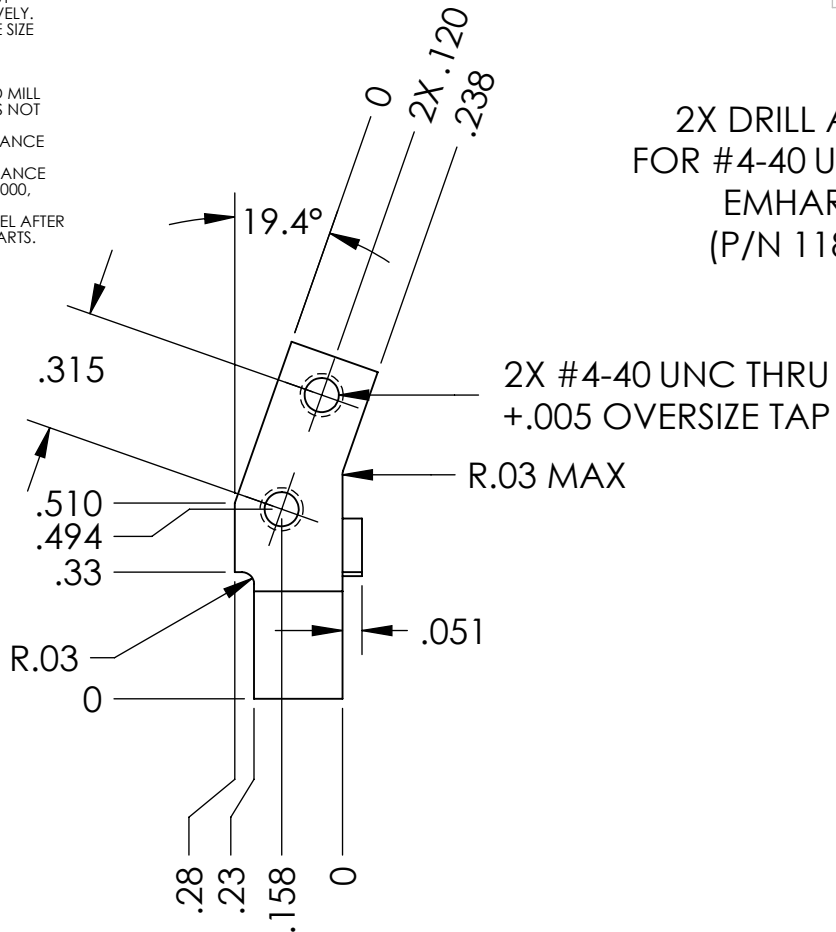


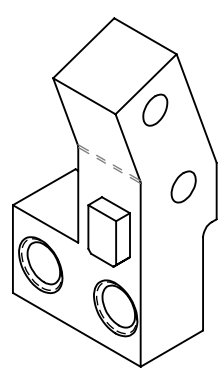
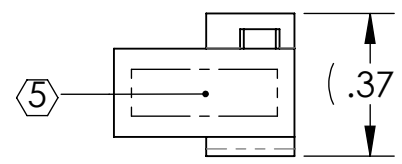
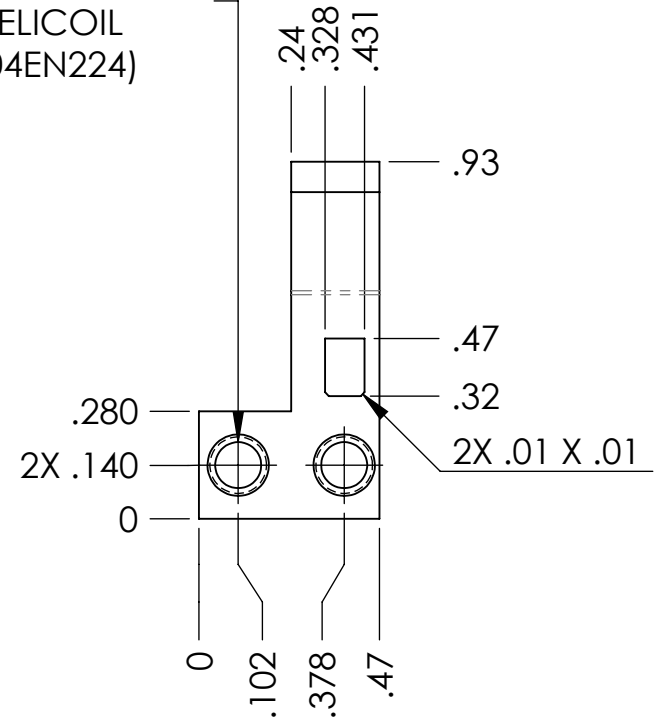
NOTES CONTINUED:

- 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	28 APR 2009	E080418	E080191
v2	30 JUN 2009	E0900184	E080191
v3	28 JUN 2010	E1000236	E080191



2X DRILL AND TAP THRU
FOR #4-40 UNC-2B X 2.0 DIA
EMHART HELICOIL
(P/N 1185-04EN224)



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES	1. INTERPRET DRAWING PER ASME Y14.5-1994.
TOLERANCES: .XX ± .01 .XXX ± .005	2. REMOVE ALL SHARP EDGES, R.02 MIN.
ANGULAR ± 0.1°	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 304, 316 OR 302 SSSL	FINISH 32 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

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

NEXT ASSY: **INTERMEDIATE WIRE ASSY**

PART NAME: **UPPER CLAMP, INT. WIRE, INSIDE**

DESIGNER: D. BRIDGES	10 OCT 2008	SIZE: A	DWG. NO.: D070585	REV.: v3
DRAFTER: R. BIEDENHARN	01 NOV 2010			
CHECKER: D. BRIDGES	04 NOV 2010			
APPROVAL:		SCALE: 2:1	PROJECTION:	SHEET 1 OF 1