



NOTES CONTINUED:

5. SCRIBE ENGRAVE OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) AND DATE IN THE UPPER RIGHT CORNER OF THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE THE SAME PART NUMBER FOR ALL ARTICLES UNLESS THE DRAWING PART NUMBER CHARACTERISTICS A VIBRATORY TOOL MAY BE USED. EXAMPLE: DX000000-VV, 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 ONLY FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.

1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SWIRL MARKS TO .002 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
 FINISH 32 μinch

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 XX ± .01
 XXX ± .005
 ANGULAR ± 0.1°

NOTES AND TOLERANCES (UNLESS OTHERWISE SPECIFIED):
 MATERIAL AISI 304
 FINISH 32 μinch

SYSTEM ADVANCED LIGO
 SUB-SYSTEM AOS
 NEXT ASSY D1001742

PART NAME TCS UHV BRACKET, SHORT SIDE, BSC7
 DESIGNER M. JACOBSON
 DRAFTER A. COLE
 CHECKER M. JACOBSON
 APPROVAL C. TORRE

REV. V1 9-AUG-2010
 V2 14-OCT-2010

DCN #
 DRAWING TREE #

REV. V2
 DWG. NO. D1002315
 SCALE 1.5:1
 PROJECTION
 SHEET 1 OF 1