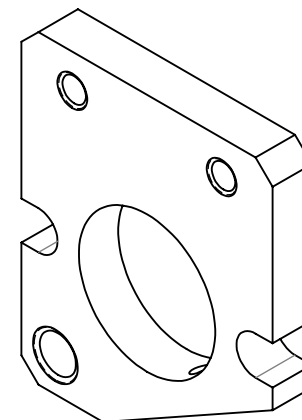
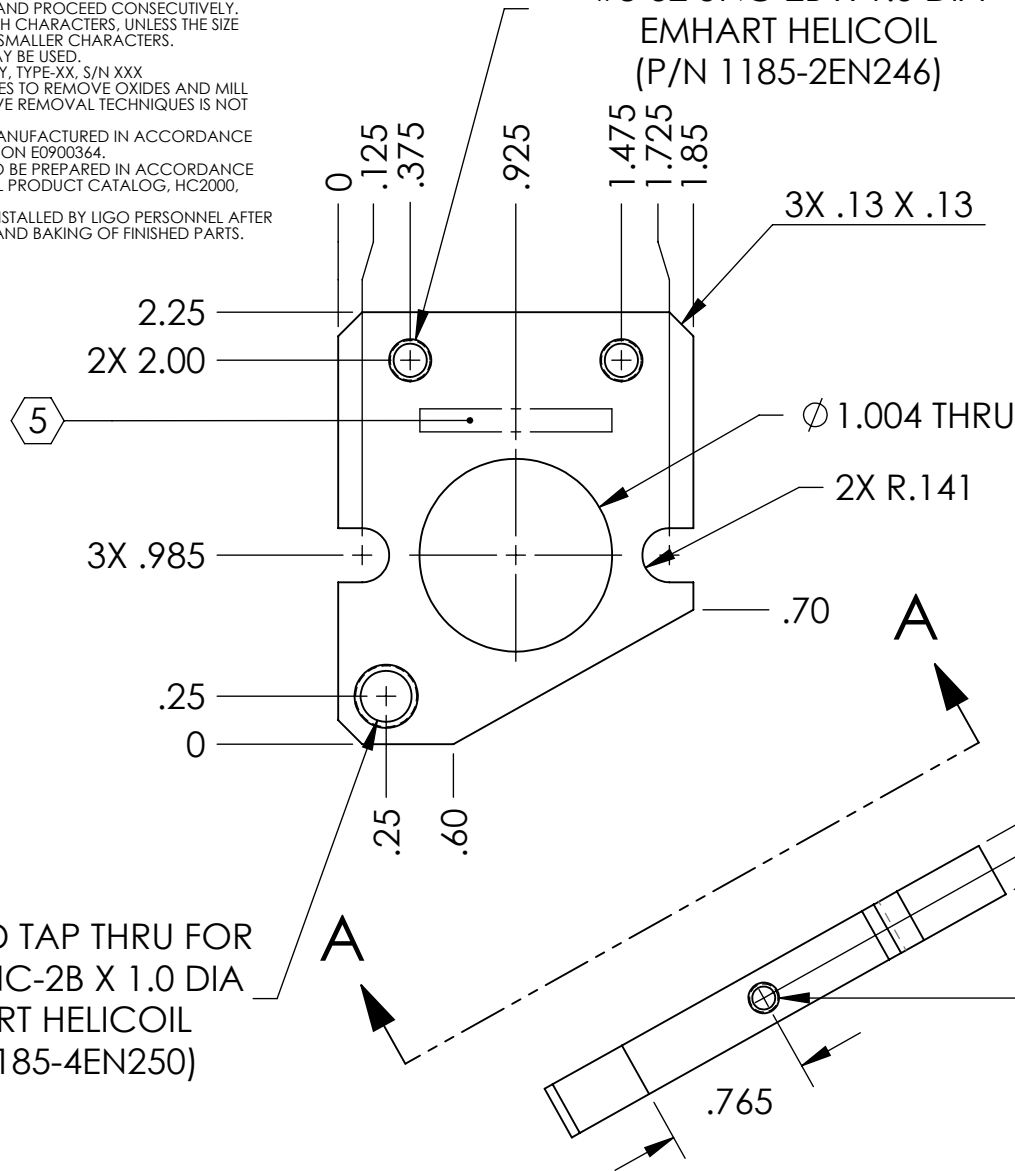


NOTES CONTINUED:

- 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-VY, 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	17 AUG 2009	E0900243	E080191
v2	10 AUG 2010	E1000301	E080191
v3	05 MAR 2011	E1100228	E080191

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



DRILL AND TAP THRU FOR 1/4-20 UNC-2B X 1.0 DIA EMHART HELICOIL (P/N 1185-4EN250)

DRILL AND TAP THRU TO BORE FOR #4-40 UNC-2B X 1.5 DIA EMHART HELICOIL (P/N 1185-04EN168)

VIEW A-A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ± .01
 .XXX ± .005
 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 MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.
 MATERIAL 6061-T6 Al
 FINISH 63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM SUS
 NEXT ASSY MULTIPLE ASSYS

PART NAME AOSEM ALIGNMENT BRACKET, BOTTOM MASS

DESIGNER	D. BRIDGES	08 MAR 2011	SIZE	DWG. NO.	REV.
DRAFTER	D. BRIDGES	09 MAR 2011	A	D0901549	v3
CHECKER	B. MOORE	09 MAR 2011	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1
APPROVAL					