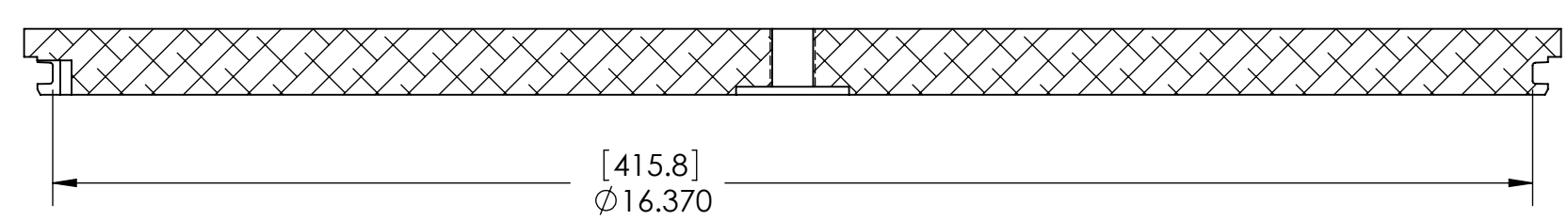
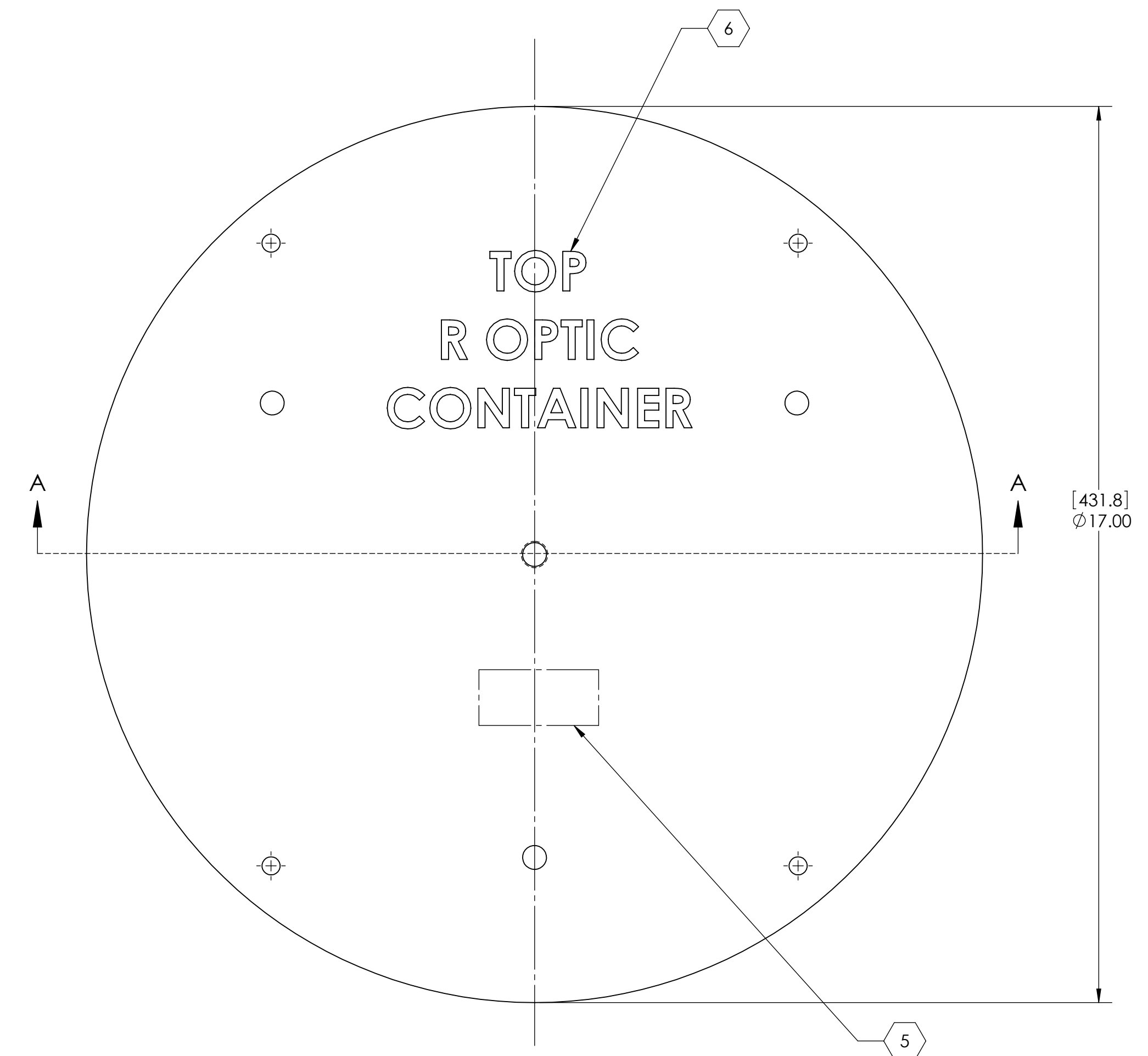
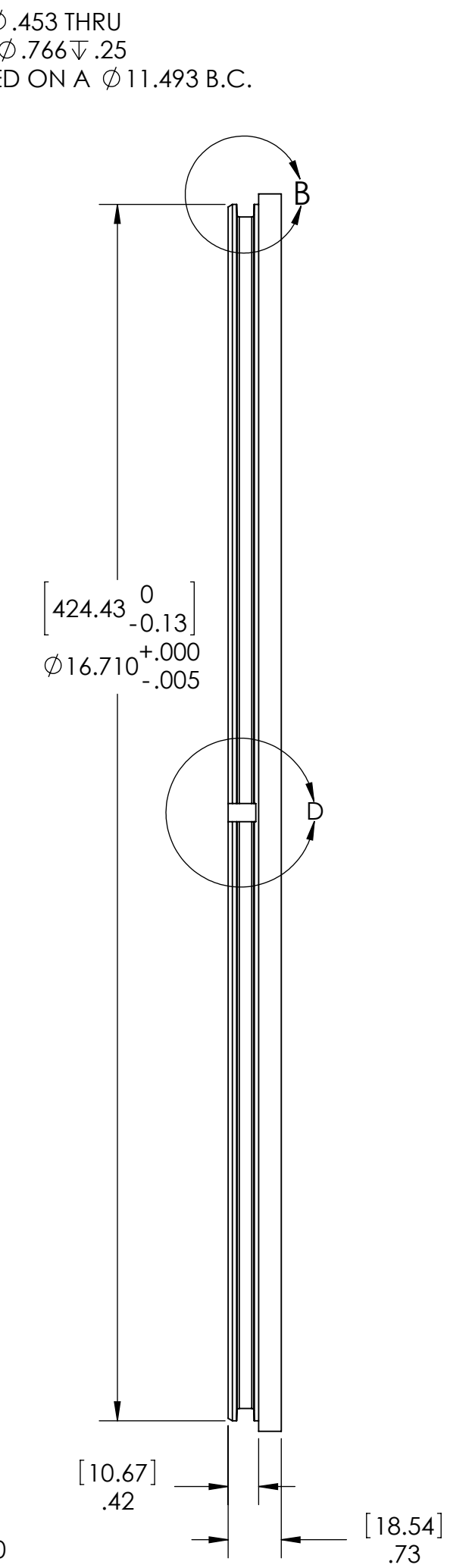
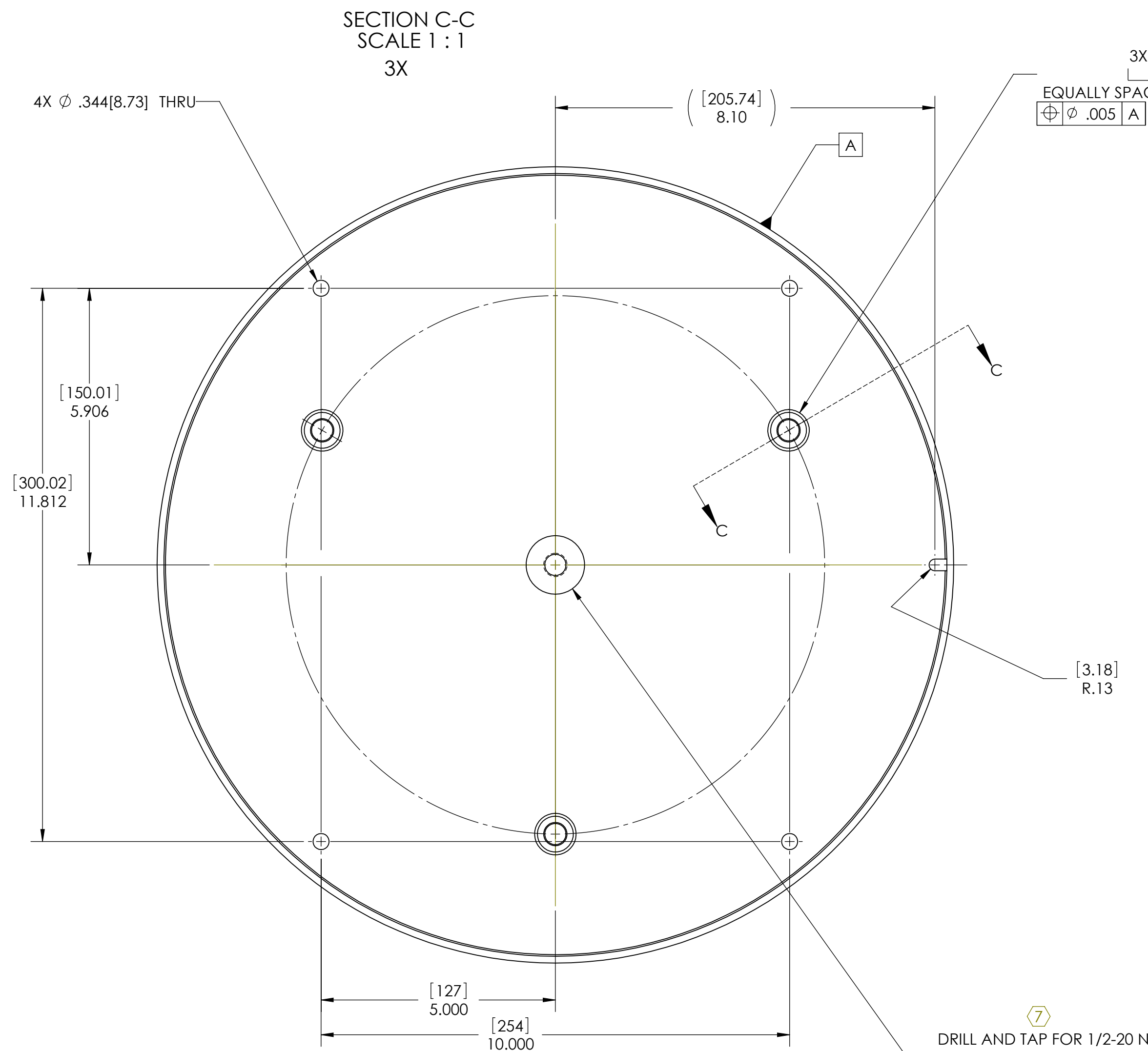
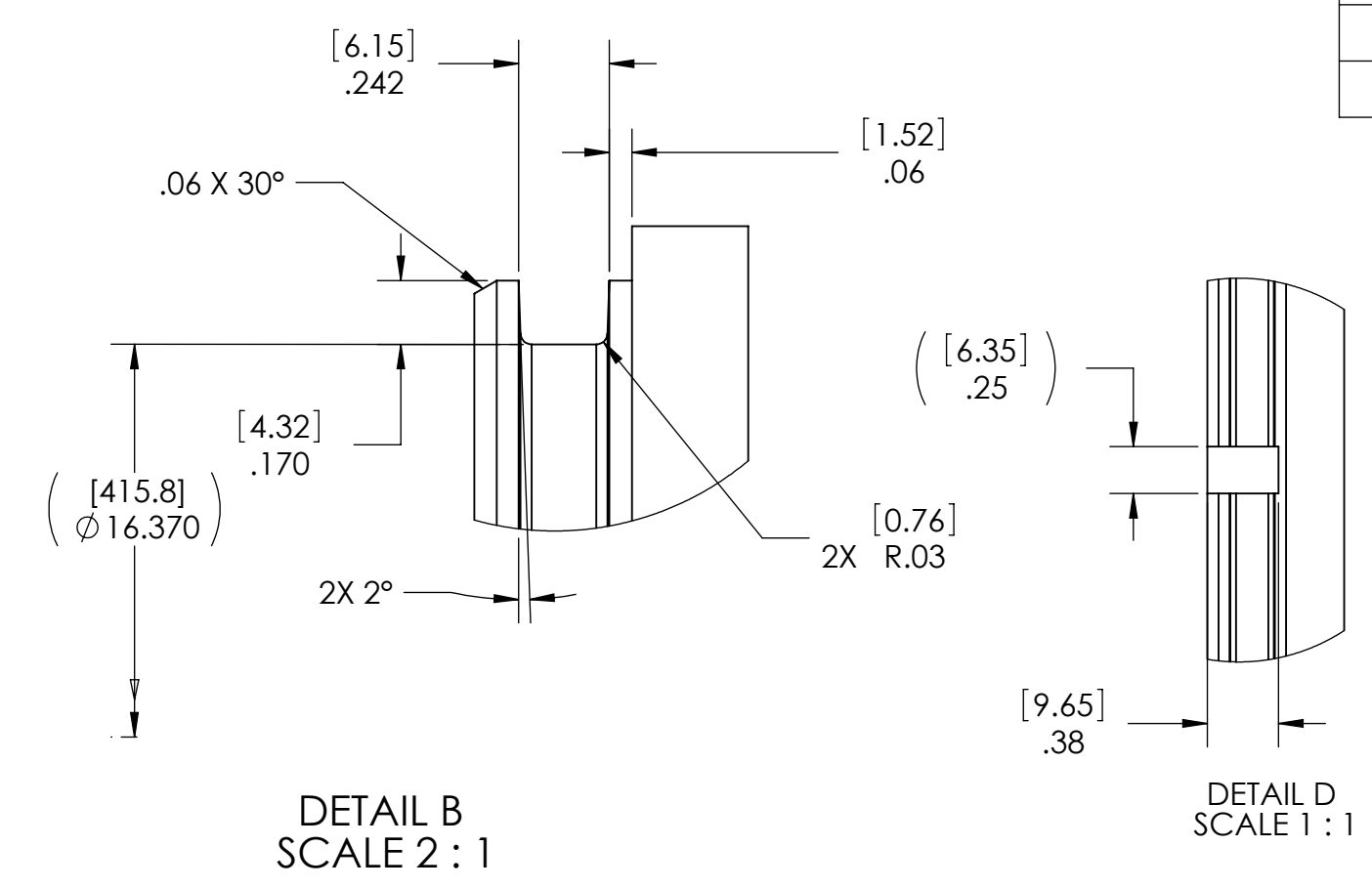
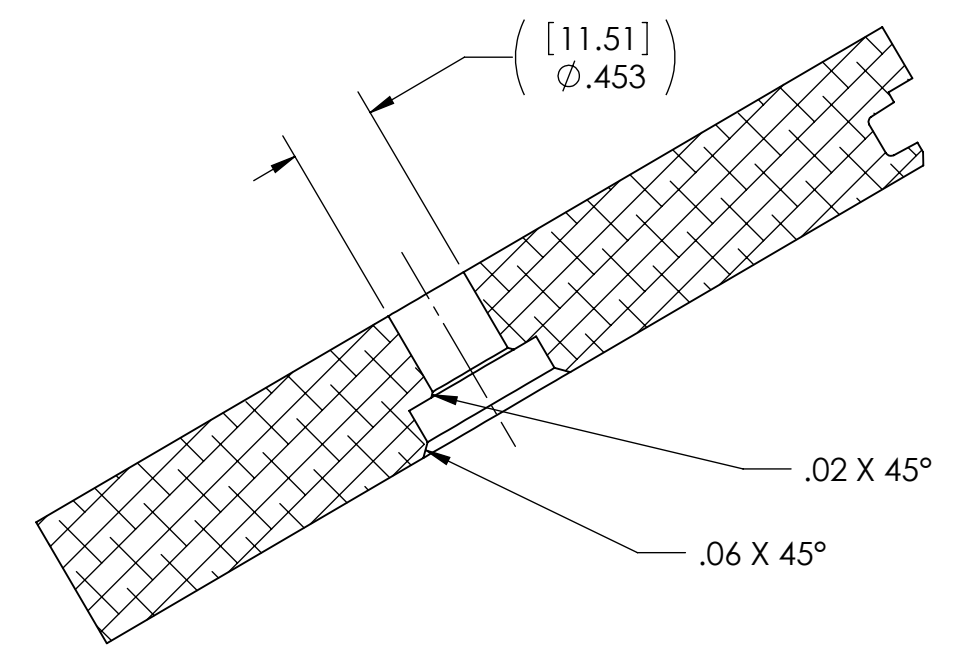


NOTES CONTINUED:  
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.  
 ⑥ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP TEXT (NO INKS OR DYES) APPROX. WHERE SHOWN. LETTERING APPROX. .75 HIGH

REV.	DATE	DCN #	DRAWING TREE #
v1	21 OCT 2009	E0900366	
v2	11 NOV 2009	E0900412	
v3	30 NOV 2009	E0900438	



⑦ 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 3/4 TO 1 1/2 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

⑦ DRILL AND TAP FOR 1/2-20 N60 HELICOIL INSERT #1191-8EN500  
 $\square$   $\phi$  1.250  $\pm$  .09

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
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.	
DIMENSIONS ARE IN INCHES [MM]	
TOLERANCES: .XX $\pm$ .01 .XXX $\pm$ .005	
ANGULAR $\pm$ .5°	
MATERIAL	6061-T6 Al
FINISH	63 $\mu$ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
ADVANCED LIGO		TOP PLATE, R OPTIC, COC OPTIC CONTAINER	
DESIGNER	K. BUCKLAND	24 SEPT 2009	SIZE DWG. NO.
DRAFTER	K. BUCKLAND	4 SEPT 2009	D D0902140
CHECKER	K. MAILAND	10 SEPT 2009	REVISION
APPROVAL	C. TORRIE	10 SEPT 2009	v3
SCALE: 1:2		PROJECTION:	
SHEET 1 OF 1			