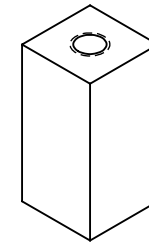
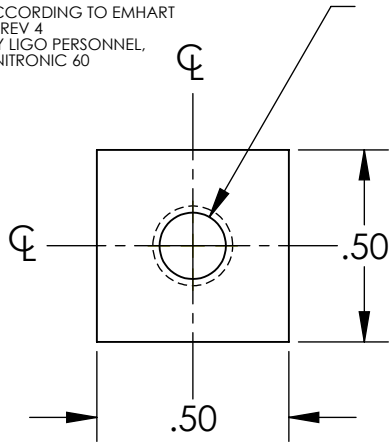


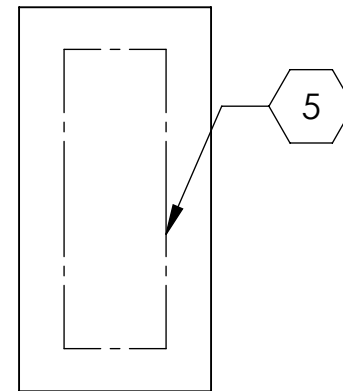
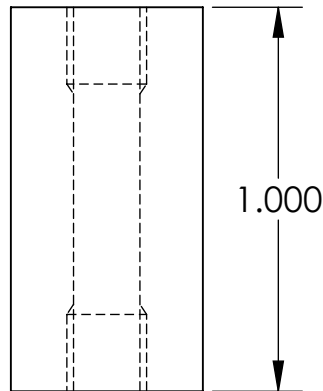
NOTES CONTINUED:

- 5. 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 101 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: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. APPROXIMATE WEIGHT = 0.068 LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 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.

DRILL AND TAP FOR
#8-32 UNC-2B X 1.5 DIA
EMHART HELICOIL
(P/N 1185-2EN246)
BOTH SIDES



ISOMETRIC VIEW



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:

.XX ± .03
.XXX ± .005

ANGULAR ± 0.2°

- 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.

MATERIAL 304, 316 OR 302 SSSL **FINISH** 63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM **ADVANCED LIGO** SUB-SYSTEM **SUS**

NEXT ASSY **D1002440**

PART NAME UPPER BLADE BAKING FIXTURE STANDOFF, HSTS

DESIGNER B. MOORE	16 SEP 2010	SIZE DWG. NO.	D1002444	REV.
DRAFTER B. MOORE	17 SEP 2010	A		v1
CHECKER M. MEYER	20 SEP 2010	SCALE: 2:1		PROJECTION:
APPROVAL				SHEET 1 OF 1