

REV.	DATE	DCN #	DRAWING TREE #
v1	08 June 2011	E1100449	E1100450

NOTES CONTINUED:

4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
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 = 1 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES (INCLUDING SANDING OR SCOURING FOR MATTE FINISH) IS NOT ALLOWED. USE OF SCOTCH-BRITE OR SIMILAR PRODUCTS IS FORBIDDEN.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
10. ALL HELI-COIL TAPPED HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG HC2000 CURRENT REV.
11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NOT WELD REPAIRS OR PLUGS) UNLESS APPROVED IN ADVANCE AND 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 USED MUST BE VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF AND WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH THE MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E09000364.

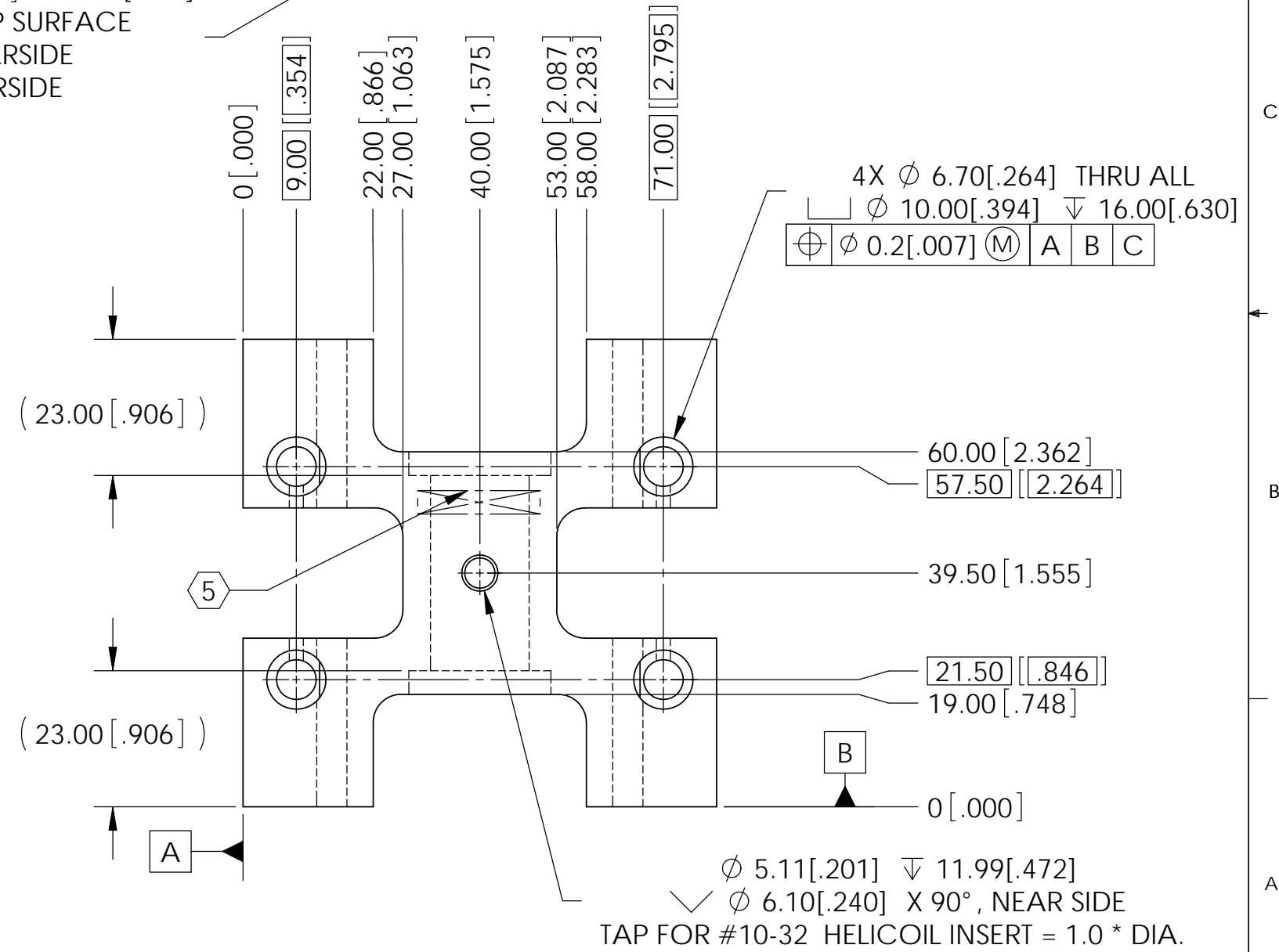
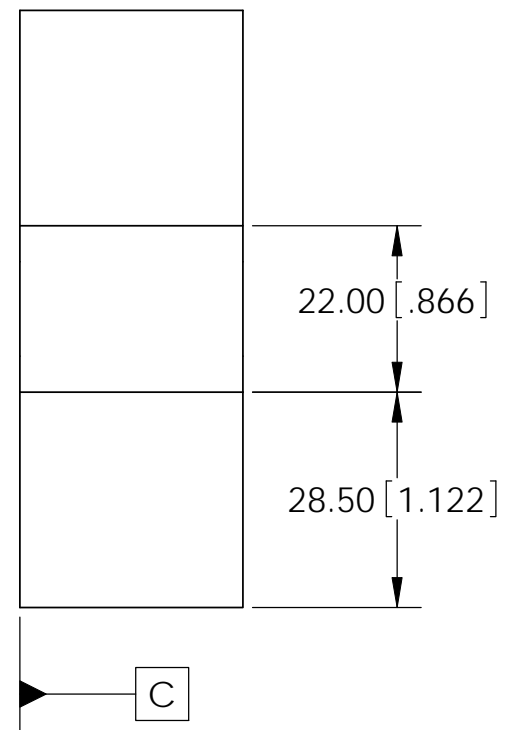
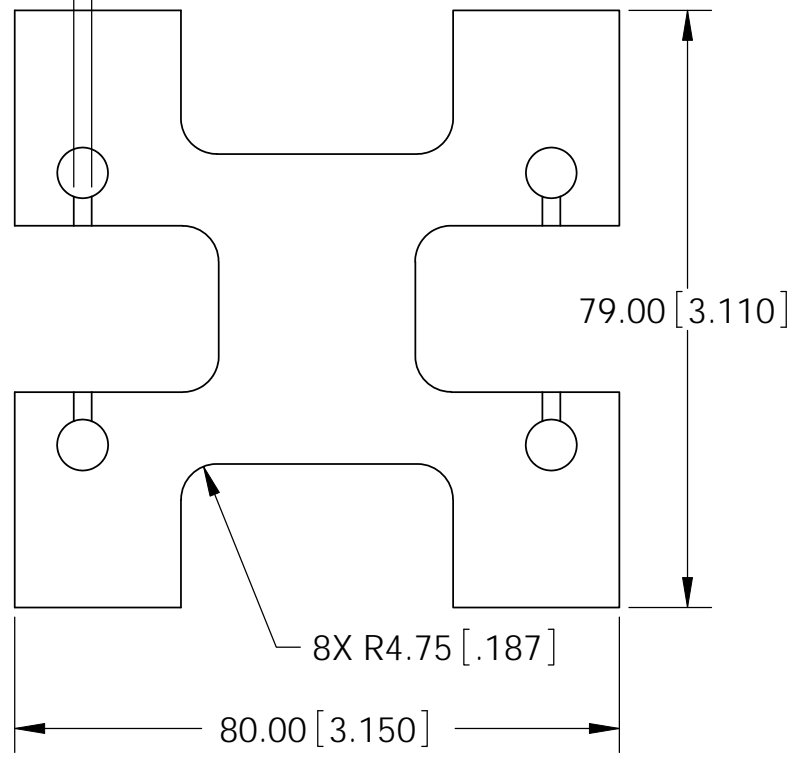
4X ϕ 5.11[.201] THRU
1/4-20 UNC THRU
USE .005 OVERSIZE TAP
2 NEAR SIDE
2 FAR SIDE

ϕ 16.67[.656] THRU ALL
3/4-10 UNC THRU ALL
.005 OVERSIZE TAP

2X ϕ 24.00[.945] ∇ 23.00[.906]
FROM TOP SURFACE
1 NEAR SIDE
1 FAR SIDE

4X 2.36[.093] ∇ 2.0[.78] VENT GROOVE
SHAPE MFG OPTION, SQ, RAD OR V.

4X ϕ 6.70[.264] THRU ALL
 ϕ 10.00[.394] ∇ 16.00[.630]
 ϕ 0.2[.007] (M) A B C



ϕ 5.11[.201] ∇ 11.99[.472]
 ∇ ϕ 6.10[.240] X 90°, NEAR SIDE
TAP FOR #10-32 HELICOIL INSERT = 1.0 * DIA.

D1101079, PART PDM REV: X-006, DRAWING PDM REV: X-005

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN MM [INCHES]				ADVANCED LIGO		QUAD UIM PITCH ADJUSTER TURRET, aLIGO SUS					
TOLERANCES: .XX ± .381[.015] .XXX ± .127[.005]				SUB-SYSTEM SUS		DESIGNER	J.ODELL	02 June 2011	SIZE	DWG. NO.	REV.
ANGULAR ± .5°				MATERIAL 6061-T6 Al		DRAFTER	M.HILLARD	08 June 2011	B	D1101079	v1
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .76[.03] x 45°. 3. DO NOT SCALE FROM DRAWING.				FINISH 63 μ inch		CHECKER	J.LEWIS	08 June 2011	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1
				NEXT ASSY D060375		APPROVAL	J.ROMIE	08 June 2011			