

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 = 1.32 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.

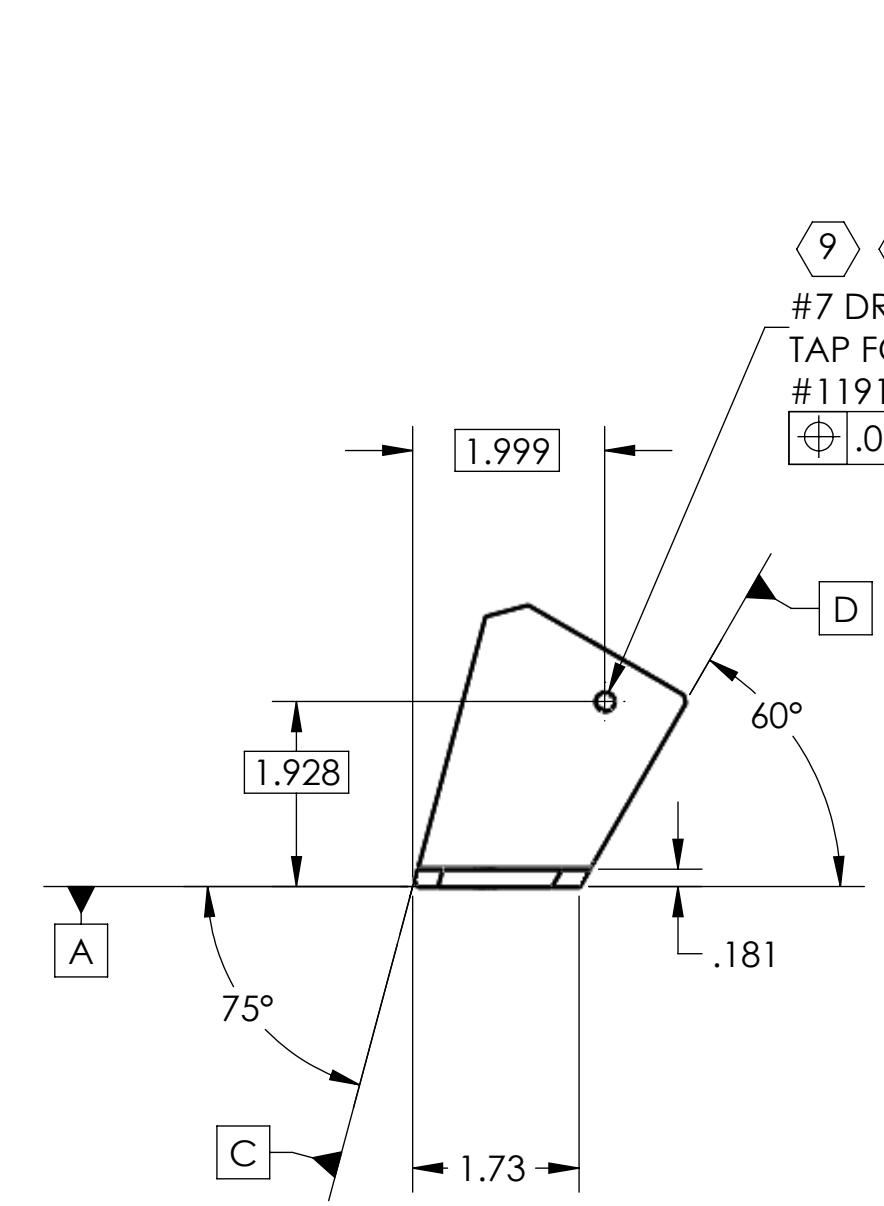
9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

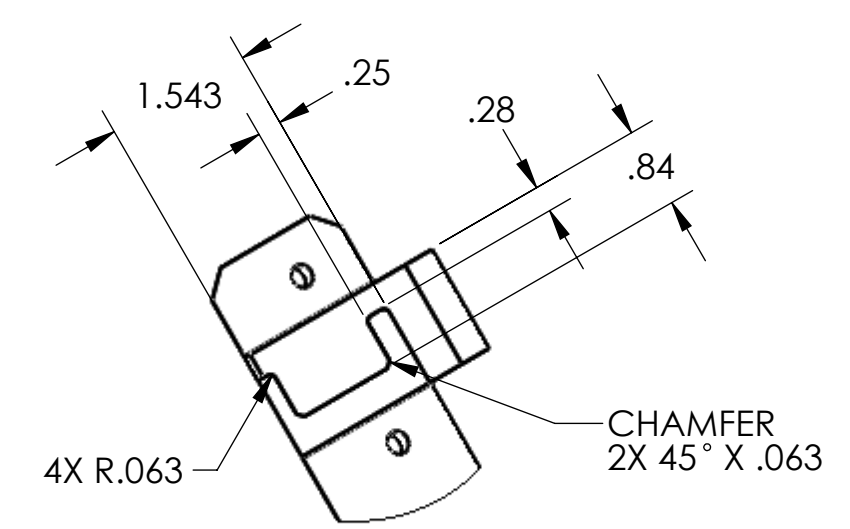
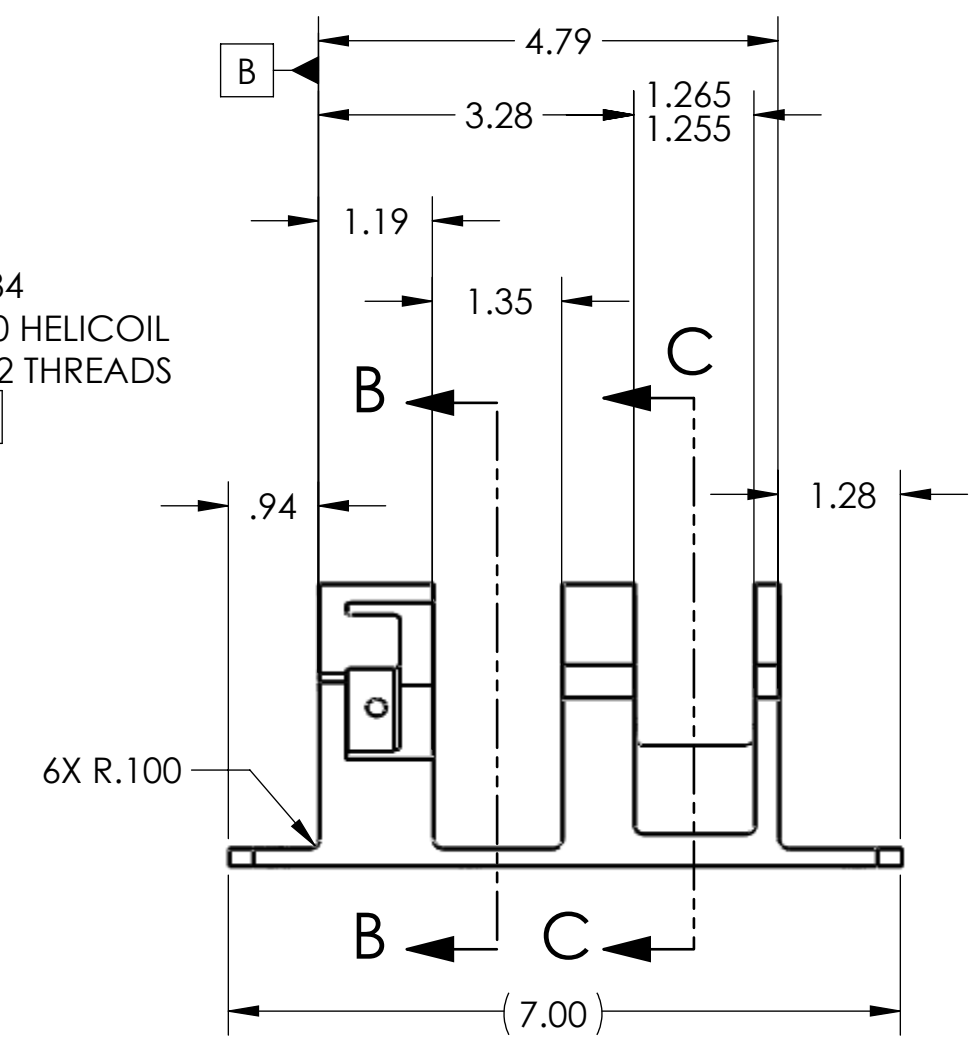
11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

12. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .015-.030.

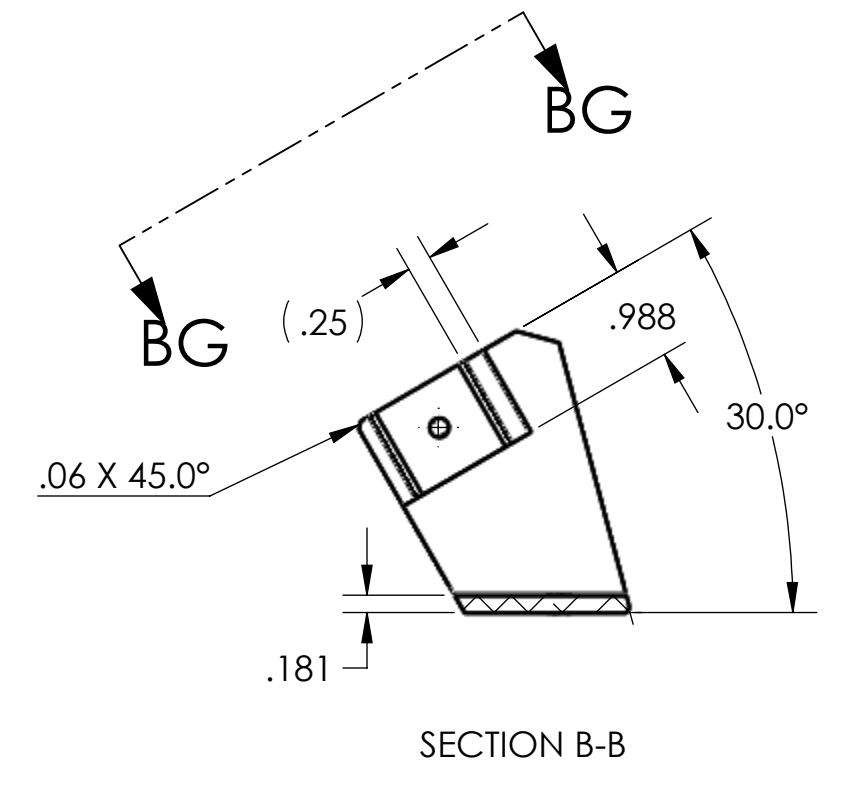
REV.	DATE	DCN #	DRAWING TREE #
v1	06-MAR-12	E1200002-v1	E1200003-v1
v2	06-AUG-12	E1200723-v1	E1200003-v2
-	-	-	-



9 10
#7 DRILLED THRU ∇ .84
TAP FOR NITRONIC 60 HELICOIL
#1191-EN380 W/10-32 THREADS
 $\oplus .010 (M) A B C$
 $\square .005 (M) D$

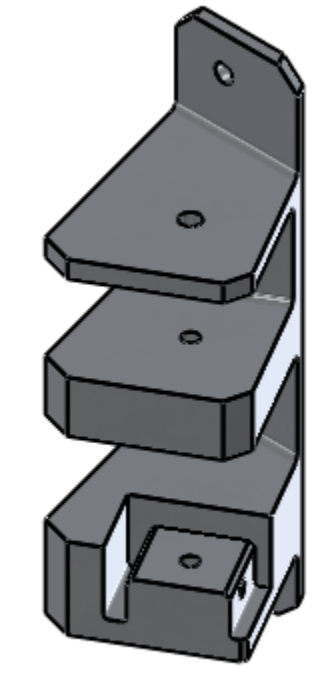


VIEW BG-BG

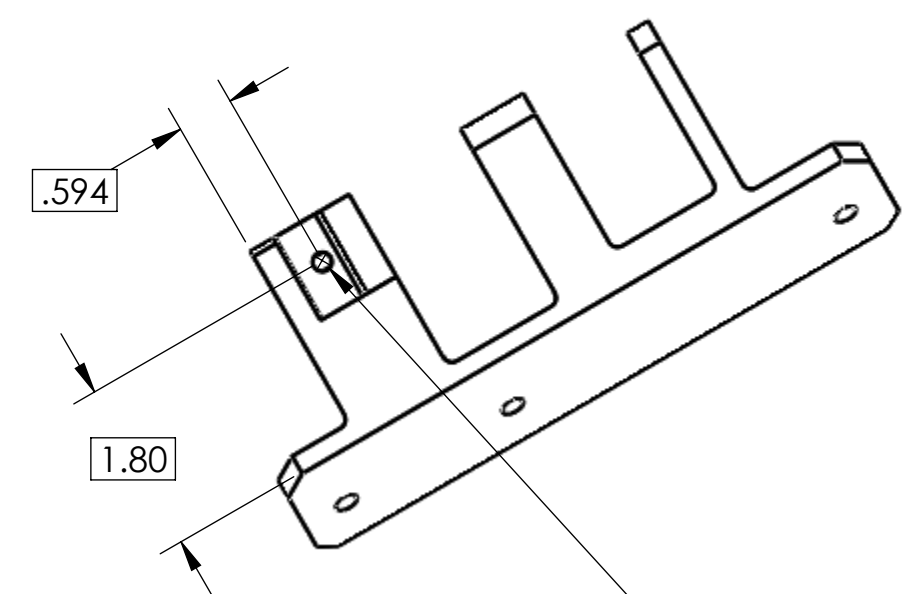


SECTION B-B

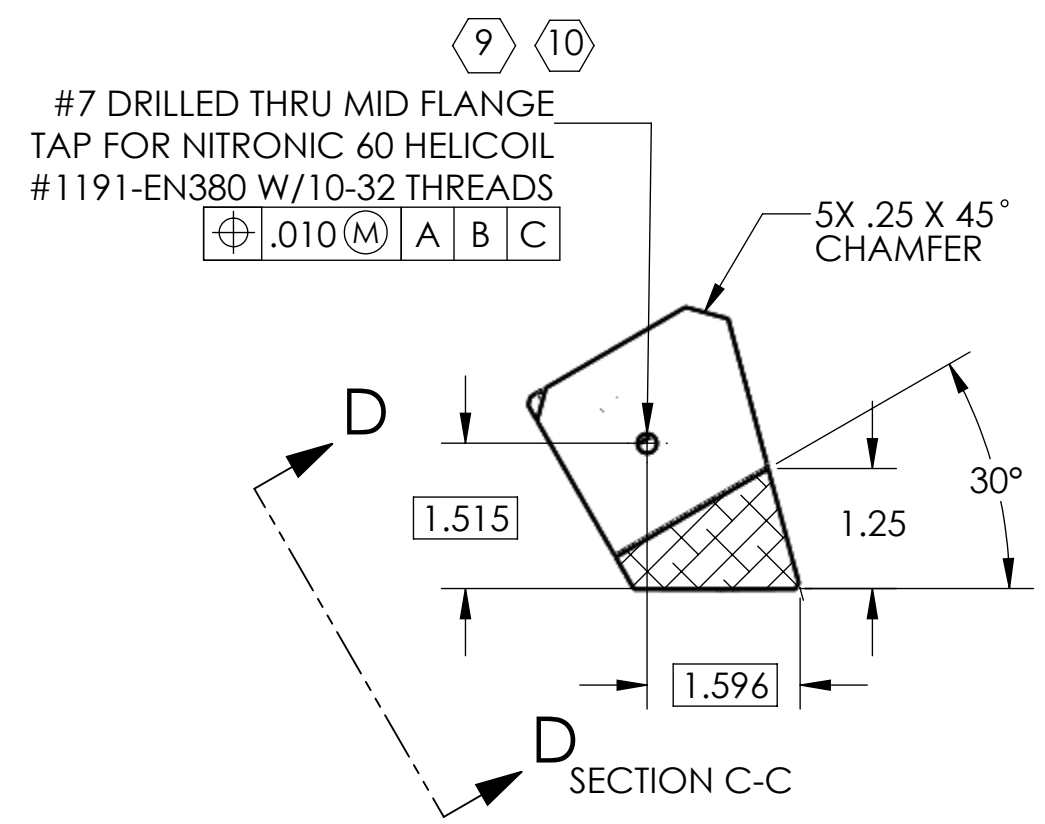
-01 CONFIGURATION



ISO VIEW



VIEW D-D

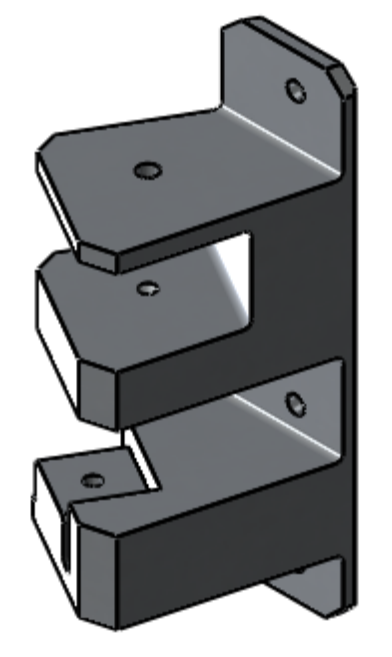


SECTION C-C

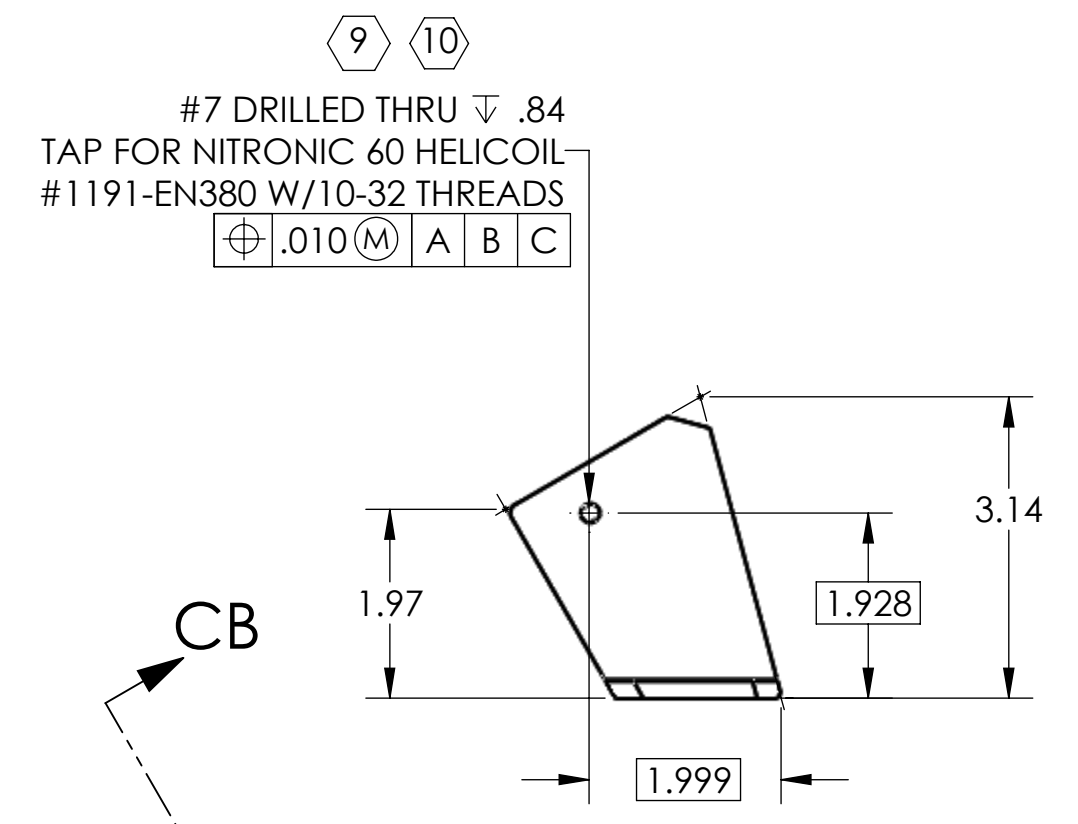
9 10
#7 DRILLED THRU MID FLANGE
TAP FOR NITRONIC 60 HELICOIL
#1191-EN380 W/10-32 THREADS
 $\oplus .010 (M) A B C$

9 10
 ϕ .260 THRU TOP FLANGE
 $\oplus .010 (M) A B C$

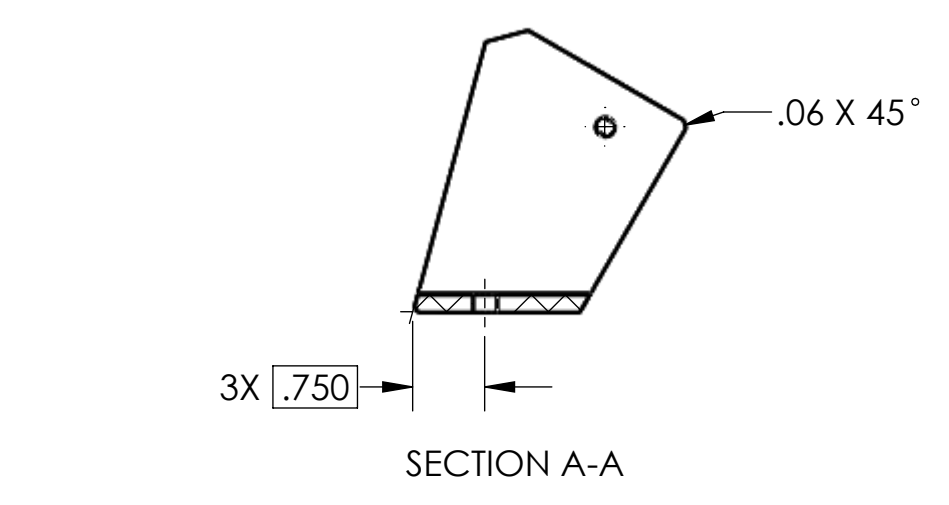
-02 CONFIGURATION



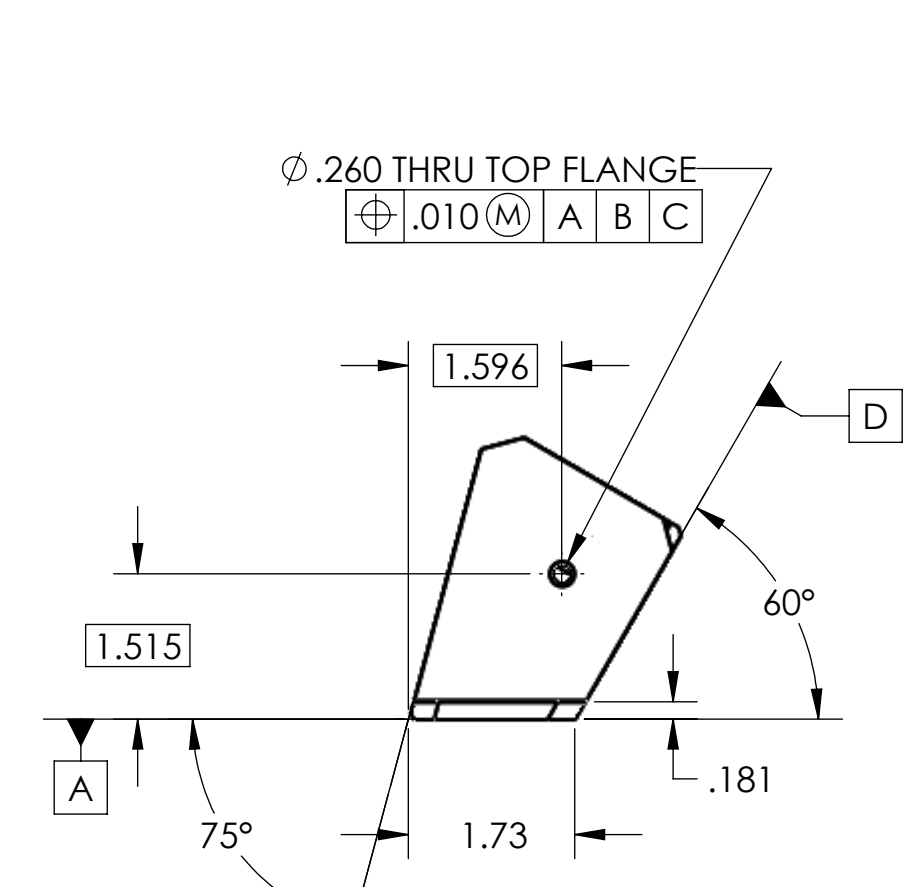
ISO VIEW



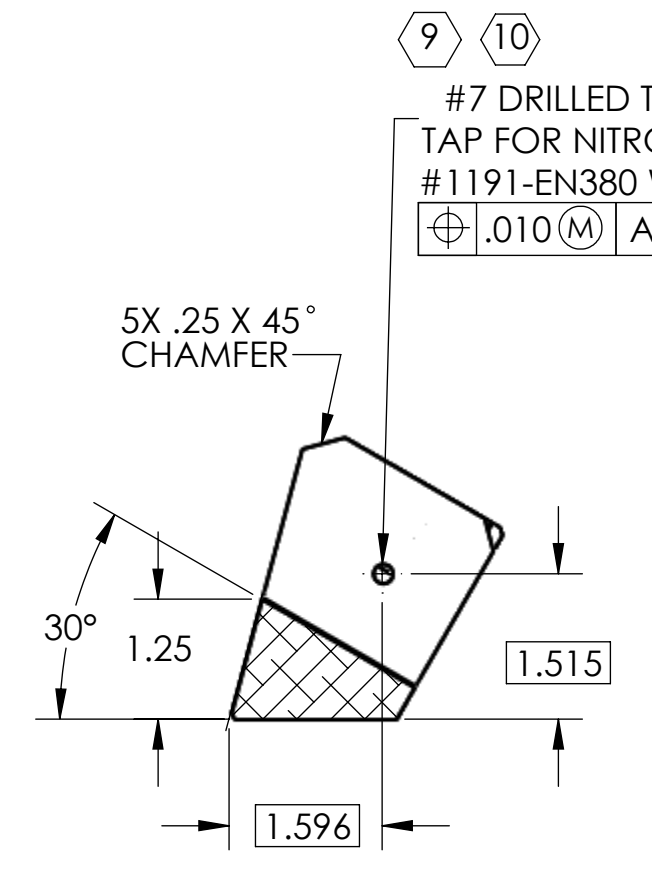
9 10
#7 DRILLED THRU ∇ .84
TAP FOR NITRONIC 60 HELICOIL
#1191-EN380 W/10-32 THREADS
 $\oplus .010 (M) A B C$



SECTION A-A

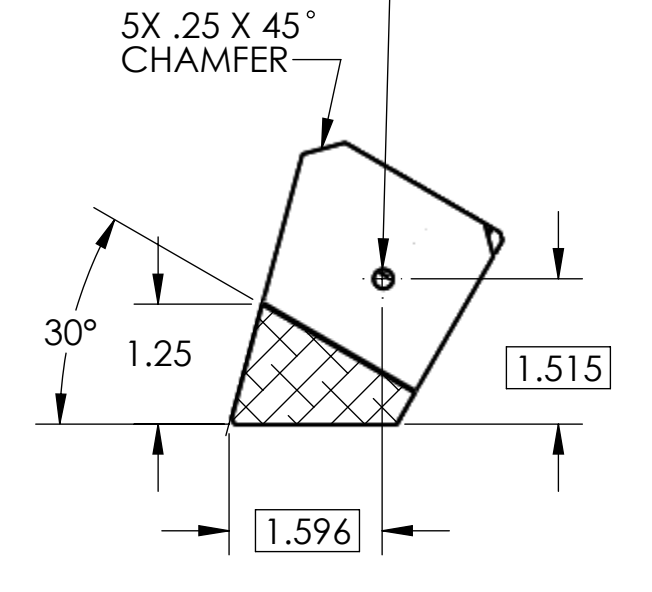


SECTION E-E

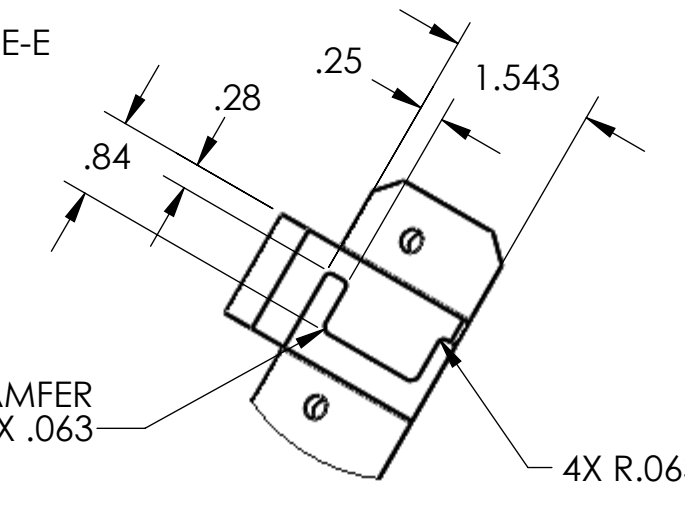


SECTION F-F

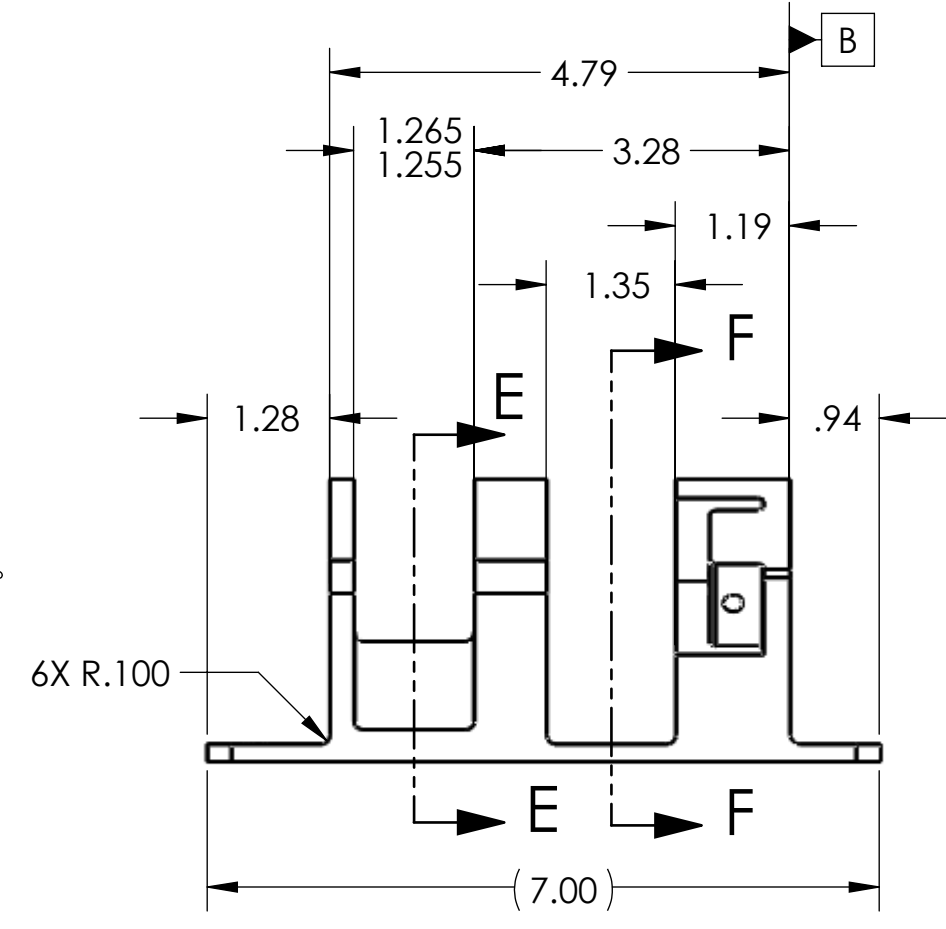
9 10
#7 DRILLED THRU MID FLANGE
TAP FOR NITRONIC 60 HELICOIL
#1191-EN380 W/10-32 THREADS
 $\oplus .010 (M) A B C$



SECTION H-H

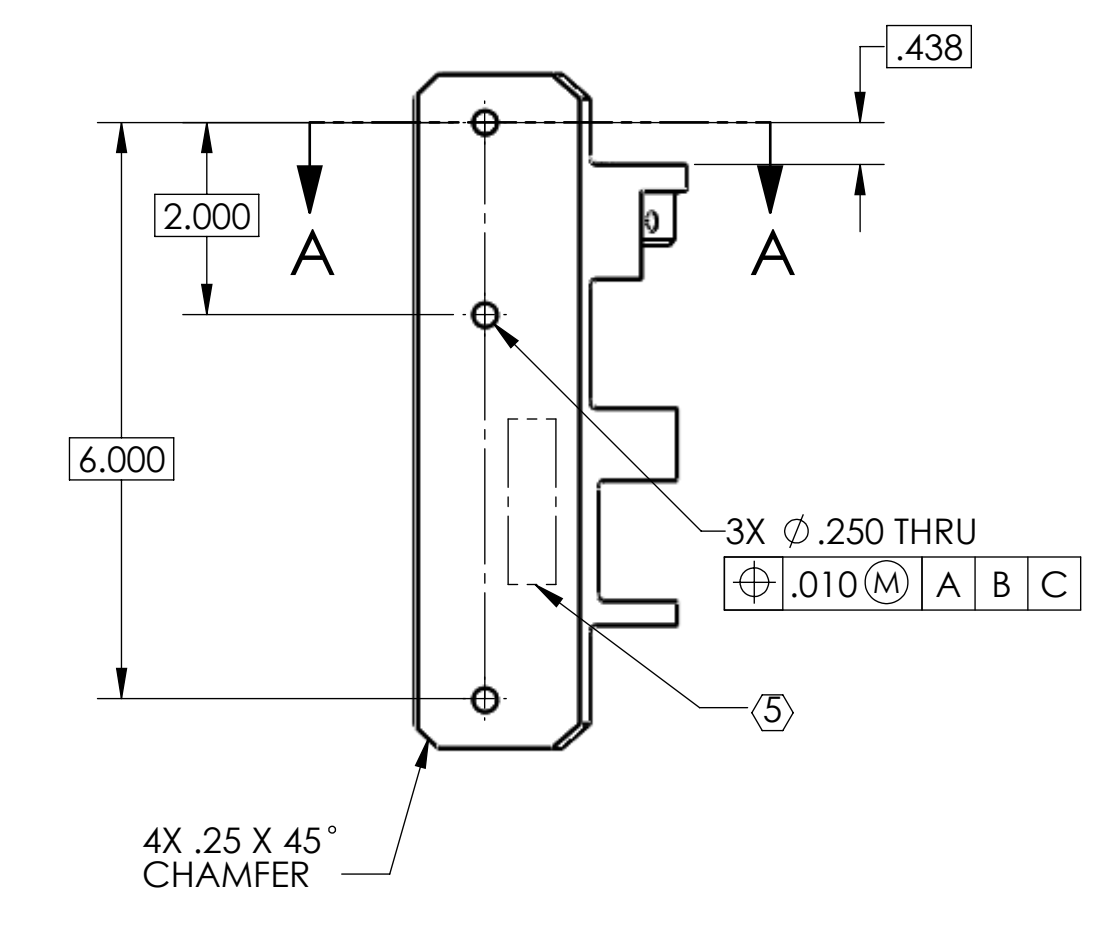


VIEW CA-CA



VIEW CB-CB

9 10
#7 DRILLED THRU TO NEXT FACE
TAP FOR NITRONIC 60 HELICOIL
#1191-EN380 W/10-32 THREADS
 $\oplus .010 (M) A B C$
 $\square .005 (M) D$



3X ϕ .250 THRU
 $\oplus .010 (M) A B C$

4X .25 X 45° CHAMFER

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°

MATERIAL	6061 Alloy	FINISH	63 μ inch
----------	------------	--------	---------------

SYSTEM	ADVANCED LIGO	SUB-SYSTEM	AOS
NEXT ASSY	D1101851-1, D1101851-2		

PART NAME		SUPPORT BRACKET, LONG-SIDE SUSPENSION ARM	
DESIGNER	M. JACOBSON	23 DEC 2011	SIZE DWG. NO.
DRAFTER	E. SANCHEZ	27 JAN 2012	D 1102441
CHECKER	J. LEWIS	06-AUG-12	
APPROVAL	M. JACOBSON	06-AUG-12	REVISION
			v2
SCALE:	1:2	PROJECTION:	SHEET 1 OF 1