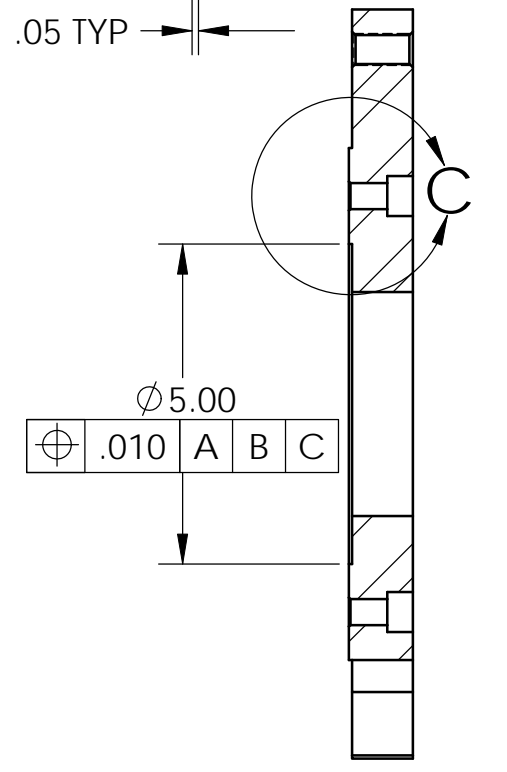
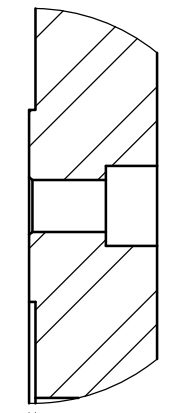


REV.	DATE	DCN #	DRAWING TREE #
v2	9 Mar. 2011	E1100015	E1100016

NOTES CONTINUED:

- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
- SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXX-VY, TYPE-XX, S/N XXX.
- APPROXIMATE WEIGHT = 14.98 LB.
- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- PAINT: ALL VISIBLE SURFACES (exclude fastening hardware) EXCEPT AREAS IDENTIFIED BY Δ M MEDIUM BLUE SHERWIN WILLIAMS (POLANE (R) T-PLUS POLYURETHANE ENAMEL) #SW-F63TX-L-2822-5864 PRIME WITH SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER P60G2
- "OXI SOLV RUST INHIBITOR" TO BE APPLIED PER MFG. INSTRUCTIONS TO ALL UNPAINTED SURFACES. BOTH TAPPED AND THRU HOLES WILL BE PLUGGED DURING APPLICATION.

DETAIL C
SCALE 2 : 3



SECTION B-B

8X .05 X 45° CHAMFER

3X ϕ .453 THRU
1/2-20 UNF THRU
 \sphericalangle ϕ .55 X 82°, BOTH SIDES
 \oplus ϕ .015 A B C

3X ϕ .201 ∇ .65
1/4-20 UNC ∇ .50
 \sphericalangle ϕ .30 X 82°, NEAR SIDE
 \oplus ϕ .005 A B C

ϕ 3.50 THRU
 \oplus ϕ .010 (M) A B C

Δ M ϕ 5.90
INSIDE CIRCLE

6X ϕ .406 THRU ALL
 ∇ ϕ .625 ∇ .40
 \sphericalangle ϕ .45 X 82°, FAR SIDE
 \oplus ϕ .005 (M) A B C

D
C
B
A

D
C
B
A

D080546 HAM HEPI Vert L4-C Adapter, PART PDM REV: X-006, 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		HAM HEPI VERT L4-C ADAPTOR	
TOLERANCES: .XX \pm .015 .XXX \pm .005				SUB-SYSTEM SEI		DESIGNER	A. STEIN 16 June 2008
ANGULAR \pm .5°				NEXT ASSY D1100145, D1100147		DRAFTER	M.HILLARD 9 Mar. 2011
MATERIAL AISI 1018 Steel, Cold Rolled				FINISH 63 μ inch		CHECKER	A.STEIN 16 June 2008
						APPROVAL	K.MASON 9 Mar. 2011
						SIZE	DWG. NO. D080546
						REVISION	v2
						SCALE	1:3
						PROJECTION	AS SHOWN
						SHEET 1 OF 1	