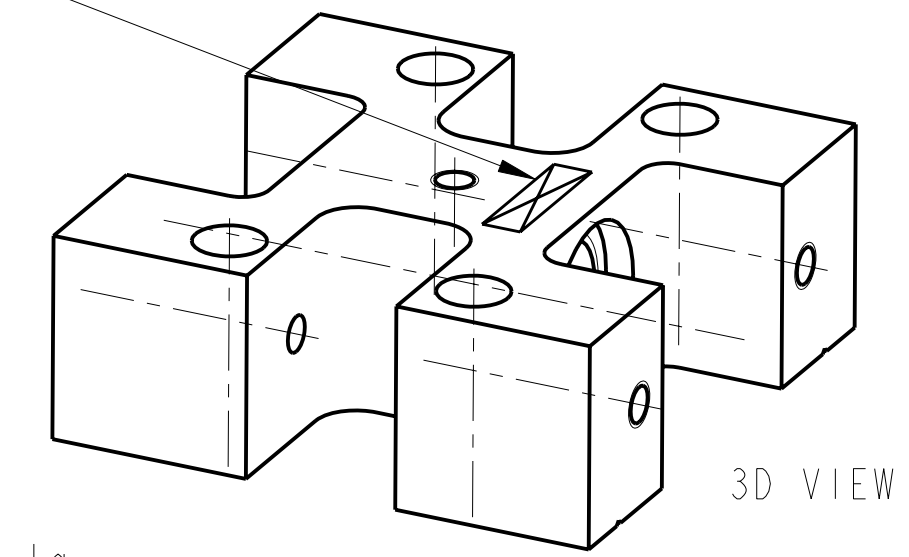


REV.	DATE	DCN #	DRAWING TREE #
A	07/JUN/11	E1100449	

PART NO. (SEE NOTE 4)  
TO BE ETCHED OR STAMPED  
IN APPROX POSITION SHOWN.



4-HOLES THRO' TO HOLE.  
1/4-20 UNC TAP 0.005"  
OVERSIZE

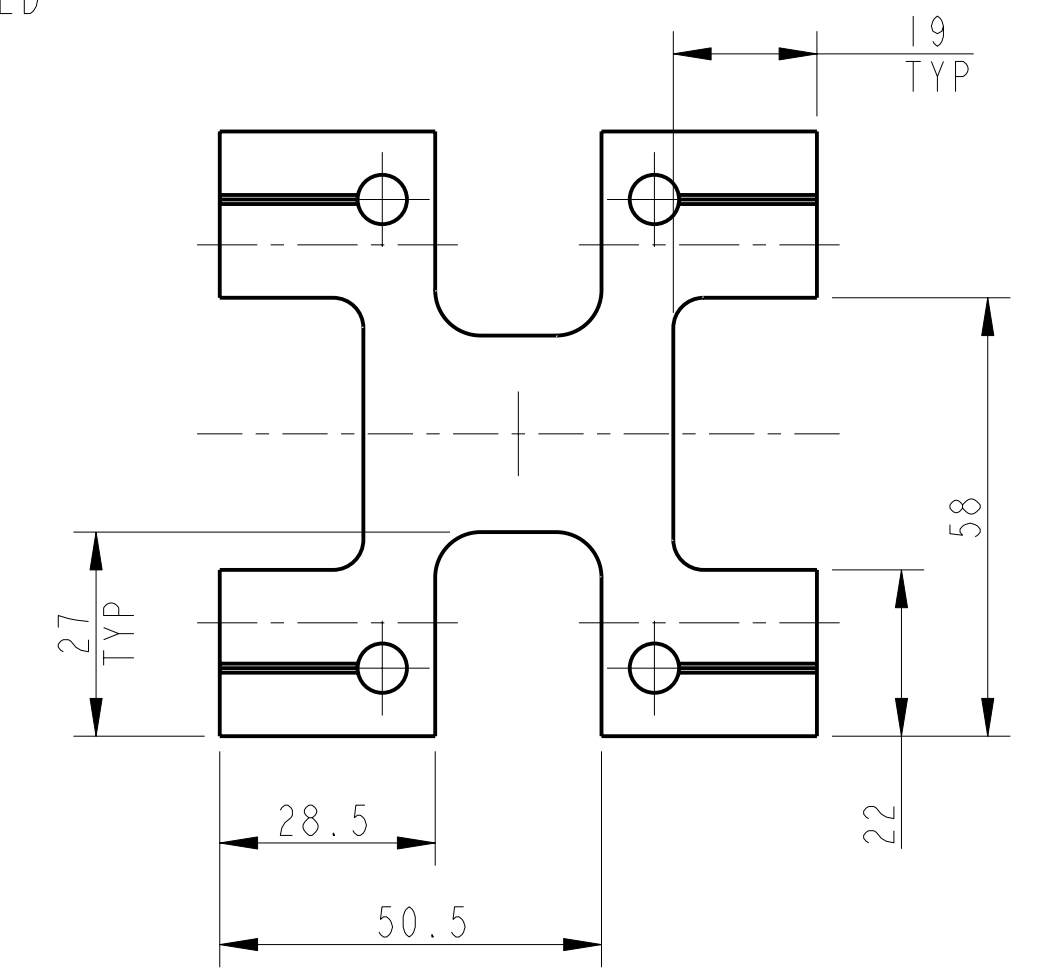
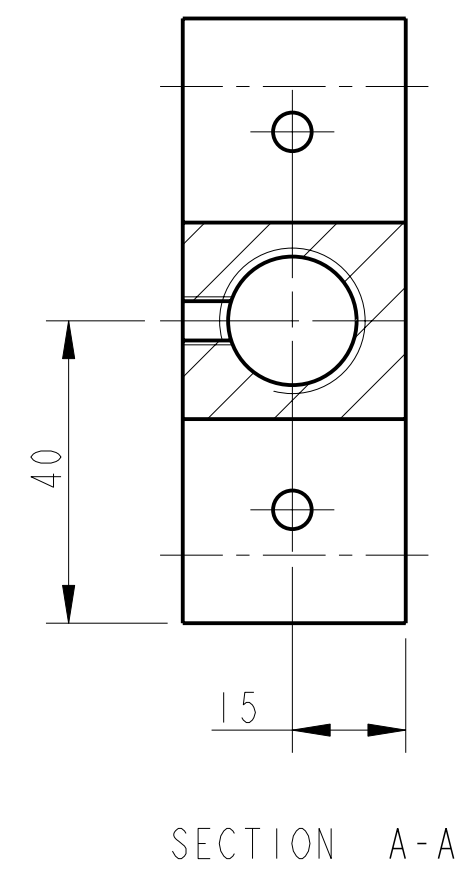
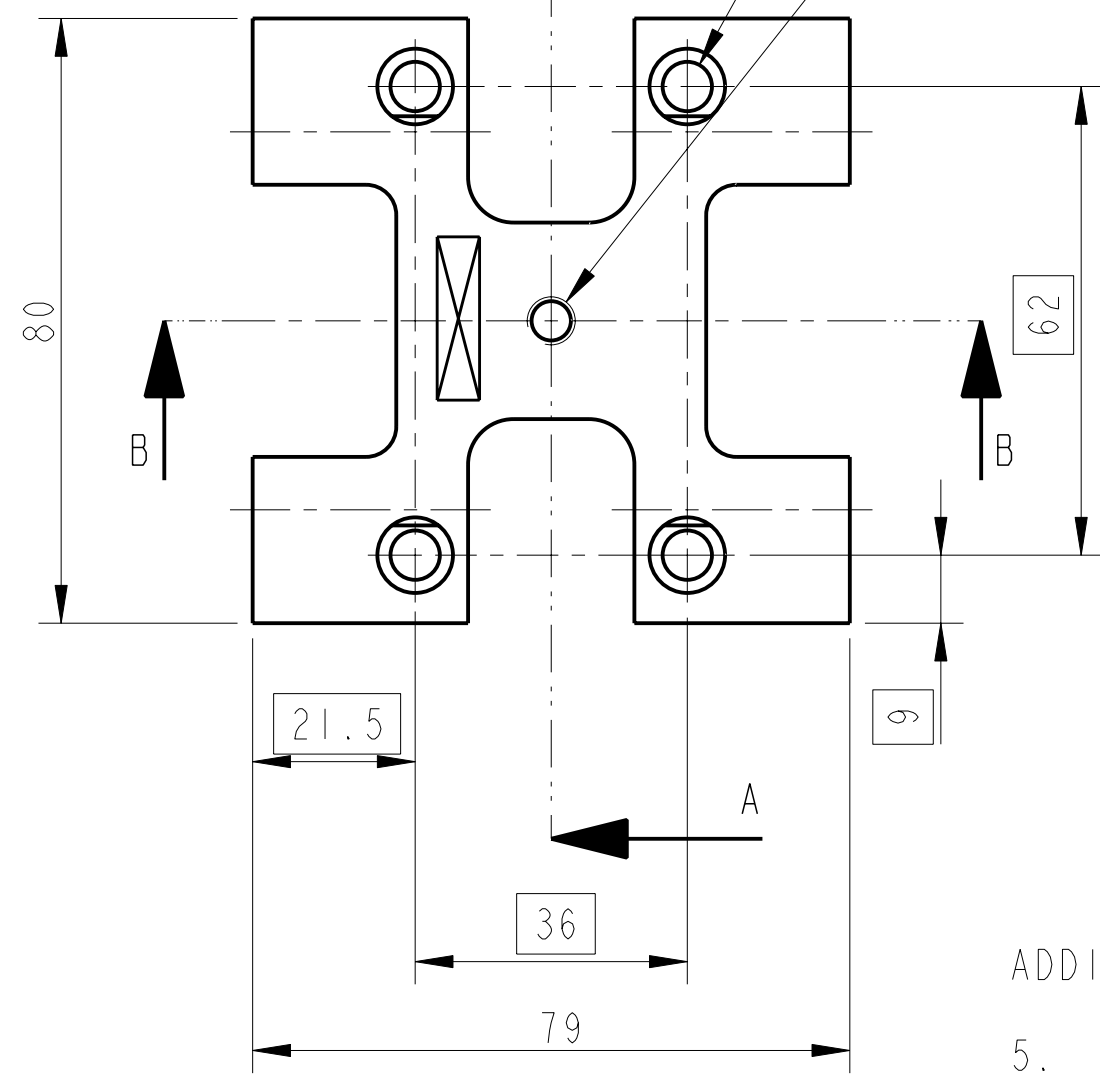
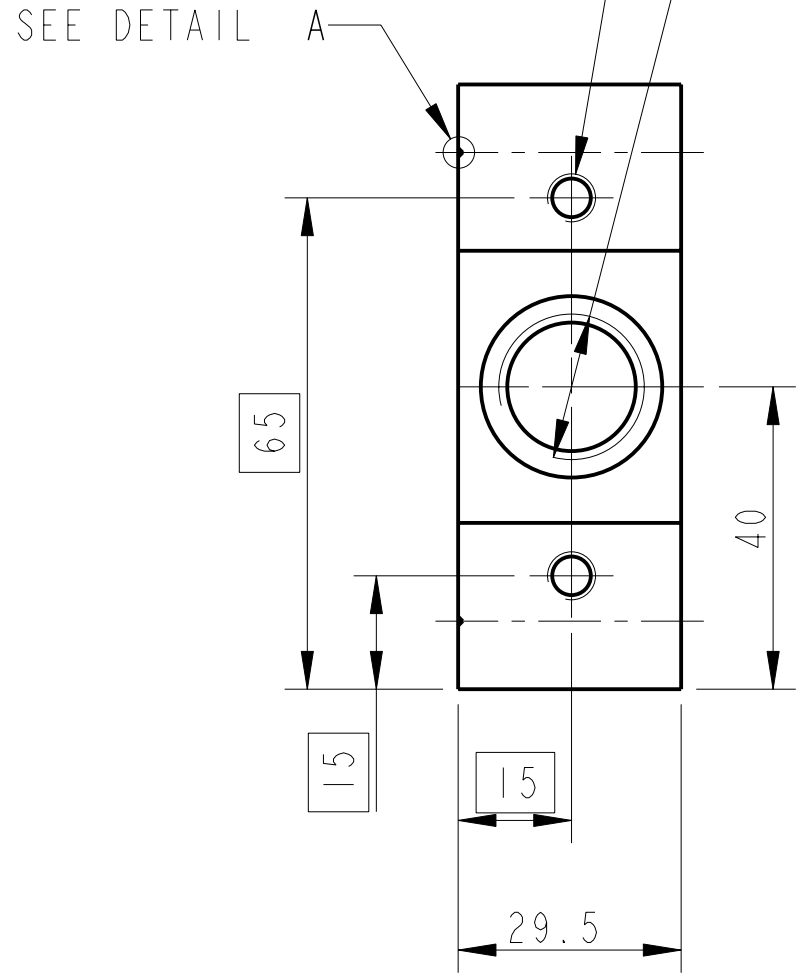
$\text{H} \begin{matrix} \oplus \\ \ominus \end{matrix} \text{ } \phi 0.2$

3/4 - 10 UNC 0.005" OVERSIZE  
(ALL RADIAL DIMENSIONS 0.005" OVERSIZE)

DRILL 4 HOLES  $\phi 6.7$  THRO',  
AND C.BORE  $\phi 10$  X 8 DP

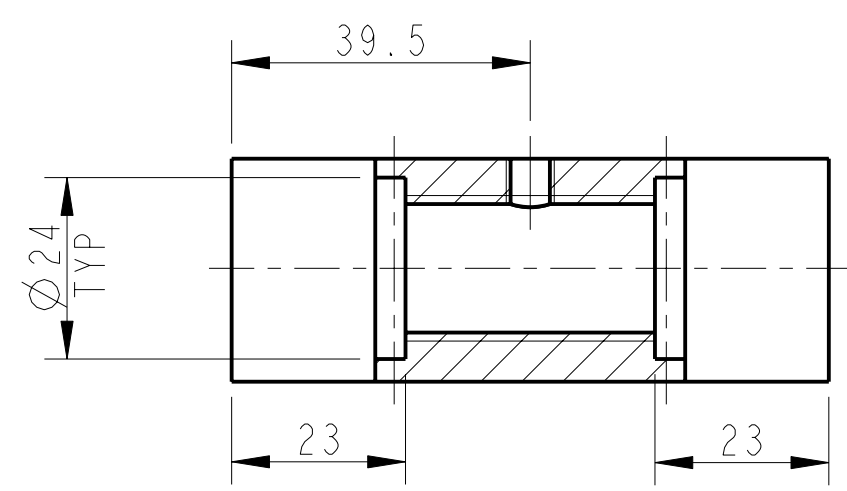
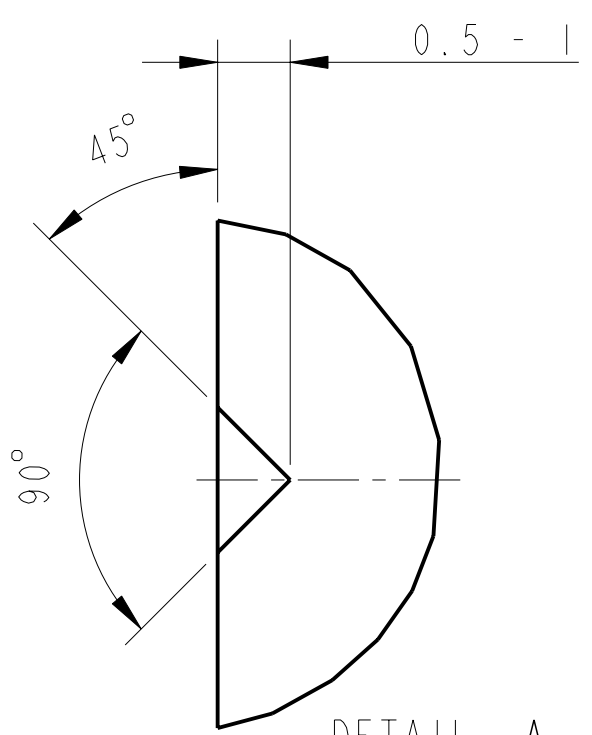
$\text{H} \begin{matrix} \oplus \\ \ominus \end{matrix} \text{ } \phi 0.2$

1-HOLE THRO' TO HOLE, FOR 1/4-20 UNC XI.D Ig  
HELICOIL - HELICOIL NOT TO BE FITTED



ADDITIONAL NOTES:

- MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- ALL HELICOIL HOLES TO BE PREPARED ACCORDING TO EMHART HELICOIL PRODUCT CATALOG, HC2000, REV 4.
- 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.
- 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 OFFICERS REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.



NOTES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES	
1. REMOVE ALL SHARP EDGES, R.02 MIN.	2. DO NOT SCALE FROM DRAWING.	SYSTEM <b>ADVANCED LIGO</b>	
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)	4. SCRIBE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: D020188-001. A VIBRATORY TOOL MAY BE USED.	SUB-SYSTEM <b>SUS</b>	
DIMENSIONS ARE IN mm (INCHES) TOLERANCES: X.XX ± mm (INCHES) ANGULAR ±0.25°		NEXT ASSY <b>QUAD UIM</b>	
MATERIAL: AL ALLOY 5083		PART NAME <b>PITCH ADJUSTER &amp; MASS</b>	
FINISH: CLEAN, GREASE FREE Ra = 1.6		DRG. NO. <b>D1101079</b>	
DRAWN: J.O'DELL 07/JUN/11		SCALE 1:1 PROJECTION	
CHECKED: J'OD 07/JUN/11		SHEET 1 OF 1	
APPROVED: JOD 07/JUN/11		REV A	