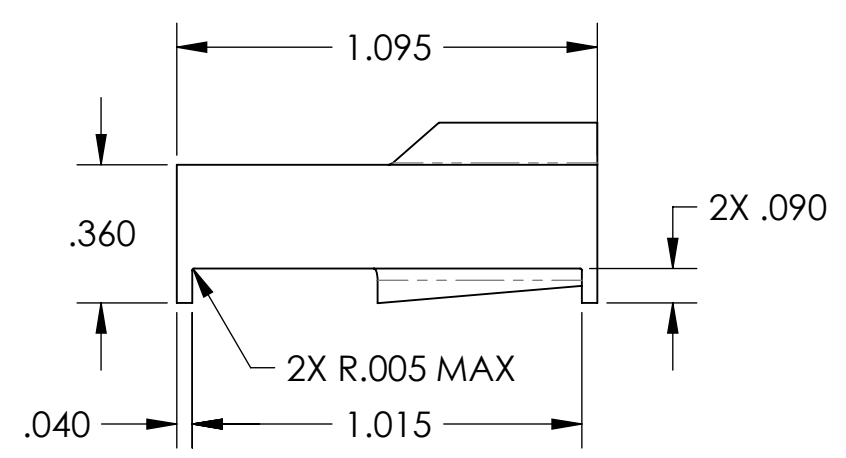
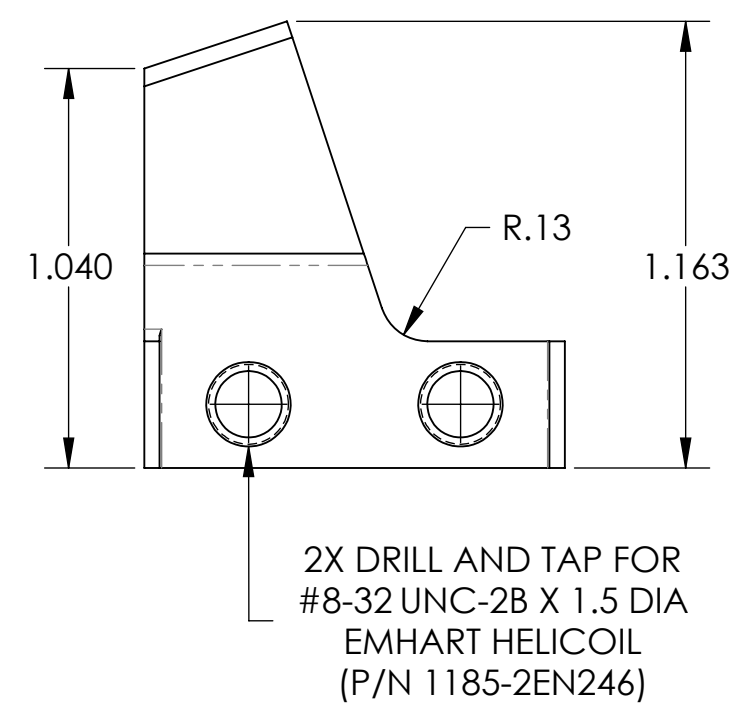
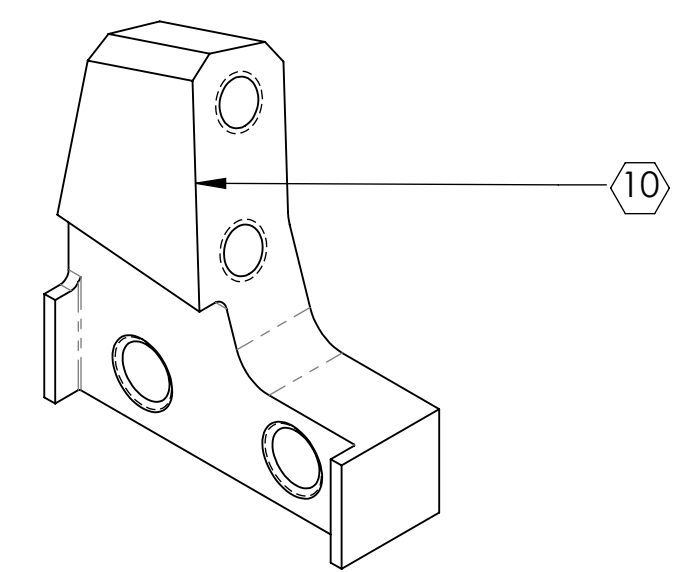
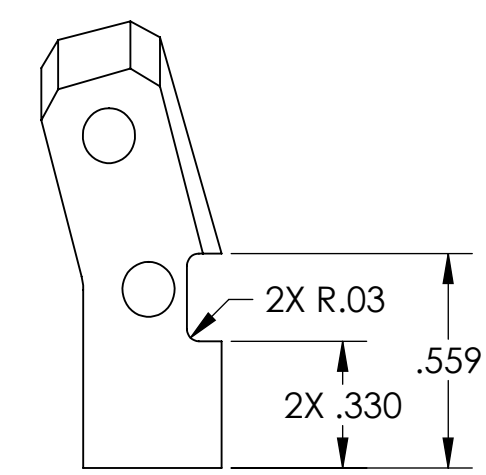
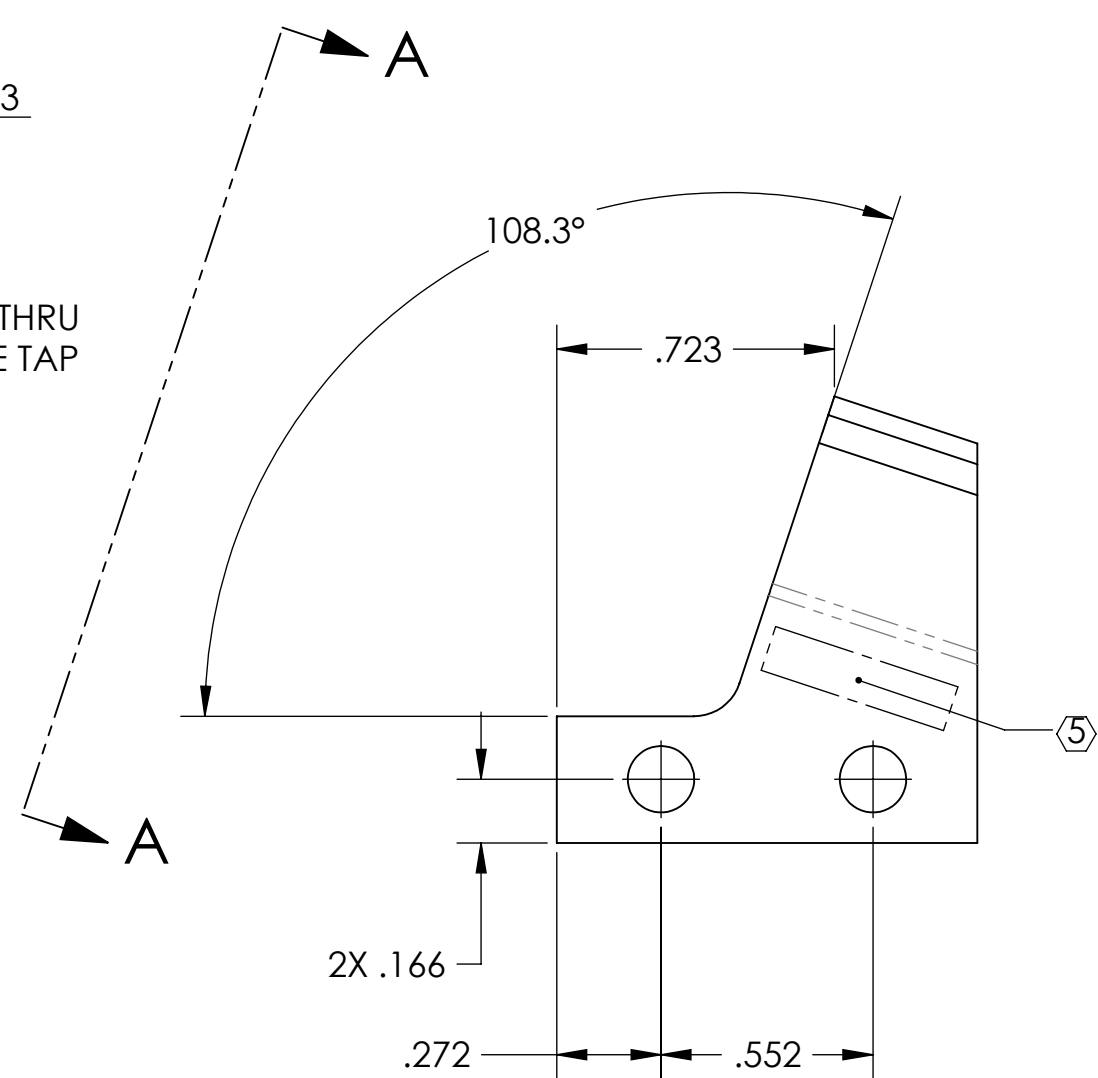
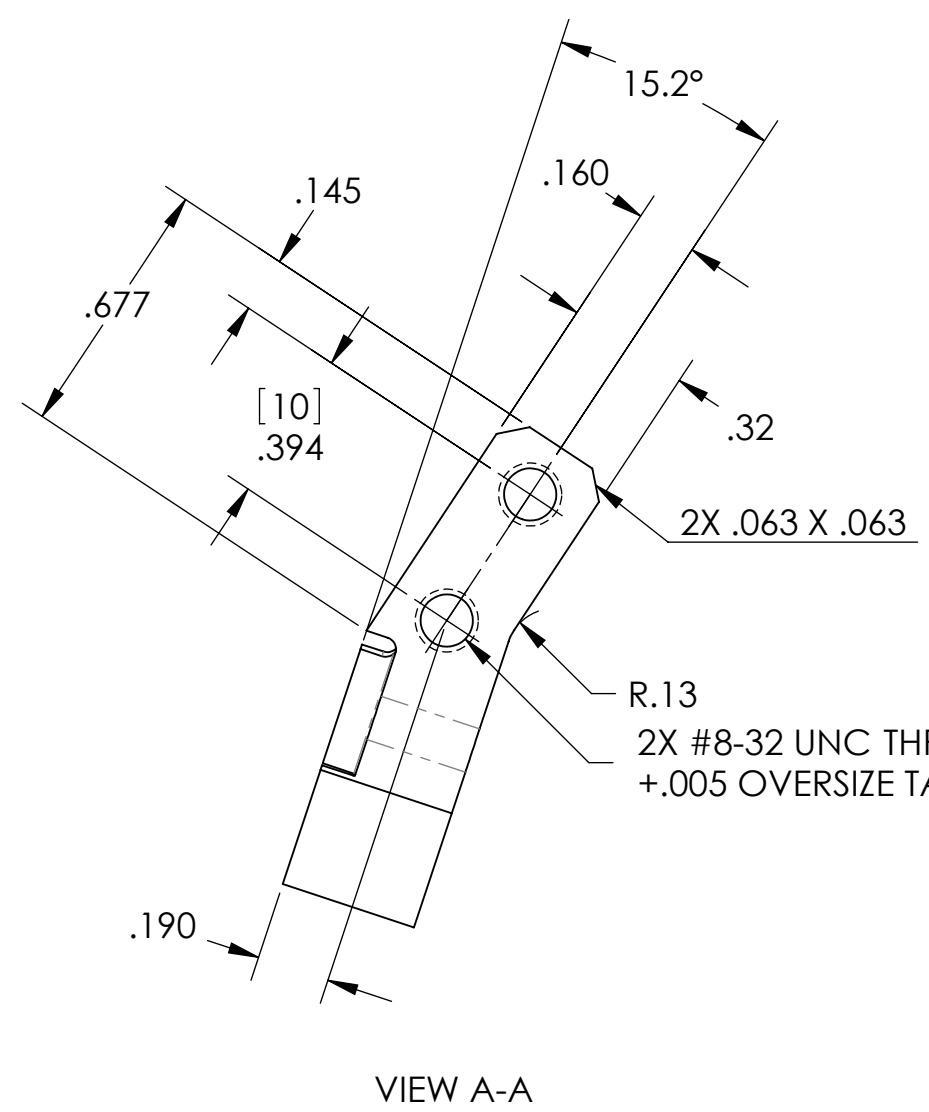


NOTES CONTINUED:

- 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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 8. ALL HELICOIL HOLES TO BE PREPARED IN ACCORDANCE WITH EMHART HELICOIL PRODUCT CATALOG, HC2000, REV. 4.
- 9. ALL HELICOILS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY, CLEANING AND BAKING OF FINISHED PARTS.
- ⑩ DO NOT REMOVE SHARP EDGES.

REV.	DATE	DCN #	DRAWING TREE #
A/v1	01 AUG 2008	E080418	E080191
v2	26 MAY 2009	E0900160	E080191
v3	28 JUN 2010	E1000236	E080191
v4	01 JAN 2011	E1100001	E080191



<p>NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)</p> <p>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.</p>		<p>LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY</p>		<p>PART NAME UPPER CLAMP, UPPER WIRE, INSIDE</p>						
<p>DIMENSIONS ARE IN INCHES [MM]</p> <p>TOLERANCES: .XX ± .01 .XXX ± .005</p> <p>ANGULAR ± 0.1°</p>		<p>SYSTEM ADVANCED LIGO</p> <p>SUB-SYSTEM SUS</p>		DESIGNER	D. BRIDGES	25 OCT 2010	SIZE	DWG. NO.	REV.	
<p>MATERIAL 304, 316 OR 302 SSTL</p>		<p>FINISH 63 μinch</p>		<p>NEXT ASSY UPPER WIRE ASSEMBLY</p>		DRAFTER	D. BRIDGES	04 JAN 2011	<p>D020611</p>	<p>v4</p>
<p>APPROVAL</p>		<p>SCALE: 2:1</p>		<p>PROJECTION:</p>		<p>SHEET 1 OF 1</p>				