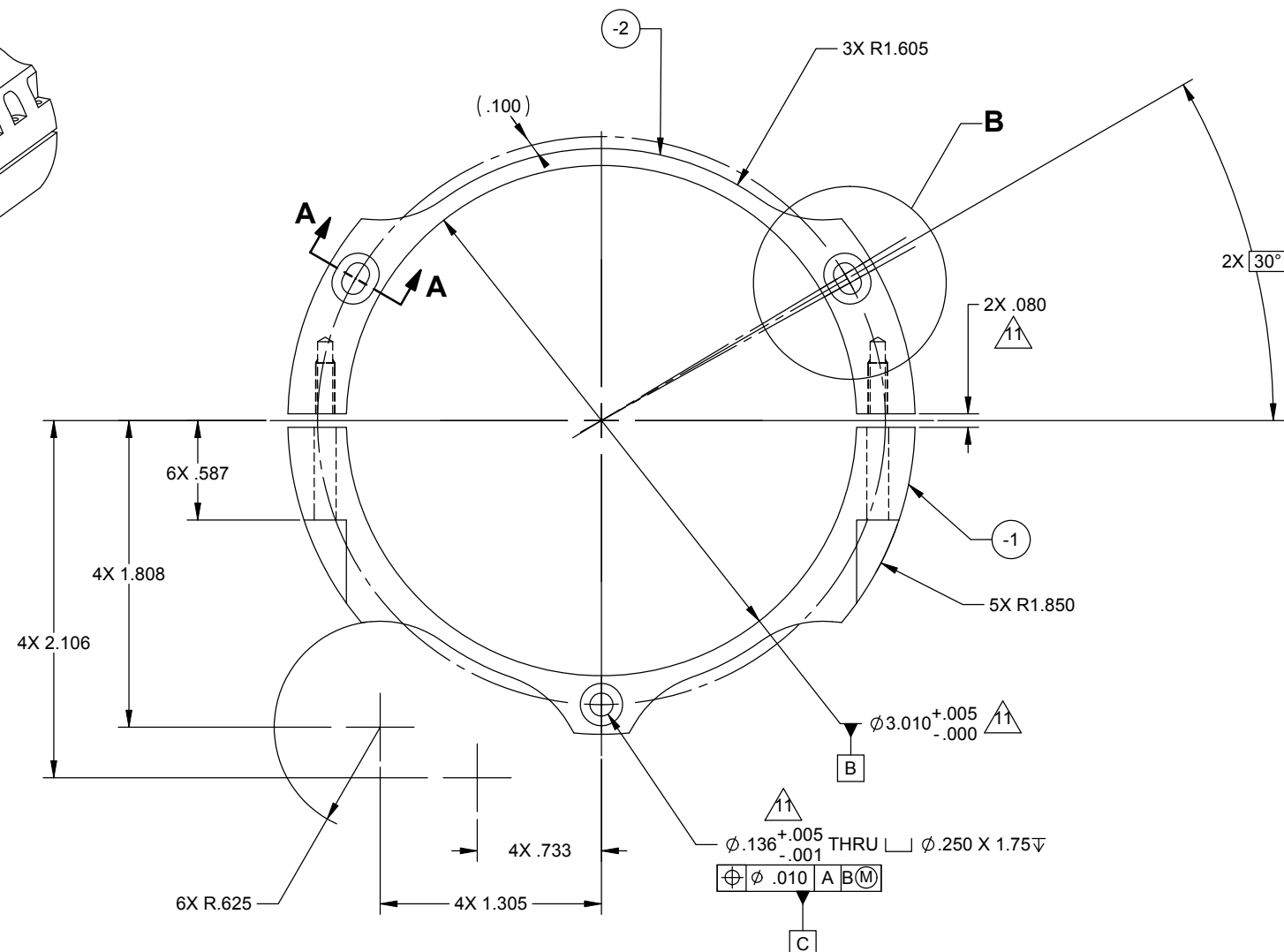
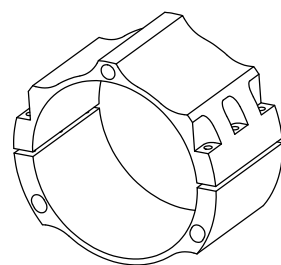
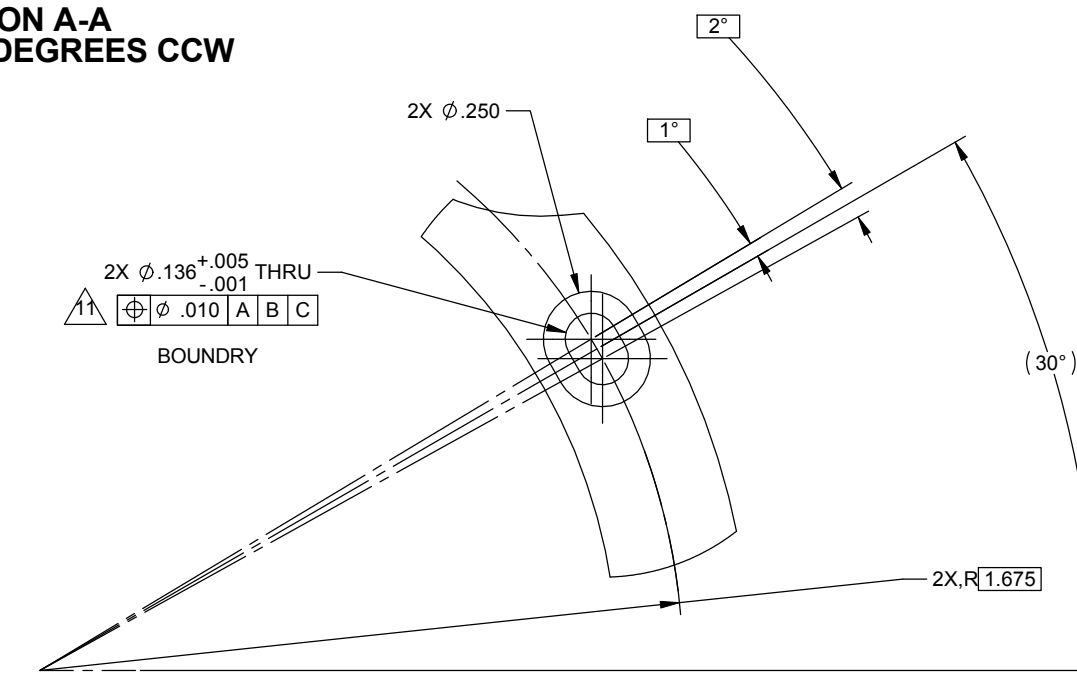
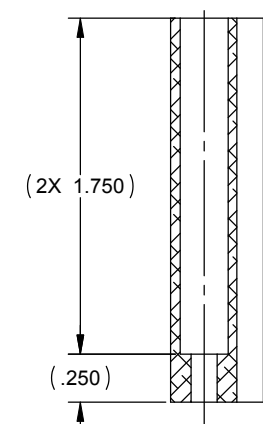


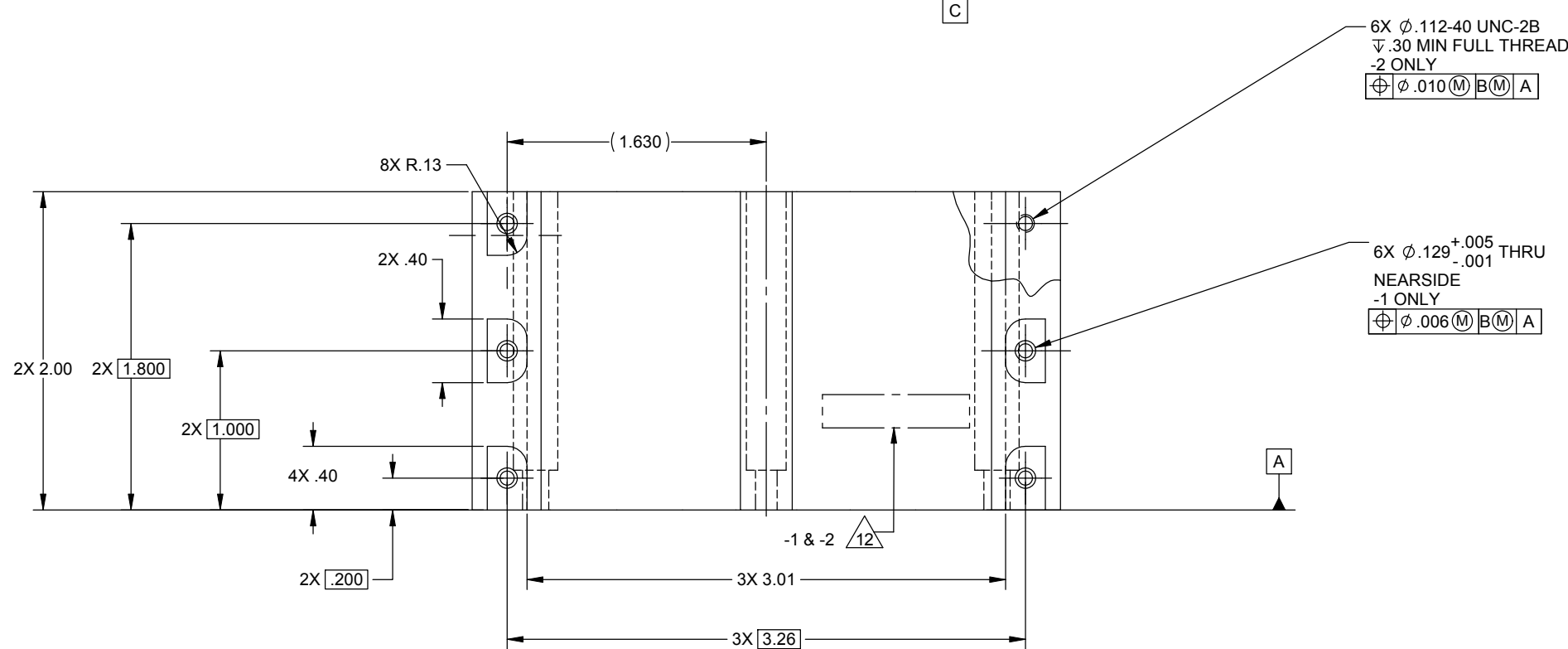
REV.	DATE	DCN #	DRAWING TREE #
V1	02 Dec 2004	-	-
V2	13 AUG 2009	-	-
V3	27 JAN 2010	E0900436	T0900600
V4	20 FEB 2010	E1000048	T0900600



**SECTION A-A  
ROTATED 30 DEGREES CCW**



**DETAIL B  
SCALE 4 : 1  
2X**



- NOTES:
- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
  - NO OVERSIZE THREADED HOLES REQUIRED ON THIS PART
  - ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.
  - MACHINE FILLET RADII .003-.015.
  - COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/- .000.
  - COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
  - NOTED FEATURES SHALL BE INSPECTED PRIOR TO .080 FEATURE COMPLETION.
  - SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± 0.5°		SYSTEM ADVANCED LIGO SUB-SYSTEM SEI NEXT ASSY D047820		Clamp for L4C in Pod	
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.		DESIGNER	ASI	02 DEC. 2004	SIZE DWG. NO.
		DRAFTER	F.MATICHARD	26 JAN. 2010	D
		CHECKER	S.BARNUM	26 JAN. 2010	D047824
		APPROVAL	K.MASON	26 JAN. 2010	REV. V4
		SCALE: 2:1		PROJECTION:	SHEET 1 OF 1

D047824 - Clamp for L4C in Pod - PART FDM REV-V3 - DRAWING FDM REV-V3-000