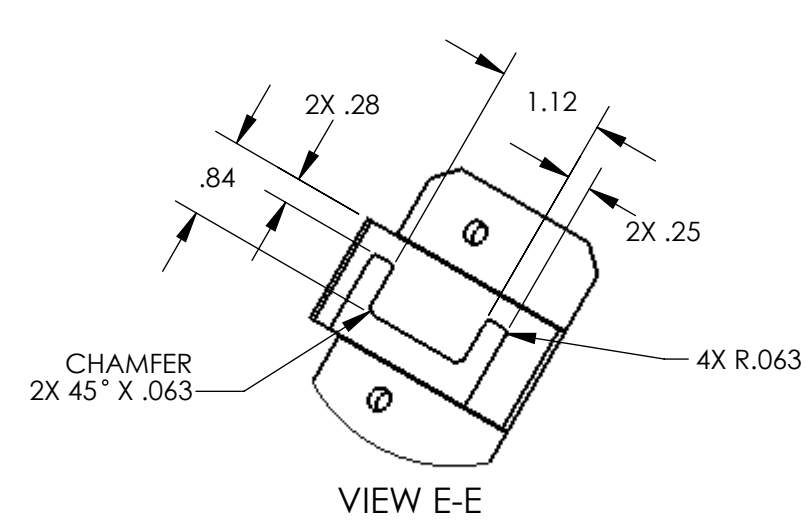
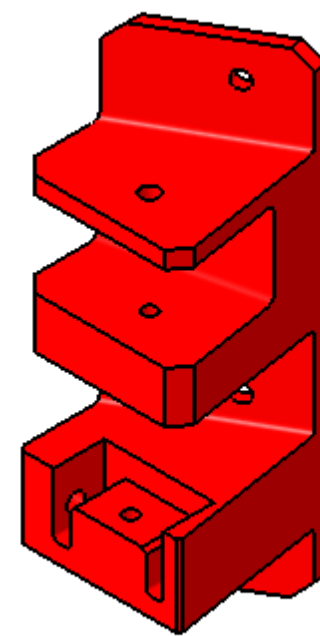


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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 = 3.28 LB.
  - 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

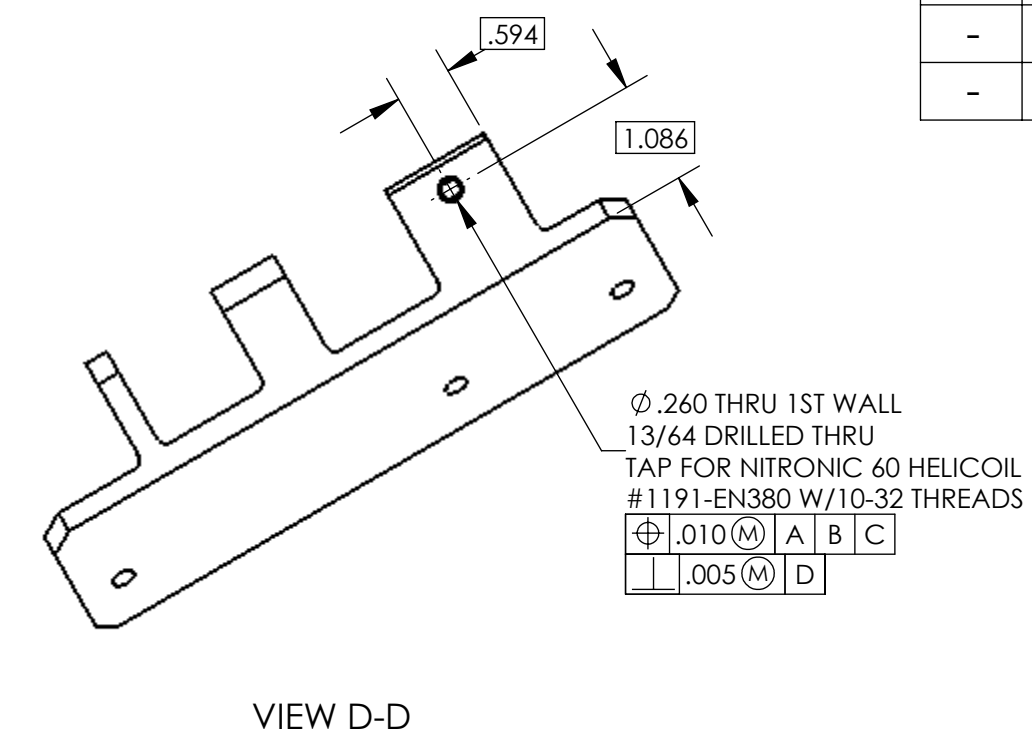
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
- 10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
- 11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
- 12. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .015-.030.



**-01 CONFIGURATION**

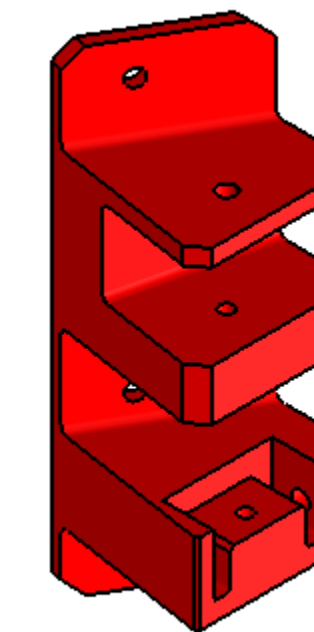


ISO VIEW

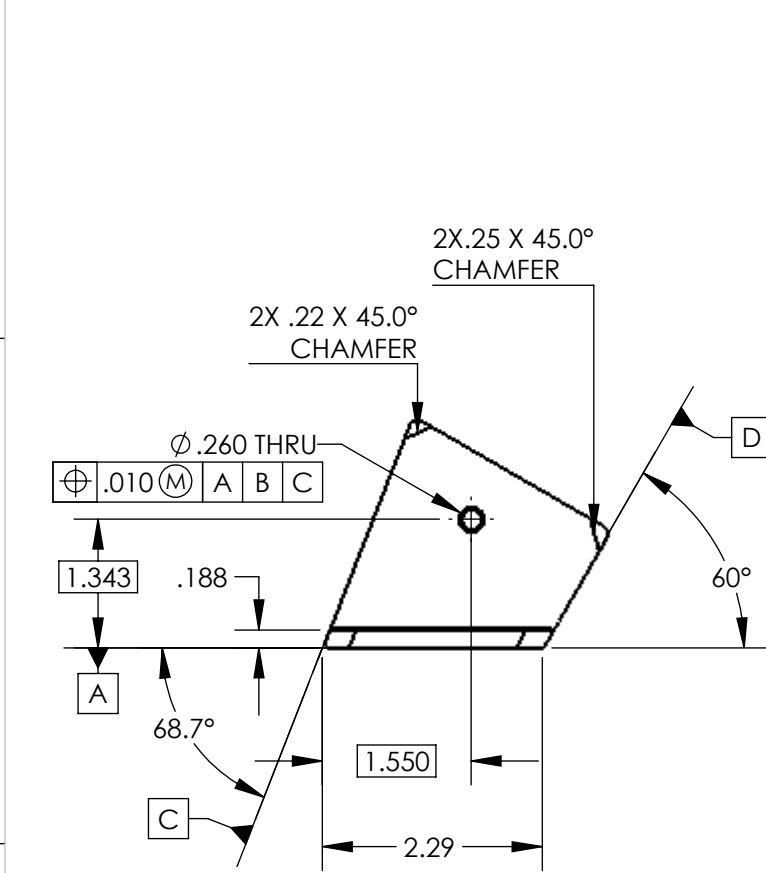


VIEW D-D

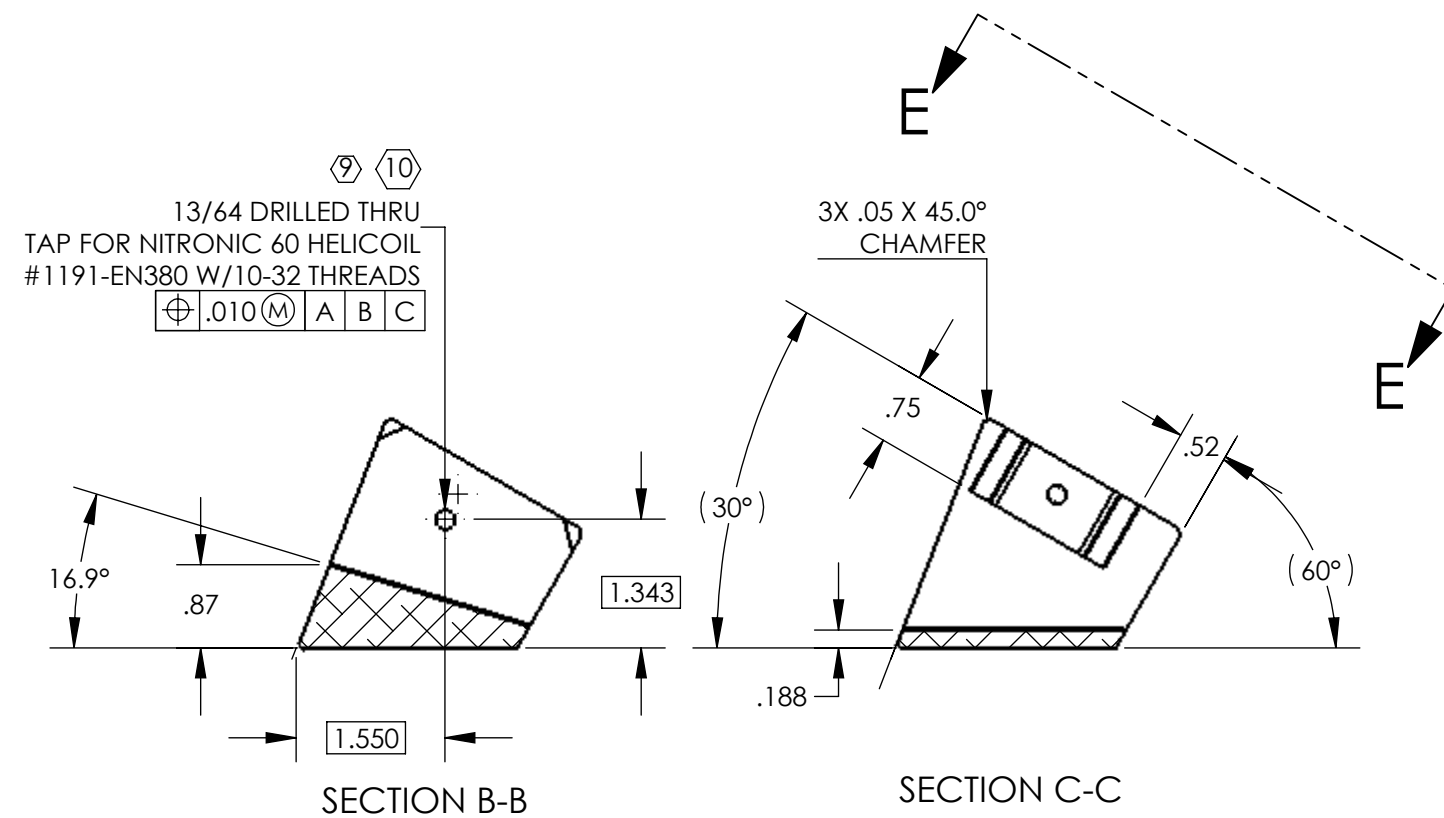
**-02 CONFIGURATION**



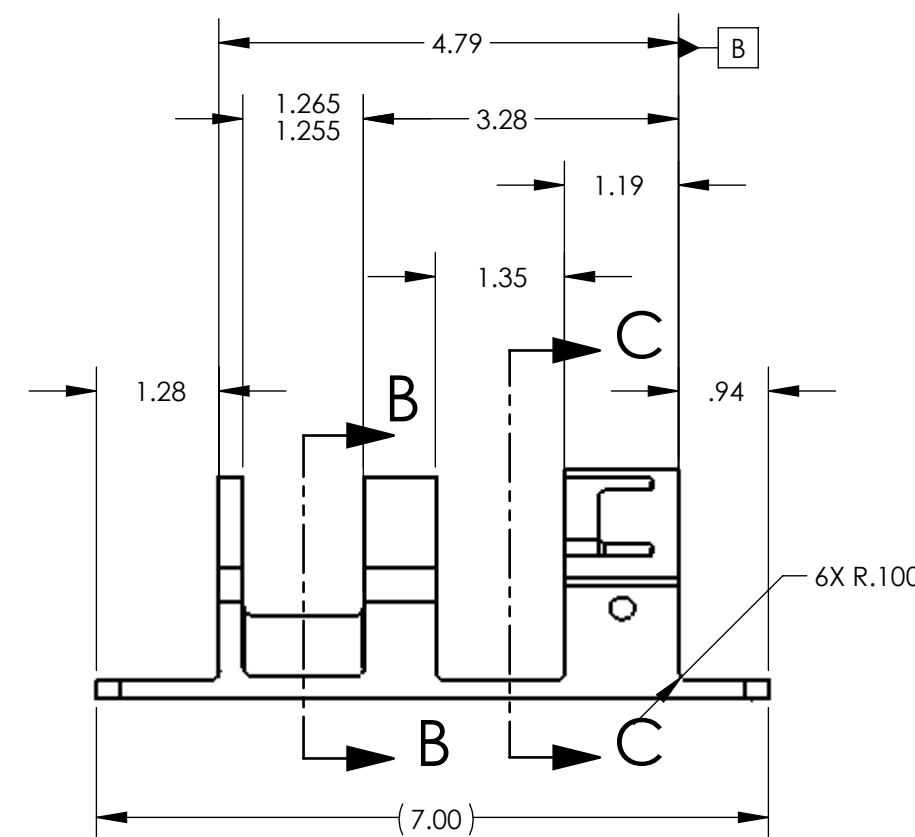
ISO VIEW



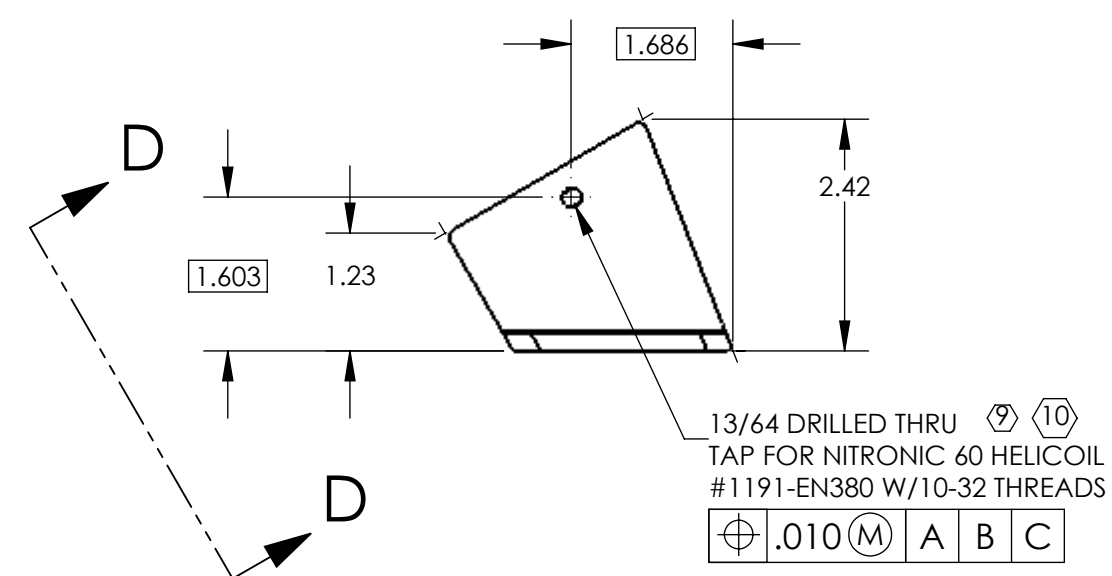
SECTION B-B



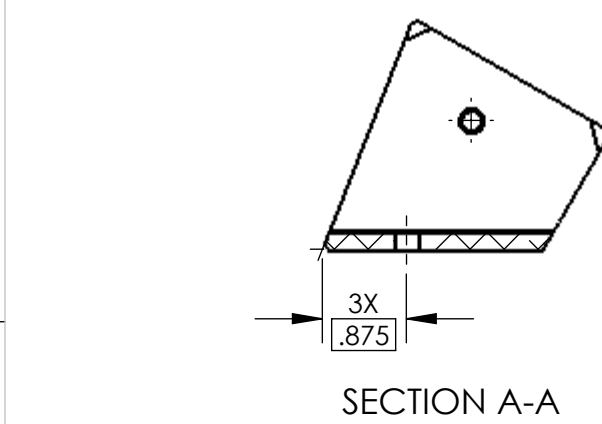
SECTION C-C



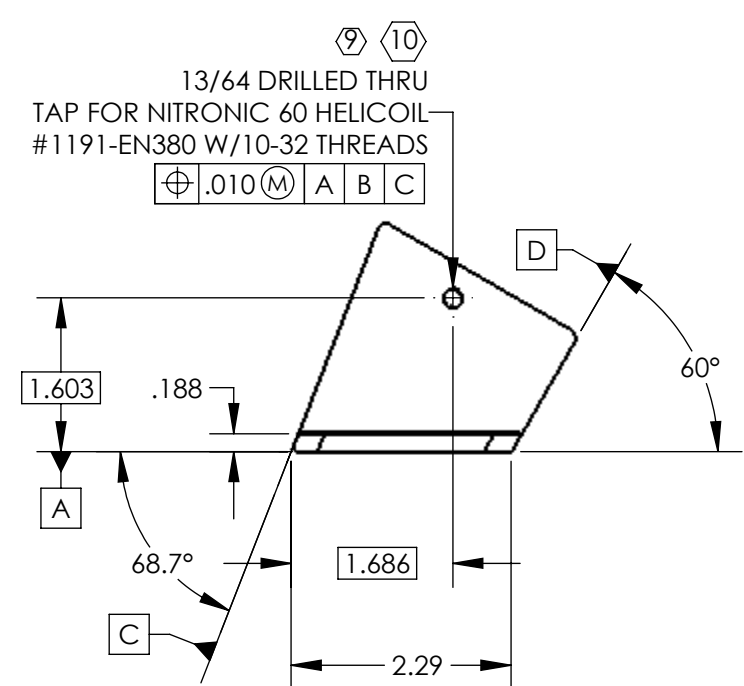
SECTION A-A



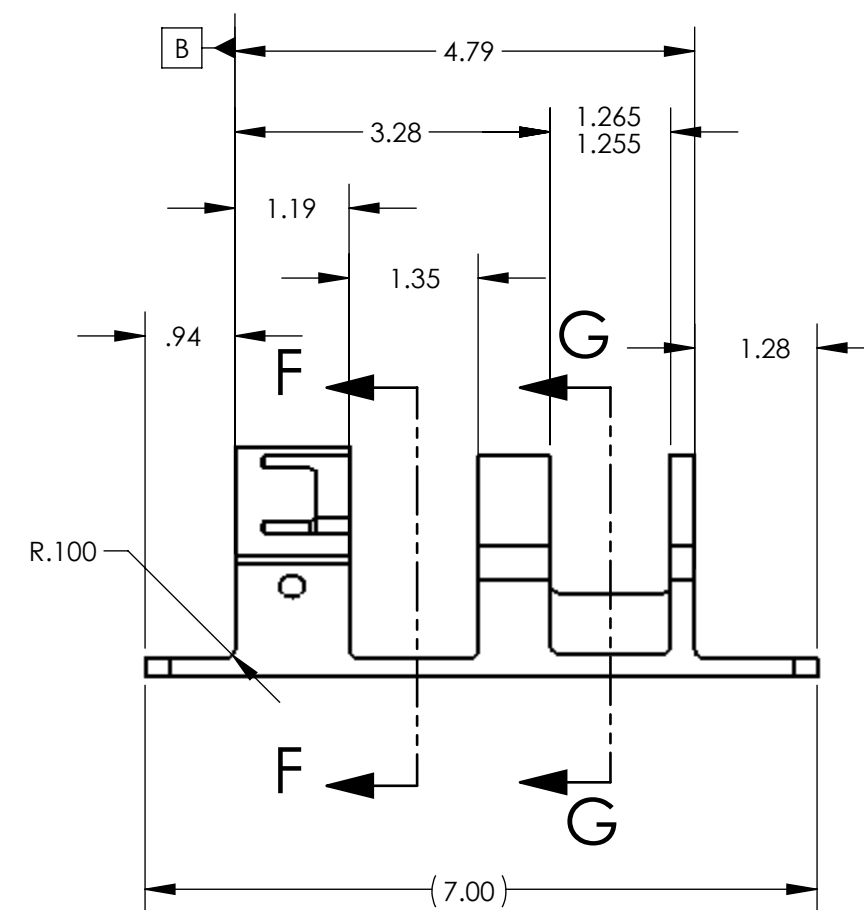
SECTION F-F



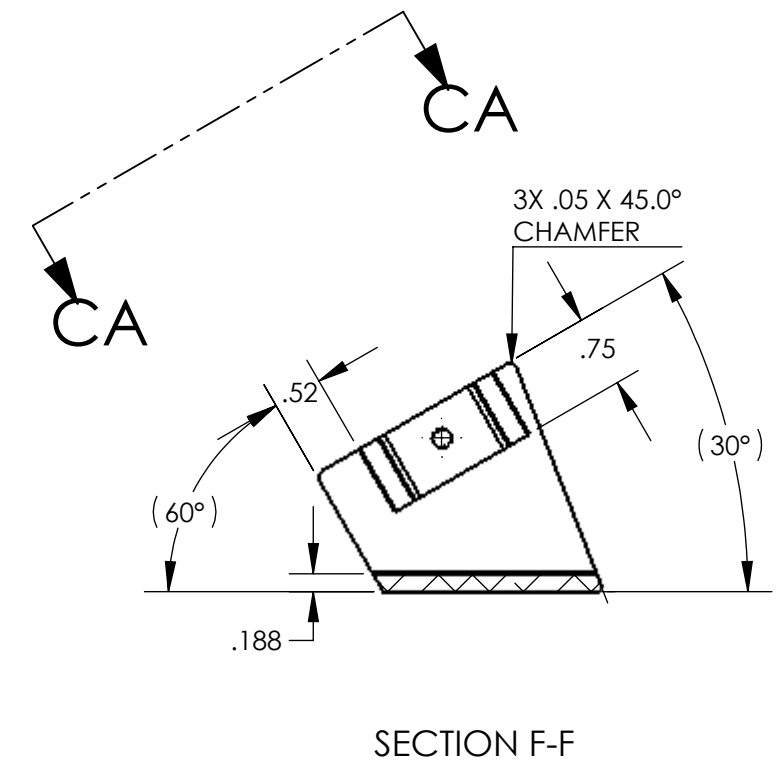
SECTION A-A



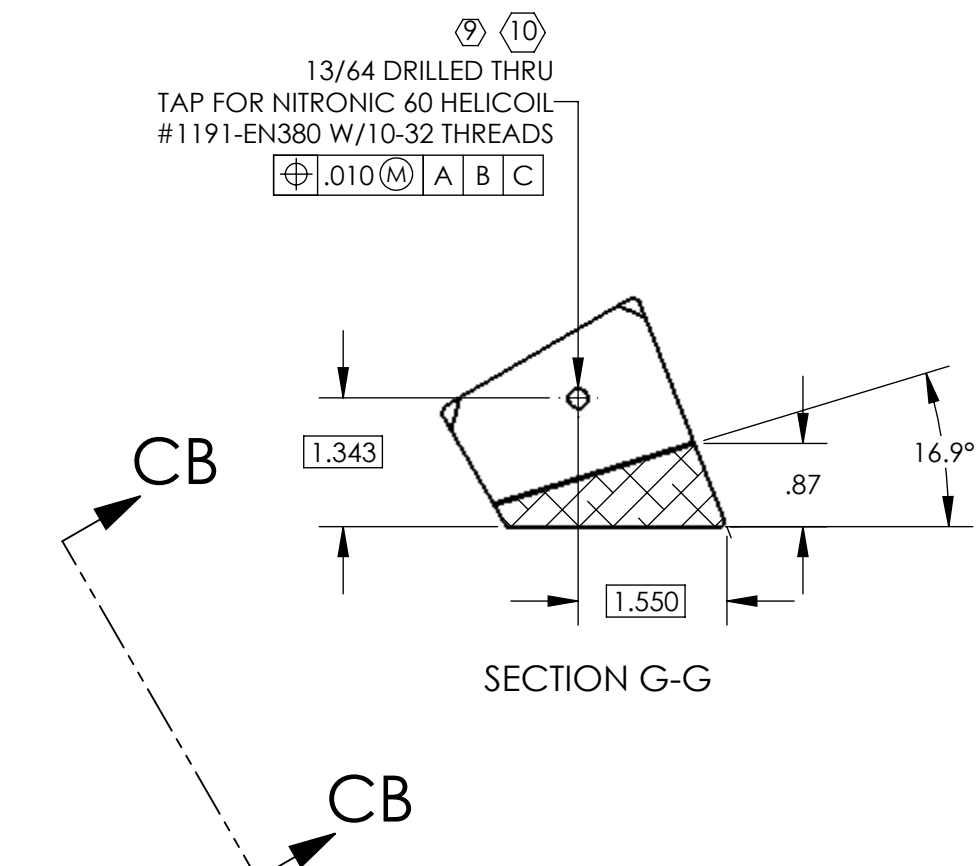
SECTION G-G



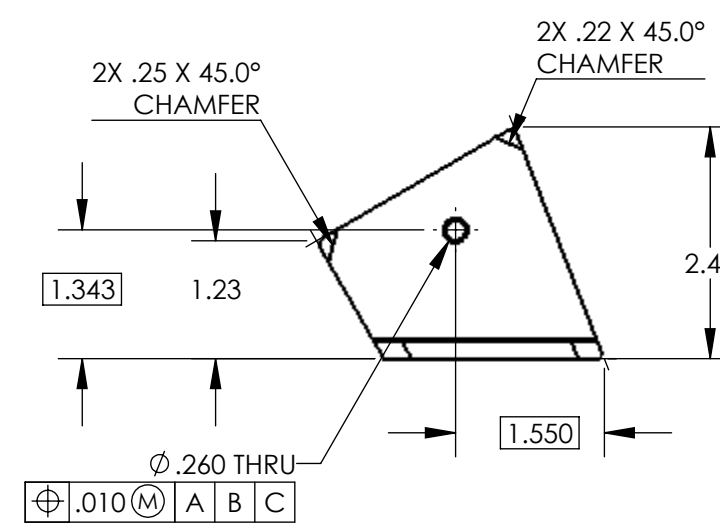
SECTION H-H



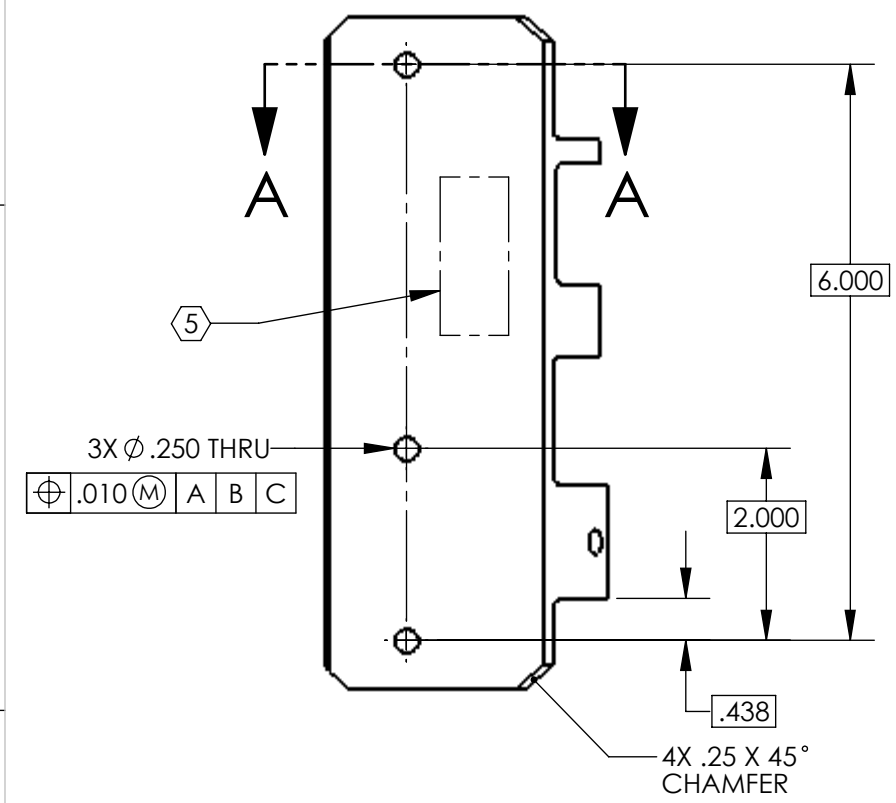
SECTION F-F



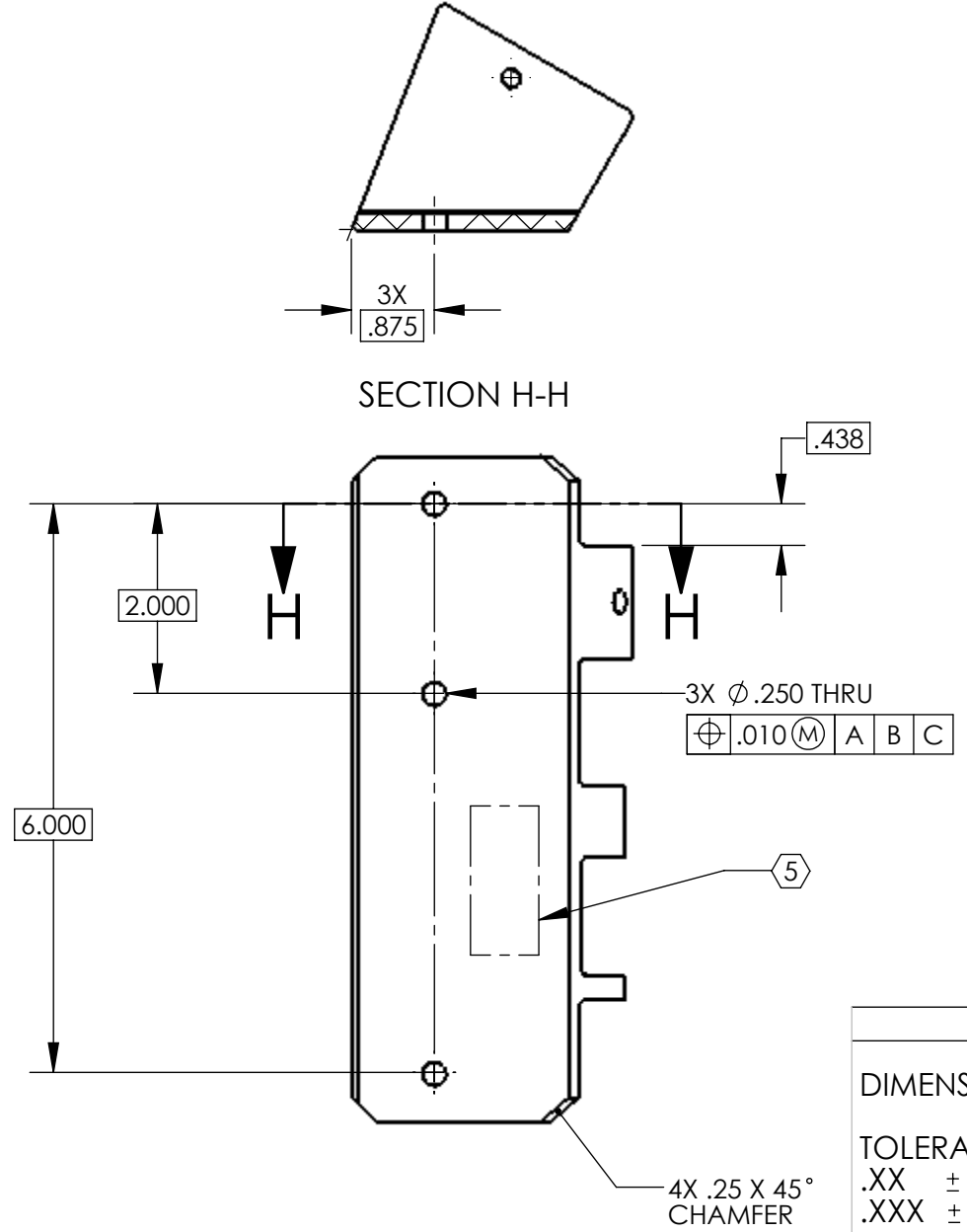
SECTION G-G



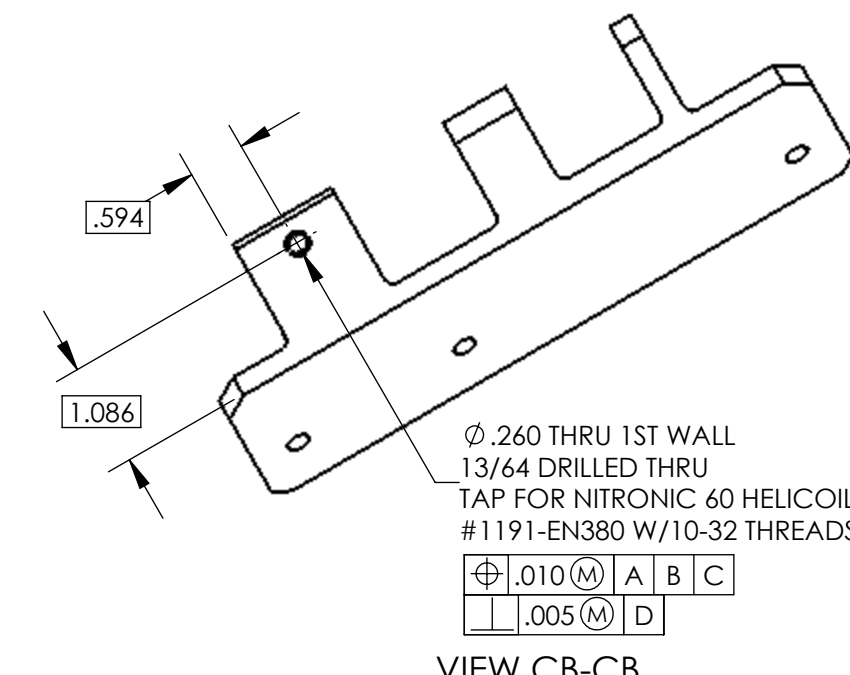
SECTION H-H



VIEW CB-CB



VIEW CA-CA



VIEW CB-CB

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
- 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 INCHES

TOLERANCES:  
 .XX ± .01  
 .XXX ± .005

ANGULAR ± 0.5°

<b>MATERIAL</b>	304 SSSL	<b>FINISH</b>	63 μinch
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<b>SYSTEM</b>	ADVANCED LIGO	<b>SUB-SYSTEM</b>	AOS
<b>NEXT ASSY</b>	D1101851-1, D1101851-2		

<b>PART NAME</b>				<b>SUPPORT BRACKET, SHORT-SIDE SUSPENSION ARM</b>			
<b>DESIGNER</b>	M. JACOBSON	23 DEC 2011	<b>SIZE</b>	<b>D</b>		<b>DWG. NO.</b>	D1102440
<b>DRAFTER</b>	E. SANCHEZ	27 JAN 2012	<b>SCALE</b>	1:2		<b>PROJECTION</b>	ASME
<b>CHECKER</b>	J. LEWIS	06-MAR-12	<b>APPROVAL</b>	A.HEPTONSTALL		05-MAR-12	SHEET 1 OF 1
<b>REV.</b>	v1						

D1102440\_SUPPORT BRACKET, SHORT-SIDE SUSPENSION ARM, PART PDM REV. X-025, DRAWING PDM REV. X-008