

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: DXXXXXXX-VY, TYPE-XX, S/N XXX

6. MASS: 20.9 G [0.046 LB].

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

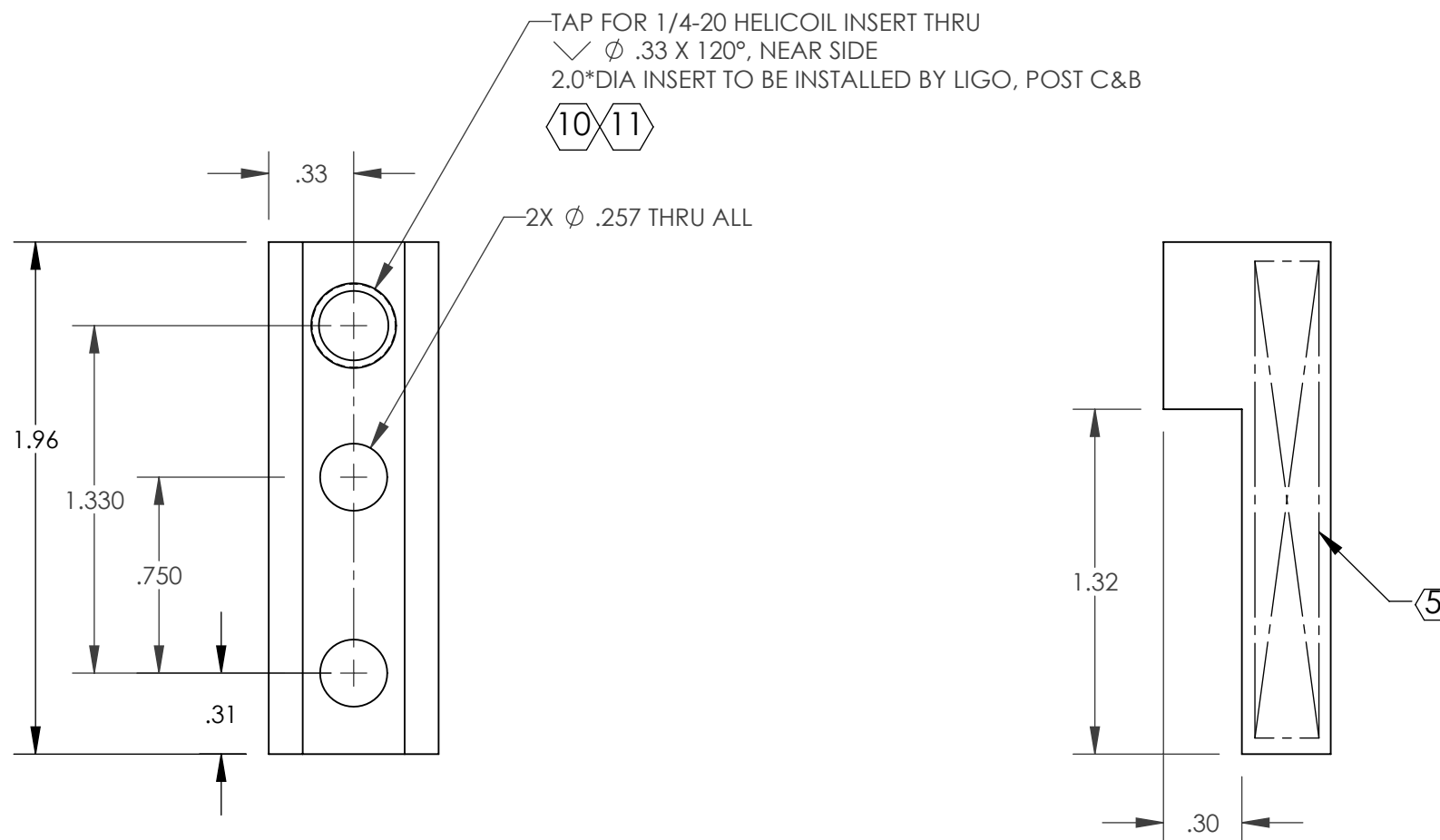
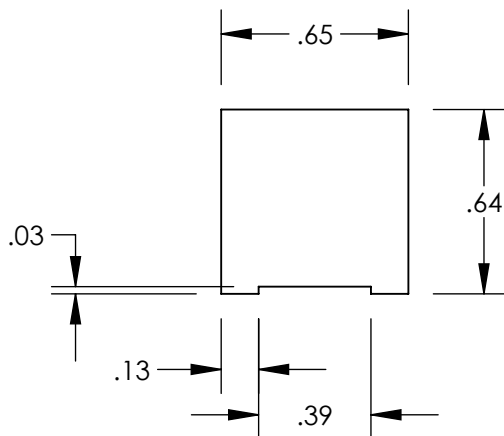
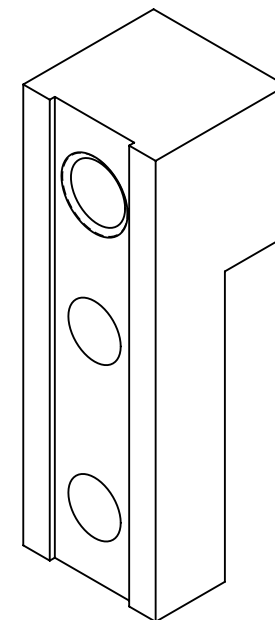
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. 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 PART 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 PREPARE HELICOIL TAPPED HOLE ACCORDING TO EMHART HELICOIL PRODUCT CATALOG HC2000. DO NOT INSTALL HELICOIL.

11 INTERNAL NOTE: HELICOILS TO BE INSTALLED BY LIGO, POST C&B. USE ONLY NITRONIC 60 HELICOILS.

REV.	DATE	DCN #	DRAWING TREE #
v1	25 MAR 2012	E1101214	-
v2	11 APR 2012	E1101214	-
-	-	-	-



D1200427 aLIGO TMS Upper SUS Wire Adjuster, PART PDM REV: X-018, DRAWING PDM REV: X-004

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		aLIGO TMS UPPER SUS WIRE ADJUSTER	
TOLERANCES: .XX ± .01 .XXX ± .005				SUB-SYSTEM AOS		DESIGNER C. CONLEY	08 MAR 2012
ANGULAR ± 1.0°				NEXT ASSY D1200525		DRAFTER C. CONLEY	25 MAR 2012
MATERIAL 6061-T6 Al				FINISH 63 μinch Ra		CHECKER SEE DCN	SIZE DWG. NO. B
						APPROVAL SEE DCN	D1200427
						SCALE: NONE PROJECTION: SHEET 1 OF 1	
						REV. v2	