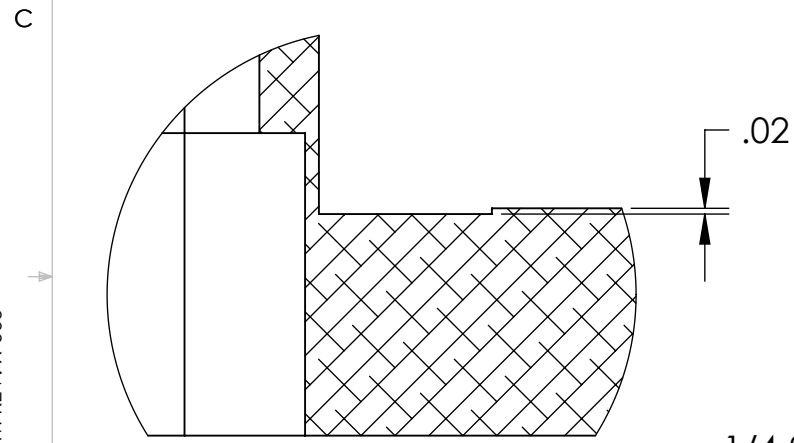
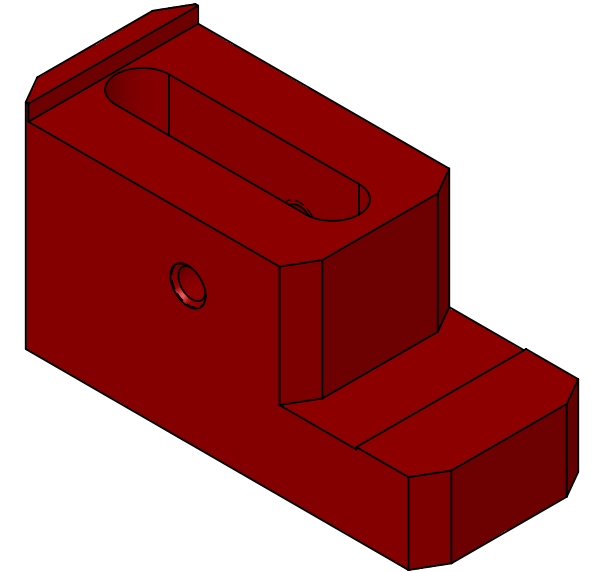
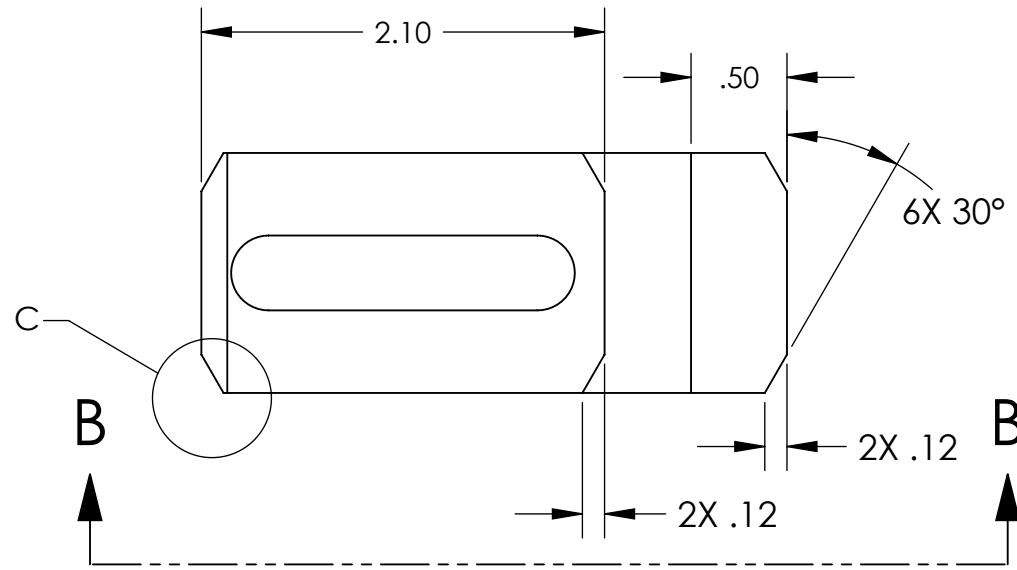


NOTES CONTINUED:

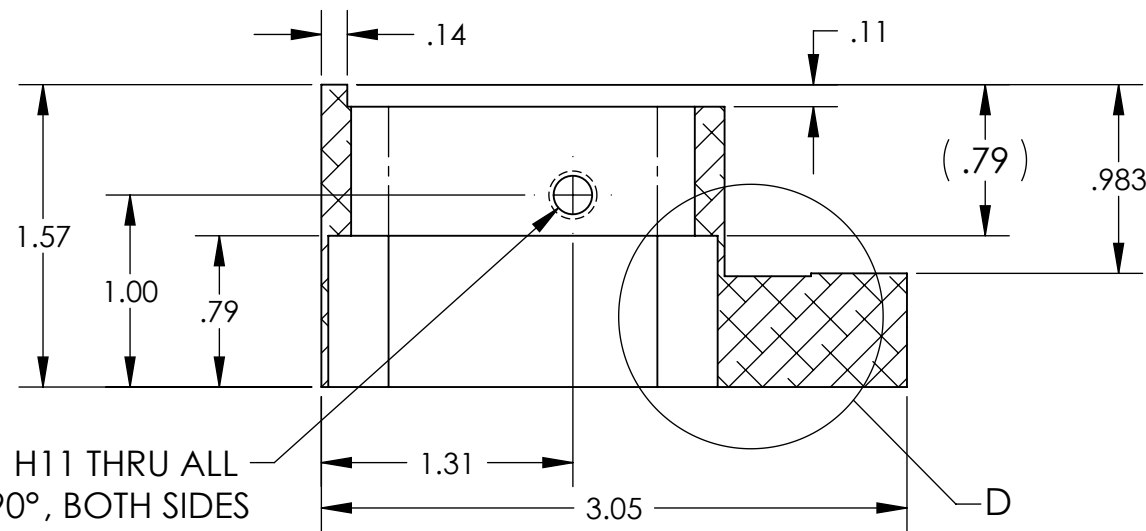
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE 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 = .89 LB [40 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. 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.
- 10. NOTED HOLE: .005" OVERSIZE BOTH DRILL & TAP.

REV.	DATE	DCN #	DRAWING TREE #
v1	06 DEC 2010	-	-
v2	29 APR 2011	-	-
-	-	-	-

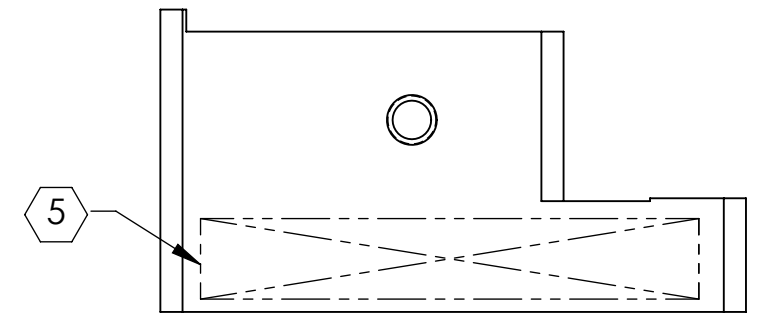


DETAIL D

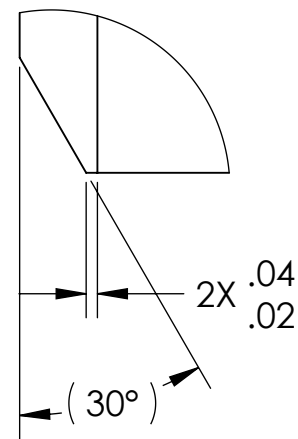
1/4-20 UNC - 2B H11 THRU ALL
 ✓ ϕ .26 X 90°, BOTH SIDES



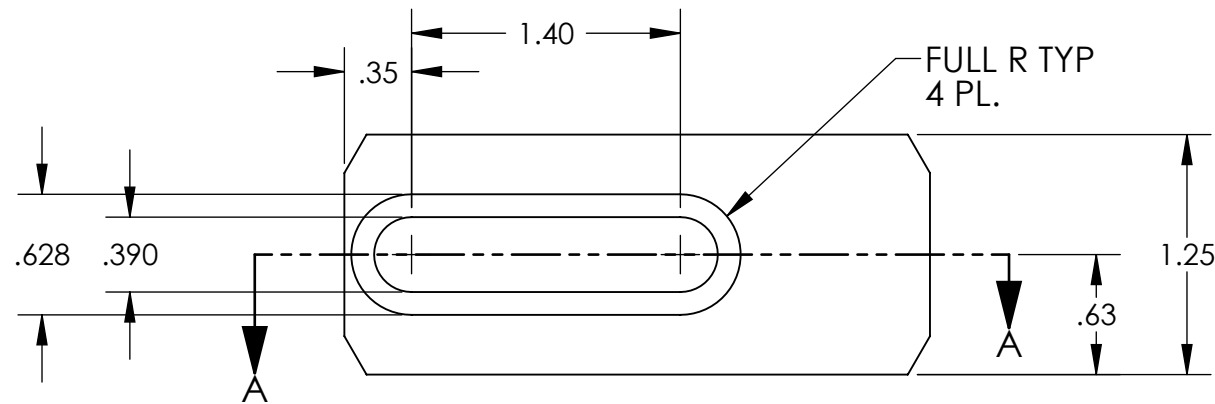
SECTION A-A



VIEW B-B



DETAIL C



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ± .015
 .XXX ± .005
 ANGULAR ± 1.0°

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.

MATERIAL 304 S316L FINISH 63 μinch Ra

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM SUS
 NEXT ASSY INSTALLATIONS

PART NAME
aLIGO QUAD SHORTER DOG CLAMP

DESIGNER	K MAILAND	10 DEC 2010	SIZE	DWG. NO.	REV.
DRAFTER	K MAILAND	10 DEC 2010	B	D1003190	v2
CHECKER			SCALE: NONE	PROJECTION:	SHEET 1 OF 1
APPROVAL					