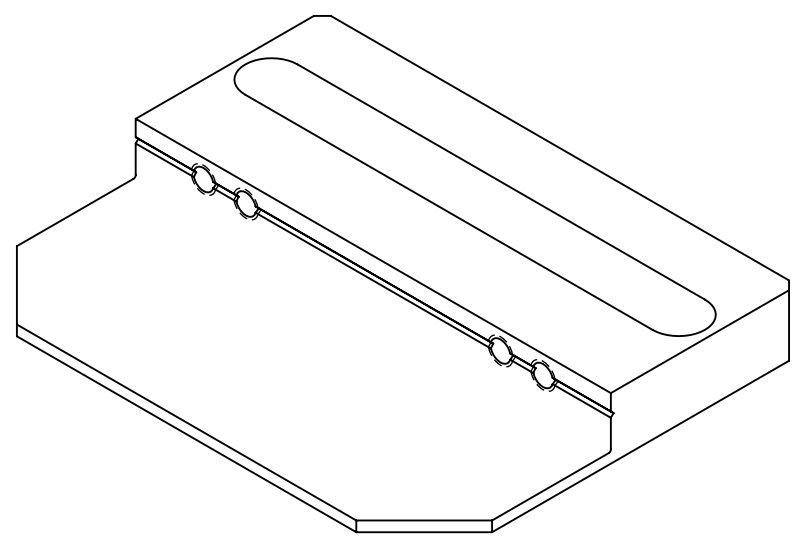
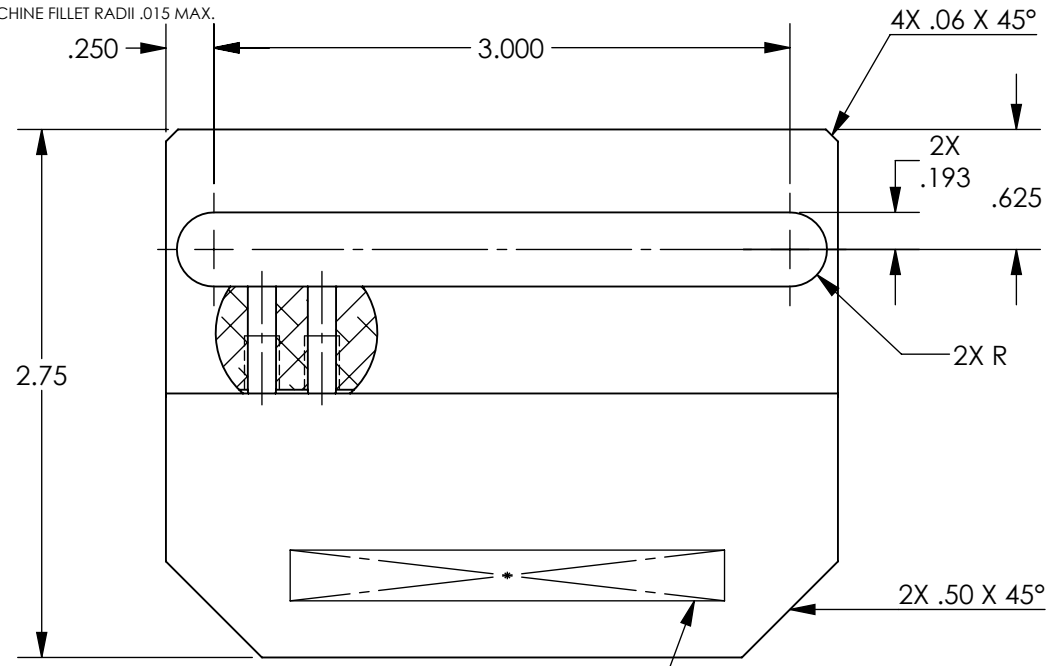


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
 - 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - 8. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
 - 9. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
 - 10. 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.
 - 11. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .015 MAX.

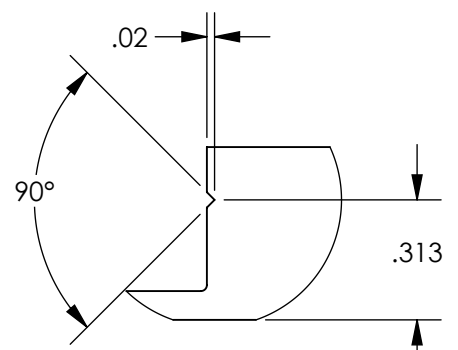
REV.	DATE	DCN #	DRAWING TREE #
v1	20 MAR 2013	E1300202-x0	-
v2	07 MAR 2014	E1400134-x0	-
-	-	-	-



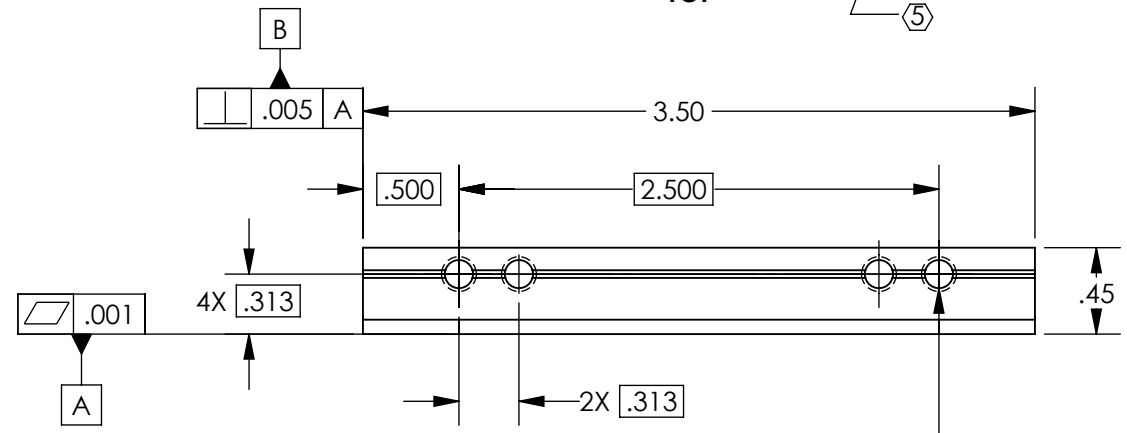
ISO VIEW



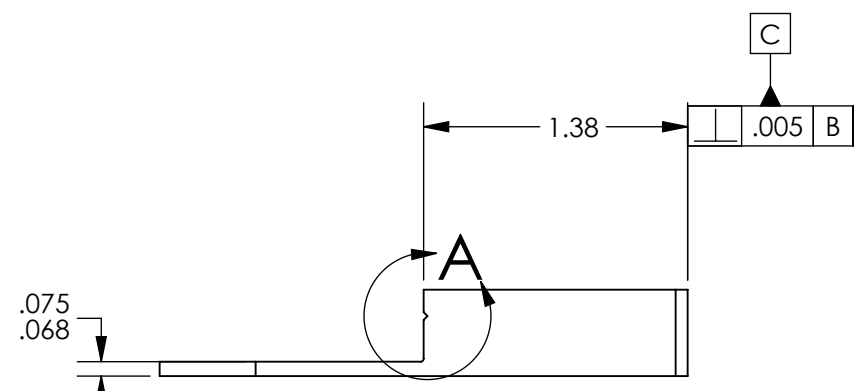
TOP



DETAIL A
SCALE 2:1



FRONT



SIDE

4X ϕ .15 THRU
TAP FOR #6-32 HELICOIL INSERT = 1.5 * DIA.

ϕ .014 (M) A B
.005 (M) C

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 0.5°

MATERIAL	6061-T6 Al	FINISH	63 μ inch
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME aLIGO, 4 in. SILICON WAFER STAND, BASE	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	SYS
DESIGNER	E.SANCHEZ	MAR 19 2013	SIZE DWG. NO.
DRAFTER	E.SANCHEZ	MAR 20 2013	B
CHECKER	SEE DCC	SEE DCC	D1300274
APPROVAL	SEE DCC	SEE DCC	REV. v2
NEXT ASSY		D1300275	SCALE: 1:1 PROJECTION:
			SHEET 1 OF 1

D1300274_Aligo_4 in. Silicon Wafer Stand, Base, PART PDM REV: X-002, DRAWING PDM REV: X-007