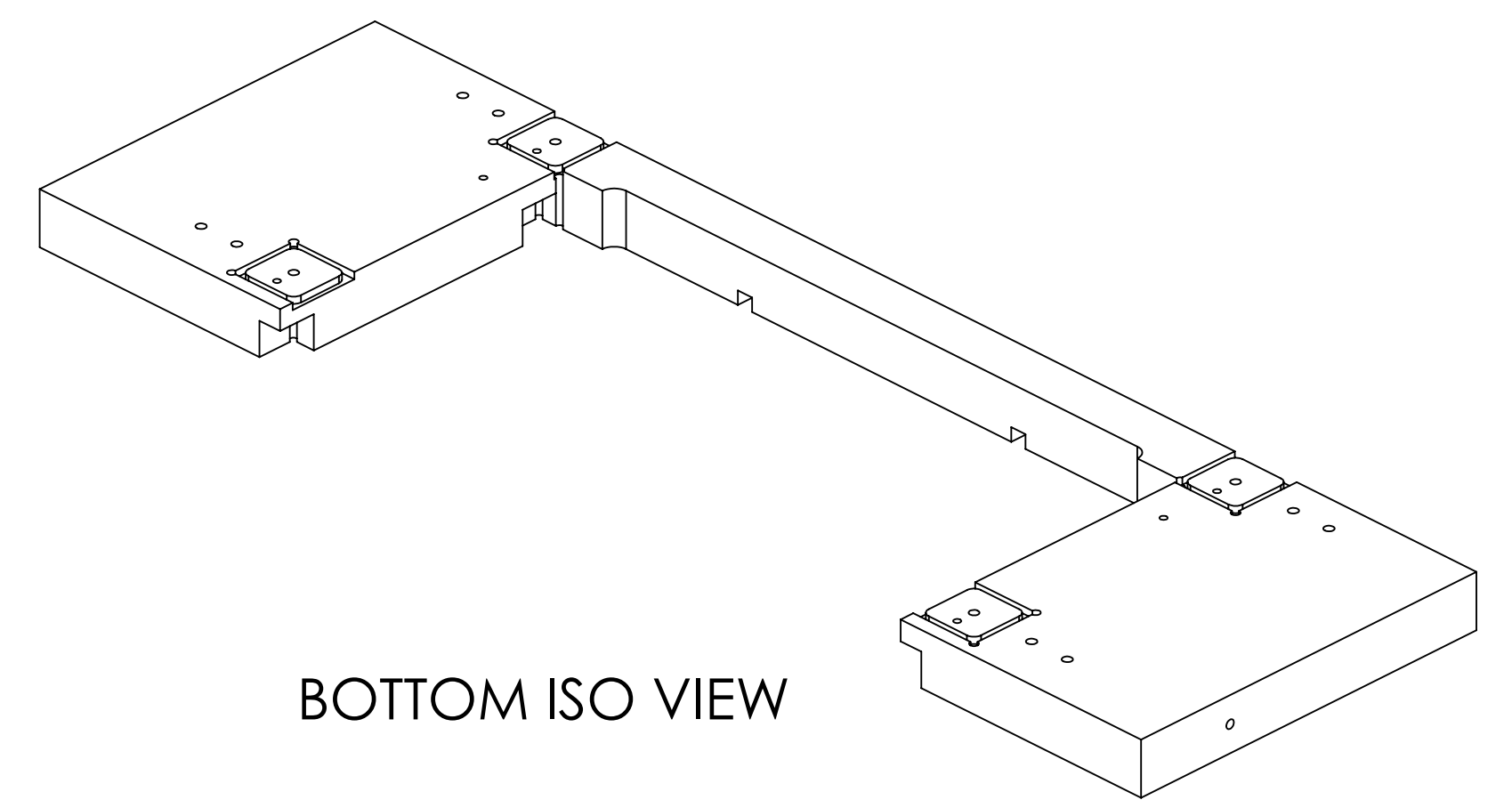
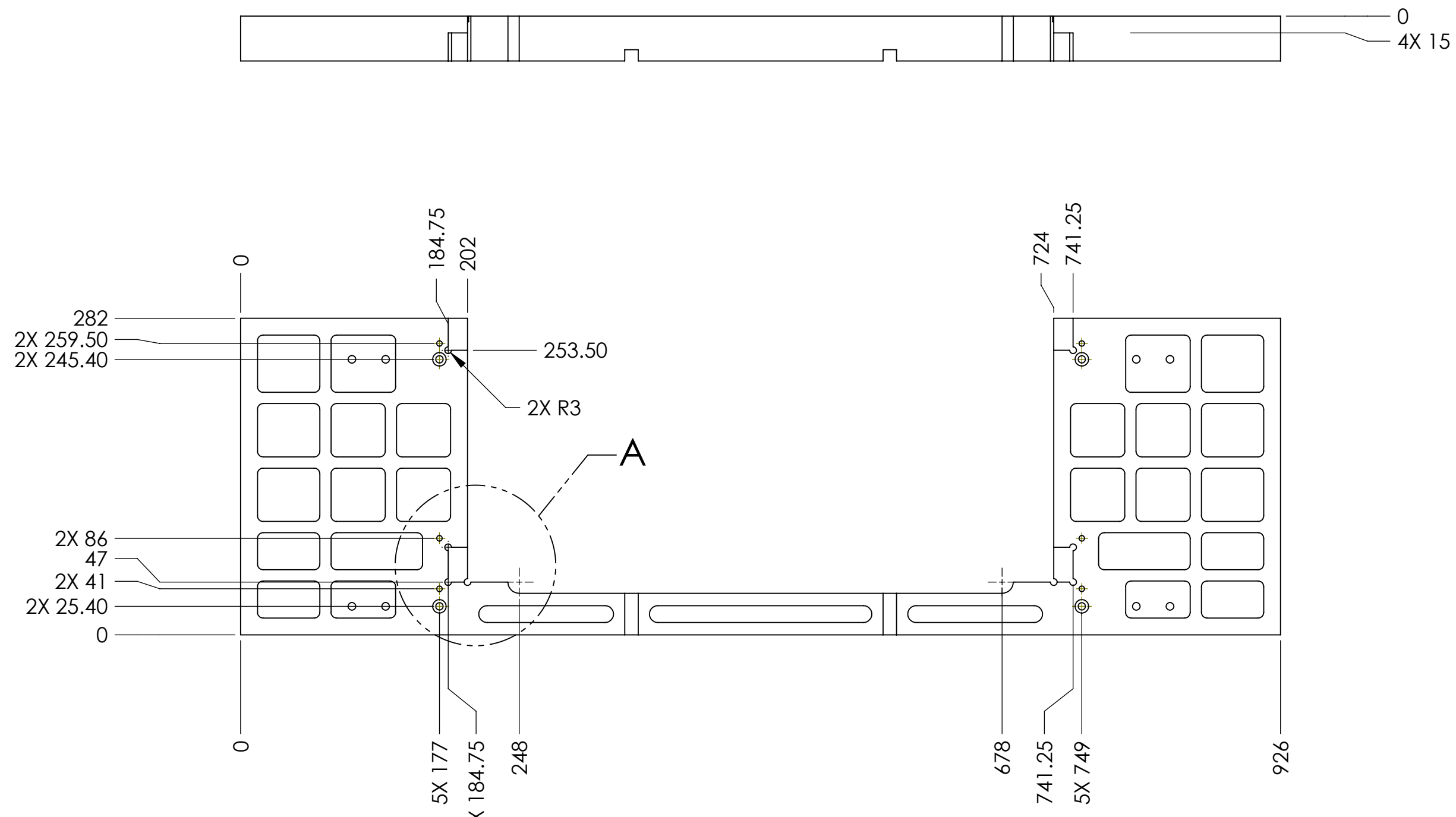


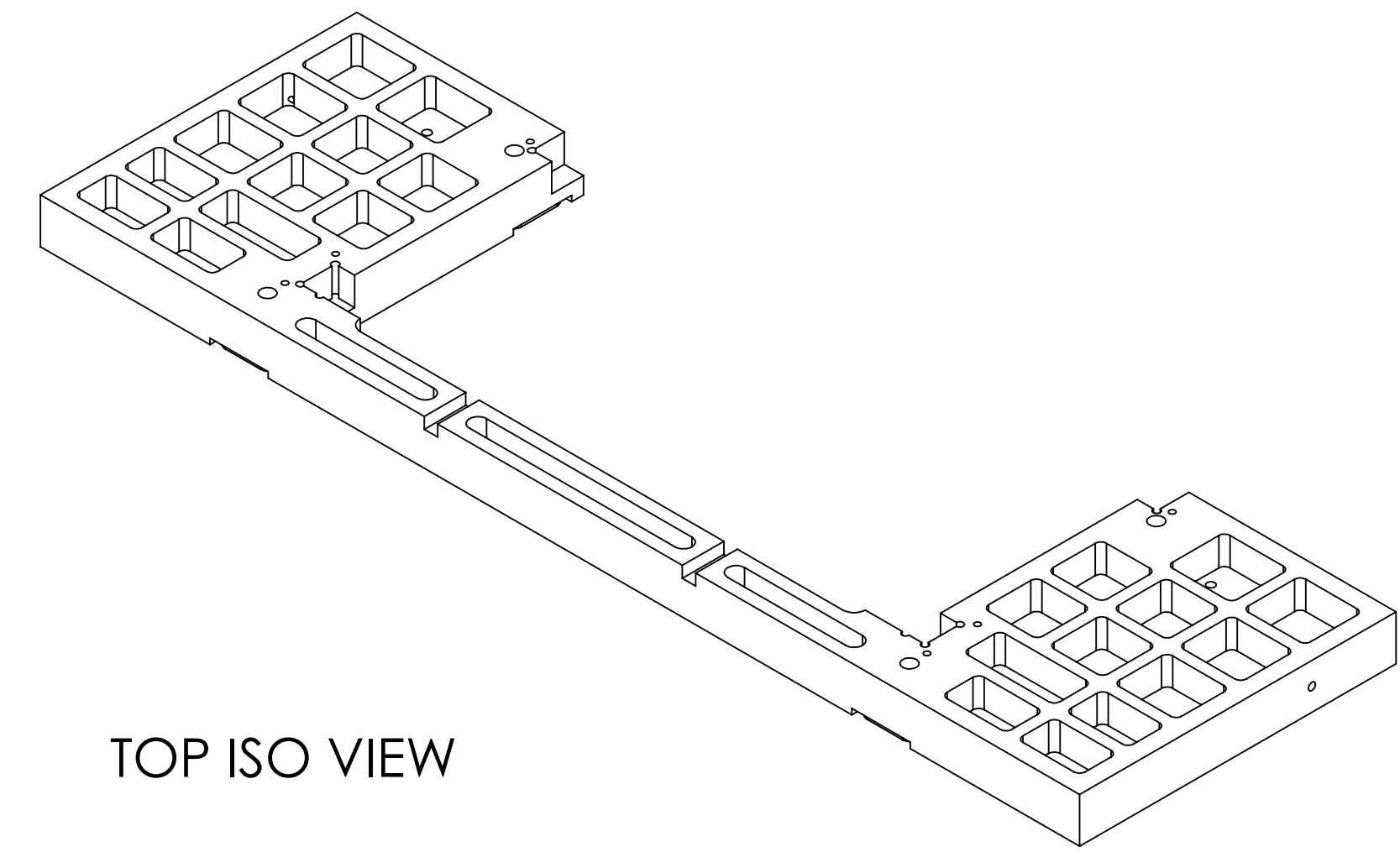
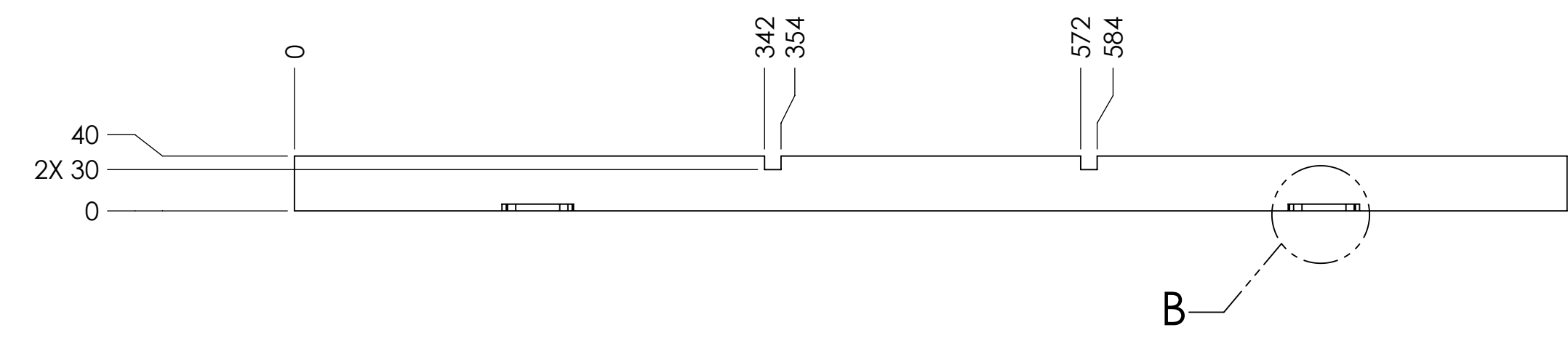
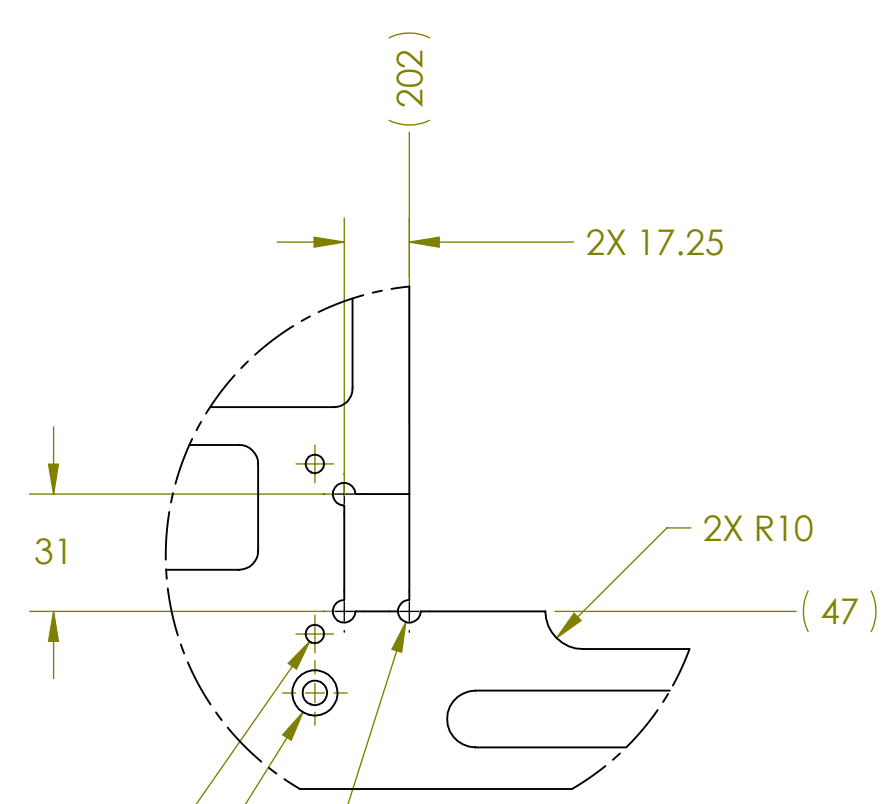
REV.	DATE	DCN #	DRAWING TREE #
v1	24 MAY 2010		
v2	16 JUL 2010		

**NOTES CONTINUED:**  
 (5) SCRIBE, ENGRAVE, 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: DXXXXXX-VY, TYPE-XX, S/N XXX

- (6) HELICOIL INSTALLATION:  
 MACHINE SHOP
- a) Drill pilot hole for insert specified on the drawing, reference HeliCoil product catalogue, HC 2000
  - b) Countersink hole to 1200±50, reference HeliCoil product catalogue, HC 2000, for diameter
  - c) Tap hole for insert specified on the drawing, reference HeliCoil product catalogue, HC 2000
  - d) Remove all chips
  - e) Gage threads with gage tool for insert specified in drawing, reference HeliCoil product catalogue, HC 2000 and as per agreed inspection
- LIGO (The following would be included in the assembly document or associated specification))
- f) clean all of the parts (tools, metal parts, HeliCoils, insert tool etc...) as per LIGO Vacuum Compatibility, Cleaning Methods and Qualification Procedures E960022
  - g) Handle parts as per LIGO Vacuum Compatibility, Cleaning Methods and Qualification Procedures E960022
  - h) Gage threads with gage tool for insert specified in drawing, reference HeliCoil product catalogue, HC 2000 as per on agreed inspection
  - i) Insert the HeliCoil with tool to ¾ to 1½ pitch below surface
  - j) Test with appropriate screw
  - k) Break off and remove tang
7. UNDIMENSIONED FEATURES ARE CONTROLLED BY THE SOLIDWORKS MODEL AND HAVE A TOLERANCE OF ±.25mm.
8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
9. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364



BOTTOM ISO VIEW



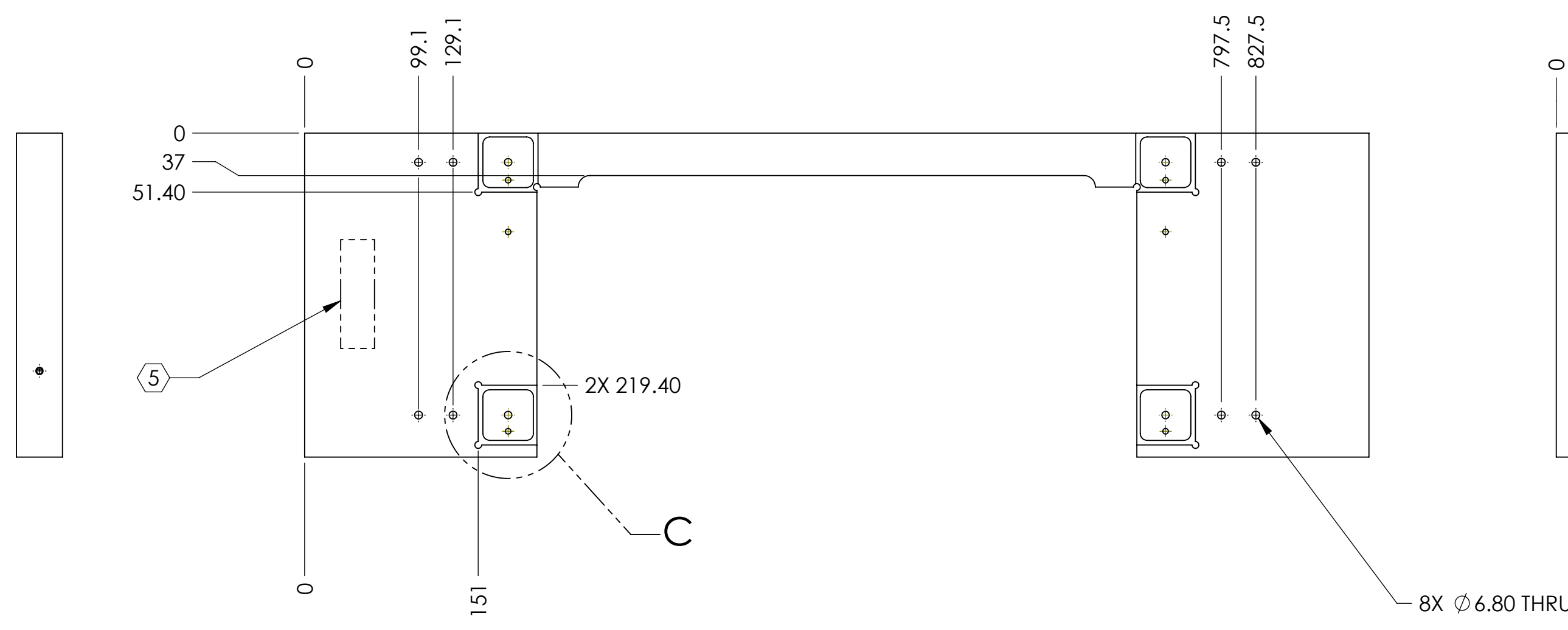
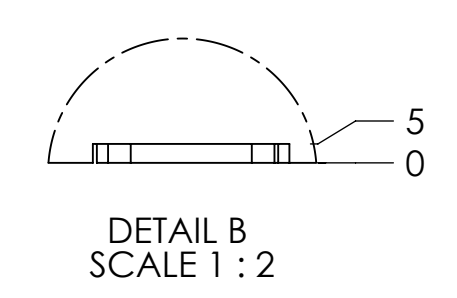
TOP ISO VIEW

(6) 6X6X DRILL AND TAP FOR 1/4-20 N60 HELICOIL INSERT #1185-4EN500

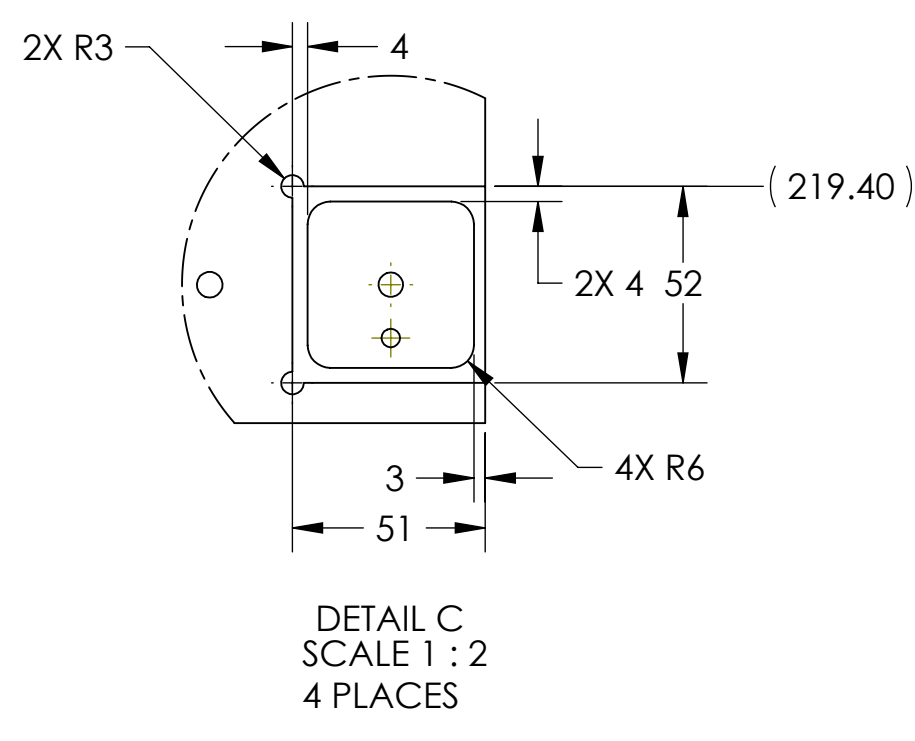
4X Ø 6.50 THRU  
 4X Ø 12±.20

3X R3

DETAIL A SCALE 1 : 2  
 2 PLACES



(6) DRILL AND TAP FOR 1/4-20 N60 HELICOIL INSERT #1185-4EN250 BOTH ENDS



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES, R.02 MIN.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN MILLIMETERS

TOLERANCES:  
 .X ± .3  
 .XX ± .13

ANGULAR ± .5°

MATERIAL	6061-T6 Al	FINISH	32 µinch
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	SYSTEM	SUB-SYSTEM	PART NAME
	ADVANCED LIGO	SUS	LSAT TOP PLATE - LARGE

DESIGNER	LOLMOS	19 MAY 2010	SIZE	DWG. NO.	REV.
DRAFTER			D	D1001222	v2
CHECKER	K. BUCKLAND	24 MAY 2010	SCALE	1:4	PROJECTION
APPROVAL	C. TORRIE	24 MAY 2010	SHEET 1 OF 1		

D1001222.LSAT TOP PLATE - LARGE.dwg (LIGO\_SIS\_PART.PDM REV: X-009) DRAWING PDM REV: X-004