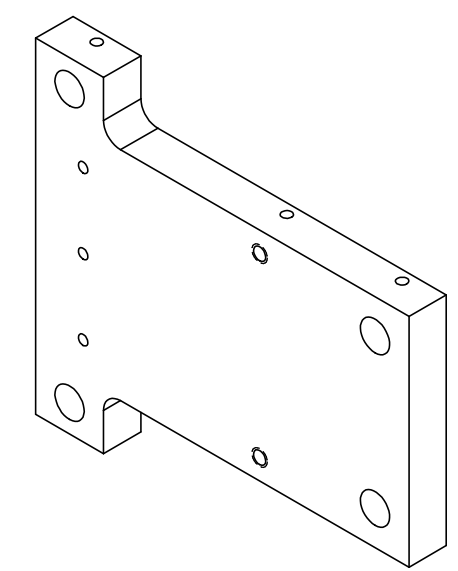
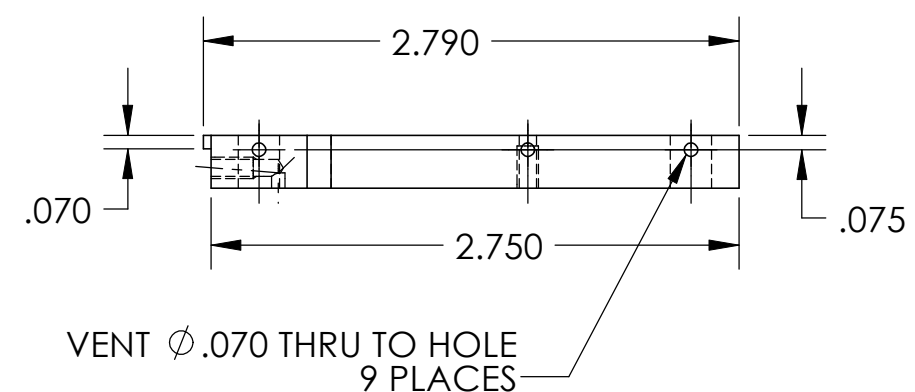


NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
EXAMPLE (PART): 001-v1
EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD
- 6. APPROXIMATE WEIGHT = 0.124 LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
- 10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.
- 11. 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.

REV.	DATE	DCN #	DRAWING TREE #
-	-	E1100131	-
-	-	-	-
-	-	-	-

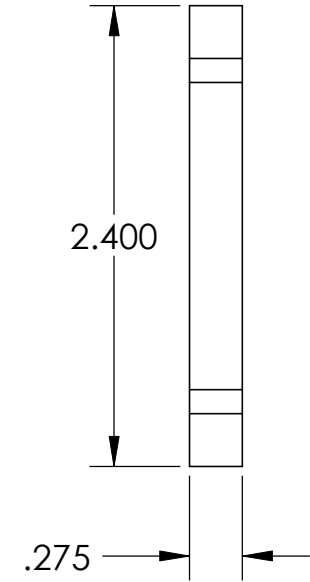
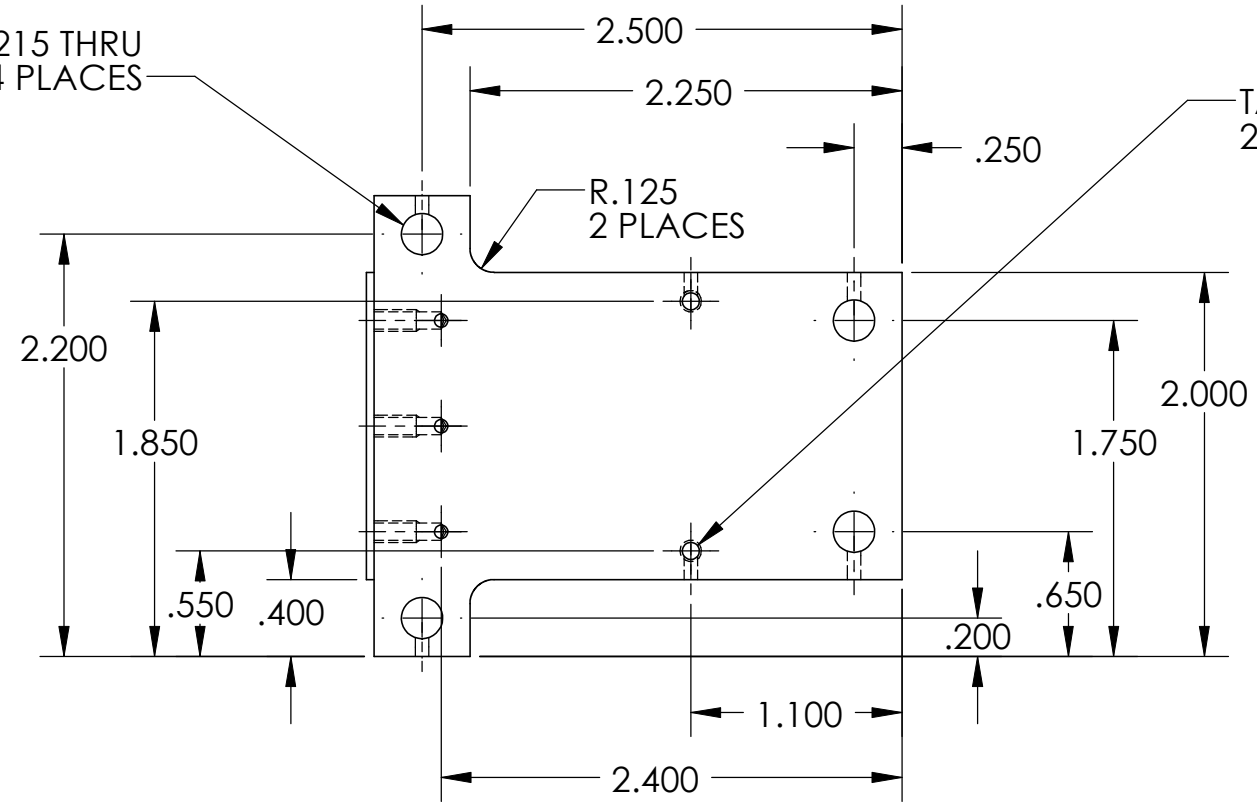
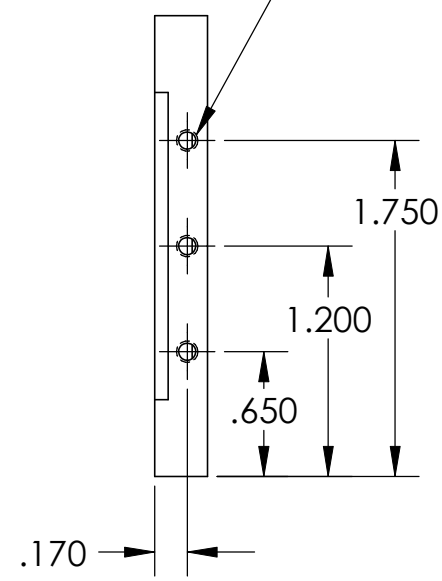


TAP FOR #4-40 HELICOIL (1185-04EN112)
.350 DEEP
3 PLACES

Ø.215 THRU
4 PLACES

R.125
2 PLACES

TAP FOR #4-40 HELICOIL THRU (1185-04EN224)
2 PLACES



D1000091 ALIGO IO HAM AUX SUS BLADE BASE PLATE, PART PDM REV: X-010, DRAWING PDM REV: X-005

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				UNIVERSITY OF FLORIDA CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES		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		BLADE BASE PLATE	
TOLERANCES: .XX ± .01 .XXX ± .003		MATERIAL 6061 Alloy		FINISH 63 μinch		SYSTEM ADVANCED LIGO SUB-SYSTEM 100	
ANGULAR ± 0.1°		NEXT ASSY D1000120		DESIGNER L.WILLIAMS 11 MAR 2010		SIZE DWG. NO. B D1000091	
				DRAFTER L.WILLIAMS 25 MAR 2010		REV. v3	
				CHECKER		SCALE: 1:1 PROJECTION:	
				APPROVAL		SHEET 1 OF 1	