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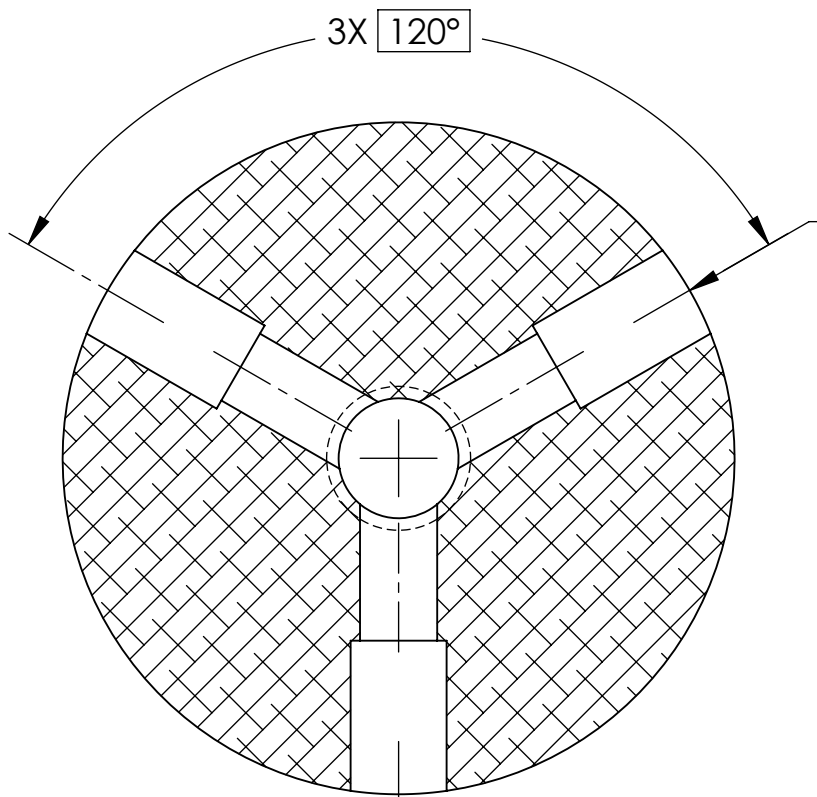
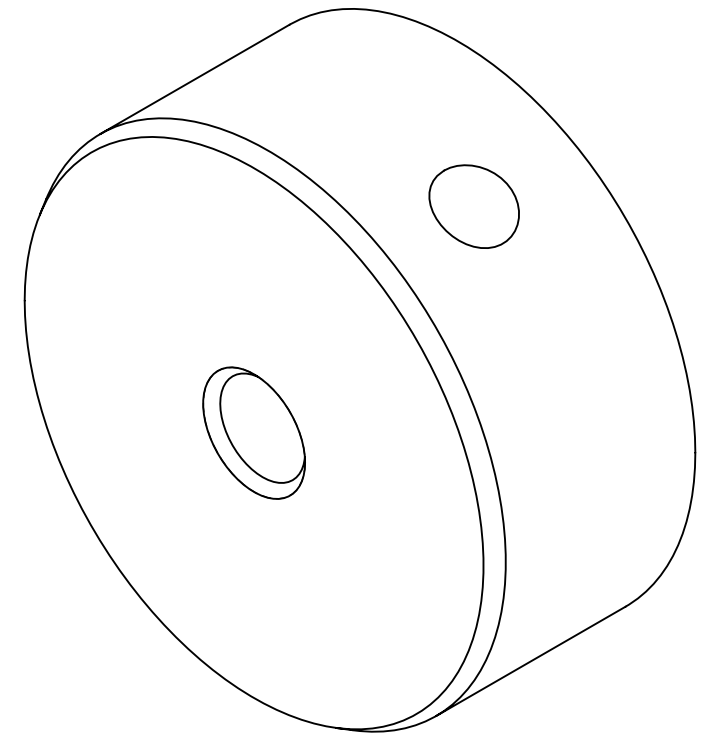
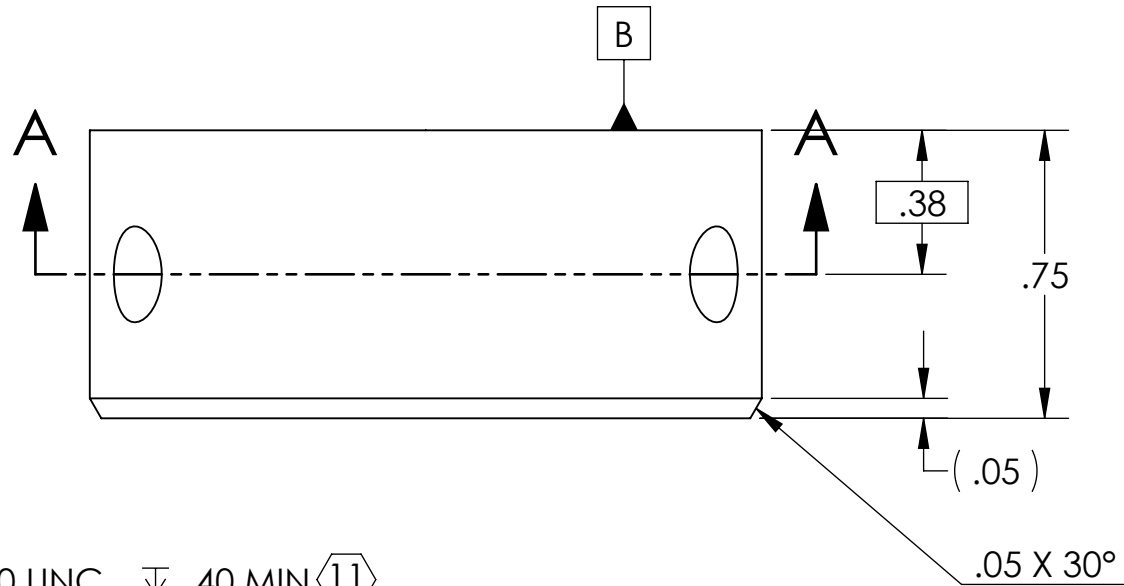
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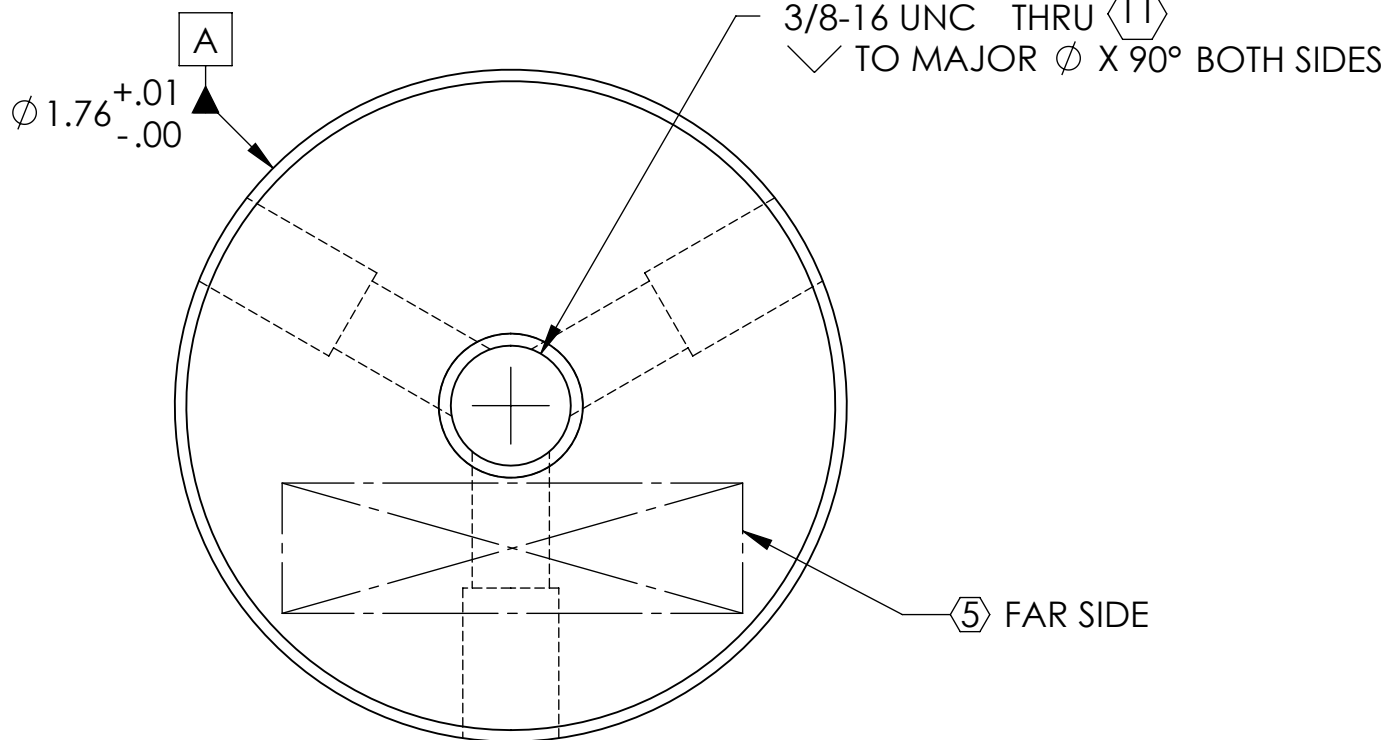
NOTES CONTINUED:

- 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. APPROXIMATE WEIGHT = .16 LB (.07 kg)
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO. REFER TO LIGO-E0900364.
- 10. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.
- 11. ALL TAPPED HOLES- USE .005 OVERSIZE DRILL & TAP.

REV.	DATE	DCN #	DRAWING TREE #
v1	03-SEPT-2010	E1000365	-
v2	16-NOV-2010	E1000688	-
-	-	-	-



3X 1/4-20 UNC  $\nabla$  .40 MIN  $\text{\textcircled{11}}$   
 DRILL THRU WALL AS SHOWN  
 $\text{\textcircled{S}}$   $\text{\textcircled{B}}$   $\phi .014$



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX $\pm$ .01 .XXX $\pm$ .005 ANGULAR $\pm$ 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.		<b>ALIGO ETM TELE TUBE THD INSERT</b>	
MATERIAL 6061-T6 Al		FINISH 63 $\mu$ inch Ra		SYSTEM ADVANCED LIGO SUB-SYSTEM AOS		DESIGNER K MAILAND 04/MAY/2010 DRAFTER I ROMERO 04/MAY/2010 CHECKER K MAILAND 04/MAY/2010 APPROVAL K MAILAND 04/MAY/2010	
NEXT ASSY D1000243				SIZE DWG. NO. B D1000242		REV. v2	
				SCALE: NONE PROJECTION:		SHEET 1 OF 1	

D1000242 cLIGO\_ETM\_Tele\_Tube\_Thd\_Insert, PART PDM REV: X-017, DRAWING PDM REV: X-013

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