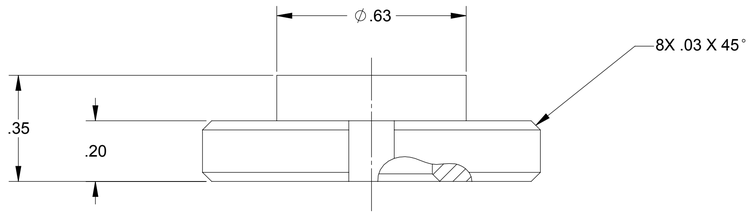
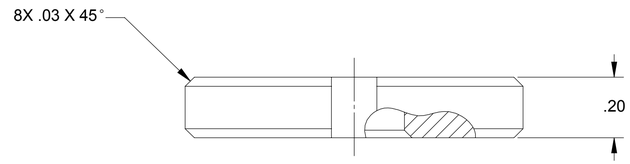
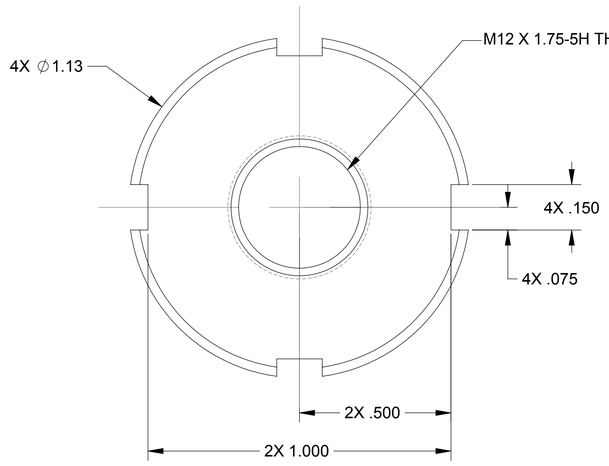
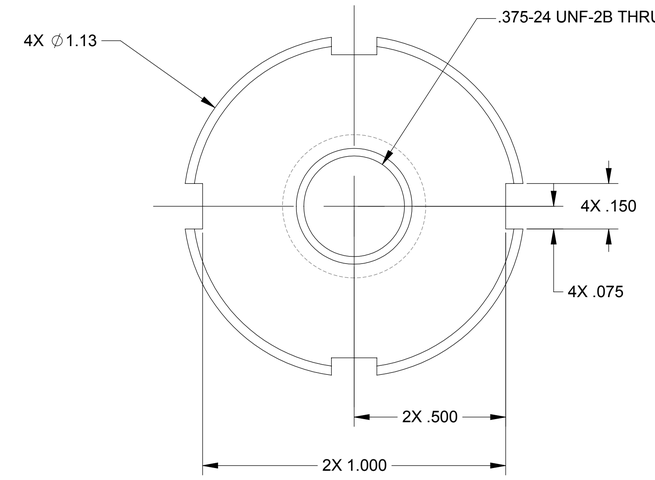
REV.	DATE	DCN #	DRAWING TREE #







-1 SHOWN



-2 SHOWN

NOTES: UNLESS OTHERWISE SPECIFIED.

5. MACHINE FILLET RADII .003-.015.
6. MARK PART AND SERIAL NUMBER IN LOCATION APPROXIMATELY AS SHOWN USING 0.07-INCH HIGH CHARACTERS IN ACCORDANCE WITH 20006686, TYPE I, CLASSES 4, 5, OR 6. SERIAL NUMBERS START AT 001 FOR FIRST PART AND PROCEED CONSECUTIVELY. PARTS TOO SMALL TO MARK SHALL BE IDENTIFIED IN ACCORDANCE WITH 20006686, TYPE II.
7. THREADED HOLES NOT REQUIRING INSERTS SHALL BE TAPPED .004-.006 OVERSIZE.
8. COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-.000.
9. RECORD WEIGHT TO NEAREST 0.1 LB ON INSPECTION REPORT AFTER FINAL MACHINING.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)									
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .03 .XXX ± .010 ANGULAR ± 0.5°	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 SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: HAM GS-13 JAM NUT				
MATERIAL: CRES 15-5 PH, AMS 5659, H1025	FINISH: 63 µinch		SYSTEM: ADVANCED LIGO	SUB-SYSTEM: SEI	DESIGNER: ASI 2 Aug 2009	SIZE: D	DWG. NO.: D047792	REV.: v2	
			NEXT ASSY: D047790		DRAFTER: ASI 2 Aug 2004				
					CHECKER: sbarnum 11 Aug 2009				
					APPROVAL:	SCALE: 4:1	PROJECTION:	SHEET 1 OF 1	