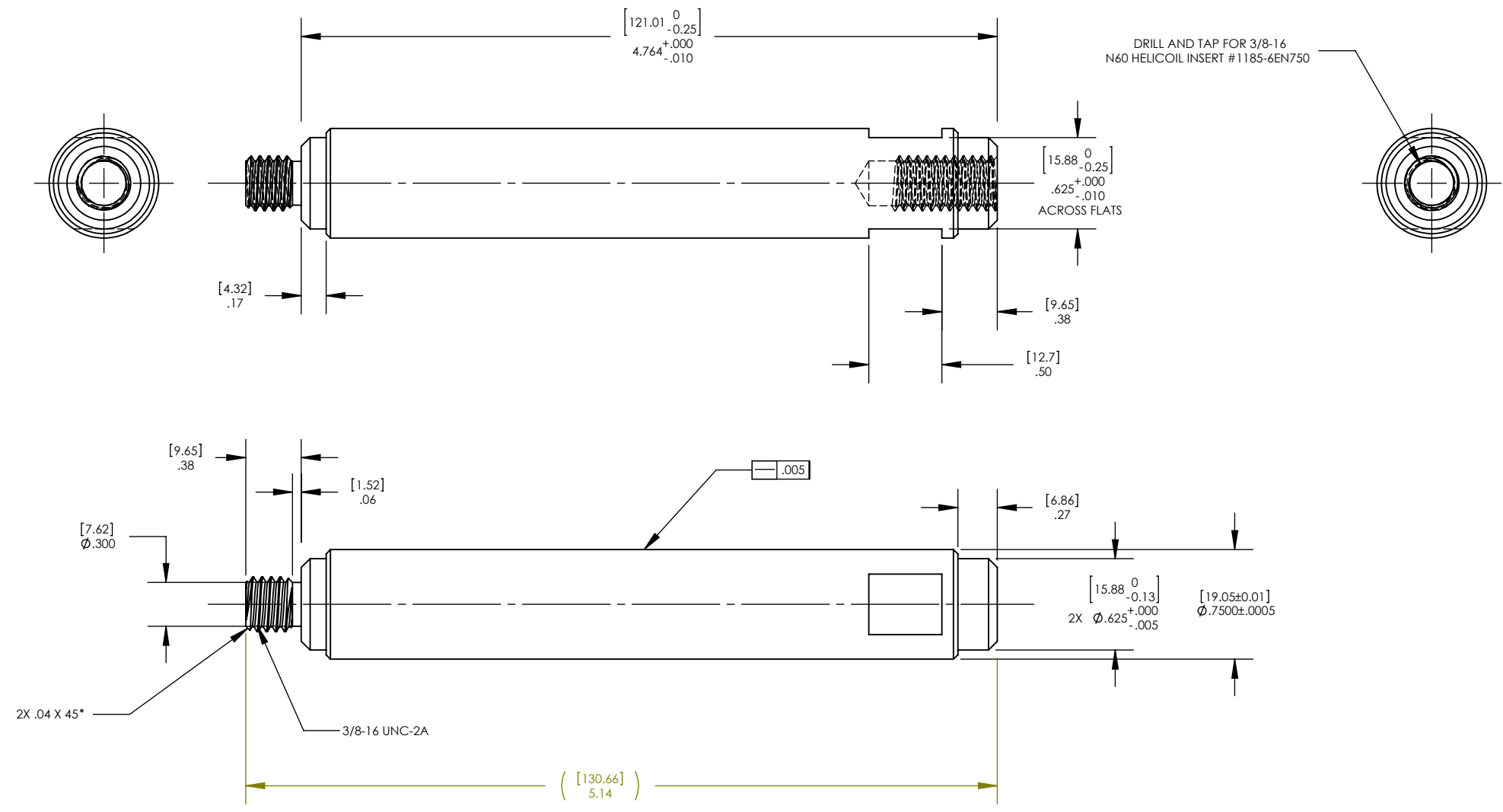


D0902124 LOCATING SHAFT, FM, COC CONTAINER, ADVANCED LIGO, PART PDM REV: X-003, DRAWING PDM REV: X-008

- NOTES CONTINUED:**
- Ⓢ BAG ALL ITEMS AND MARK OR TAG EACH BAG WITH DRAWING NUMBER, REVISION, AND QUANTITY. EXAMPLE: DXXXXXX-VY, QTY: TBD
  - Ⓢ CAN BE MADE FROM McMASTER #8934K18 PRECISION GROUND SHAFTING
  - Ⓢ HELICOIL INSTALLATION:
    - A) DRILL PILOT HOLE FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELI-COIL PRODUCT CATALOGUE, HC 2000
    - B) COUNTERSINK HOLE FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELI-COIL PRODUCT CATALOGUE, HC 2000
    - C) TAP HOLE FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELI-COIL PRODUCT CATALOGUE, HC 2000
    - D) REMOVE ALL CHIPS
    - E) GAGE THREADS WITH GAGE TOOL FOR INSERT SPECIFIED IN DRAWING, REFERENCE HELI-COIL PRODUCT CATALOGUE, HC 2000
    - F) CLEAN THE HOLE, INSERTING TOOL AND HELI-COIL WITH SOAP AND WATER
    - G) CLEAN THE HELI-COIL AND INSERT TOOL IN ACETONE (IF THE INSERT TOOL HAS ANY PLASTIC USE ISOPROPYL ALCOHOL INSTEAD OF ACETONE TO CLEAN THE INSERT TOOL)
    - H) CLEAN THE HOLE WITH ACETONE AND A STAINLESS STEEL WIRE BRUSH
    - I) RINSE THE HELI-COIL, INSERTING TOOL AND THE HOLE WITH DE-IONIZED WATER
    - J) POWDER FREE LATEX GLOVES MUST BE WORN WHEN INSERTING THE HELI-COILS. (LATEX GLOVES FROM ANSELL EDMONT, ACCUTECH-ULTRA CLEAN 91-300)
    - K) INSERT THE HELI-COIL WITH TOOL TO ¾ TO 1½ PITCH BELOW SURFACE
    - L) BREAK OFF AND REMOVE TANG
    - M) ONCE HELI-COILS HAVE BEEN INSERTED AND FINAL ASSEMBLY IS BEING CARRIED OUT, FOR EXAMPLE, INSERTING THE O-RINGS PLEASE KEEP THE ASSEMBLIES AS CLEAN AS POSSIBLE I.E. FREE FROM OIL, GREASE, DIRT, AND CHIPS OR

REV.	DATE	DCN #	DRAWING TREE #
v1	23 SEPT 2009	E0900365	
v2	11 NOV 2009	E0900412	



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME				
DIMENSIONS ARE IN INCHES [MM] 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.		LOCATING SHAFT, FM, COC CONTAINER				
						SYSTEM <b>ADVANCED LIGO</b>	SUB-SYSTEM <b>COC</b>	DESIGNER K. BUCKLAND	23 SEPT 2009	SIZE DWG. NO. <b>B</b>
MATERIAL 304 SSSL 6		FINISH 63 μinch		NEXT ASSY D0902120		DRAFTER K. BUCKLAND	23 SEPT 2009	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1