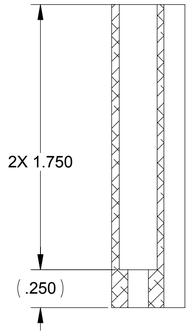
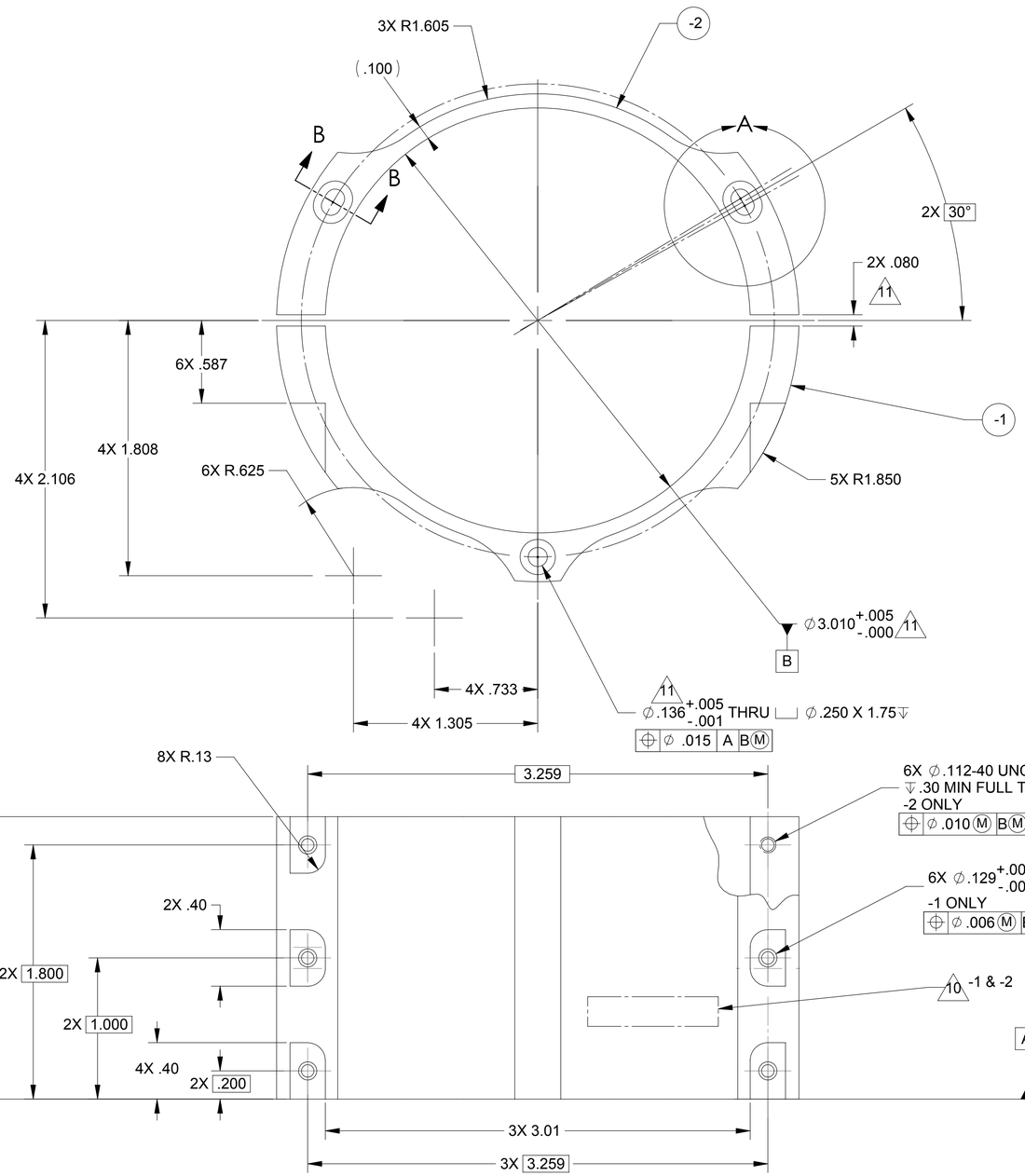
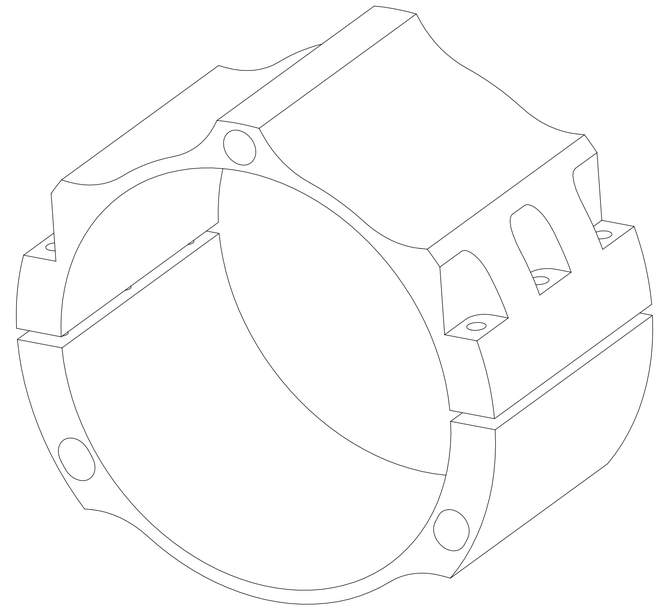
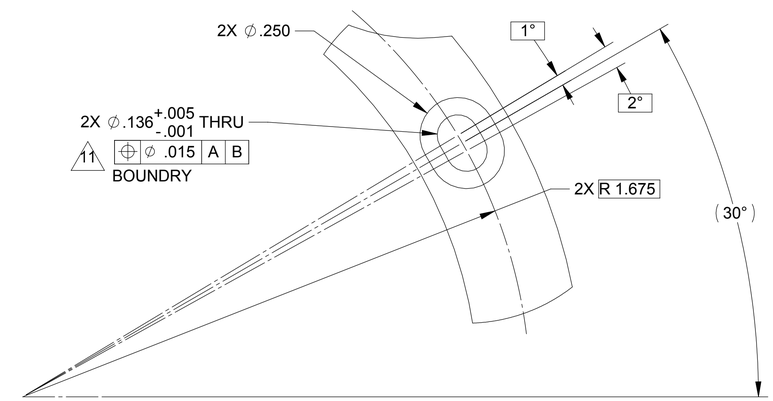
REV.	DATE	DCN #	DRAWING TREE #



SECTION B-B
ROTATED 30° CCW







DETAIL A
SCALE 4 : 1
2X

NOTES: UNLESS OTHERWISE SPECIFIED.

5. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASI SPECIFICATION 20008225 (LIGO E048225).
6. THREADED HOLES NOT REQUIRING INSERTS SHALL BE TAPPED .004-.006 OVERSIZE.
7. MACHINE FILLET RADII .003-.015.
8. COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-.000.
9. COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.

10. MARK PART AND SERIAL NUMBER IN LOCATION APPROXIMATELY AS SHOWN USING 0.07-INCH HIGH CHARACTERS IN ACCORDANCE WITH 20006686, TYPE I, CLASSES 4, 5, OR 6. SERIAL NUMBERS START AT 001 FOR FIRST PART AND PROCEED CONSECUTIVELY. PARTS TOO SMALL TO MARK SHALL BE IDENTIFIED IN ACCORDANCE WITH 20006686, TYPE II.
11. NOTED FEATURES SHALL BE INSPECTED PRIOR TO .080 FEATURE COMPLETION.
12. RECORD WEIGHT IN INSPECTION REPORT AFTER FINAL MACHINING.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .03 .XXX ± .010 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 SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: Clamp, Seismometer, L-4C
	MATERIAL: 6061-T6	FINISH: 125 µinch	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: SEI	DESIGNER: ASI DRAFTER: ASI 23 Jun 2004 CHECKER: sbarnum 12 Aug 2009 APPROVAL
			NEXT ASSY: D047820		SIZE: D DWG. NO.: D047824 REV.: v2 SCALE: 2:1 PROJECTION: SHEET 1 OF 1

20007824-A L-4C Clamp, PART PDM REV: , DRAWING PDM REV: X-003