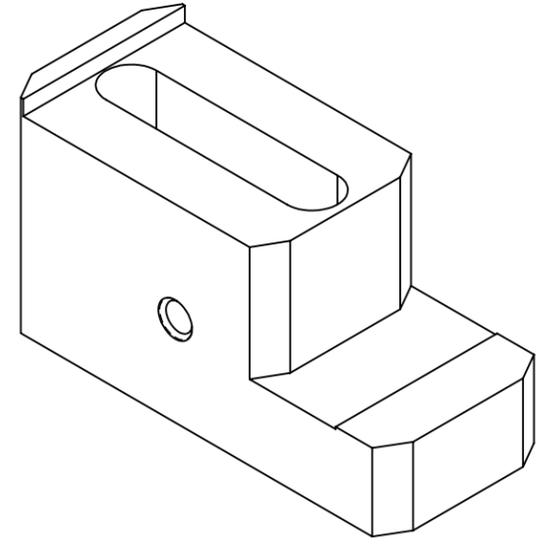
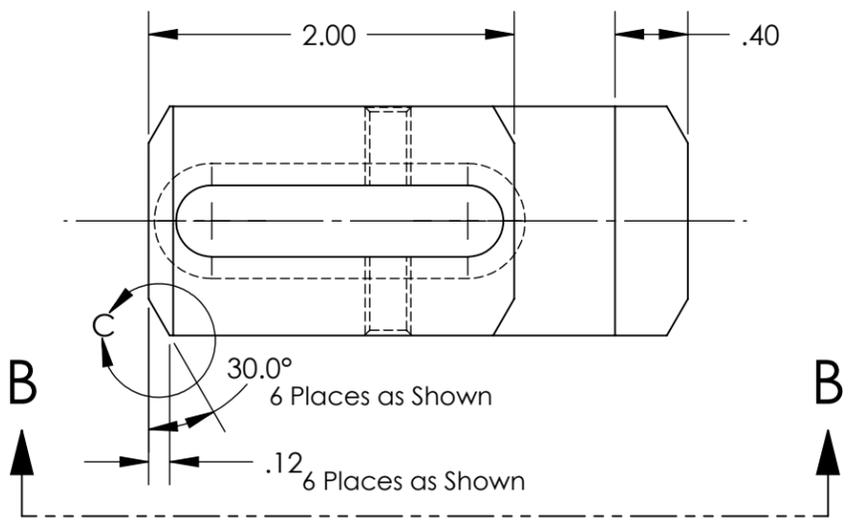


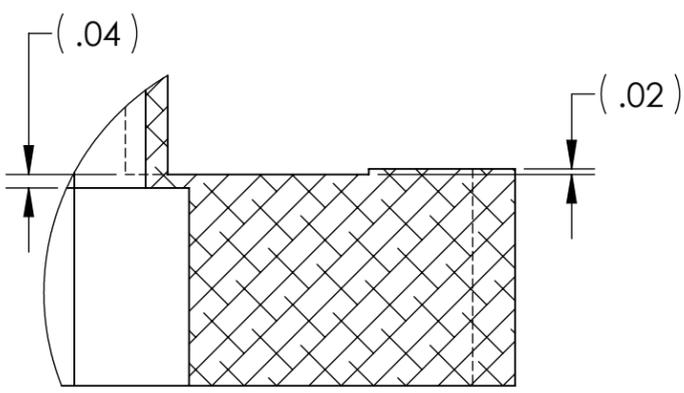
- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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
 - 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.
 - 11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.
 - 12. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE. THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.
 - 13. DRILL AND TAP +.005 OVERSIZE

| REV. | DATE | DCN # | DRAWING TREE # |
|------|-------------|-------|----------------|
| v1 | 06 DEC 2010 | - | - |
| - | - | - | - |
| - | - | - | - |

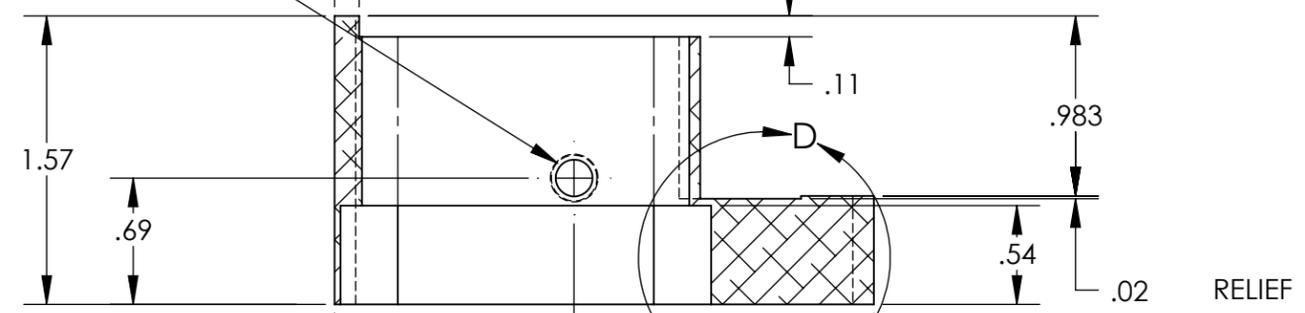


1/4-20 Tapped Hole THRU BOTH SIDES INLINE

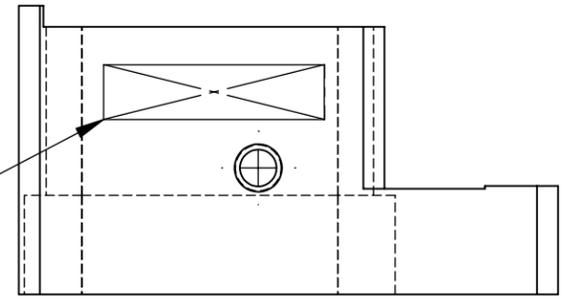
13



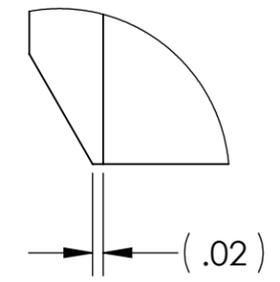
DETAIL D



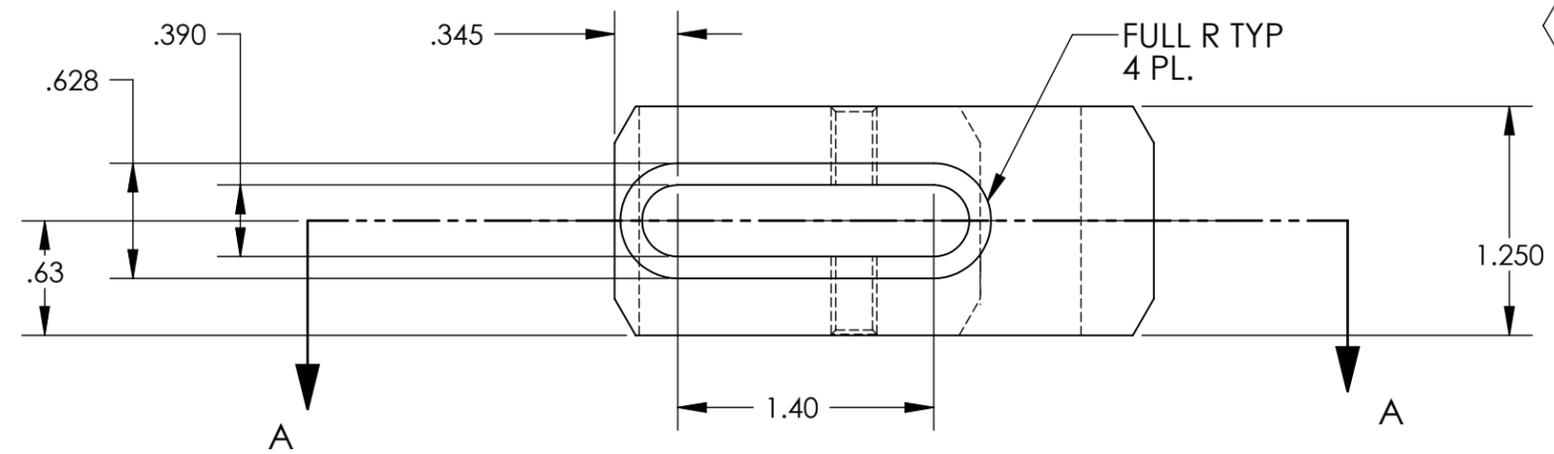
SECTION A-A SCALE 1:1



VIEW B-B SCALE 1:1



DETAIL C SCALE 3:1



5

| NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) | |
|--|----------|
| DIMENSIONS ARE IN INCHES | |
| TOLERANCES: .XX ± .015 .XXX ± .005 | |
| ANGULAR ± 1.0° | |
| MATERIAL | 304 SSSL |
| FINISH | 63 μinch |

| | |
|-------------|---|
| LIGO | CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY |
| SYSTEM | ADVANCED LIGO |
| SUB-SYSTEM | SUS |
| NEXT ASSY | |

| | | | |
|------------|----------|------------------------------|---------------|
| PART NAME | | aLIGO QUAD SHORTER DOG CLAMP | |
| DESIGNER | KMAILAND | 10 DEC 2010 | SIZE DWG. NO. |
| DRAFTER | KMAILAND | 06 DEC 2010 | B |
| CHECKER | | | D1003190 |
| APPROVAL | | | REV. v1 |
| SCALE: 2:1 | | PROJECTION: | |
| | | SHEET 1 OF 1 | |

D1003190 aLIGO QUAD Shorter Dog Clamp, PART PDM REV: X-011, DRAWING PDM REV: X-000