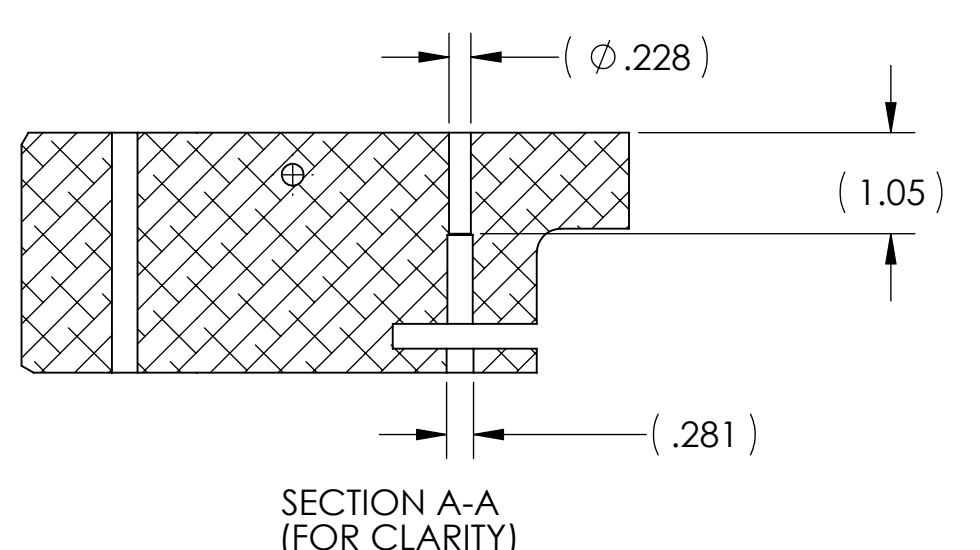
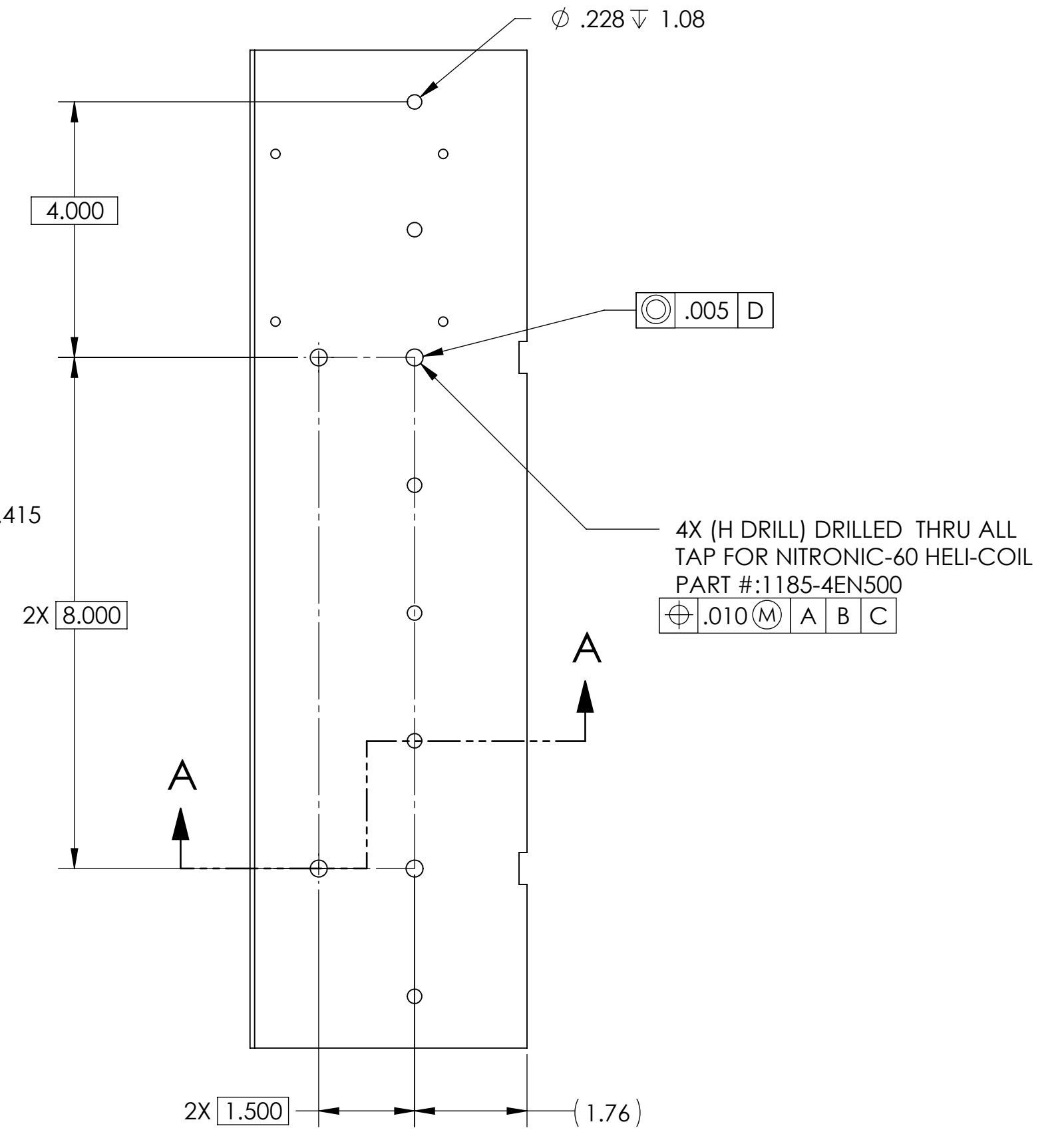
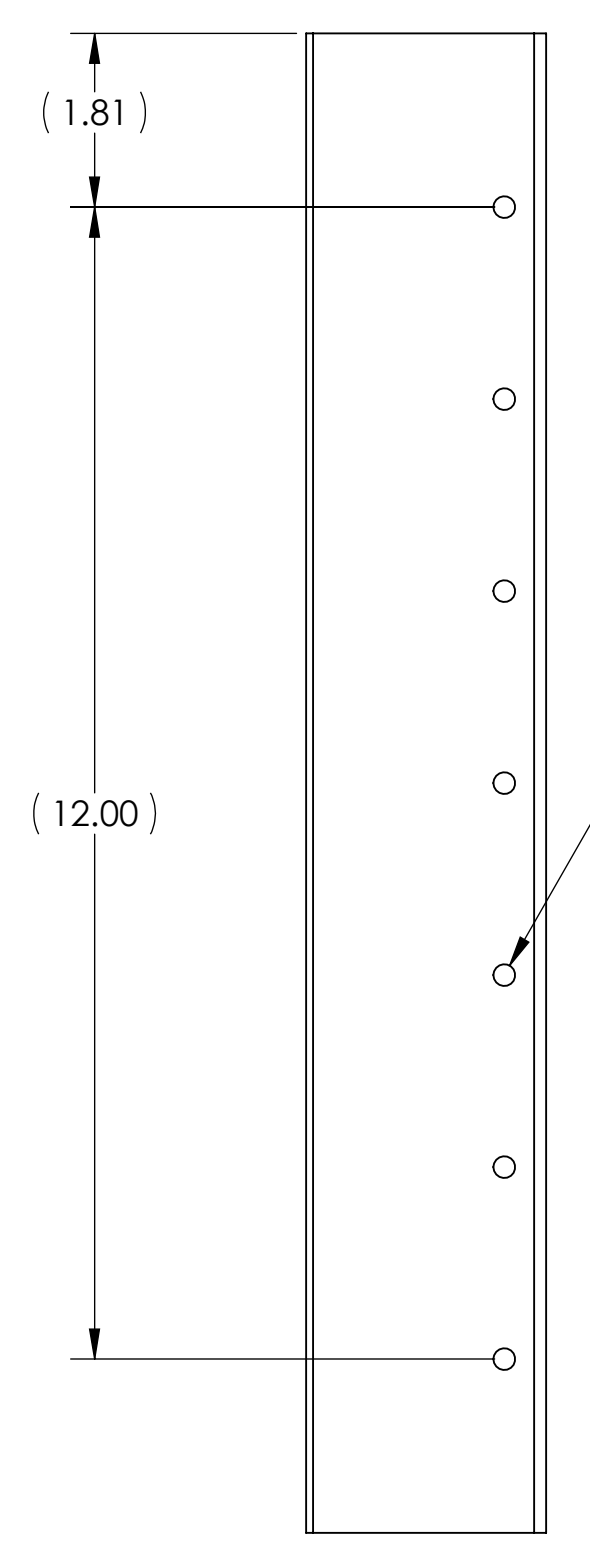
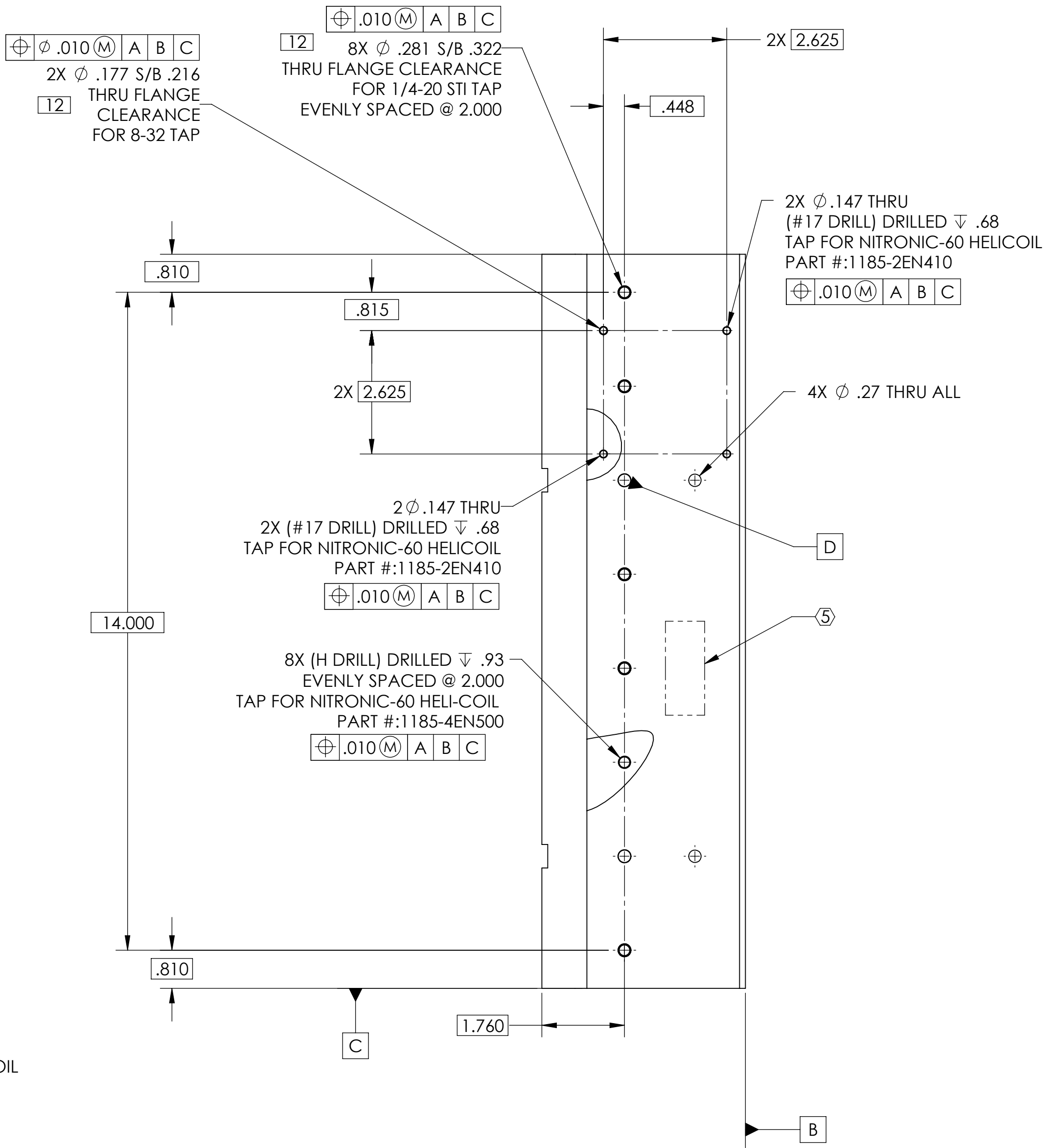
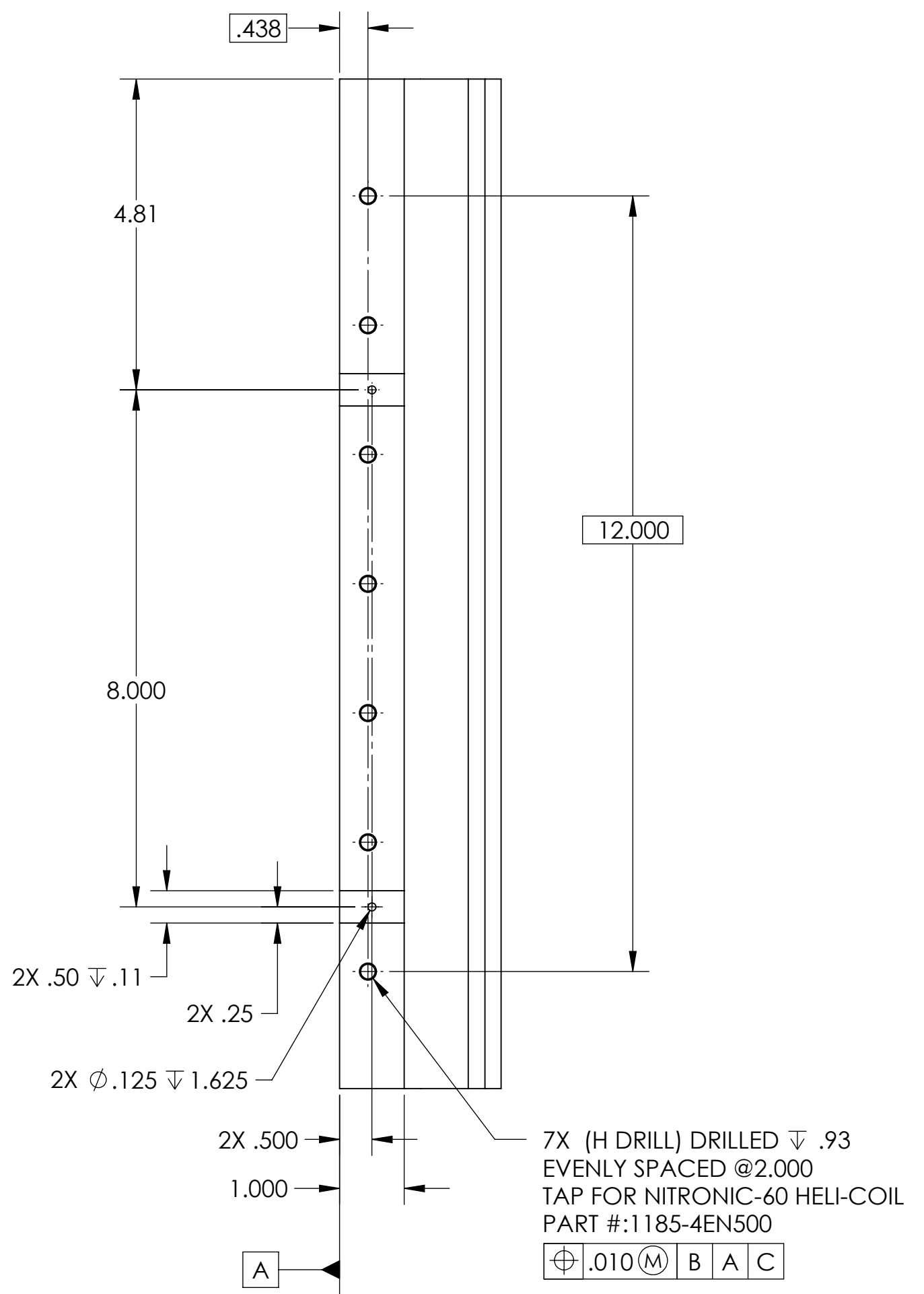
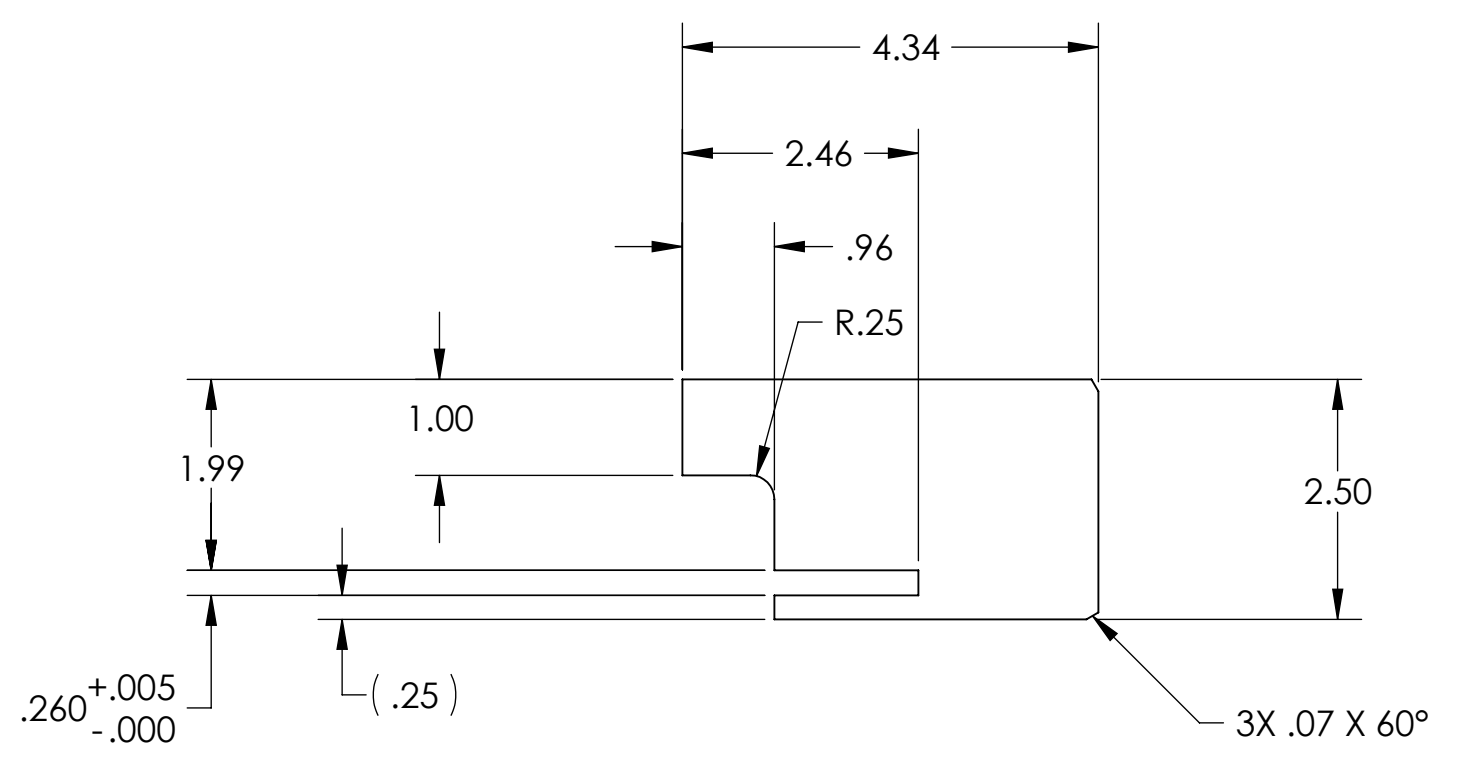


- NOTES CONTINUED:**
- SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
 - APPROXIMATE WEIGHT = 13.384 LB.
 - MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
 - ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - ALL HELI-COIL INSERTS TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
 - ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
 - 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.

[12] CLEARANCE HOLES ARE THRU NEARSIDE (.25) FLANGE ONLY

CONFIG.	DDESCRIPTION
-01	X-ARM, BSC3
-02	Y-ARM, BSC1

REV.	DATE	DCN #	DRAWING TREE #
v1	05-JUN-2012	E1101043-v1	E1101044-v1
-	-	-	-
-	-	-	-



-01

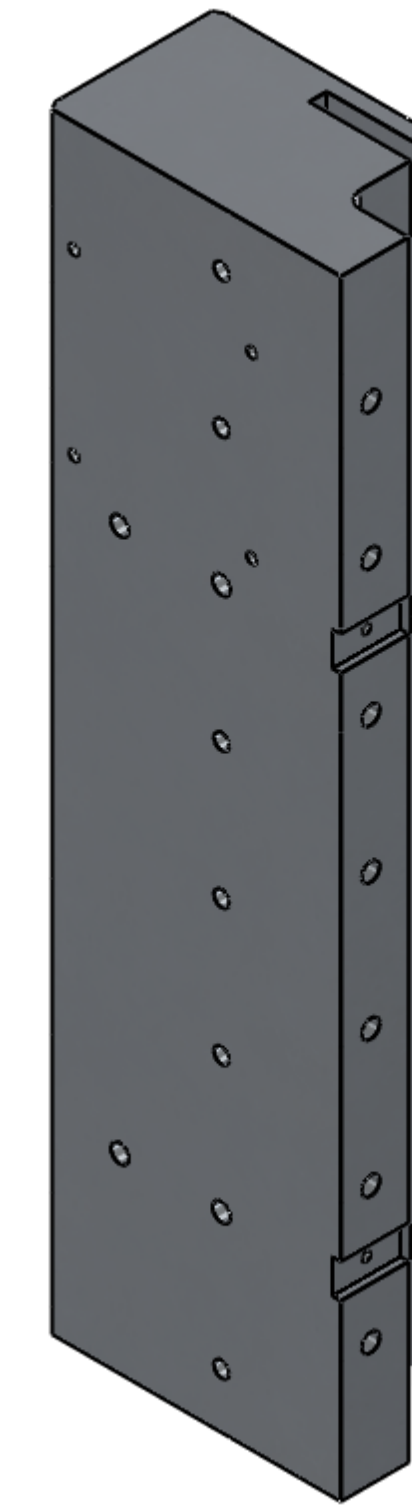
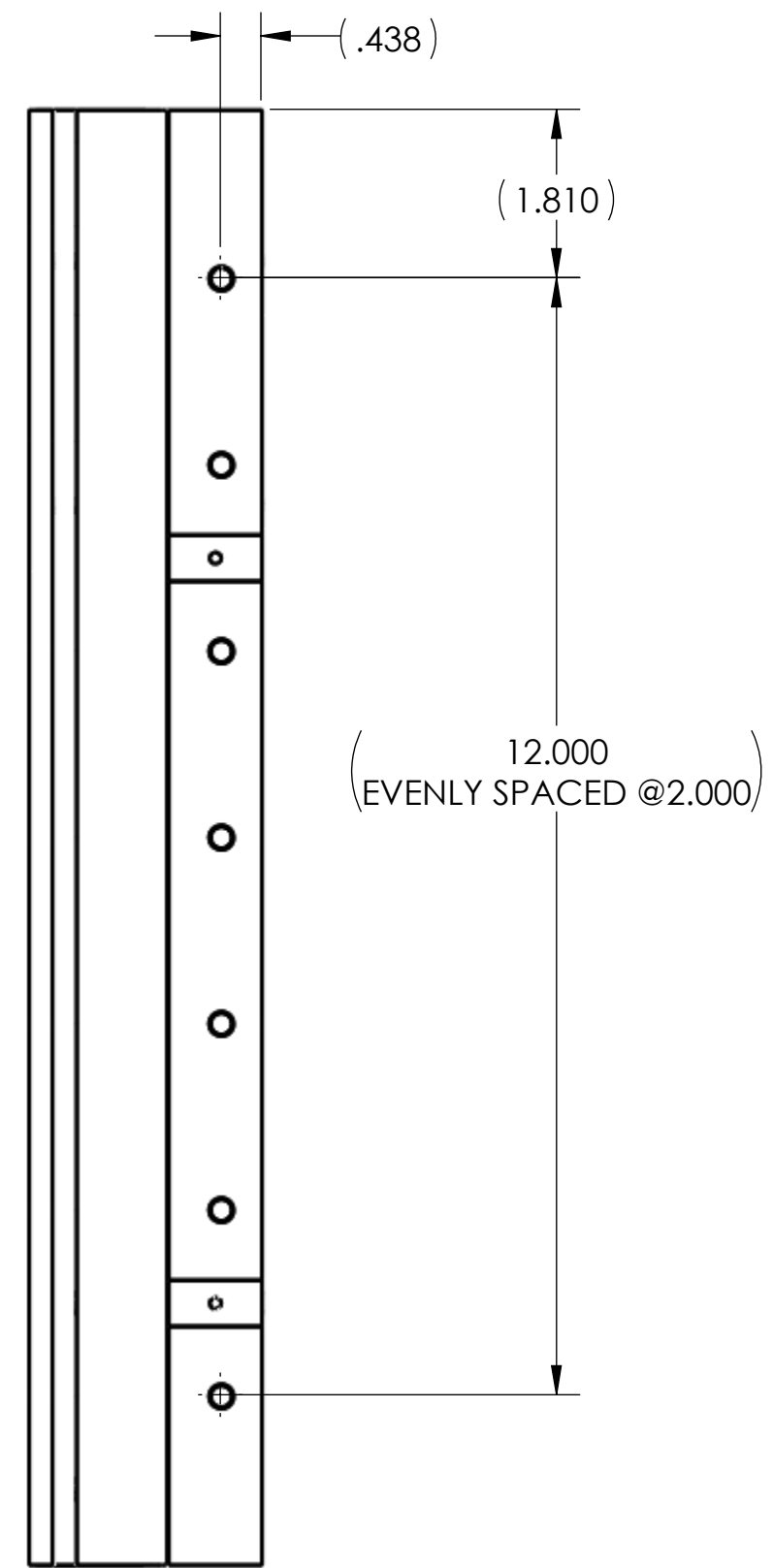
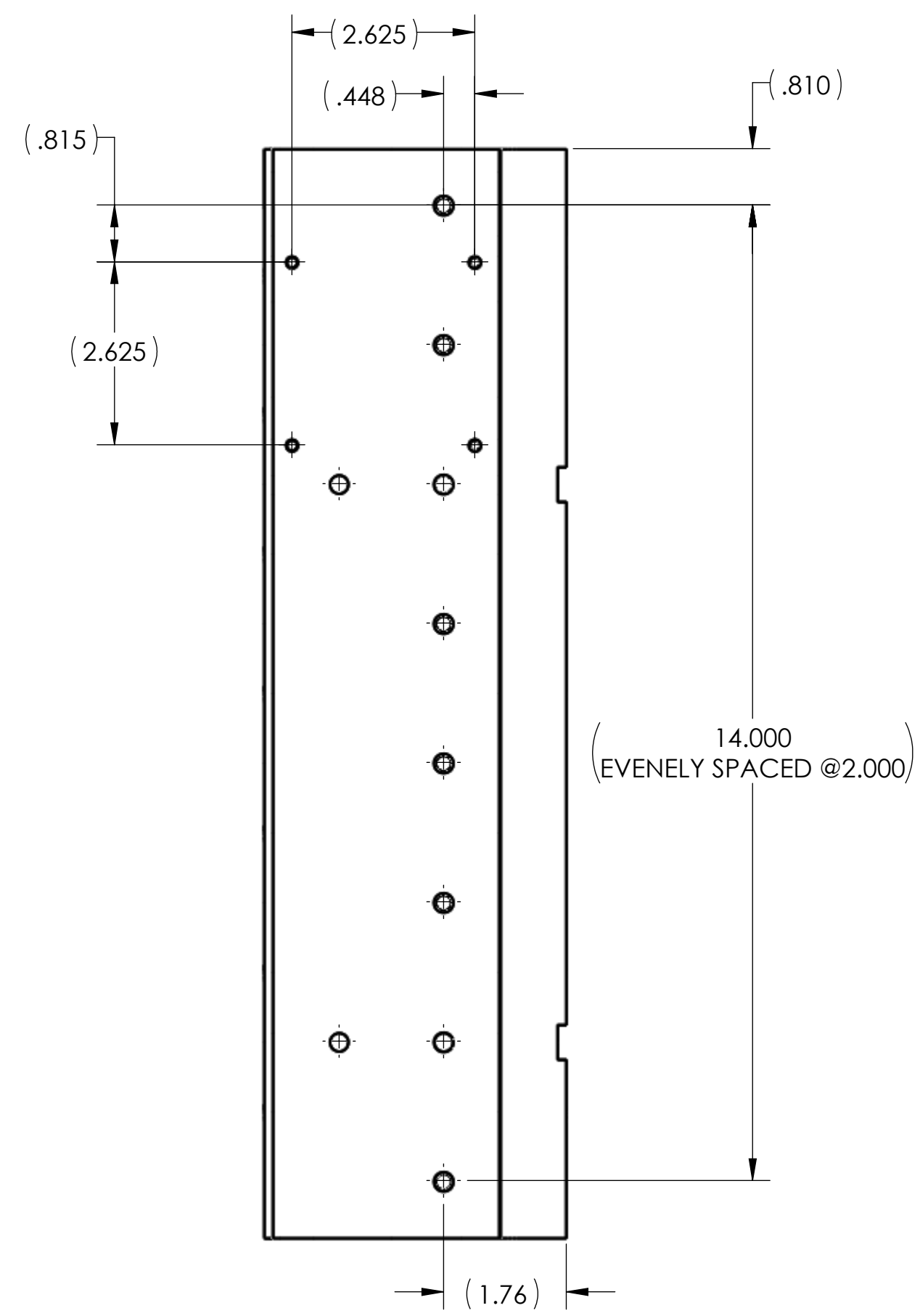
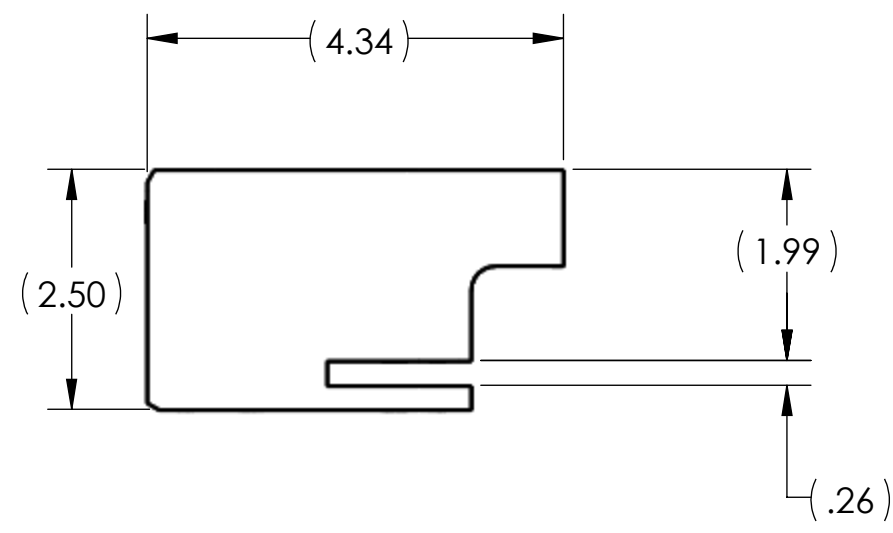
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		
1. INTERPRET DRAWING PER ASME Y14.5-1994.		
2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.		
3. DO NOT SCALE FROM DRAWING.		
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		
DIMENSIONS ARE IN INCHES	TOLERANCES: .XX ±.01 .XXX ±.005	ANGULAR ± 1.0°
MATERIAL	FINISH	NEXT ASSY
6061-T6 ALLOY	63 μinch	D1102078

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	SYSTEM	SUB-SYSTEM	PART NAME	
	ADVANCED LIGO	AOS	H1-L1 STEER M1 BRACKET	
DESIGNER	M. JACOBSON	13 JUN 2011	SIZE	DWG. NO.
DRAFTER	A. COLE	12-OCT-2011	D	D1101291
CHECKER	J. LEWIS	01-MAR-12	SCALE:	1:2
APPROVAL	A. HEPTONSTALL	05-MAR-12	PROJECTION:	

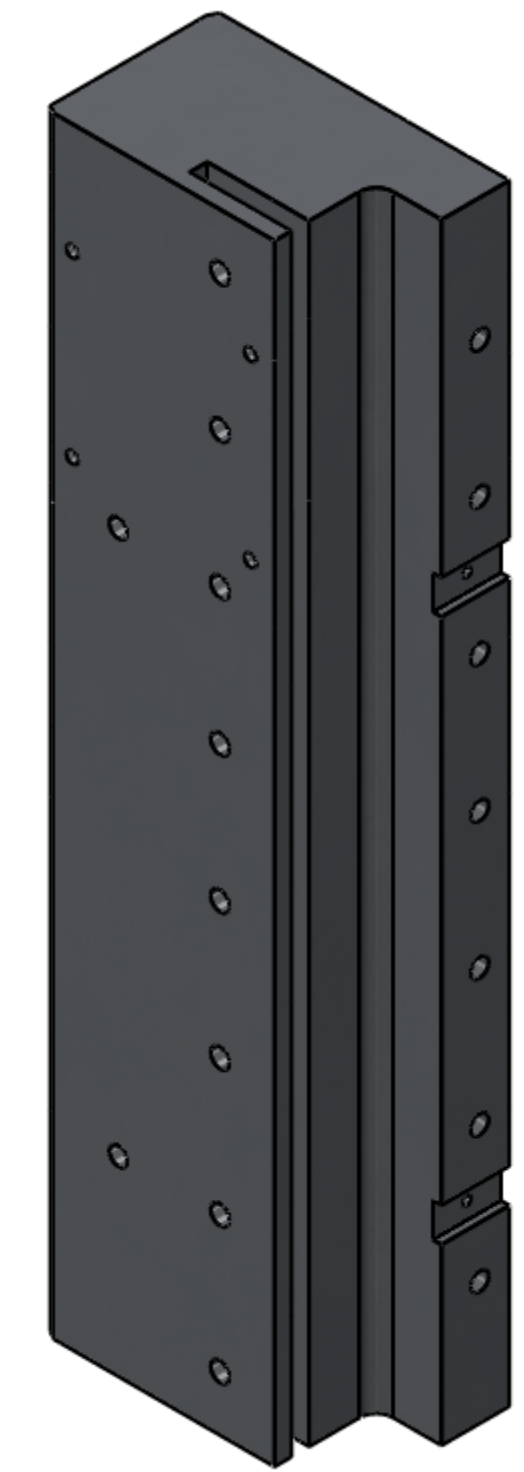
REVISION	DATE	BY	APP'D	DESCRIPTION
v1	05-JUN-2012			
-	-	-	-	-
-	-	-	-	-

SHEET 1 OF 2

D110291-H1-L1-STEER-M1-BRACKET-PART-PDM-REV-X-040-DRAWING-PDM-REV-X-020



-01



-02

**-02
MIRRORED PART
SEE SH11 FOR DETAILS ALL DIMENSIONS
ARE FOR REFERENCE ONLY**

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE DWG. NO.	REV.
D D1101291-02	v1
SCALE: 1:2	PROJECTION: SHEET 2 OF 2

D:\10\291_L11-L1 STEER.M1 BRACKET.PART.PDM.REV.X-003.DRAWING.PDM.REV.X-020