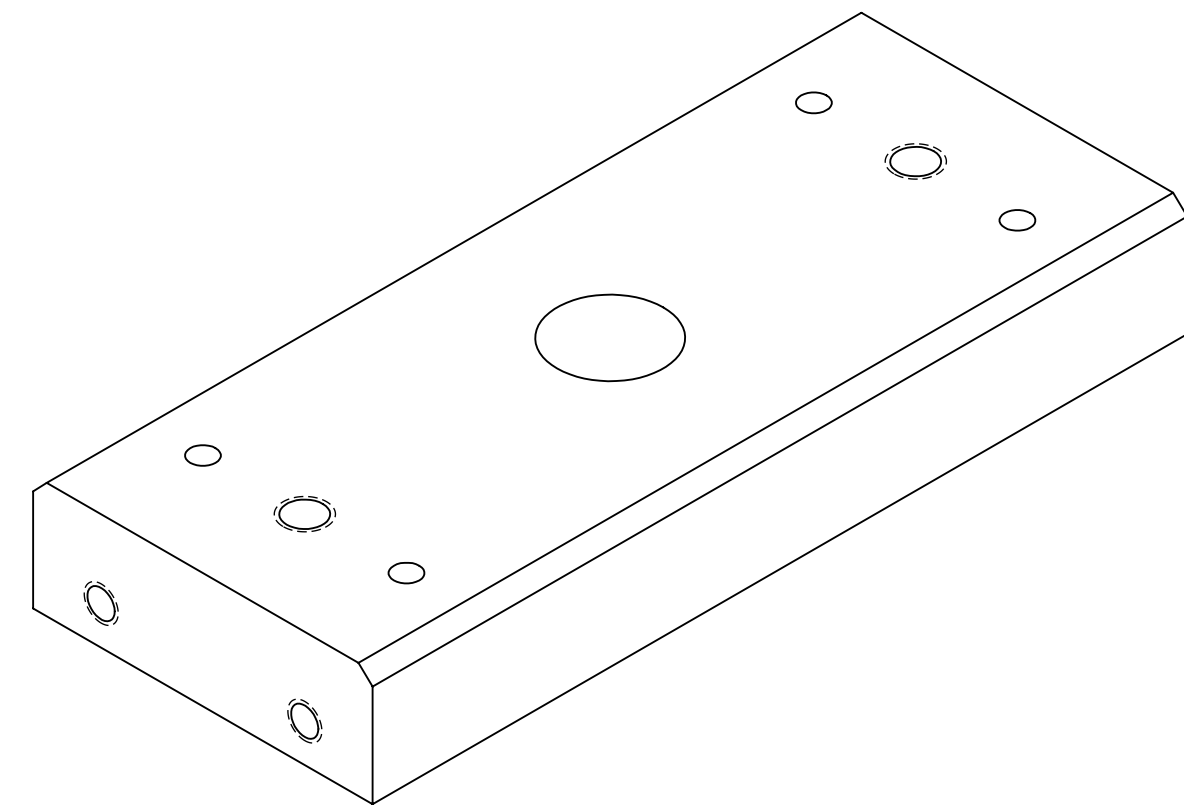
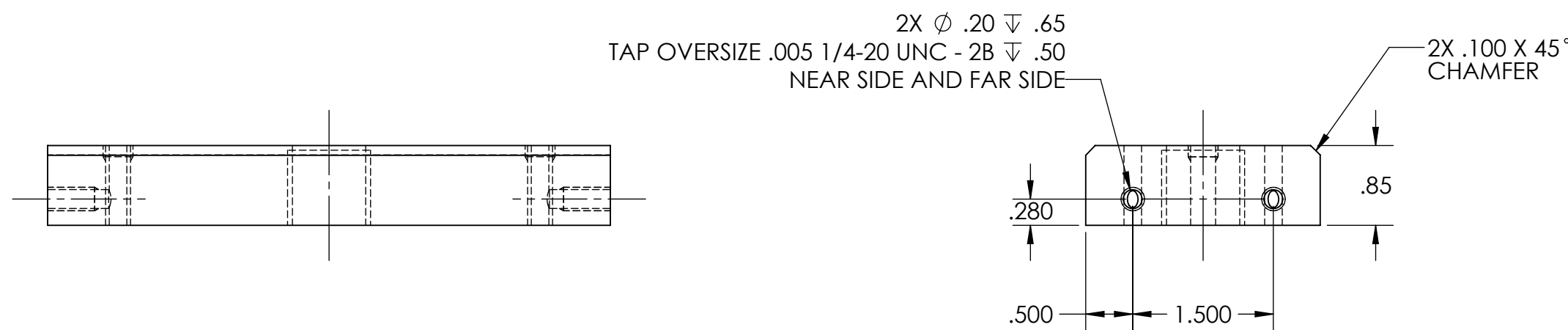
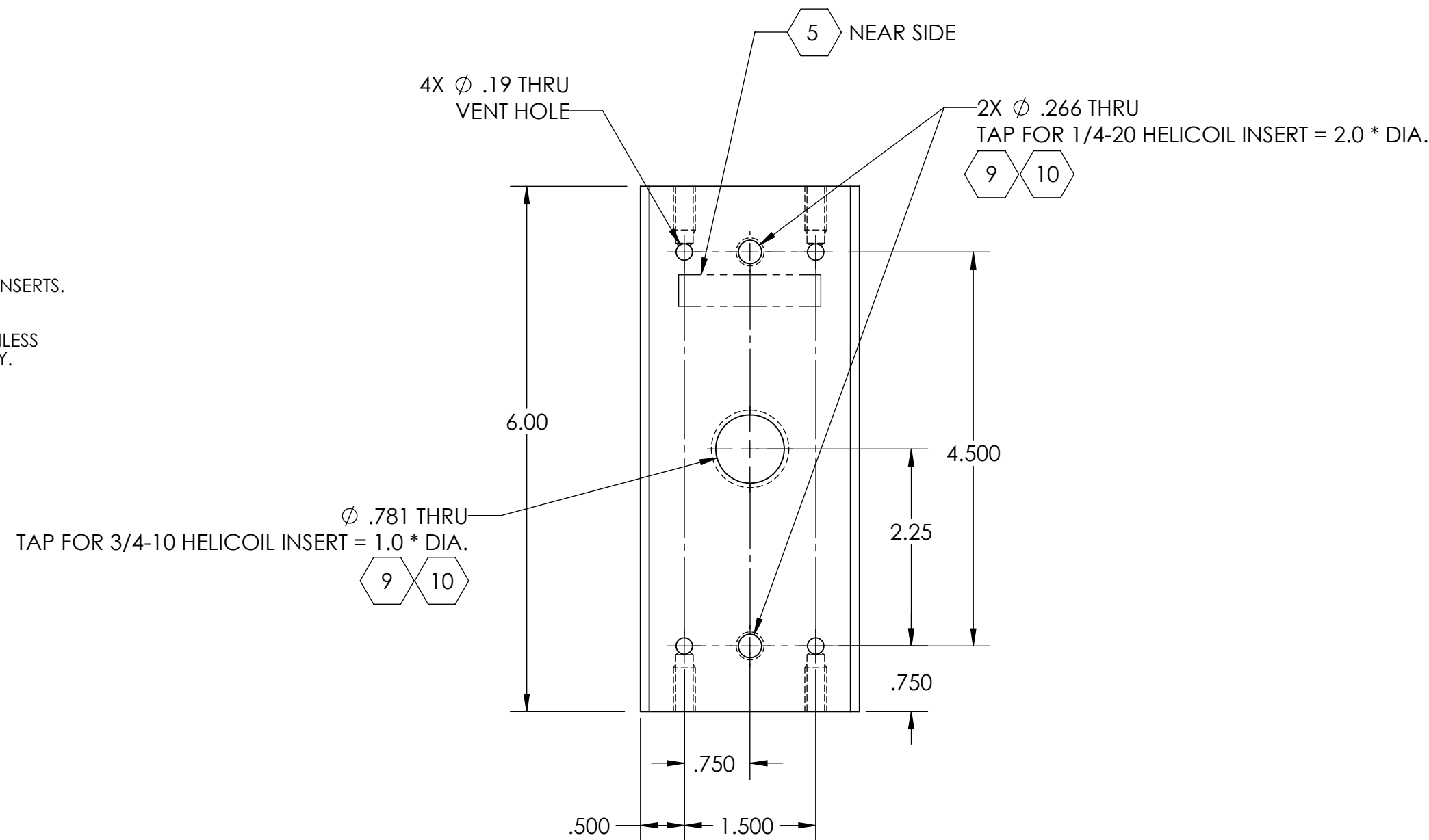


NOTES CONTINUED:

- 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 = X.XXX LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 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.

REV.	DATE	DCN #	DRAWING TREE #
V1	26 JUN 2012	E1200700	
V2	13 JUL 2012	E1200700	
V3	20 AUG 2012	E1200700	



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	SUPPLIER
3	1	1185-12EN750	INSERT, HELI-COIL, 1/4-20 X .50 LG NITRONIC 60	HELI-COIL
2	2	1185-4EN500	INSERT, HELI-COIL, 1/4-20 X .50 LG NITRONIC 60	HELI-COIL
1	1	D1200731	PCAL PLATE RING CONNECTOR	

BOM Table

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .02
 .XXX ± .005

ANGULAR ± 0.5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
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	6061 Alloy	FINISH	63 μinch
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LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

NEXT ASSY: D1200174

PART NAME				PCAL PLATE RING CONNECTOR			
DESIGNER	S. SHANKLE	26 JUN 2012	SIZE	DWG. NO.	REV.		
DRAFTER	S. SHANKLE	26 JUN 2012	c	D1200731	v3		
CHECKER	S. SHANKLE	26 JUN 2012	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1		
APPROVAL	S. SHANKLE	26 JUN 2012					