

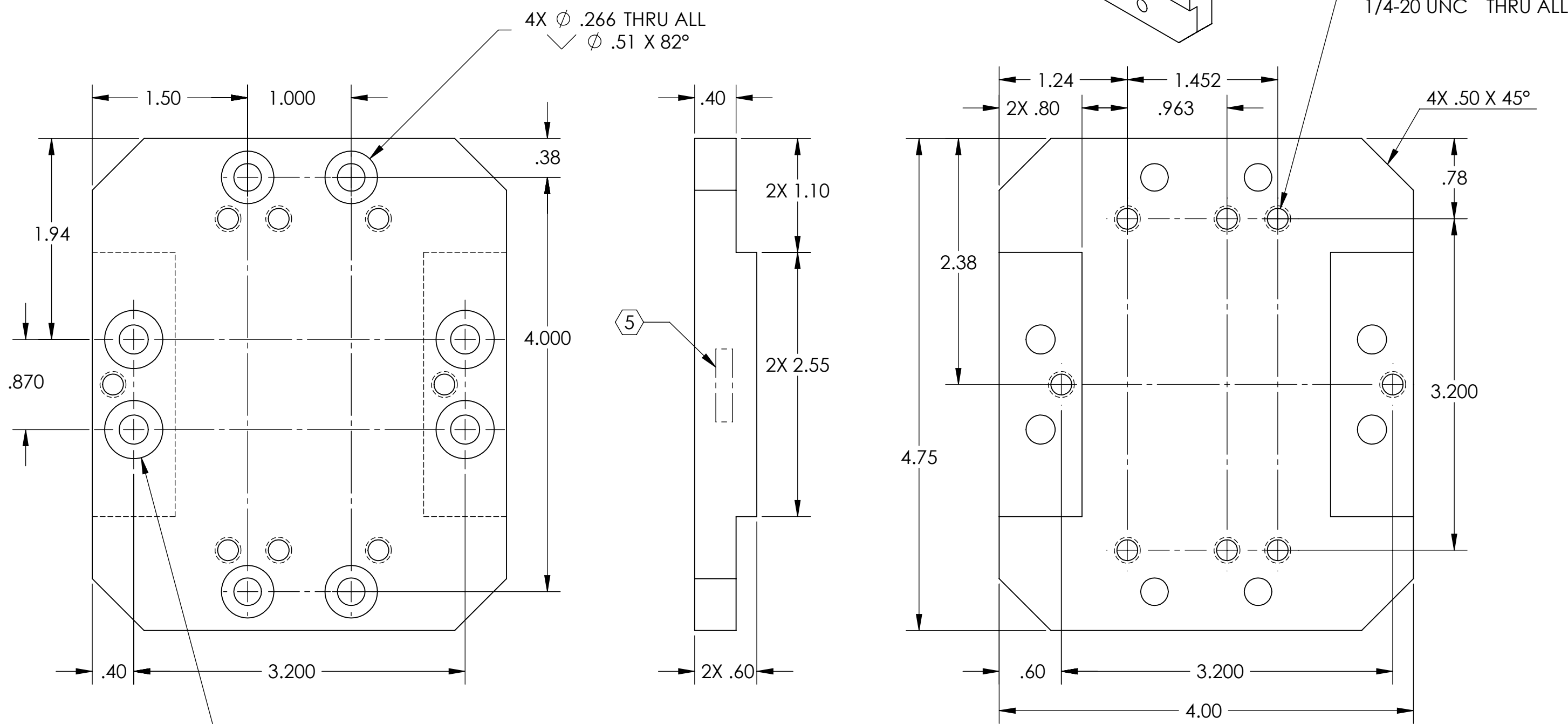
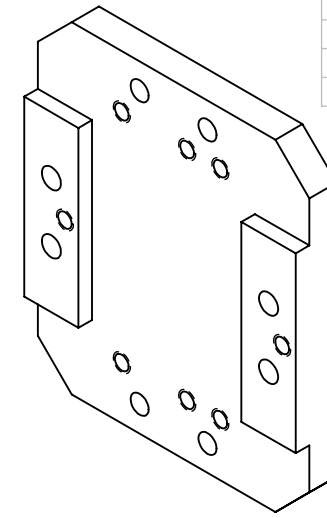
D1002594 QUGO, SUS, UPPER QUAD VIBRATION ABSORBER MOUNTING PLATE, PART PDM REV: X-001, DRAWING PDM REV: X-001

8 7 6 5 4 3 2 1

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 = X.XXX 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	6 OCT 2010	E1000493	
V2	15 NOV 2010	E1000698	



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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 MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX \pm .01
 .XXX \pm .005
 ANGULAR \pm 0.5°

MATERIAL 6061-T6 Al **FINISH** 63 μ inch

SYSTEM ADVANCED LIGO **SUB-SYSTEM** SUS **NEXT ASSY** D1002424

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME UPPER QUAD VIBRATION ABSORBER MOUNTING PLATE

DESIGNER K. BUCKLAND	6 OCT 2010	SIZE B	DWG. NO. D1002594	REV. v2
DRAFTER K. BUCKLAND	6 OCT 2010			
CHECKER				
APPROVAL				

SCALE: 1:1 **PROJECTION:** **SHEET 1 OF 1**

8 7 6 5 4 3 2 1