

⑤ 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

6. APPROXIMATE WEIGHT = 24.23 LBS.

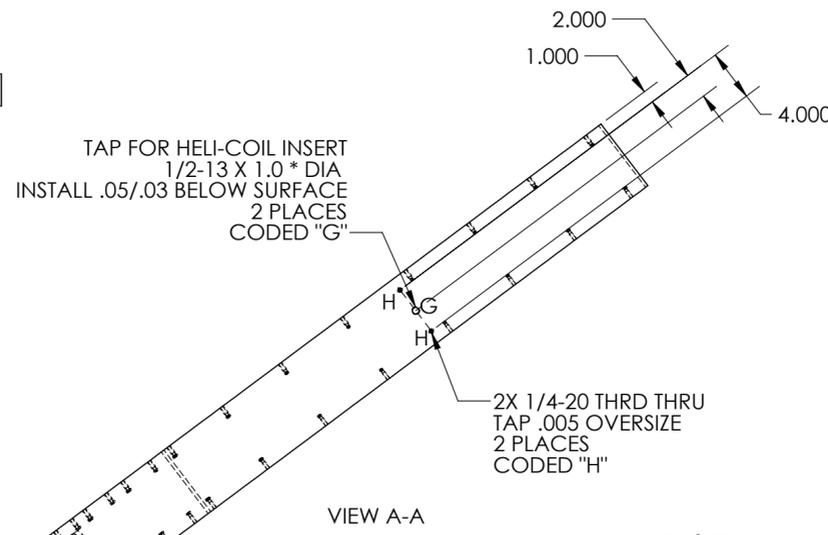
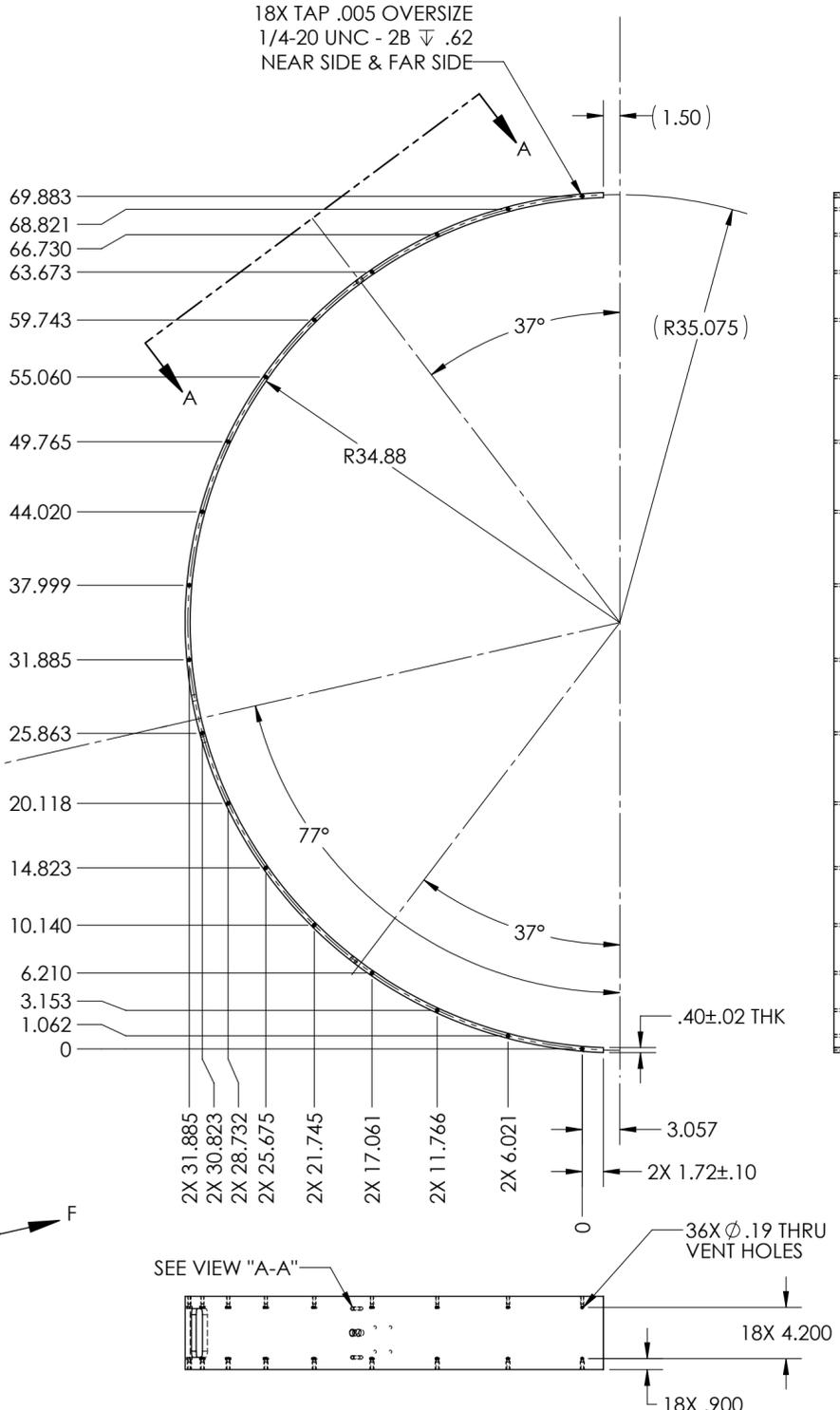
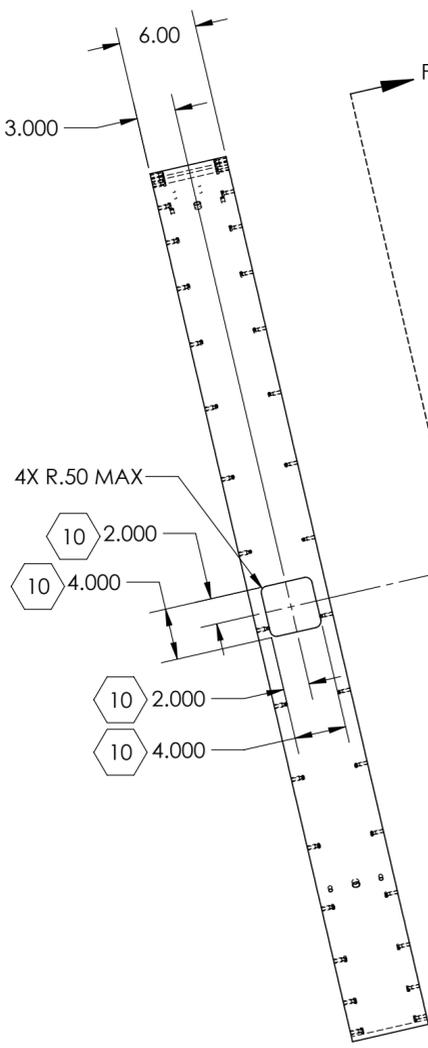
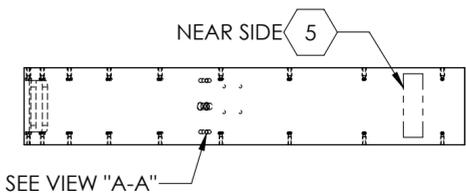
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364.

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

9. ALL 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.

⑩ DIMENSIONS APPLY AFTER ROLLING.

REV.	DATE	DCN #	DRAWING TREE #
V1	26 JUN 2012	E1200700	
V2	13 JUL 2012	E1200700	
V3	20 AUG 2012	E1200700	
V4	03 SEP 2012	E1200700	



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	SUPPLIER
3	2	1185-8EN500	INSERT, HELI-COIL, 1/2-13 X .50LG NITRONIC 60	HELI-COIL
2	1	D1102354	PCAL SUSPENSION RING RECEIVE SIDE	
1	36	1185-4EN500	INSERT, HELI-COIL, 1/4-20 X .50LG NITRONIC 60	HELI-COIL

BOM Table

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .05
 .XXX ± .010

ANGULAR ± 0.5°

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL: 6061-T6 Al
 FINISH: 63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
 SUB-SYSTEM: AOS

NEXT ASSY: D1200174

PART NAME: PCAL SUSPENSION RING RECEIVE SIDE

DESIGNER: S. SHANKLE, 26 JUN 2012
 DRAFTER: S. SHANKLE, 26 JUN 2012
 CHECKER: S. SHANKLE, 26 JUN 2012
 APPROVAL: S. SHANKLE, 26 JUN 2012

SIZE: c
 DWG. NO.: D1102354
 REV.: v4

SCALE: 1:10
 PROJECTION: [Symbol]
 SHEET 1 OF 1