

8

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NOTES CONTINUED:

5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.

EXAMPLE (PART): 001-v1  
EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD

6. APPROXIMATE WEIGHT = 0.109 LB.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

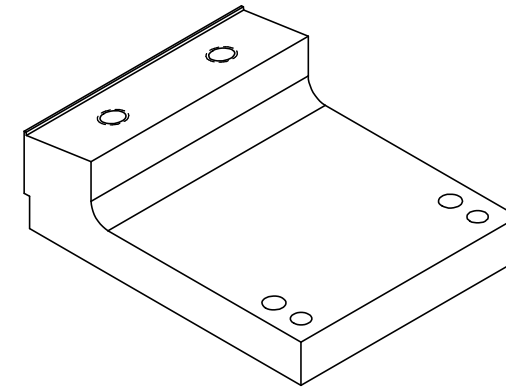
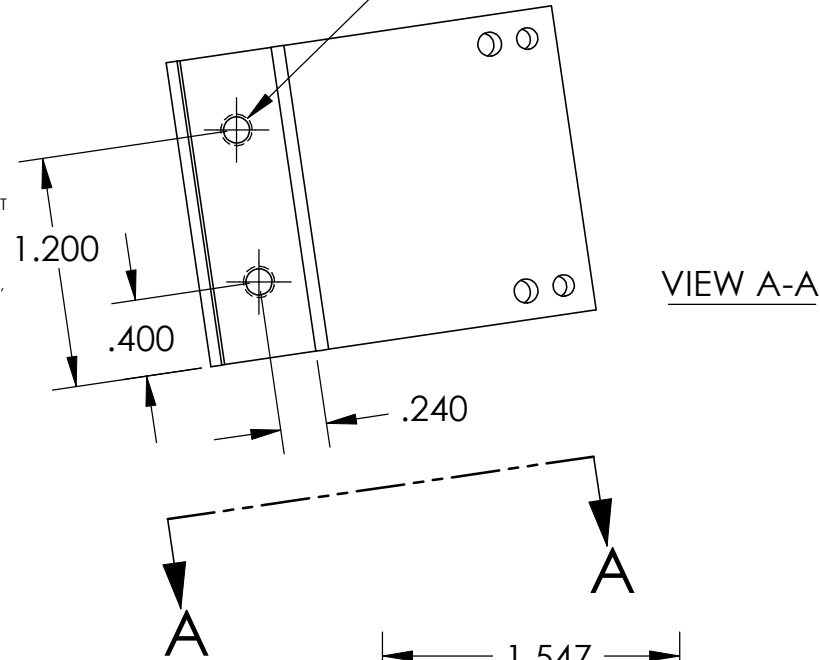
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

TAP FOR #8-32 HELICOIL THRU (1185-2EN328)  
2 PLACES



VIEW A-A

D

D

C

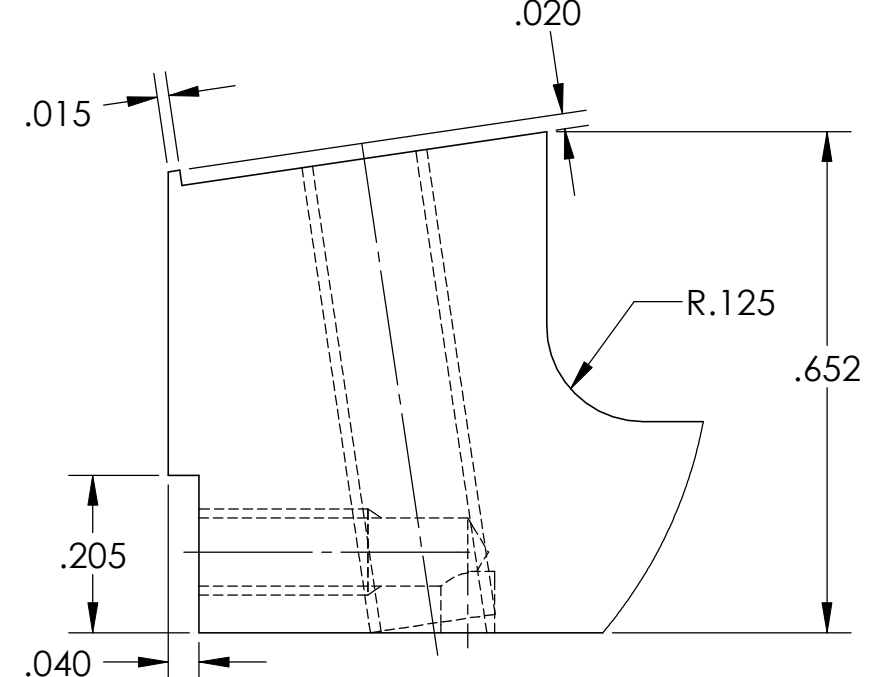
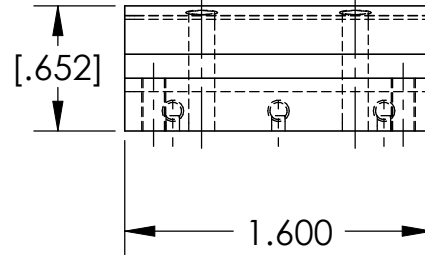
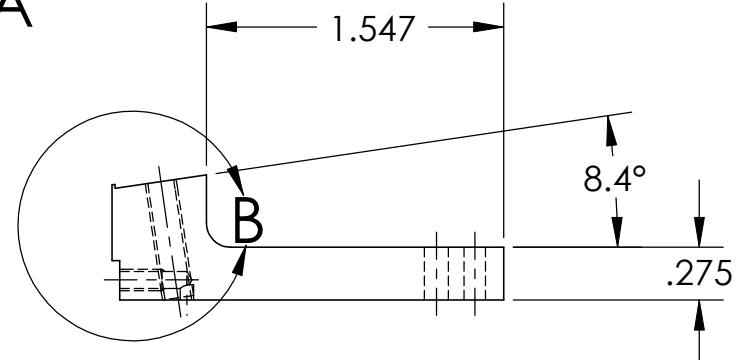
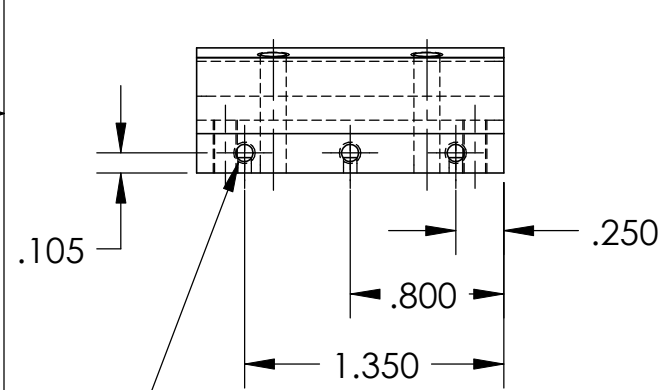
C

B

B

A

A



DETAIL B  
SCALE 4 : 1

Ø.070  
THRU TO HOLE  
3 PLACES

TAP FOR #4-40 HELICOIL (1185-04EN112)  
.315 DEEP  
3 PLACES

Ø.125 THRU  
2 PLACES

TAP FOR #4-40 HELICOIL THRU (1185-04EN224)  
2 PLACES

2.040

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:  
.XX ± .01  
.XXX ± .003

ANGULAR ± 0.1°

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.

MATERIAL 6061 Alloy FINISH 63 µinch

LIGO UNIVERSITY OF FLORIDA CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM 100

NEXT ASSY D1000120

PART NAME BLADE PITCH ADJUSTER

DESIGNER L.WILLIAMS 11 MAR 2010 SIZE DWG. NO. B D1000092 REV. v3

DRAFTER L.WILLIAMS 25 MAR 2010 CHECKER APPROVAL SCALE: 1:1 PROJECTION: SHEET 1 OF 1

D1000092 ALIGO IO HAM AUX SUS BLADE PITCH ADJUSTER, PART PDM REV: X-011, DRAWING PDM REV: X-005

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