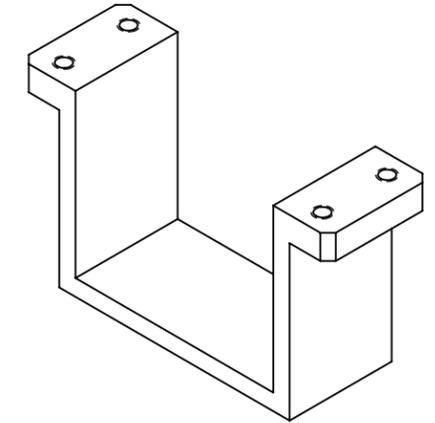
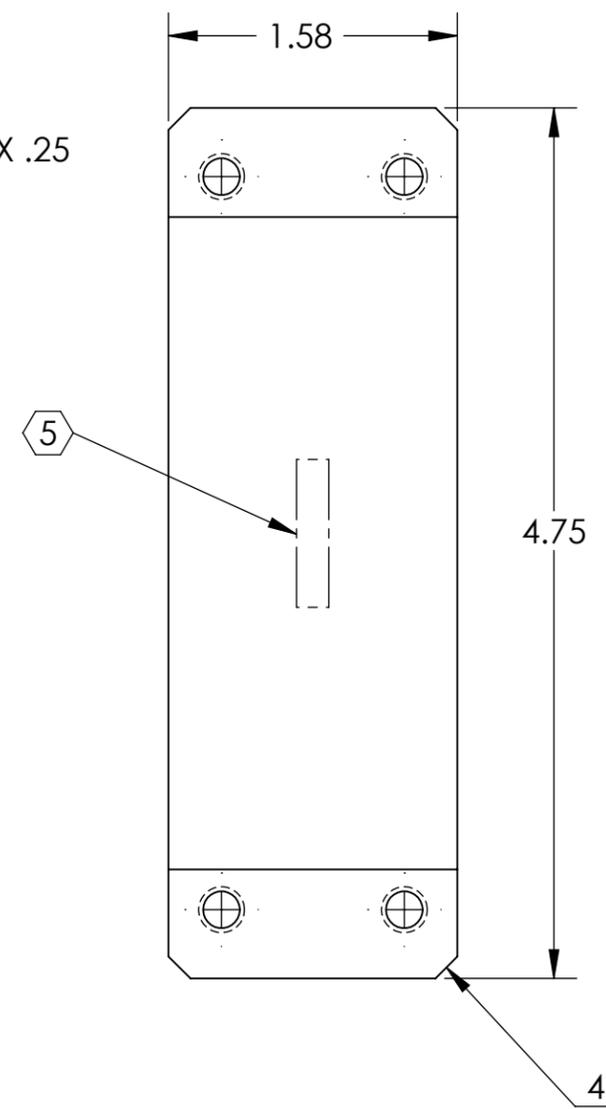
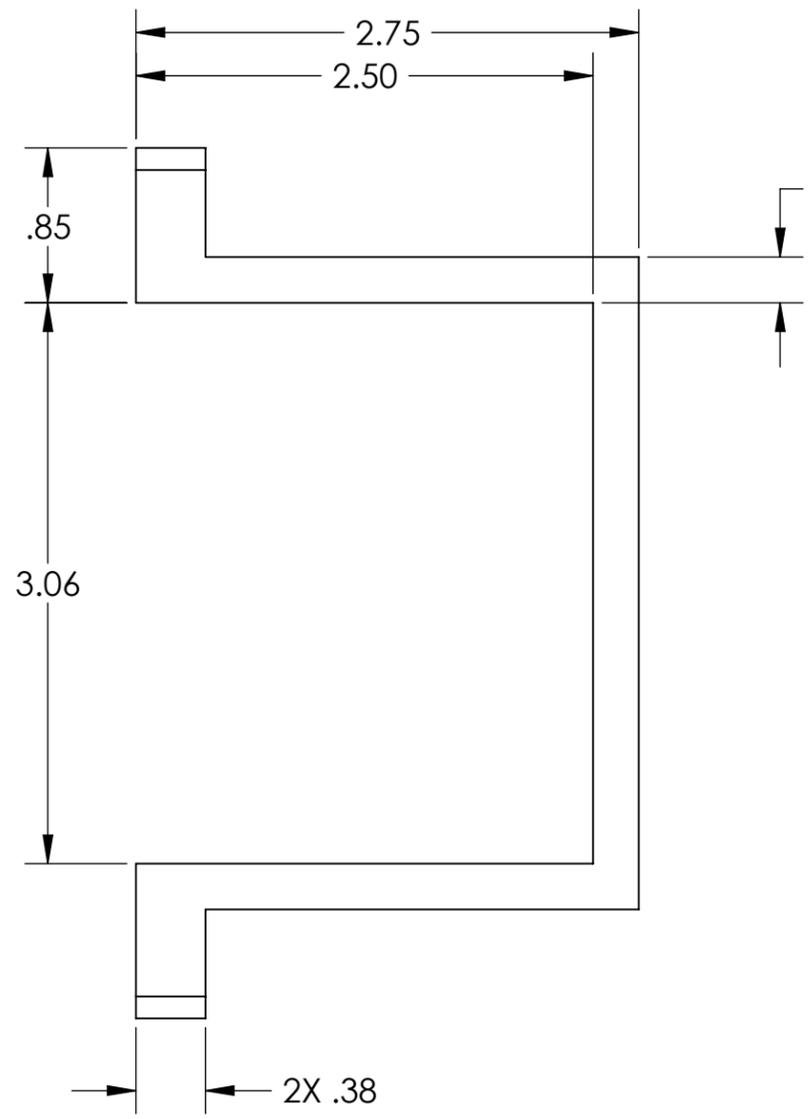
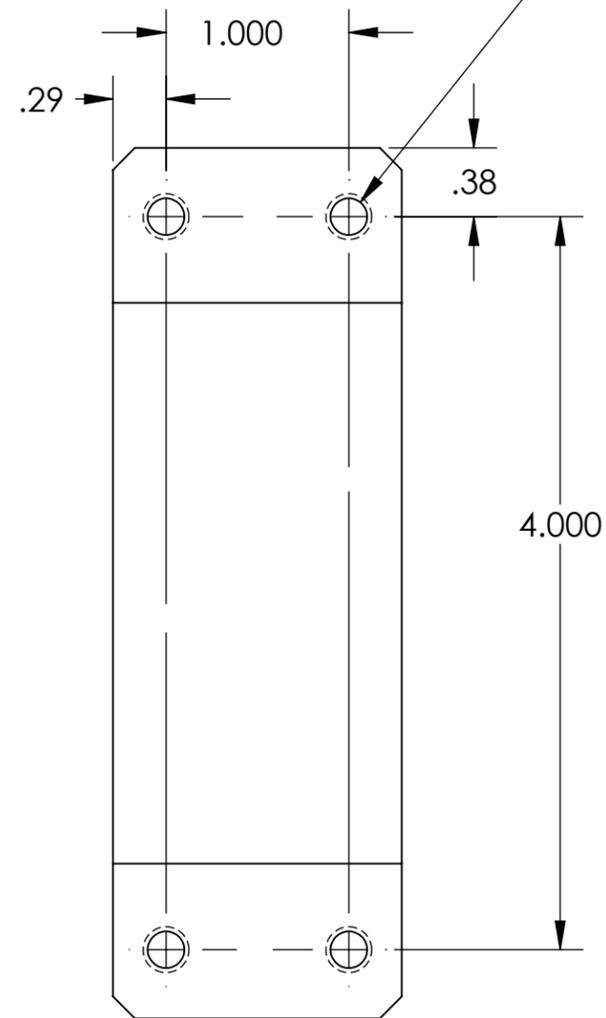


**NOTES CONTINUED:**  
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.  
 EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

REV.	DATE	DCN #	DRAWING TREE #
V1	6 OCT 2010	E1000493	

6. APPROXIMATE WEIGHT = X.XXX 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.

4X 1/4-20 UNC THRU  
 +.005 OVERSIZE TAP



D1002597 QUGO, SUS, UPPER QUAD VIBRATION ABSORBER CLAMP, PART PDM REV: X-000, DRAWING PDM REV: X-004

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°				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.		CLAMP, VIBRATION ABSORBER, UPPER QUAD	
MATERIAL		FINISH		SYSTEM		SUB-SYSTEM	
6061-T6 Al		63 μinch		ADVANCED LIGO		SUS	
NEXT ASSY				DESIGNER		DATE	
D1002424				K. BUCKLAND		6 OCT 2010	
APPROVAL				DRAFTER		DATE	
				K. BUCKLAND		6 OCT 2010	
				CHECKER			
				APPROVAL			
				SIZE		DWG. NO.	
				B		D1002597	
				SCALE: 1:1		PROJECTION:	
						SHEET 1 OF 1	