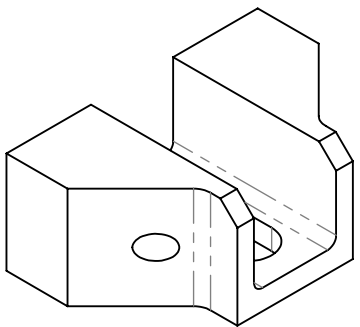
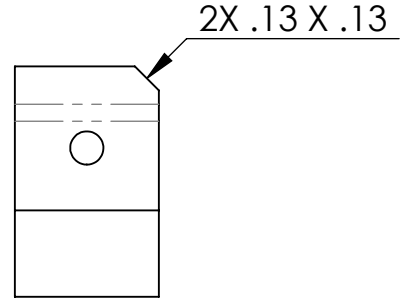
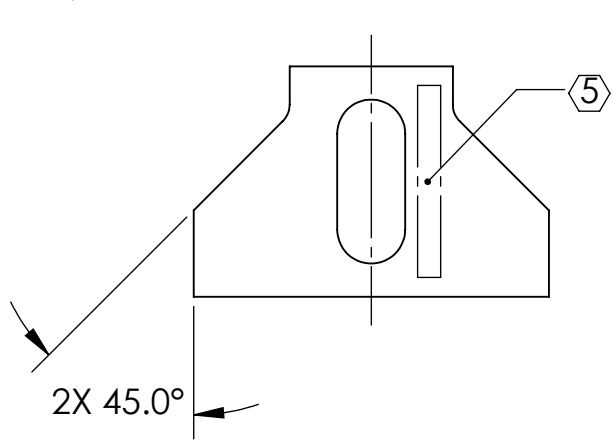


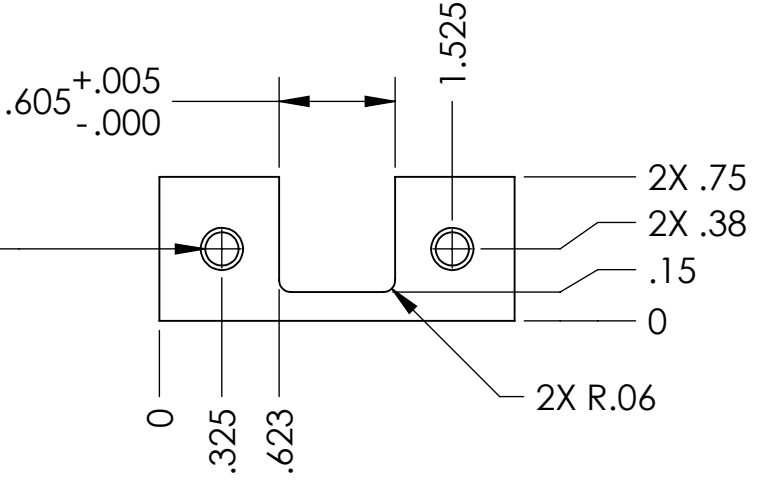
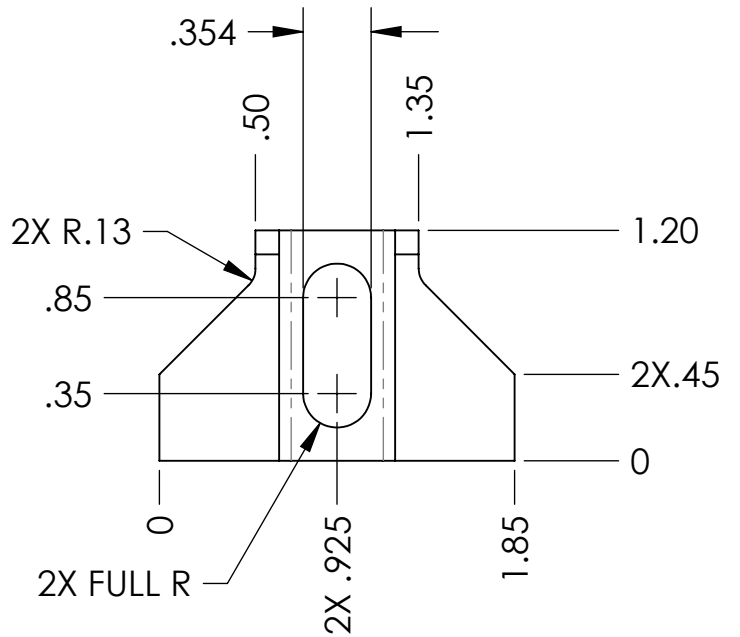
NOTES CONTINUED:

- 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 | 02 JUN 2009 | E0900162 | E080191 |
| v2 | 10 AUG 2010 | E1000301 | E080191 |
| - | - | - | - |



2X DRILL AND TAP THRU FOR
#8-32 UNC-2B X 2.5 DIA
EMHART HELICOIL
(P/N 1185-2EN410)



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 ± 0.5° | 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 | 63 μinch |

| | | | | | |
|---|------------------------------|------------|----------------------|-------------------------------|------------------------|
| CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY | | PART NAME | | EARTHQUAKE STOP MOUNT, BRIDGE | |
| SYSTEM | ADVANCED LIGO | SUB-SYSTEM | SUS | DESIGNER | D. BRIDGES 26 AUG 2010 |
| NEXT ASSY | EARTHQUAKE STOP ASSY, BRIDGE | CHECKER | B. MOORE 16 SEP 2010 | APPROVAL | |
| SIZE | A | DWG. NO. | D0901241 | | REV. |
| SCALE | 1:1 | PROJECTION | | | v2 |
| | | | | | SHEET 1 OF 1 |