

D1102072\_Advanced\_LIGO\_SUS\_HLTS\_Earthquake\_Stop\_Mount\_Bridge\_Upper\_PART PDM REV: X-002, DRAWING PDM REV: X-001

**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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

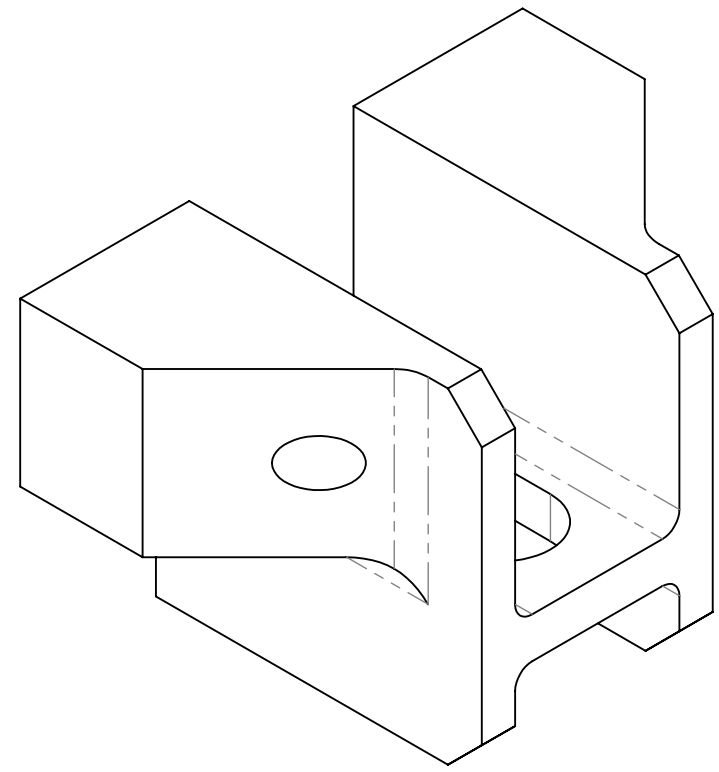
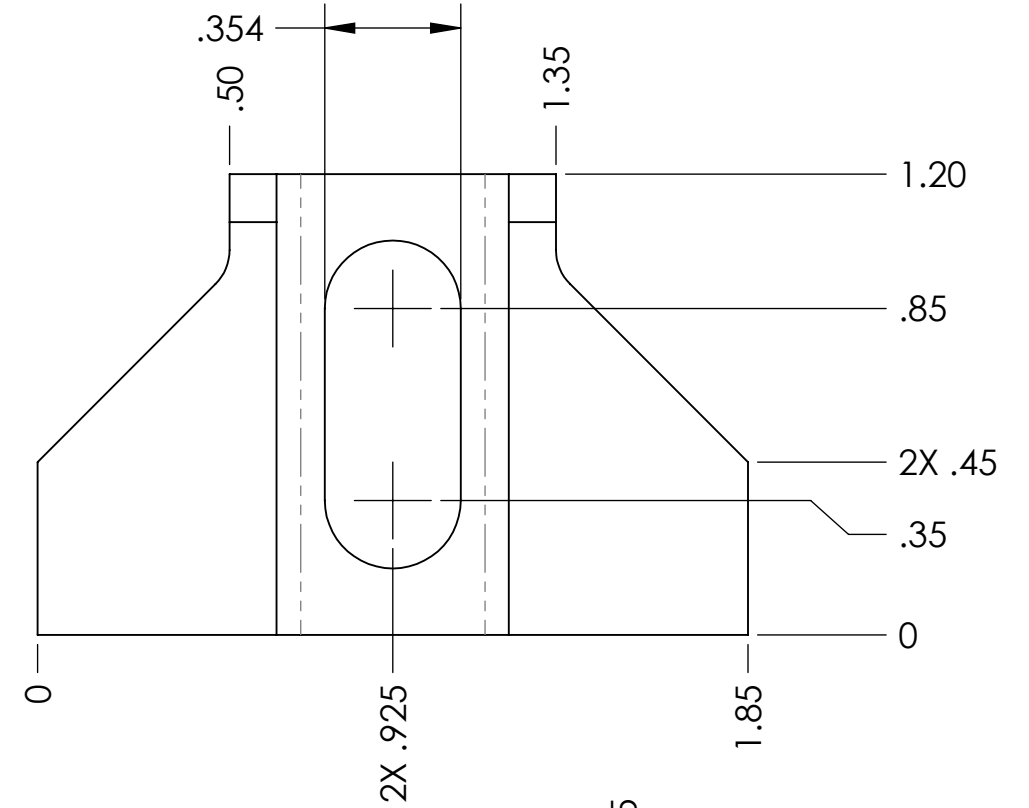
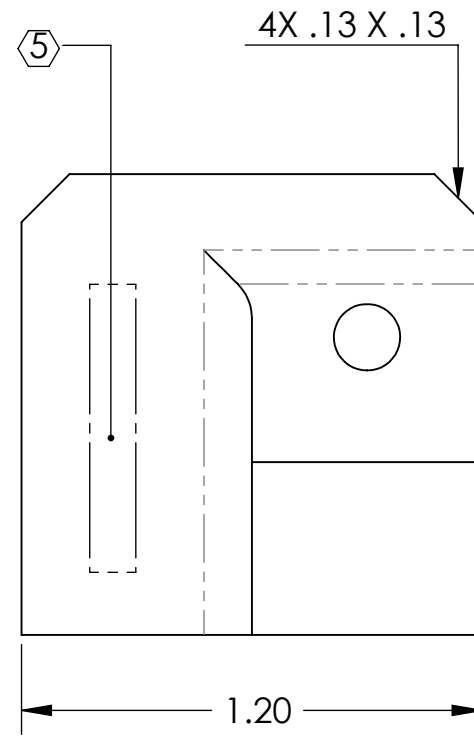
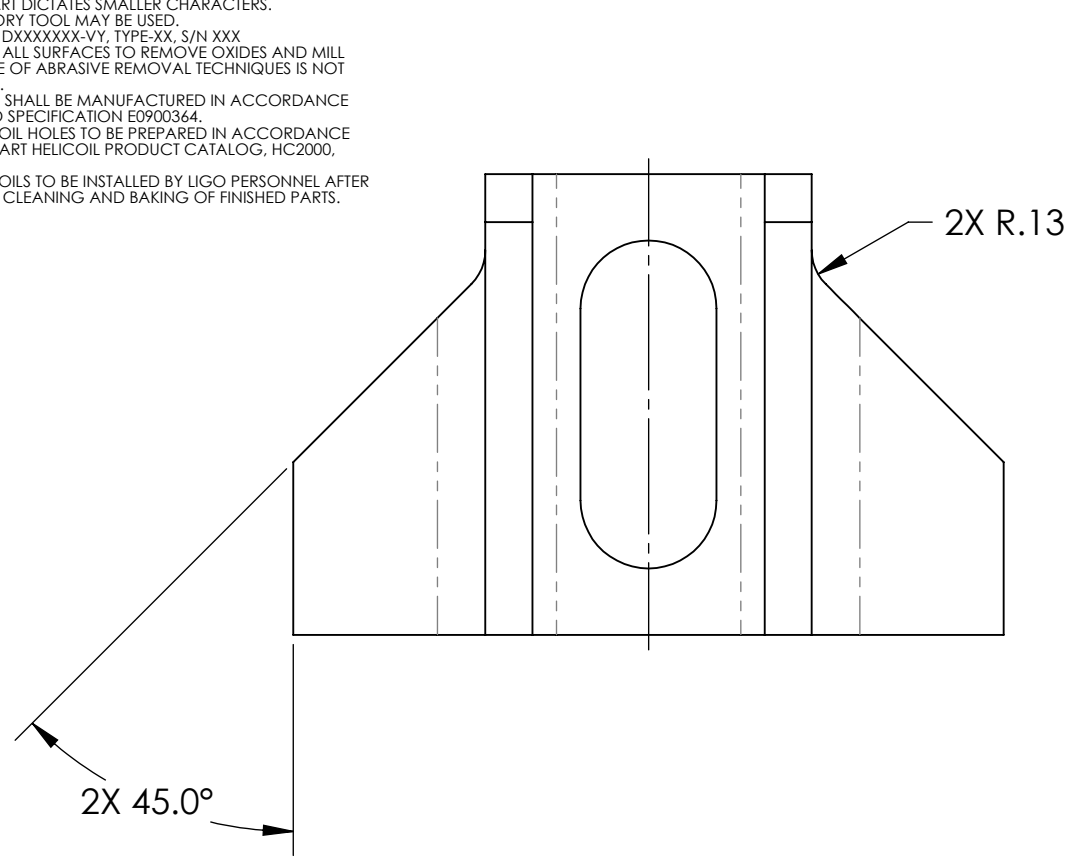
8. ALL HELICOIL HOLES TO BE PREPARED IN ACCORDANCE WITH EMHART HELICOIL PRODUCT CATALOG, HC2000, REV. 4.

9. ALL HELICOILS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY, CLEANING AND BAKING OF FINISHED PARTS.

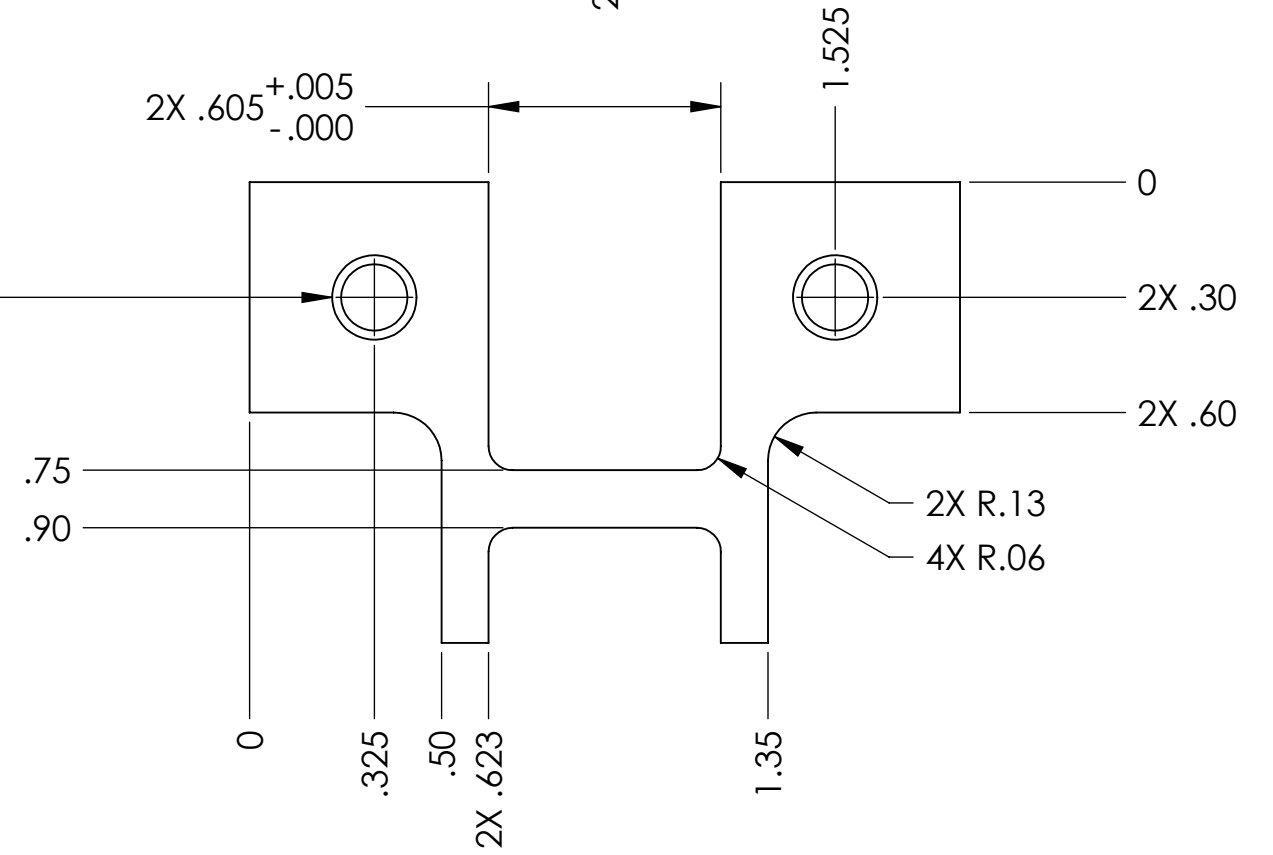
| REV. | DATE        | DCN #    | DRAWING TREE # |
|------|-------------|----------|----------------|
| v1   | 24 OCT 2011 | E1101053 | E080191        |
| -    | -           | -        | -              |
| -    | -           | -        | -              |

D  
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A

D  
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2X DRILL AND TAP THRU FOR  
 #8-32 UNC-2B X 2.5 DIA.  
 EMHART HELICOIL  
 (P/N 1185-2EN410)



| NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)   |  |   |  | LIGO  |  | PART NAME                                      |  |
|--|--|---|--|---|--|--|--|
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>.XX ± .01<br>.XXX ± .005<br>ANGULAR ± 0.5°  |  |   |  | CALIFORNIA INSTITUTE OF TECHNOLOGY<br>MASSACHUSETTS INSTITUTE OF TECHNOLOGY |  | EARTHQUAKE STOP MOUNT, BRIDGE, UPPER           |  |
| 1. INTERPRET DRAWING PER ASME Y14.5-1994.<br>2. REMOVE ALL SHARP EDGES, R.02 MIN.<br>3. DO NOT SCALE FROM DRAWING.<br>4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. |  |   |  | ADVANCED LIGO   |  | SUS  |  |
| MATERIAL: 6061-T6 Al   |  |   |  | FINISH: 63 μinch  |  | NEXT ASSY: EARTHQUAKE STOP ASSY, BRIDGE, UPPER |  |
|  |  | DESIGNER: D. BRIDGES<br>DRAFTER: D. BRIDGES<br>CHECKER: B. MOORE<br>APPROVAL: |  | DATE: 26 OCT 2011<br>DATE: 26 OCT 2011<br>DATE: 27 OCT 2011                 |  | SIZE: B<br>DWG. NO.: D1102072<br>REV.: v1      |  |
|  |  |   |  | SCALE: 2:1  |  | PROJECTION:                                    |  |
|  |  |   |  | SHEET 1 OF 1  |  |  |  |

8 7 6 5 4 3 2 1