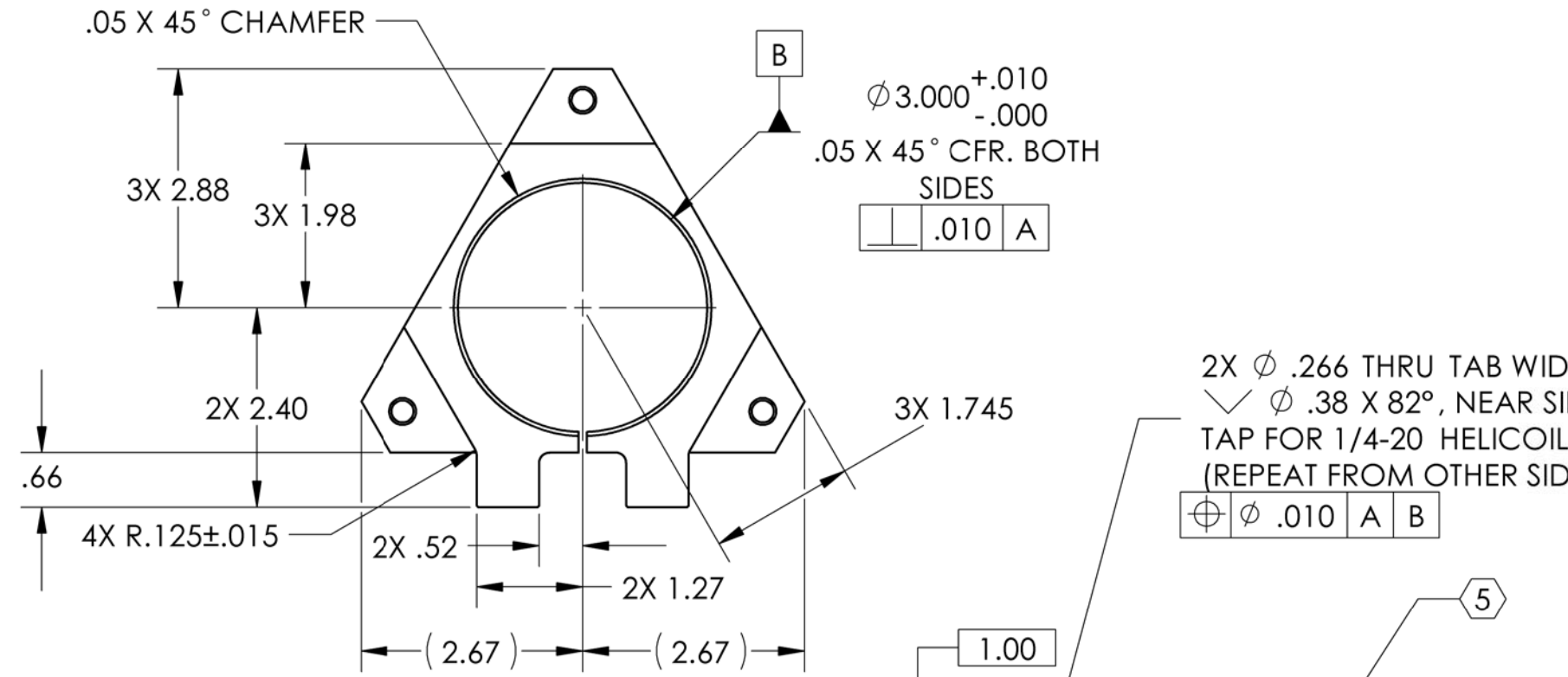
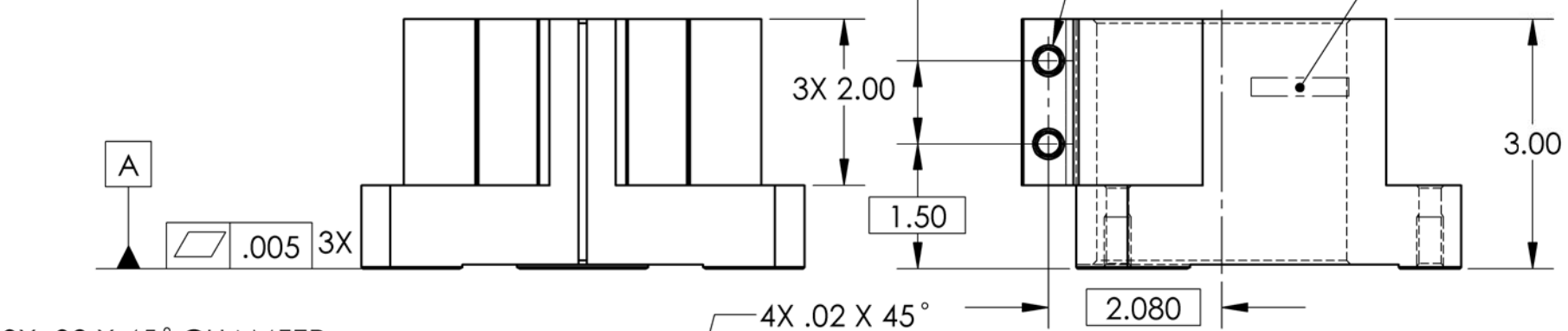
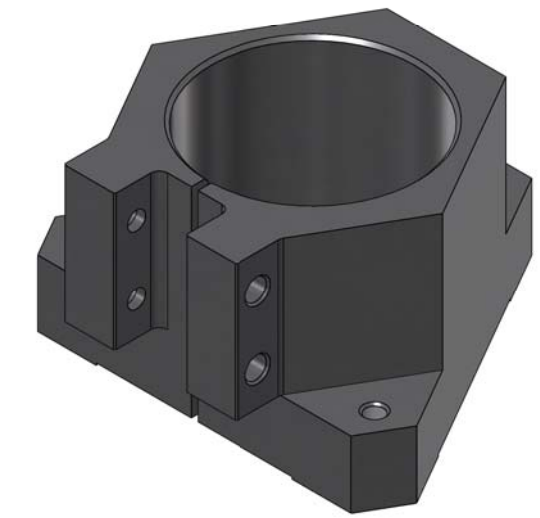


REV.	DATE	DCN #	DRAWING TREE #
v4	9 Mar. 2011	E1100015	E1100016



$\phi 3.000^{+.010}_{-.000}$   
 .05 X 45° CFR. BOTH SIDES  
 .010 A

2X  $\phi .266$  THRU TAB WIDTH  
 $\checkmark \phi .38 \times 82^\circ$ , NEAR SIDE  
 TAP FOR 1/4-20 HELICOIL INSERT = 2.0 \* DIA.  
 (REPEAT FROM OTHER SIDE, FOR OTHER TAB)  
 $\phi .010$  A B



3X .02 X 45° CHAMFER ALL AROUND PADS  
 3X 60.0°  
 4X .02 X 45° CHAMFER

3X  $\phi .266$  THRU  
 $\checkmark \phi .38 \times 82^\circ$ , NEAR SIDE  
 TAP FOR 1/4-20 HELICOIL INSERT = 2.0 \* DIA.  
 $\checkmark \phi .33 \times 82^\circ$ , FAR SIDE  
 $\phi .005$  A B

NOTES CONTINUED:

- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
- SCRIBE, ENGRAVE, 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.
- APPROXIMATE WEIGHT = 1.84 LB.
- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
- ALL HELI-COIL TAPPED HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG HC2000 CURRENT REV.
- BLACK ANODIZE PER MIL-A-8625, TYPE II, CLASS 2 (NO SALT SPRAY CERTIFICATION REQUIRED).
- USE (3) 1/4-20 HELICOIL INSERTS SHOWN IN BOTTOM VIEW (B-5) ONLY FOR HORIZONTAL L-4C'S.
- ONLY INSERT (2) 1/4-20 HELICOIL INSERTS (D-5) IN 1 OF THE 2 TABS. CHOICE OF TAB DEPENDS ON SCREW ACCESS AFTER ASSEMBLY IN D030326, FOR LEFT OR RIGHT CONFIG. REFER TO ASSEMBLY DRAWING FOR FURTHER DETAIL.

D030586 HEPI L4-C MOUNT, PART PDM REV: X-004, DRAWING PDM REV: X-002

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		HEPI L4-C Mount	
TOLERANCES: .XX ± .015 .XXX ± .005				SUB-SYSTEM SEI		DESIGNER	M. HAMMOND 15 Apr. 2009
ANGULAR ± .5°				MATERIAL 6061-T6 Al		DRAFTER	M. HILLARD 9 Mar. 2011
				FINISH 63 μinch		CHECKER	A. STEIN 19 July 2010
				NEXT ASSY D1100145, D1100147 D1100305, D1100306		APPROVAL	K. MASON 9 Mar. 2011
						SIZE	DWG. NO. B D030586
						SCALE	1:2
						PROJECTION	AS SHOWN
						SHEET	1 OF 1
						REV.	v4