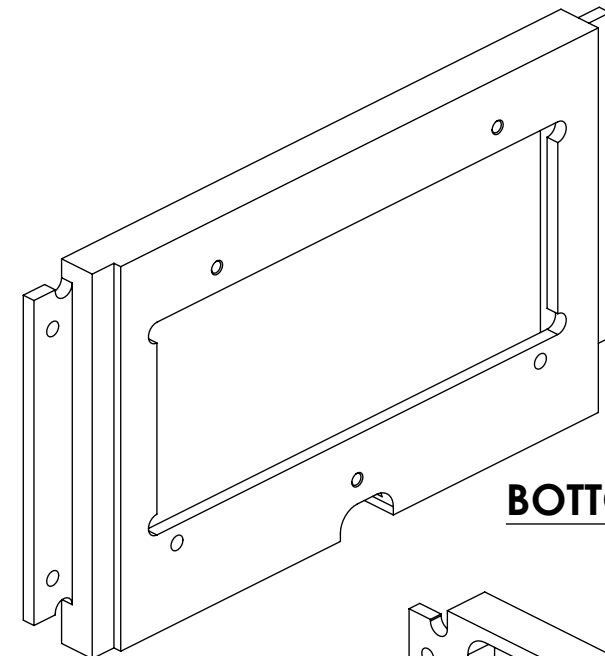
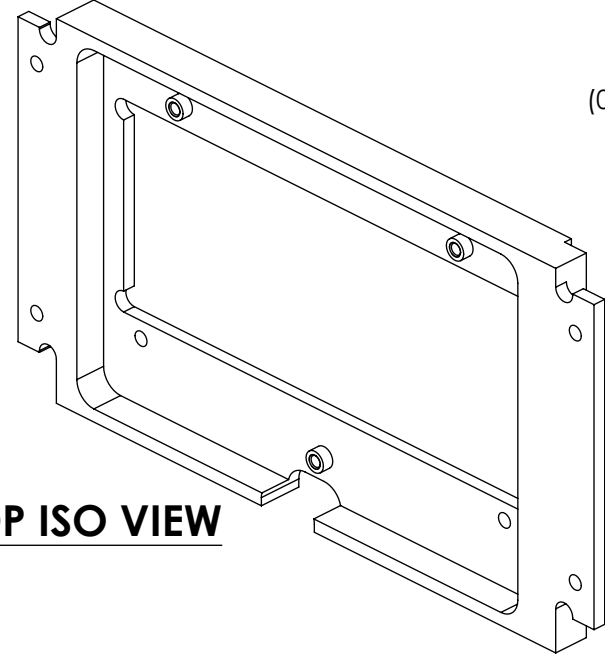


D1000410 QUGO\_OSUMS\_INTERMEDIATE\_SUPPORT\_LEFT\_SIDE\_TRAY, PART PDM REV: X-182, DRAWING PDM REV: X-020

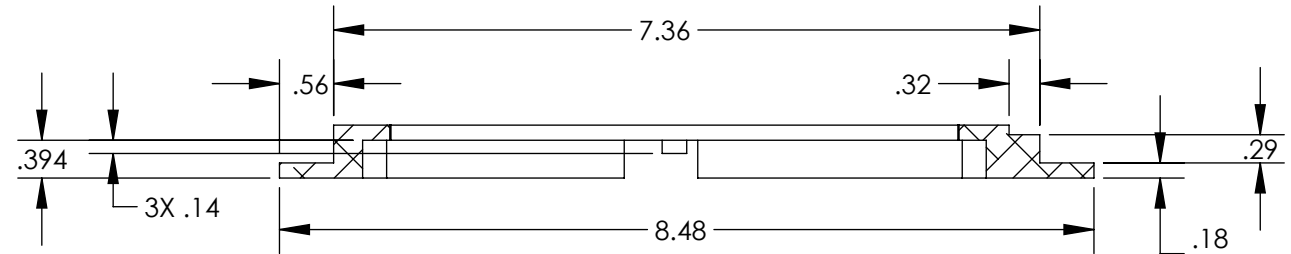
REV.	DATE	DCN #	DRAWING TREE #
v1	29 JUN 2010	E1000234	
v2	31 MAR 2011	E1100277	
v3	13 MAR 2012	E1200216	



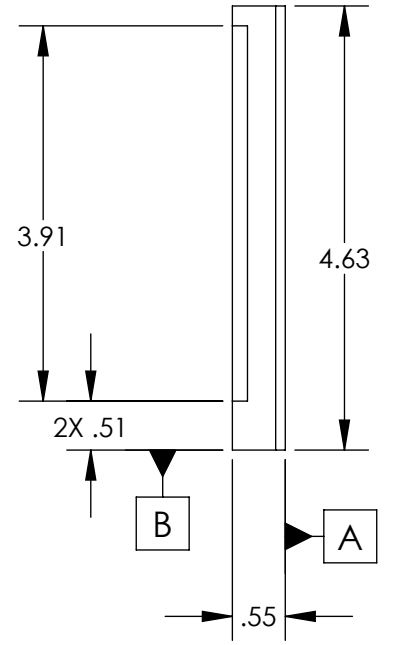
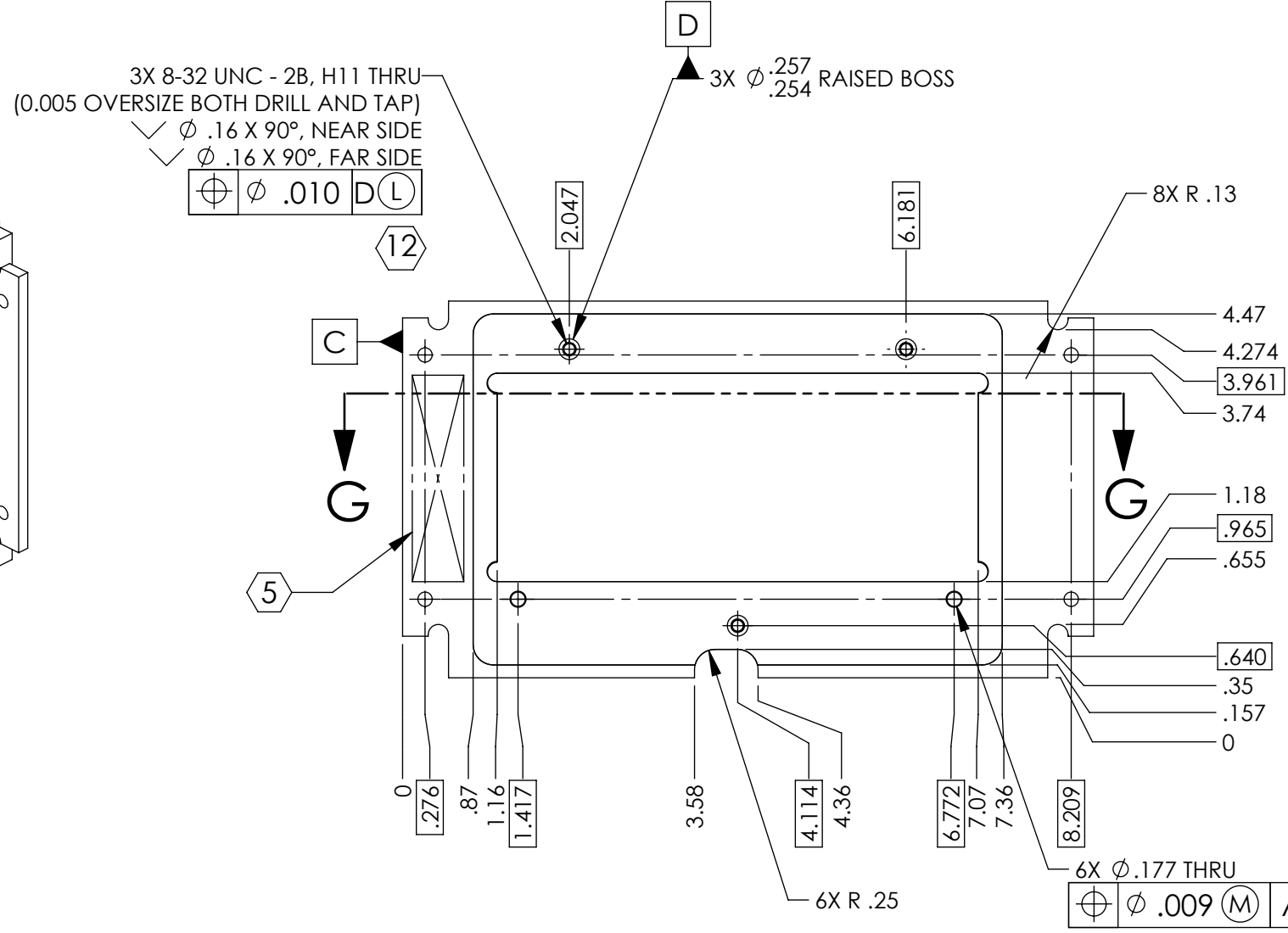
**BOTTOM ISO VIEW**



**TOP ISO VIEW**



**SECTION G-G**



**NOTES (CONTINUED):**

- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE, PER LIGO SPECIFICATION E0900237.
- 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. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXXX-VY, TYPE-XX, S/N XXX.
- MASS: 256 G [0.564 LB].
- MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364.
- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- ALL HELI-COIL TAPPED HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG HC2000.
- ALL HELICOIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
- ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NOT WELD REPAIRS OR PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING BY LIGO LABORATORY. REFER TO LIGO-E0900364.
- ALL TAPPED HOLES: 0.005" OVERSIZE, BOTH DRILL AND TAP.

DIMENSIONS ARE IN INCHES	
TOLERANCES:	.XX ± .01
	.XXX ± .005
ANGULAR ± 1.0°	

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
1. INTERPRET DRAWING PER ASME Y14.5-1994.	
2. REMOVE ALL SHARP EDGES, .005-.015.	
3. DO NOT SCALE FROM DRAWING.	

MATERIAL		FINISH		NEXT ASSY		PART NAME	
6061-T6 Al		63 µinch Ra		D1000549		QUGO OSUMS INTERMEDIATE SUPPORT LEFT SIDE TRAY	
DESIGNER	K. MAILAND	23 FEB 2010	SIZE	DWG. NO.		REV.	
DRAFTER	I ROMERO	23 OCT 2010	B	D1000410		v3	
CHECKER	SEE DCN		SCALE: NONE	PROJECTION:		SHEET 1 OF 1	
APPROVAL	SEE DCN						