NOTES CONTINUED:

Ⓢ 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: DXXXXXXX-VY, TYPE-XX, S/N XXX

6. APPROXIMATE WEIGHT = .913 LB.

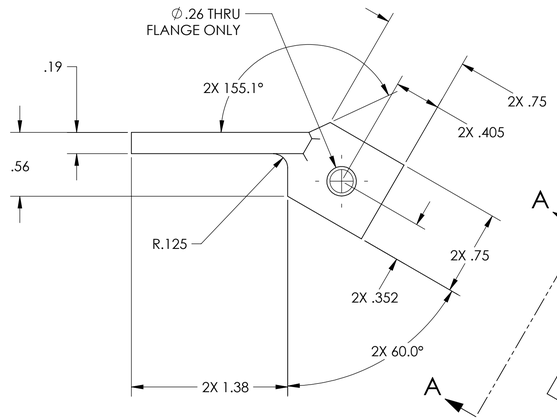
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

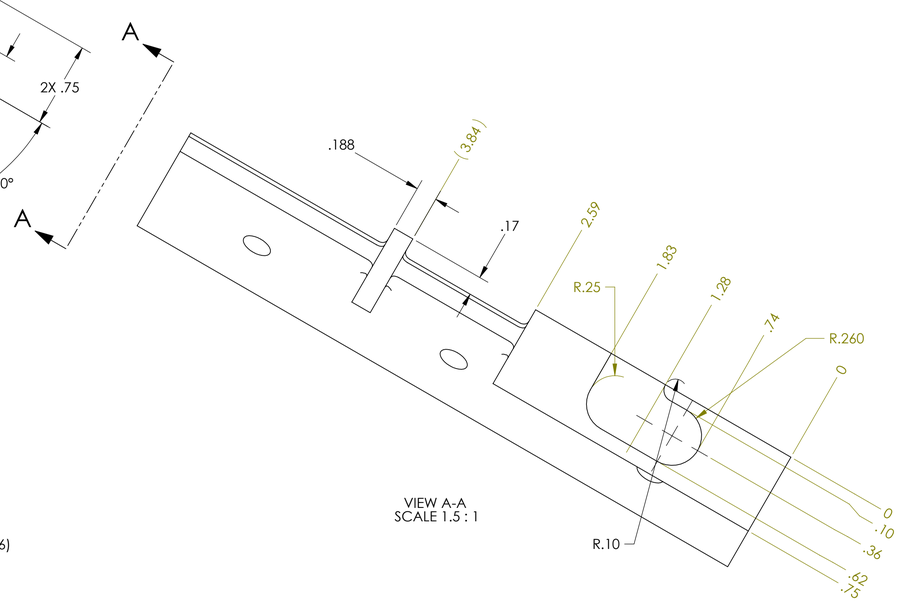
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9 ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

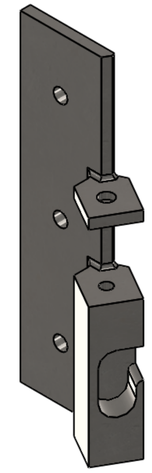
10 ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

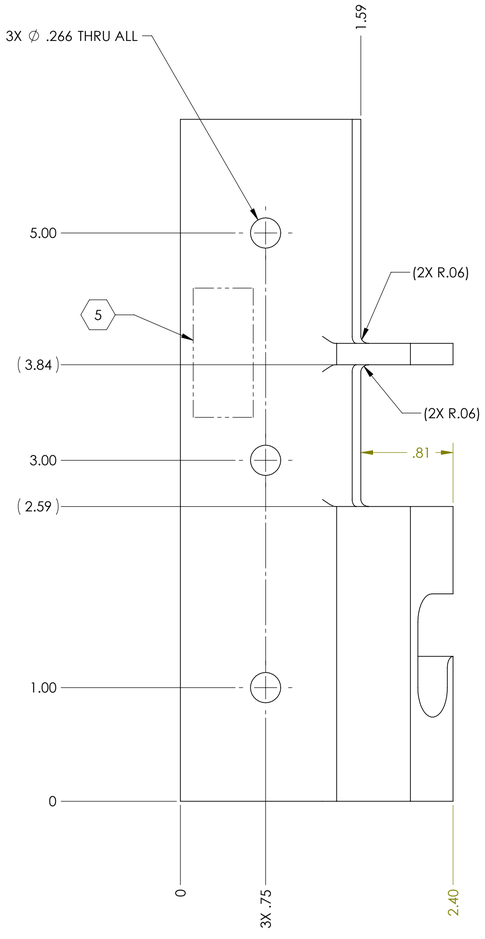
REV.	DATE	DCN #	DRAWING TREE #
v1	9-AUG-2010	-	-
-	-	-	-
-	-	-	-

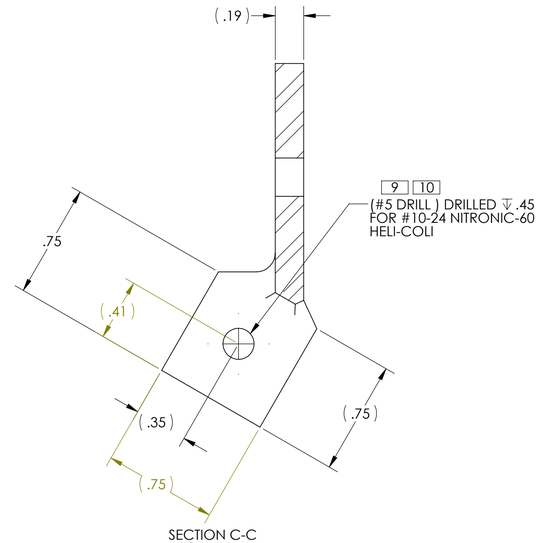




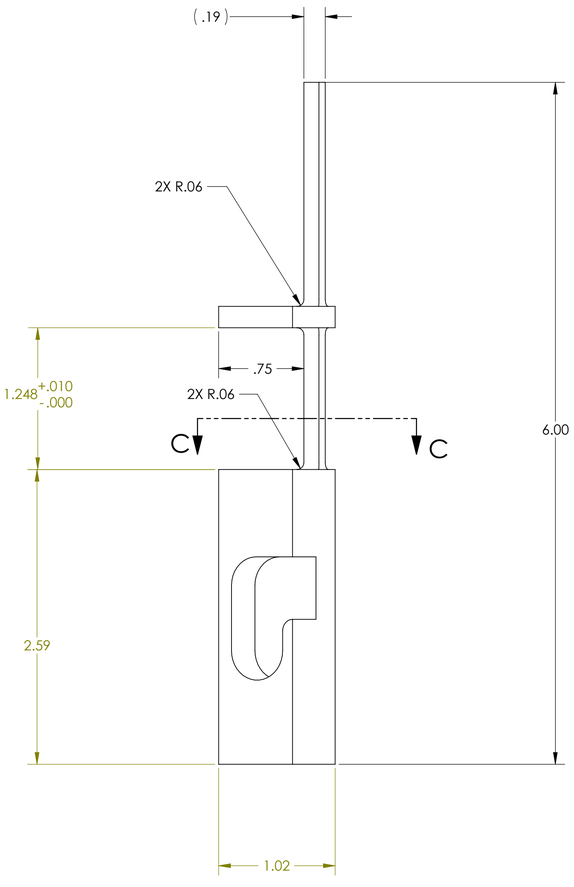
VIEW A-A
SCALE 1.5 : 1







SECTION C-C
SCALE 2 : 1



DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.1°	NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) 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.	LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: TCS UHV BRACKET, SHORT SIDE, BSC7	
	MATERIAL: AISI 304	FINISH: 32 µinch	NEXT ASSY: D1001742	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS
				DESIGNER: M. JACOBSON 25-AUG-2010	SIZE: D
				DRAFTER: A.COLE 9-AUG-2010	DWG. NO.: D1002315
				CHECKER: M.JACOBSON 9-AUG-2010	REV.: v1
				APPROVAL: C. TORRIE 9-AUG-2010	SCALE: 1.5:1 PROJECTION: SHEET 1 OF 1

D1002315_TCS UHV BRACKET, SHORT SIDE, BSC7, PART FDM REV: X-005, DRAWING FDM REV: X-004