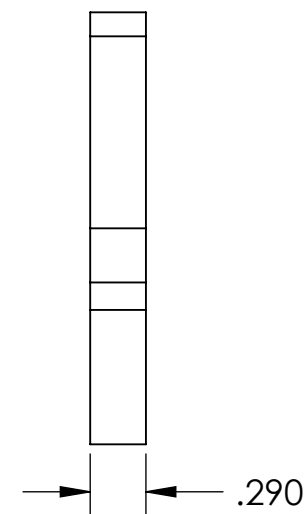
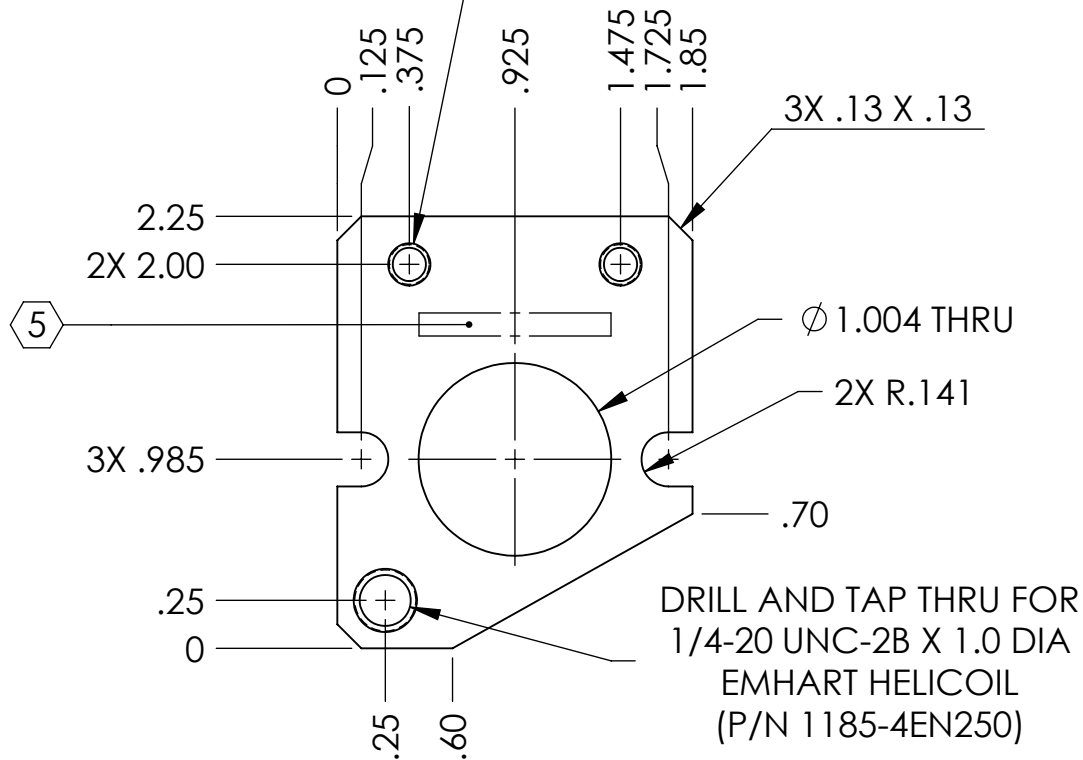
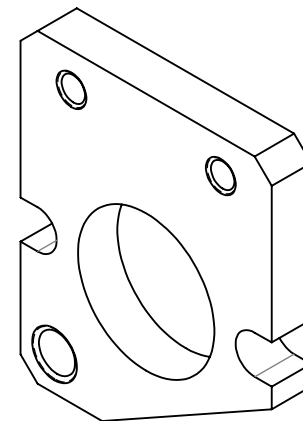


NOTES CONTINUED:

- 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	17 AUG 2009	E0900243	E080191
v2	10 AUG 2010	E1000301	E080191
-	-	-	-

2X DRILL AND TAP THRU FOR  
#8-32 UNC-2B X 1.5 DIA  
EMHART HELICOIL  
(P/N 1185-2EN246)



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 63 μinch

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM SUS NEXT ASSY MULTIPLE ASSYS

PART NAME AOSEM ALIGNMENT BRACKET, BOTTOM MASS

DESIGNER	D. BRIDGES	01 NOV 2010	SIZE	DWG. NO.	REV.
DRAFTER	D. BRIDGES	01 NOV 2010	A	D0901549	v2
CHECKER	B. MOORE	02 NOV 2010	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1
APPROVAL					