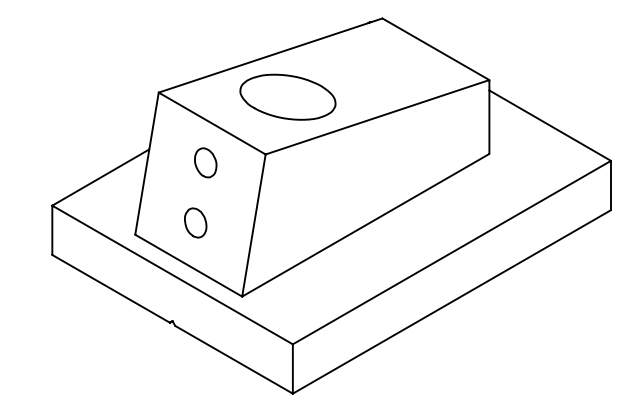
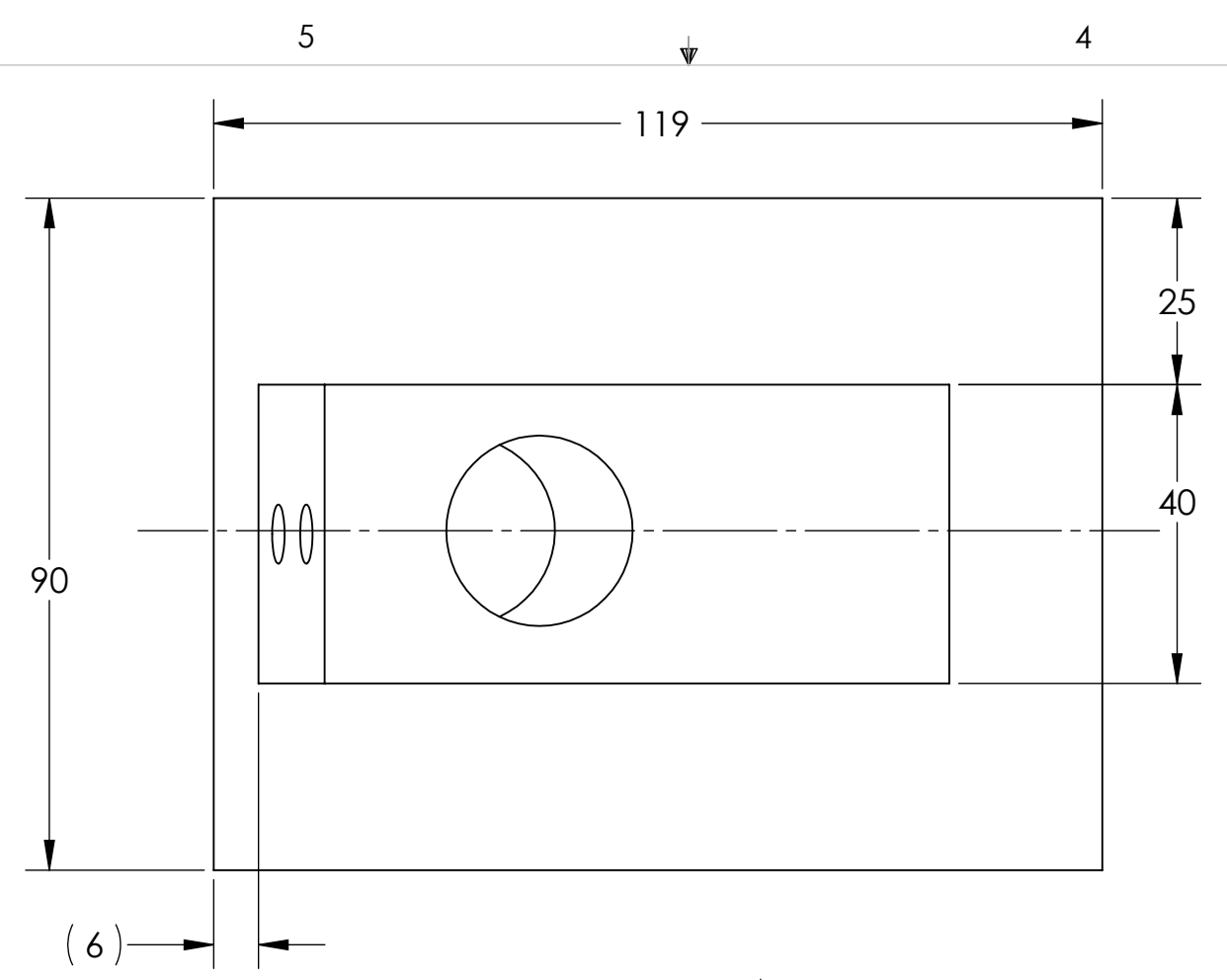
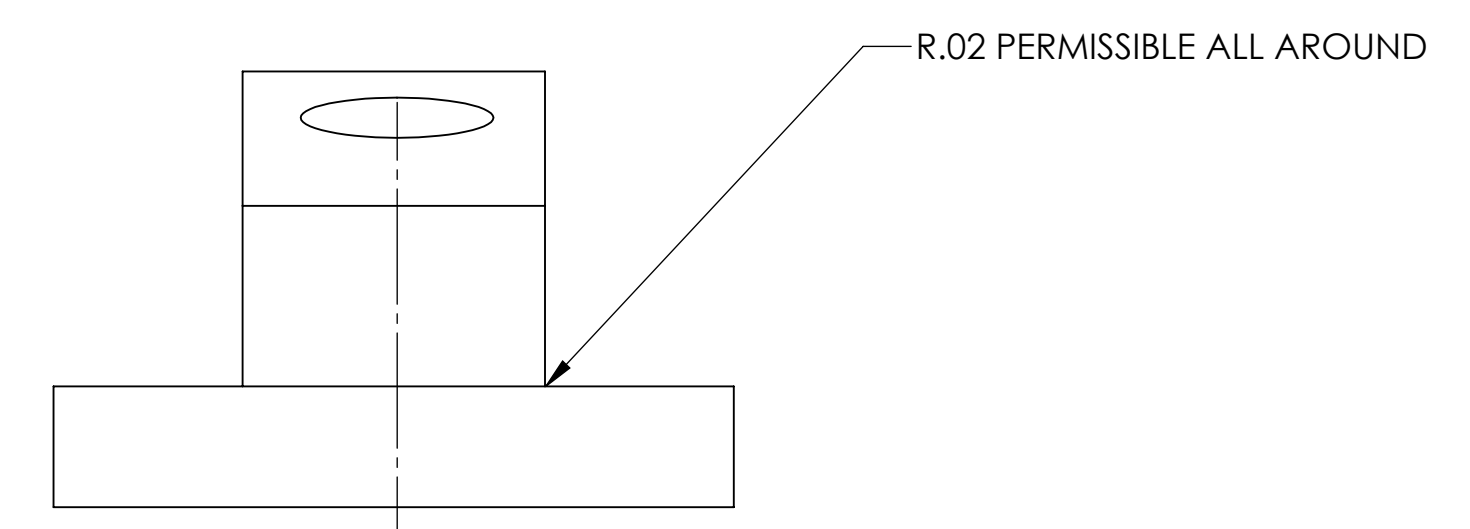
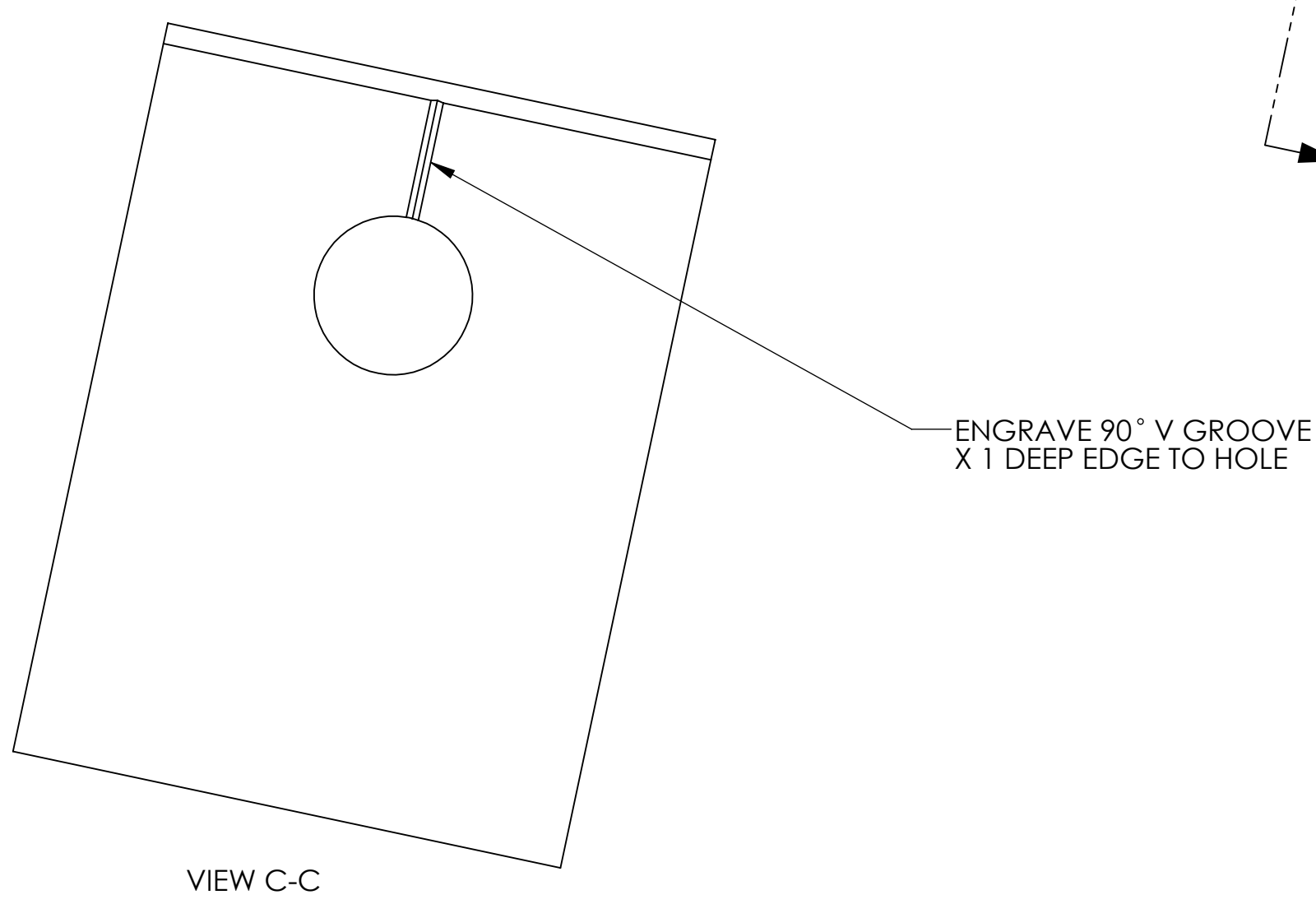
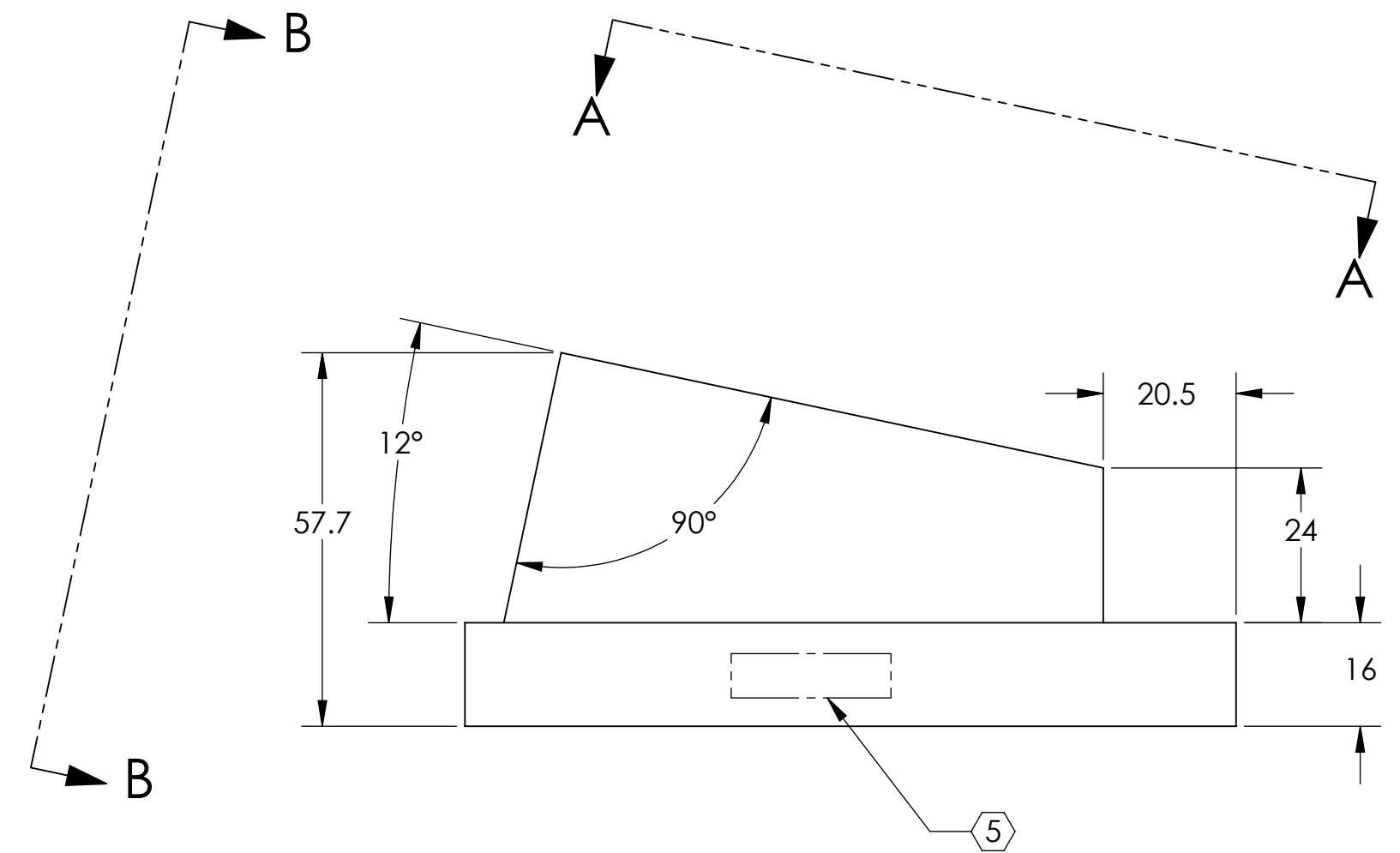
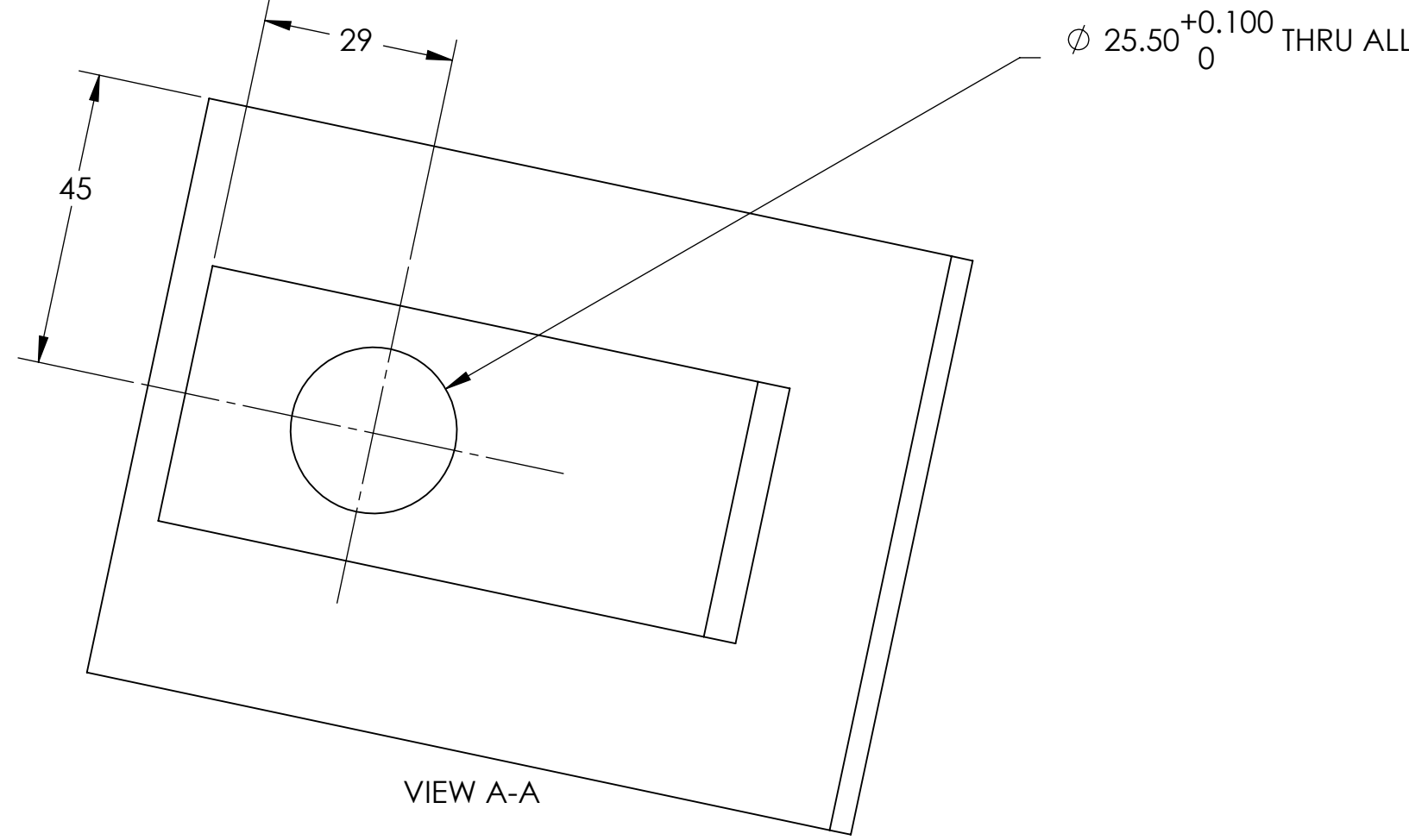
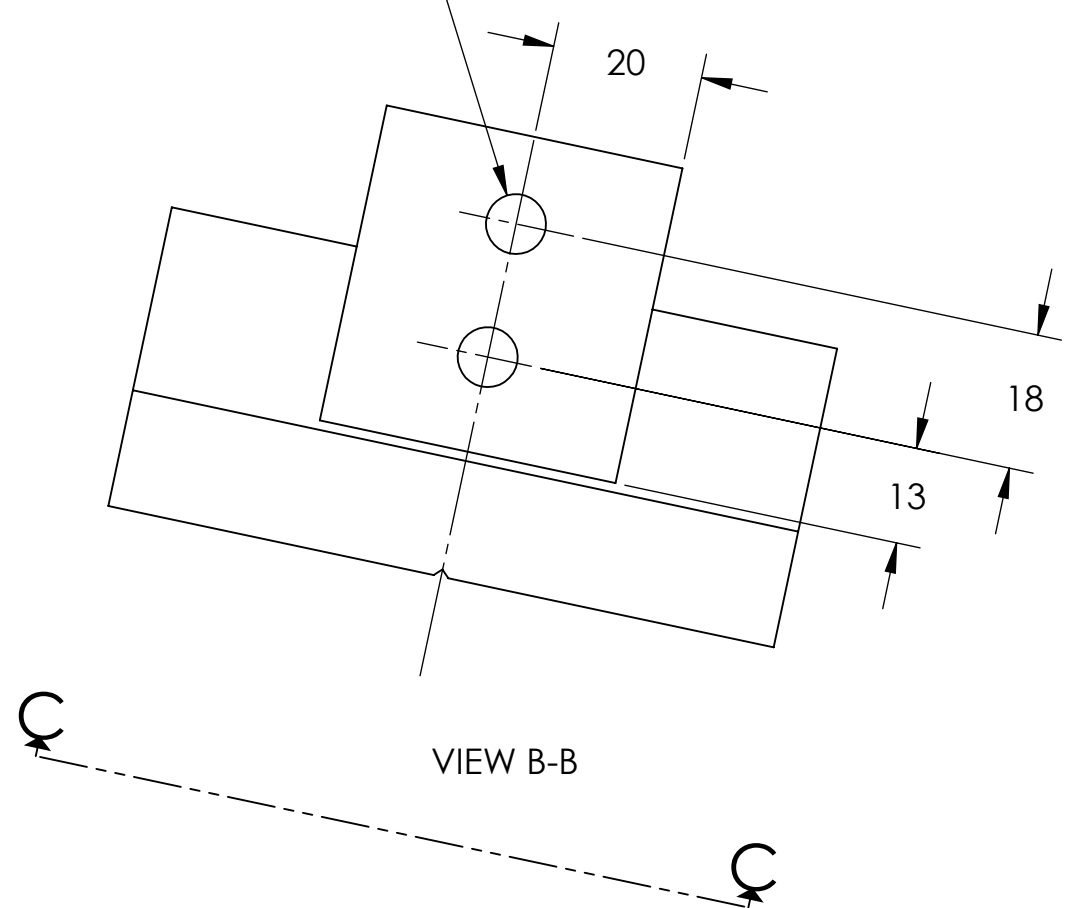


- NOTES CONTINUED:**
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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 = 1.55 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.

REV.	DATE	DCN #	DRAWING TREE #
V1	13 DEC 2010	E1100272	



2X DRILL AND TAP FOR 3/8-16 N60 HELICOIL INSERT #1185-6EN375 THRU TO Ø25.5 HOLE



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN MILLIMETERS TOLERANCES: .XX ± .25 .XXX ± .13 ANGULAR ± 0.5°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		<b>12 DEG BS/FM BSC STAY - TABLE INTERFACE</b>					
MATERIAL		FINISH		NEXT ASSY		DESIGNER	K. BUCKLAND	13 DEC 2010	SIZE	DWG. NO.	REV.
6061-T6 Al		63 μinch		D080501		DRAFTER	K. BUCKLAND	13 DEC 2010	D	D1003279	v1
						CHECKER			SCALE: 1:1	PROJECTION:	SHEET 1 OF 1

D1003279.dwg, SUS, 12 DEG BS/FM BSC STAY - TABLE INTERFACE - PART PDM REV: X-010, DRAWING PDM REV: X-006