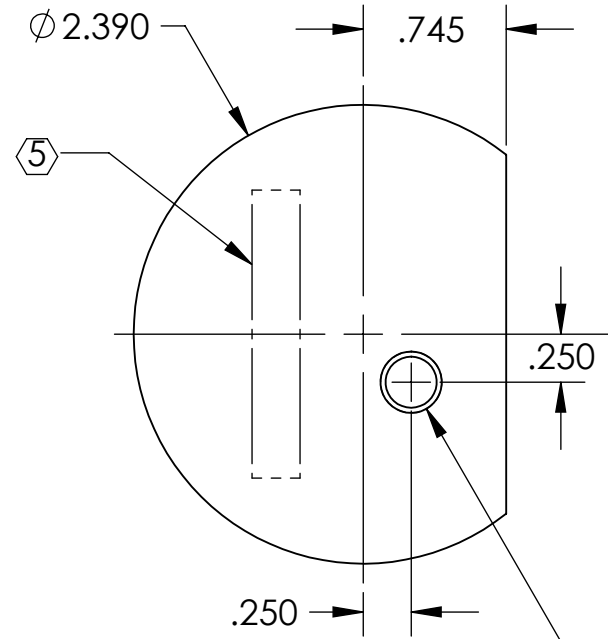
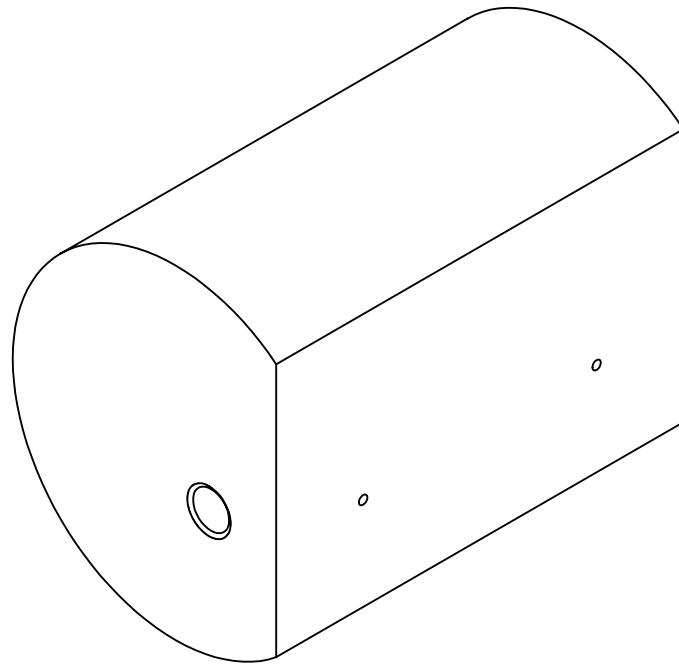


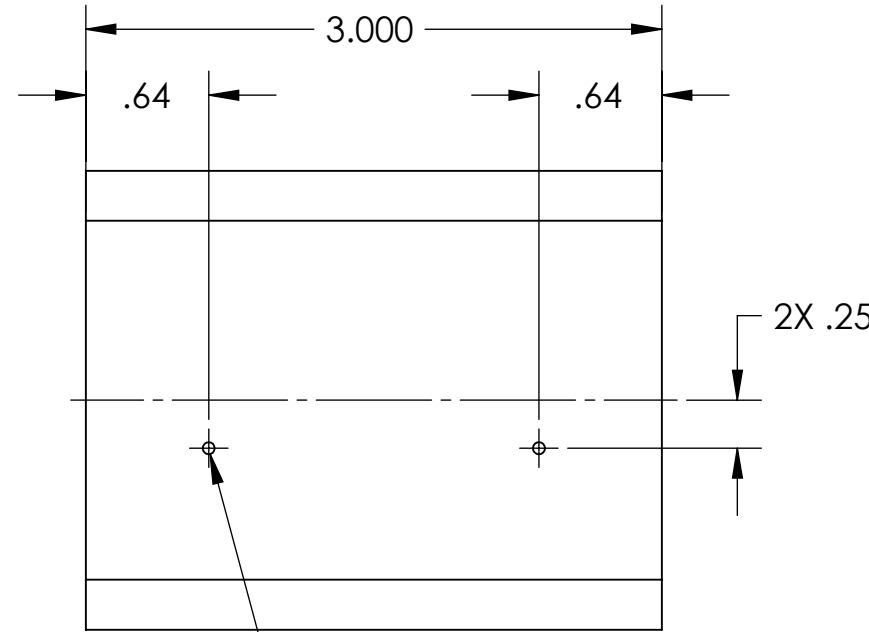
D030156\_Advanced\_LIGO\_SUS\_HLTs\_Side\_Offset\_Intermediate\_Mass\_PART PDM REV: V1-000, DRAWING PDM REV: V1-001

- 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.

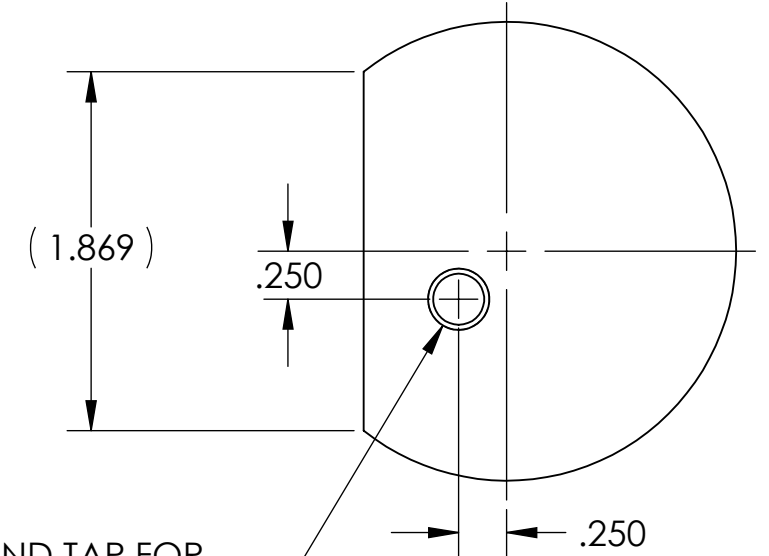
REV.	DATE	DCN #	DRAWING TREE #
v1	22 JUN 2009	E0900173	E080191
v2	18 MAY 2010	E1000166	E080191
-	-	-	-



DRILL AND TAP FOR  
1/4-20 UNC -2B X 1.0 DIA  
EMHART HELICOIL  
(P/N 3585-4EN250)



2X  $\phi$  .06 THRU TO  
TAPPED HOLE



DRILL AND TAP FOR  
1/4-20 UNC -2B X 1.0 DIA  
EMHART HELICOIL  
(P/N 3585-4EN250)

**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

DIMENSIONS ARE IN INCHES

TOLERANCES:  
.XX ± .01  
.XXX ± .005  
ANGULAR ± 0.5°

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.

MATERIAL	6061-T6 Al	FINISH	32 $\mu$ inch
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**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **SUS**

NEXT ASSY: **INTERMEDIATE MASS ASSY**

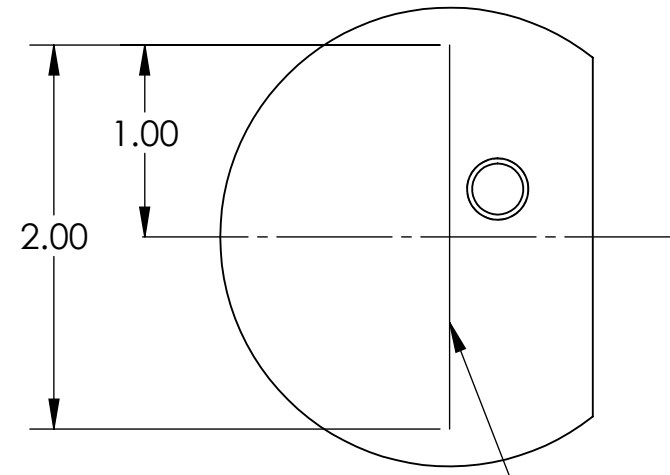
DESIGNER			PART NAME		
D. BRIDGES	02 AUG 2010		SIDE OFFSET		
DRAFTER			SIZE DWG. NO.		
D. BRIDGES	03 AUG 2010		B D030156		
CHECKER			REV.		
M. MEYER	03 AUG 2010		v2		
APPROVAL			SCALE: 1:1 PROJECTION:		
			FIRST ANGLE SHEET 1 OF 2		

D030156\_Advanced\_LIGO\_SUS\_HLTS\_Side\_Offset\_Intermediate\_Mass\_PART\_PDM\_REV: V1-000, DRAWING PDM REV: V1-001

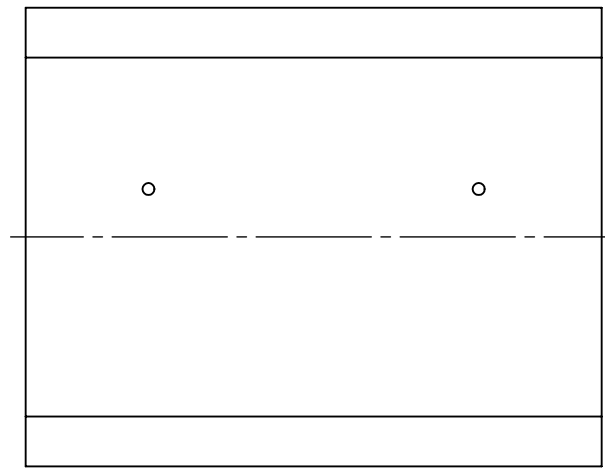
8 7 6 5 4 3 2 1

NOTES CONTINUED:  
⑩ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) AS MARKED ON NOTED SURFACE OF PART. USE .12" HIGH CHARACTERS.

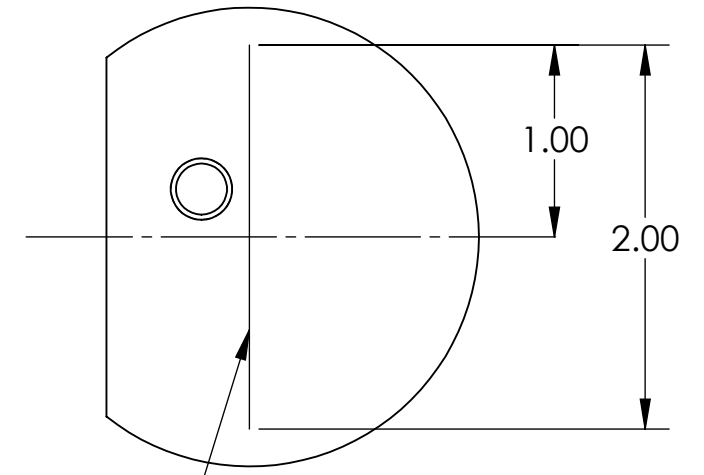
D  
C  
B  
A





⑩ THRU CENTER OF CYLINDER



⑩ THRU CENTER OF CYLINDER



D  
C  
B  
A

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE <b>B</b>	DWG. NO. D030156
SCALE: 1:1	PROJECTION:  SHEET 2 OF 2
REV. v2	

8 7 6 5 4 3 2 1