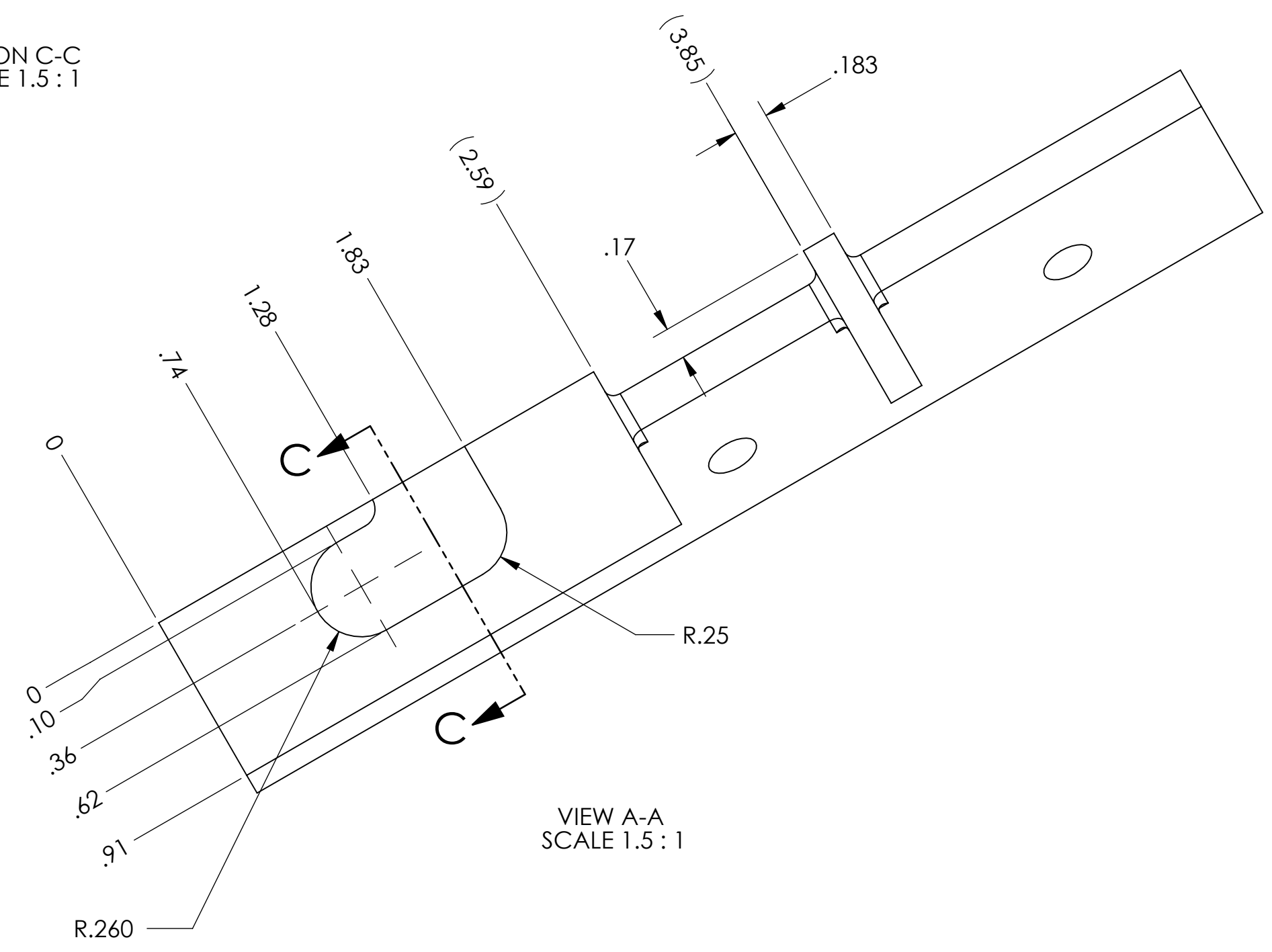
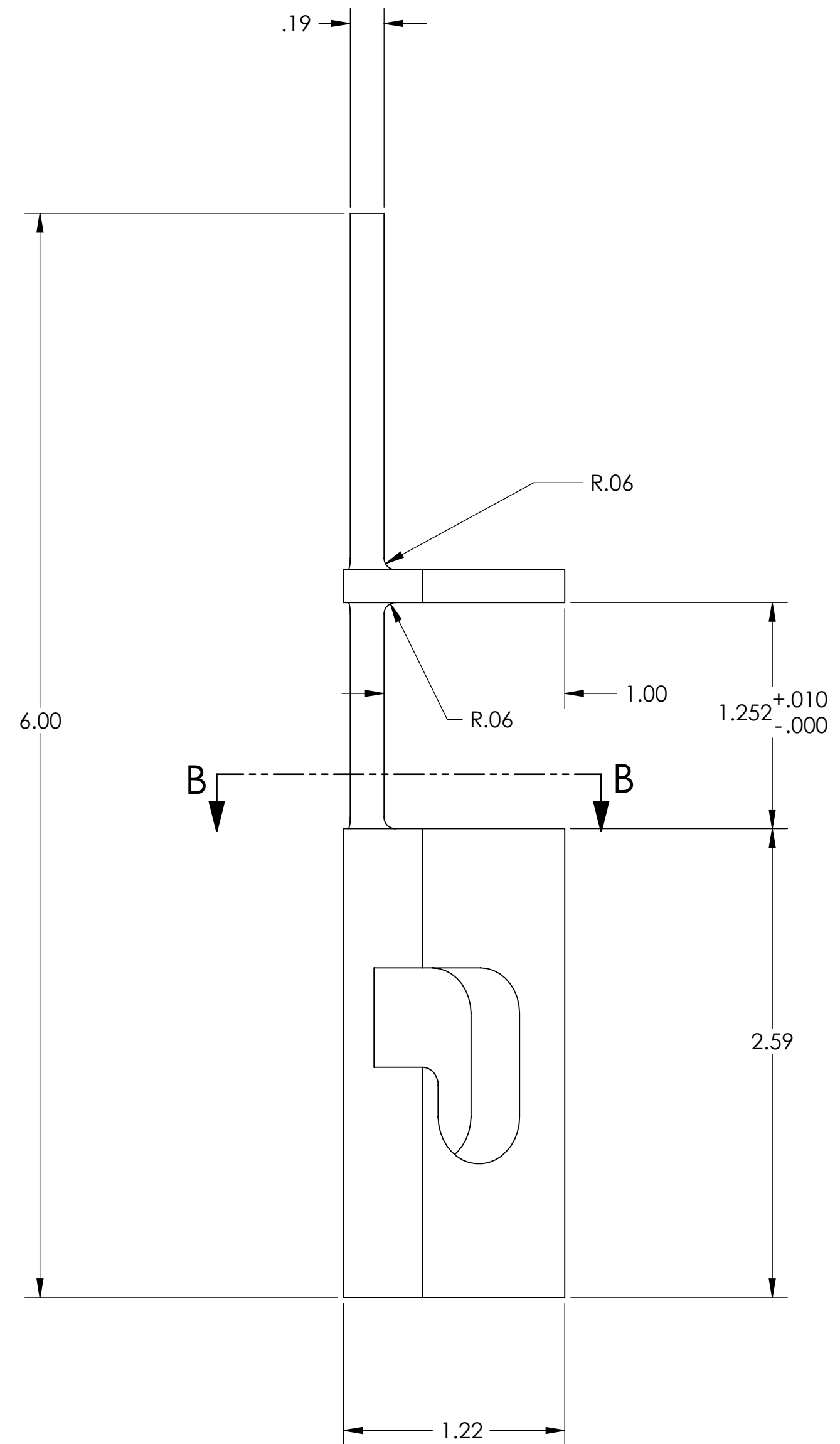
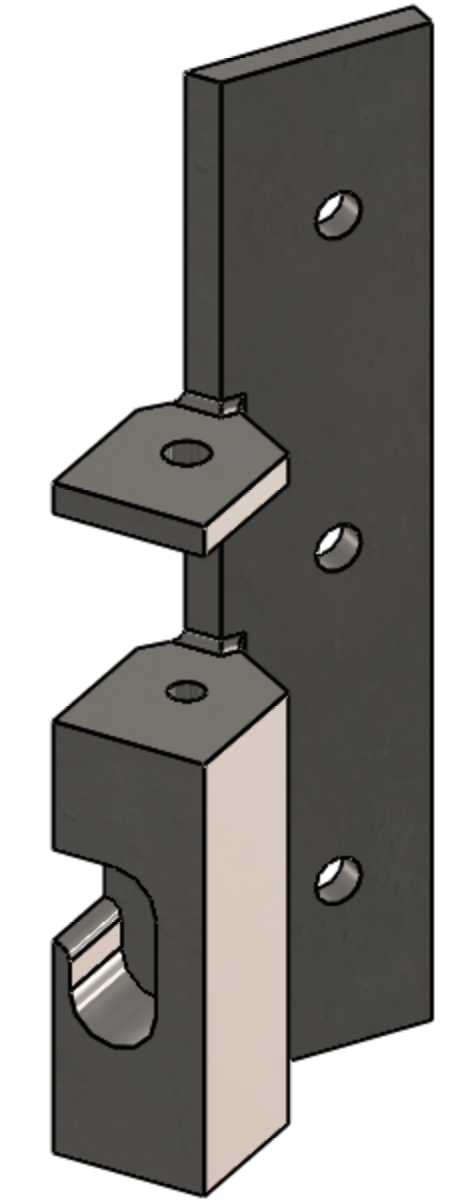
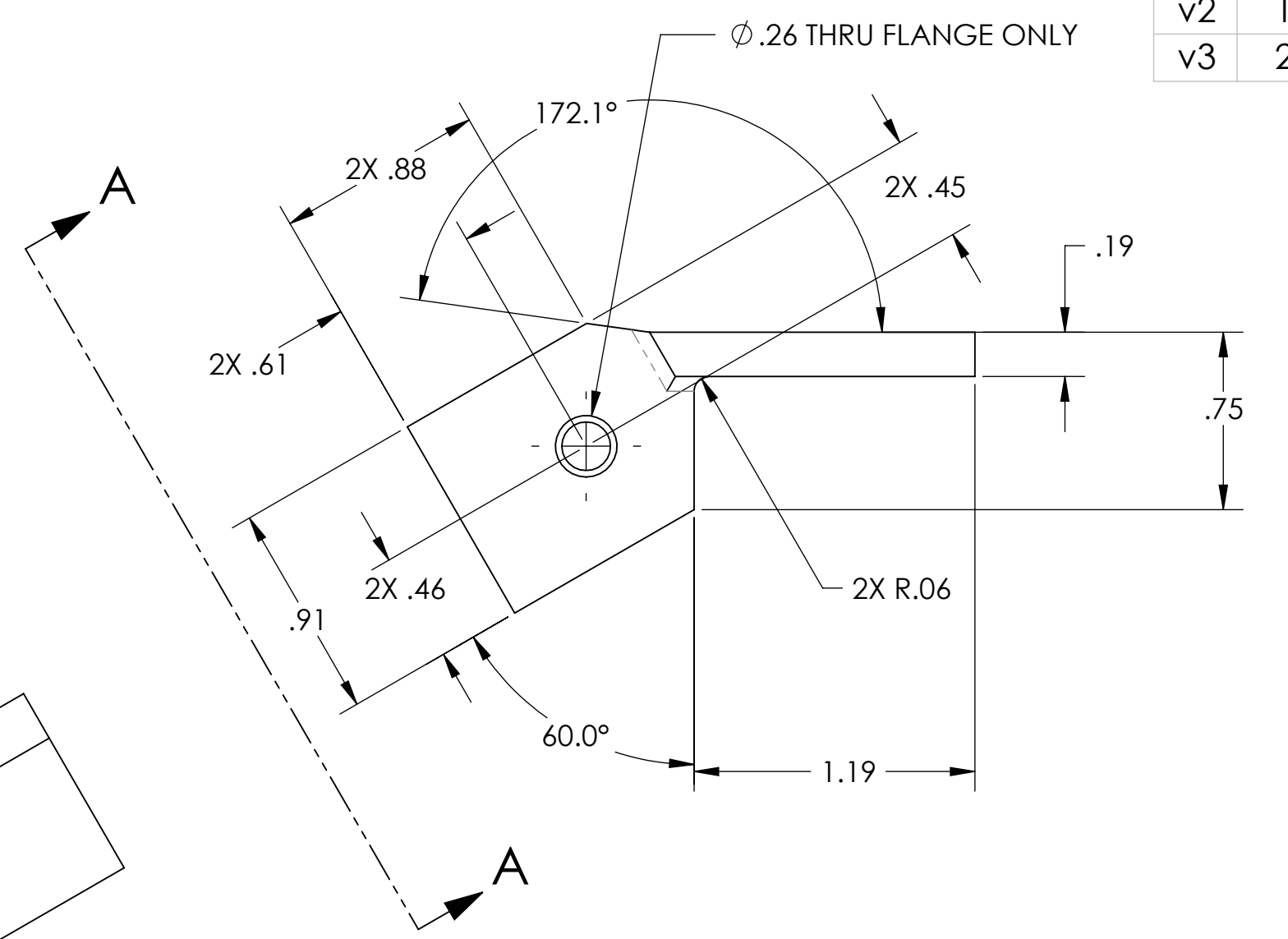
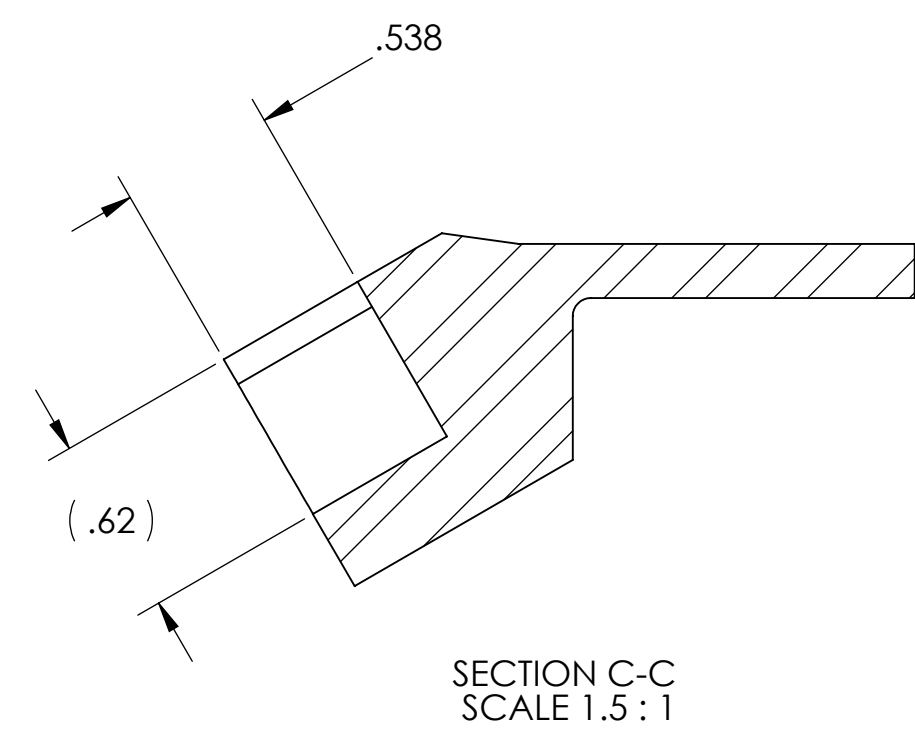
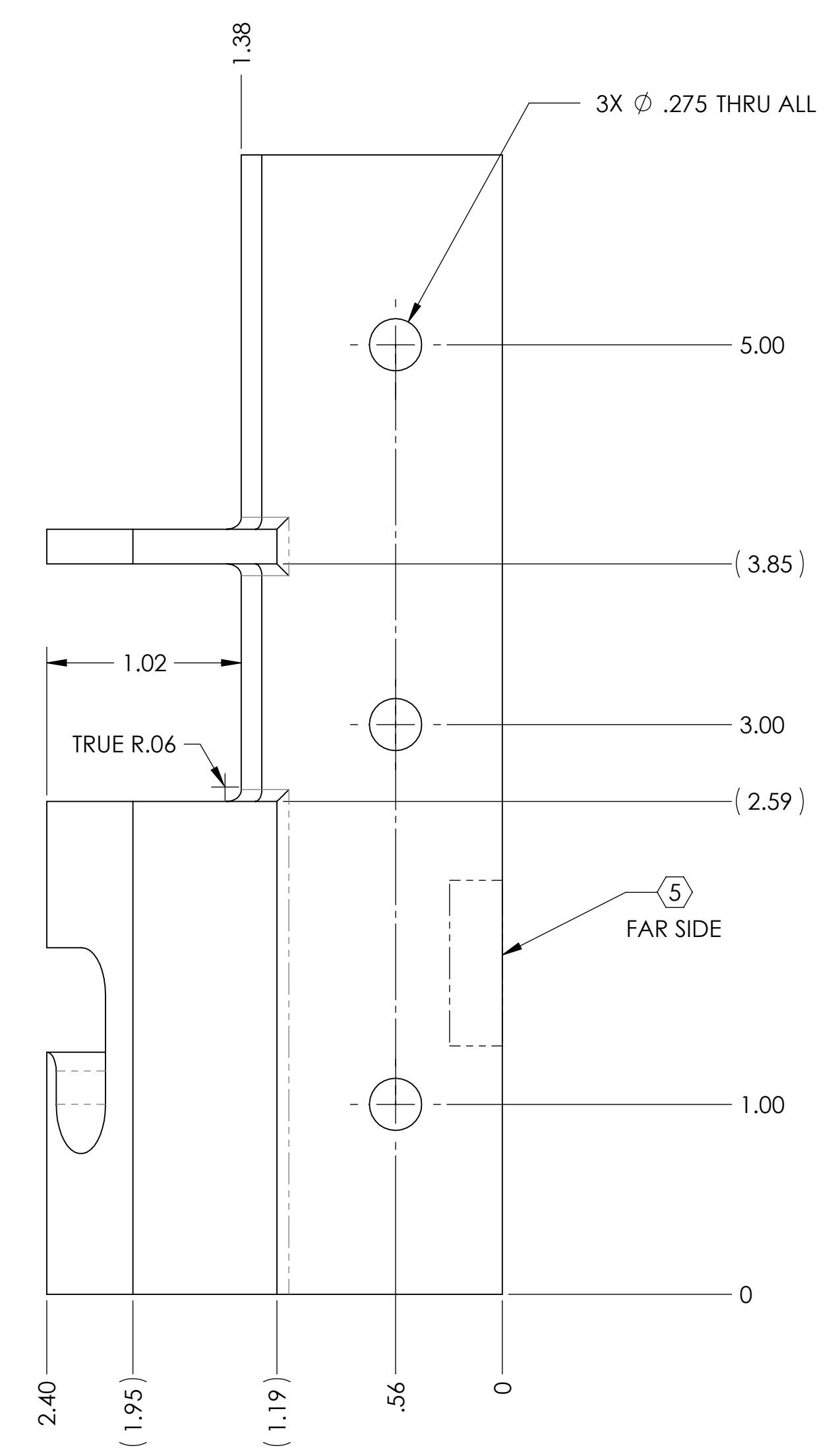
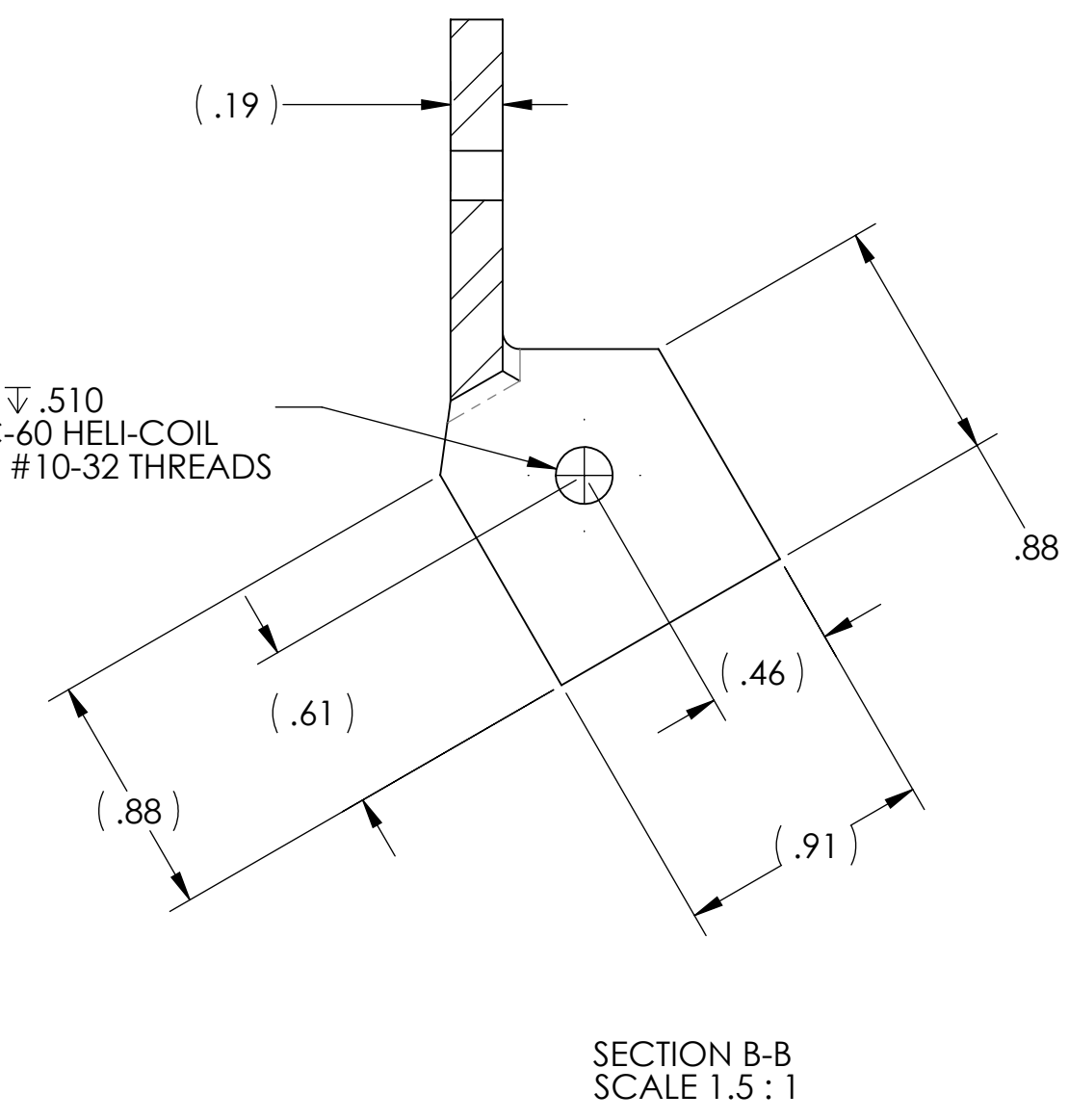


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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. APPROXIMATE WEIGHT = 1.028 LB.
  - 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 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.

REV.	DATE	DCN #	DRAWING TREE #
v1	10-AUG-2010	-	-
v2	14-OCT-2010	-	-
v3	22-DEC-2010	E1000883-v1	E1000884-v1



9 10  
 (#5 DRILL) DRILLED  $\nabla$ .510  
 TAP FOR NITRONIC-60 HELI-COIL  
 #1191-EN475 WITH #10-32 THREADS



DIMENSIONS ARE IN INCHES		TOLERANCES:		ANGULAR ± 0.5°		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		MATERIAL		FINISH		NEXT ASSY		PART NAME		DESIGNER		DRAFTER		CHECKER		APPROVAL	
		.XX ± .01 .XXX ± .005				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .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.		AISI 304		63 μinch		D1001742		TCS UHV BRACKET, LONG SIDE, BSC7		M. JACOBSON		A. COLE		B. ANDERSON		C. TORRIE	
														ADVANCED LIGO		SUB-SYSTEM AOS		D		D1002287		SHEET 1 OF 1	

D1002287\_TCS\_UHV\_BRACKET\_LONG\_SIDE\_BSC7\_PART\_PDM\_REV\_X014\_DRAWING\_PDM\_REV\_X010