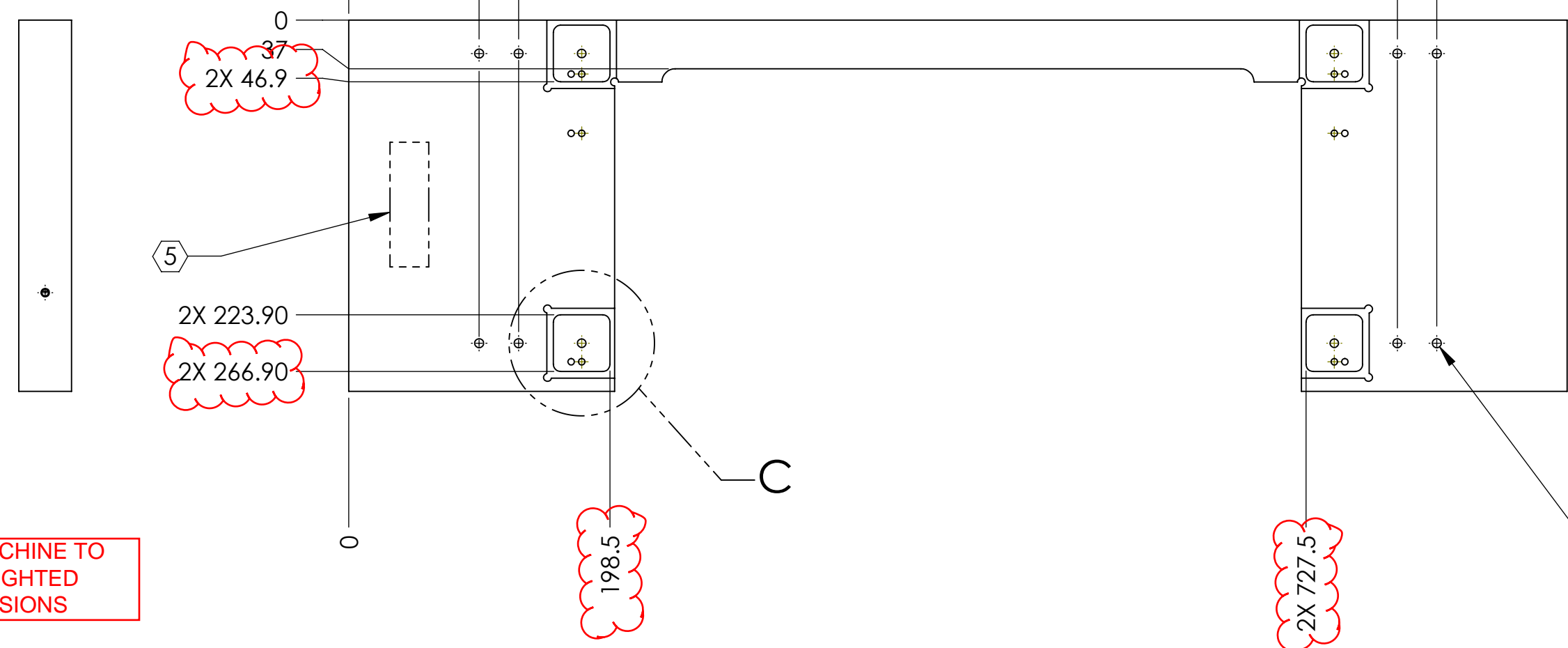
4X $\phi 6.50$ THRU $\phi 12 \nabla 20$



DETAIL B SCALE 1 : 2



RE-MACHINE TO HIGHLIGHTED DIMENSIONS



DRILL AND TAP FOR 1/4-20 N60 HELICOIL INSERT #1185-4EN250 BOTH ENDS

v2 TO v3 CHANGES

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 MILLIMETERS

TOLERANCES:
.X $\pm .3$
.XX $\pm .13$

ANGULAR $\pm .5^\circ$

MATERIAL	6061-T6 Al	FINISH	32 μ inch
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CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM	ADVANCED LIGO	SUB-SYSTEM	SUS
NEXT ASSY	D1001221		

PART NAME		LSAT TOP PLATE - LARGE	
DESIGNER	LOLMOS	DATE	19 MAY 2010
DRAFTER	K. BUCKLAND	DATE	24 MAY 2010
CHECKER	C. TORRIE	DATE	24 MAY 2010
APPROVAL		SCALE	1:4

SIZE	D	DWG. NO.	D1001222	REV.	v3
SHEET 1 OF 1		PROJECTION:			

D1001222.LSAT TOP PLATE - LARGE.dwg: 3/15/11 PART PDM REV: X-012 DRAWING PDM REV: X-005