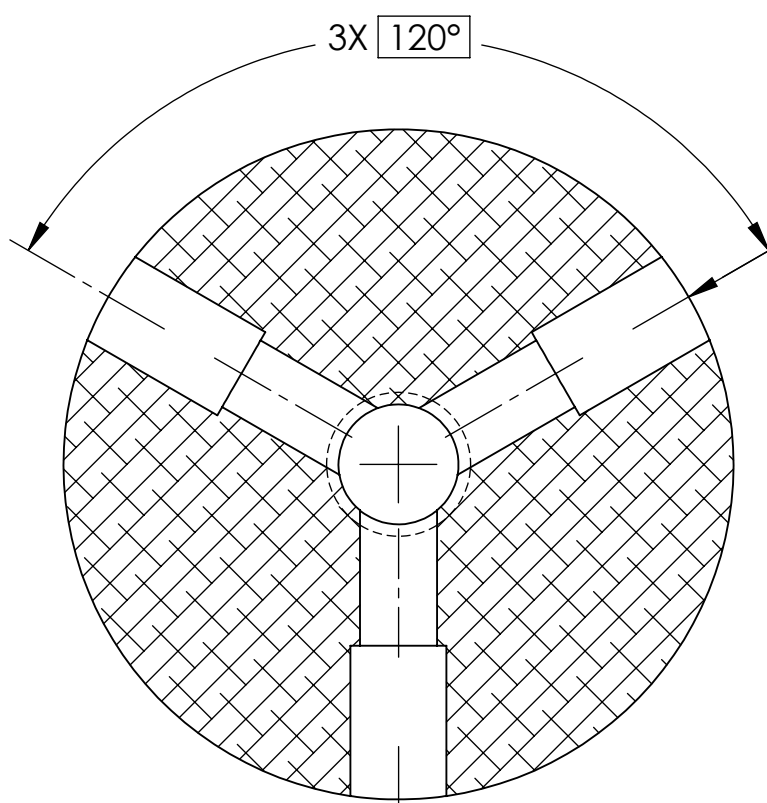
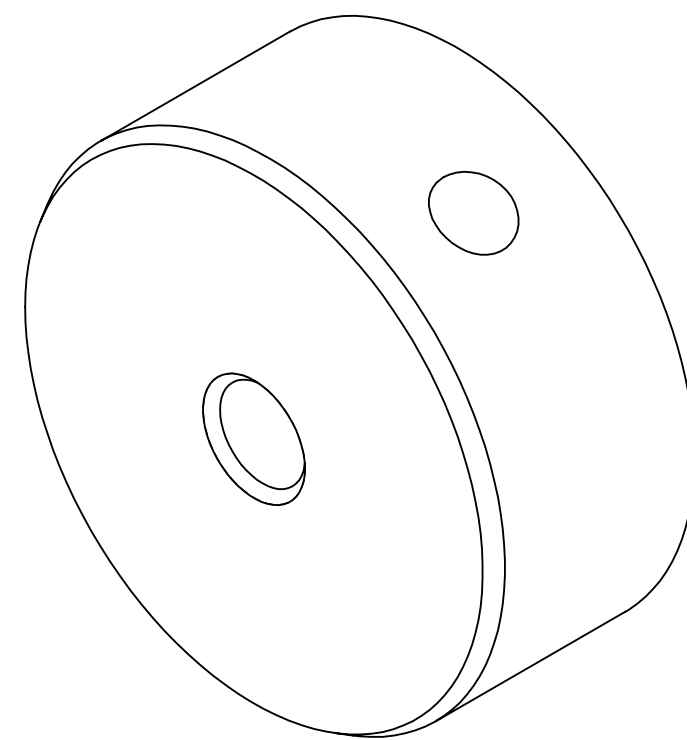
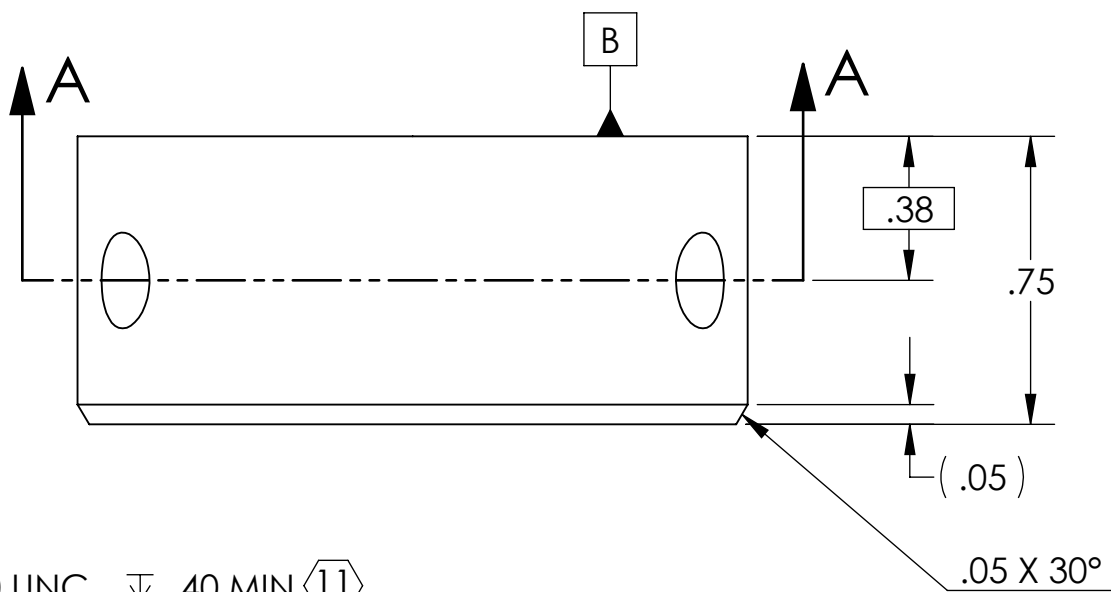


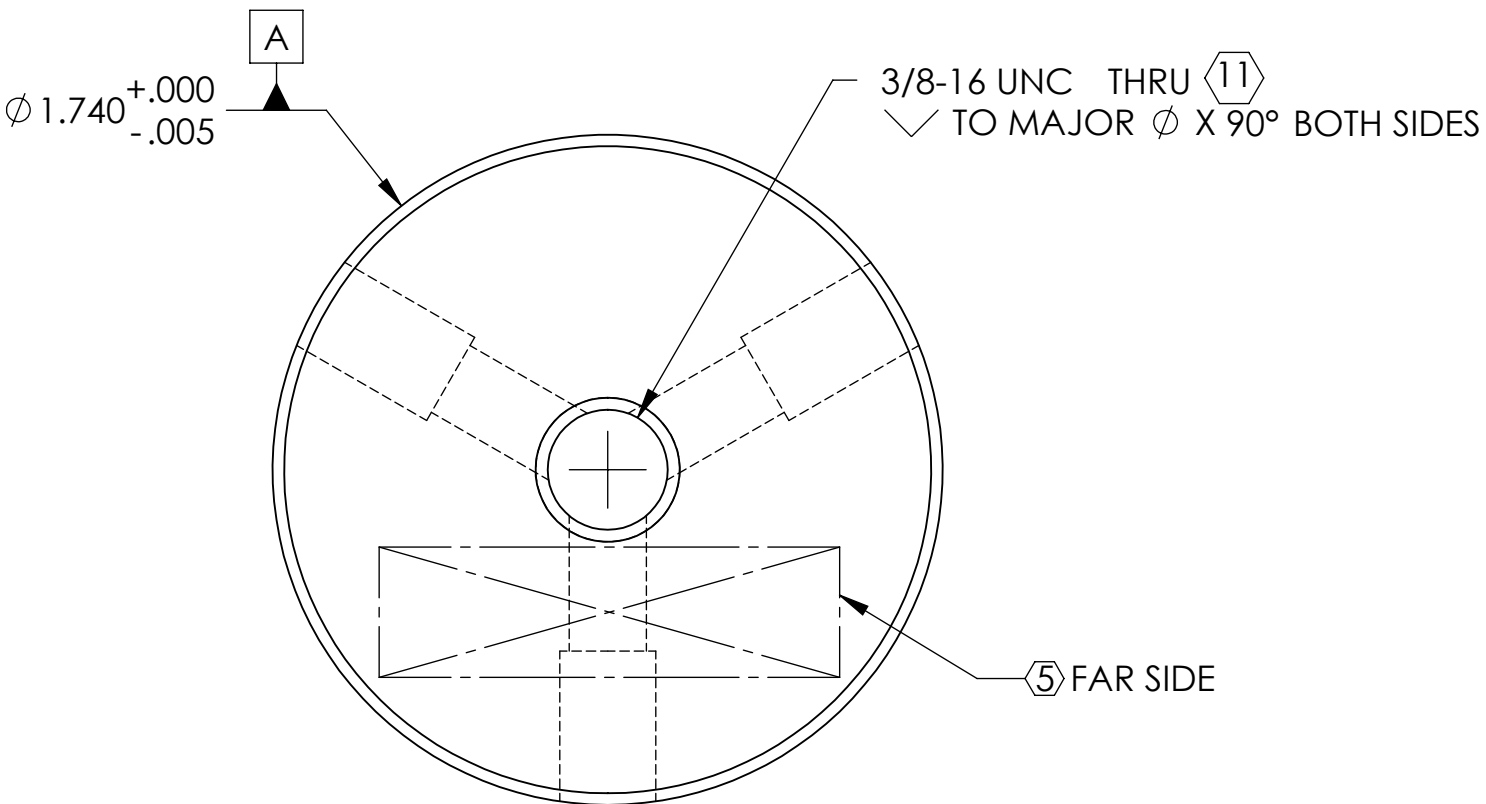
NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. APPROXIMATE WEIGHT = .16 LB (.07 kg)
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO. REFER TO LIGO-E0900364.
- 10. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.
- 11. ALL TAPPED HOLES- USE .005 OVERSIZE DRILL & TAP.

REV.	DATE	DCN #	DRAWING TREE #
v1	03-SEPT-2010	E1000365	-
v2	16-NOV-2010	E1000688	-
v3	24 MAR 2012	E1200317-x0	-



3X 1/4-20 UNC  $\nabla$  .40 MIN  $\text{\textcircled{11}}$   
 DRILL THRU WALL AS SHOWN  
 $\text{\textcircled{+}} \phi .014 \text{\textcircled{A}} \text{\textcircled{S}} \text{\textcircled{B}}$



D1000242 cLIGO\_ETM\_TEL\_TUBE\_THD\_INSERT, PART PDM REV: X-033, DRAWING PDM REV: X-019

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX $\pm$ .01 .XXX $\pm$ .005 ANGULAR $\pm$ 0.5°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		ALIGO ETM TELE TUBE THD INSERT	
MATERIAL		FINISH		SYSTEM		SUB-SYSTEM	
6061-T6 Al		63 $\mu$ inch Ra		ADVANCED LIGO		AOS	
NEXT ASSY				DESIGNER		DATE	
D1000243				K MAILAND		04 MAY 2010	
REVISION				DRAFTER		DATE	
REV. v3				I ROMERO		04/MAY/2010	
CHECKER				APPROVAL		SCALE: NONE	
K MAILAND				K MAILAND		04/MAY/2010	
DRAWING NO.				PROJECTION:		SHEET 1 OF 1	
B D1000242				FIRST ANGLE		1	