

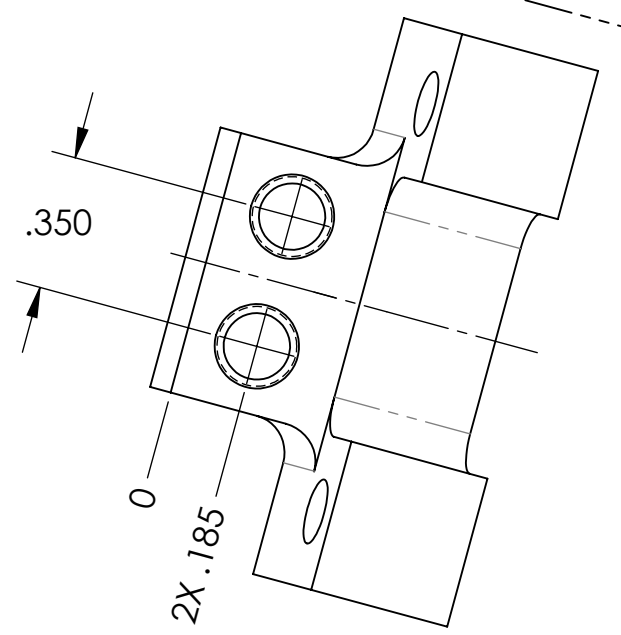
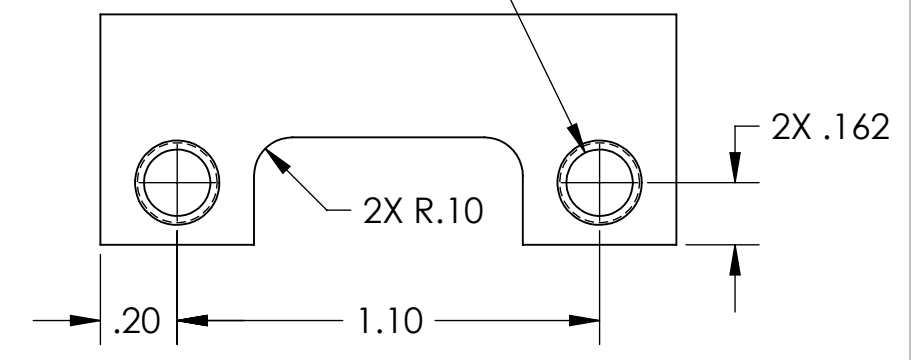
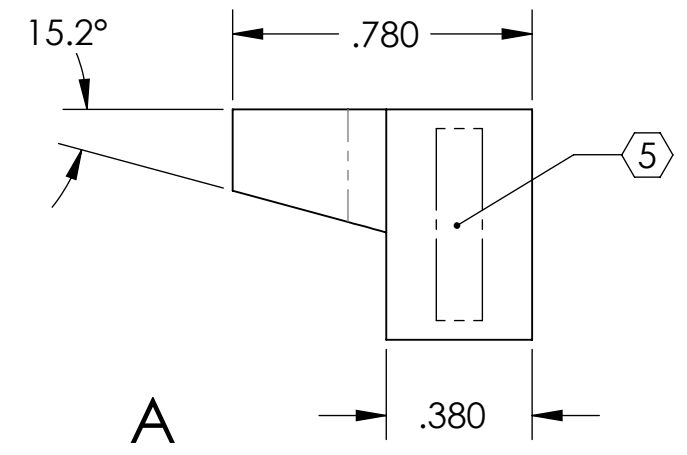
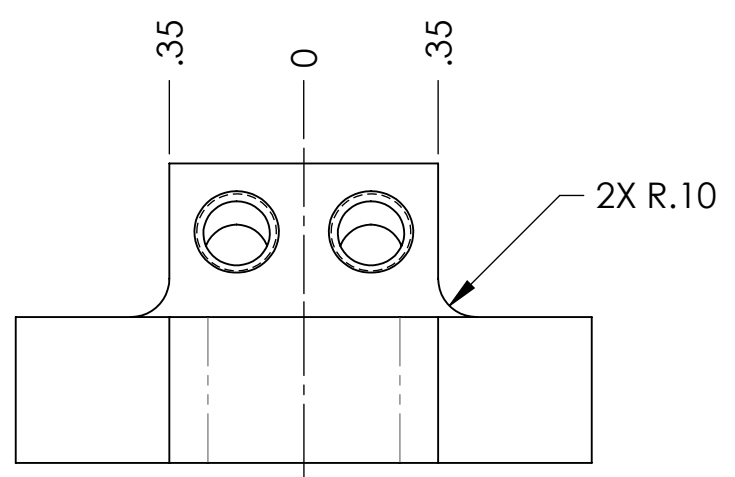
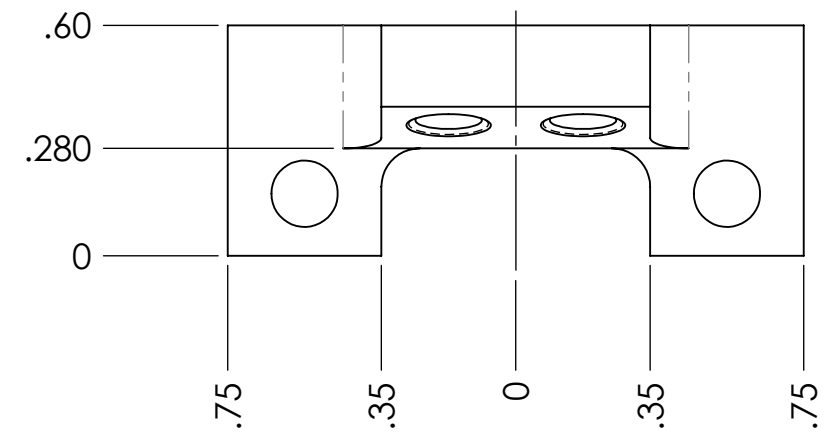
**NOTES CONTINUED:**  
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.  
 EXAMPLE: DXXXXXX-VV TYPE-XX S/N XXX  
 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.  
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.  
 8. ALL HELICOIL HOLES TO BE PREPARED IN ACCORDANCE WITH EMHART HELICOIL PRODUCT CATALOG, HC2000, REV. 4.  
 9. ALL HELICOILS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY, CLEANING AND BAKING OF FINISHED PARTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	26 MAY 2009	E0900160	E080191
v2	28 JUN 2010	E1000236	E080191
-	-	-	-

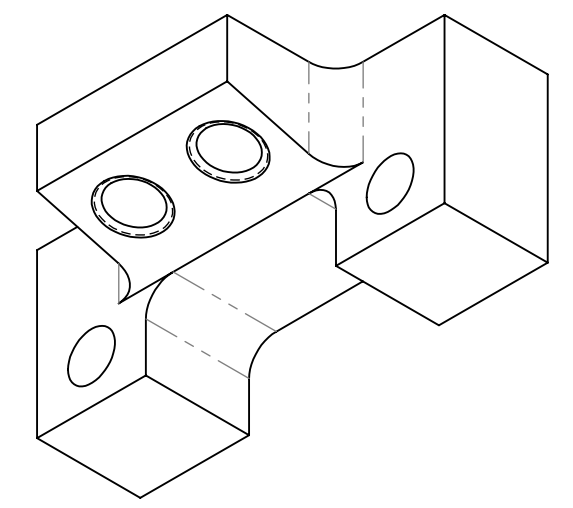
4X DRILL AND TAP THRU FOR #8-32 UNC-2B X 1.5 DIA EMHART HELICOIL (P/N 1185-2EN246)

D  
C  
B  
A

D  
C  
B  
A



VIEW A-A



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.1°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		<b>C-CLAMP, UPPER MASS</b>	
MATERIAL 6061-T6 Al		FINISH 32 μinch		SYSTEM ADVANCED LIGO SUB-SYSTEM SUS		DESIGNER B. KIRSNER 4 MAR 2008 DRAFTER R. BIEDENHARN 01 NOV 2010 CHECKER D. BRIDGES 04 NOV 2010 APPROVAL	
NEXT ASSY UPPER WIRE ASSEMBLY				SIZE DWG. NO. B D020652		REV. v2	
				SCALE: 2:1		PROJECTION: SHEET 1 OF 1	