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: DXXXXXXX-VY, TYPE-XX, S/N XXX

6. APPROXIMATE WEIGHT = 1.099 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.

Ⓥ ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC200, REV 4.

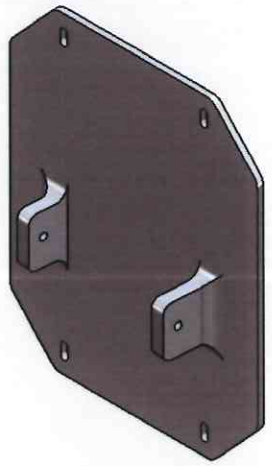
⑩ ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

11. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .015-.030.

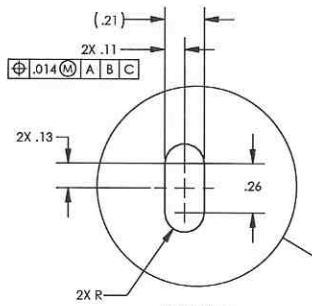
12. ALL MATERIAL TO BE VIRGIN MATERIAL. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY THE LIGO LABORATORY. REFER TO LIGO-E0900364

REV.	DATE	DCN #	DRAWING TREE #
v1	06-MAR-12	E1200002-v1	E1200003-v1
-	-	-	-
-		-	-

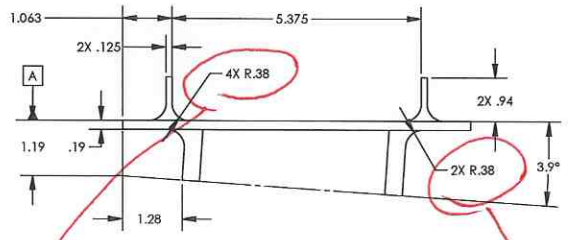
-01 CONFIGURATION

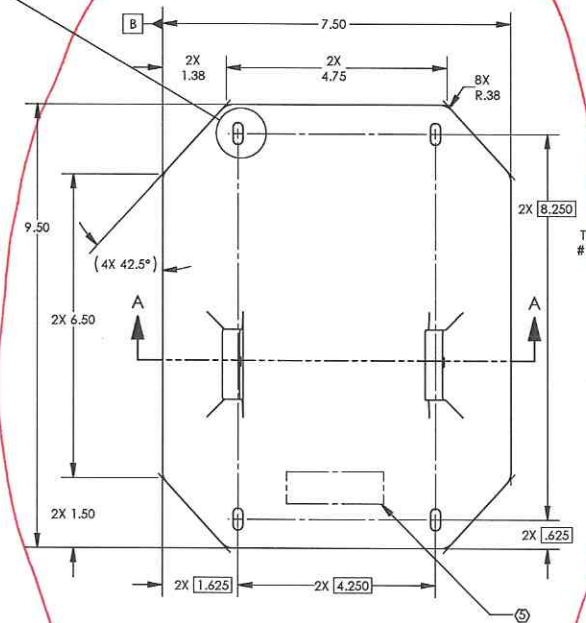


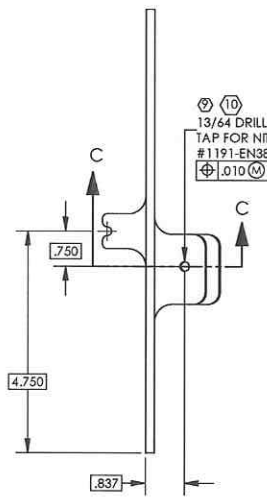
ISO FRONT - RIGHT

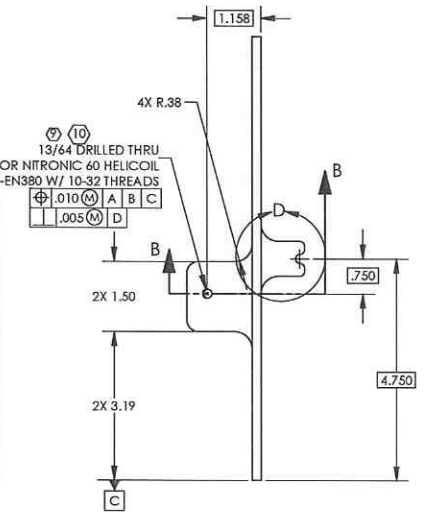


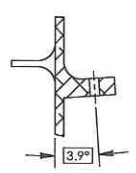
DETAIL E
SCALE 2 : 1
4 PLACES



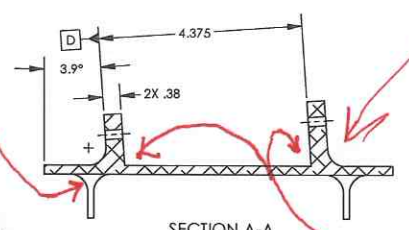




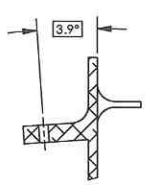




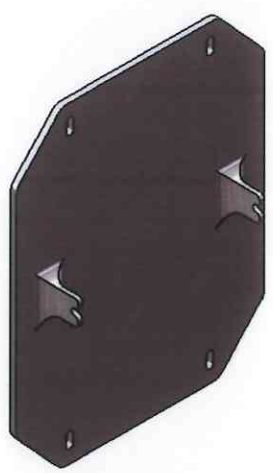
SECTION C-C



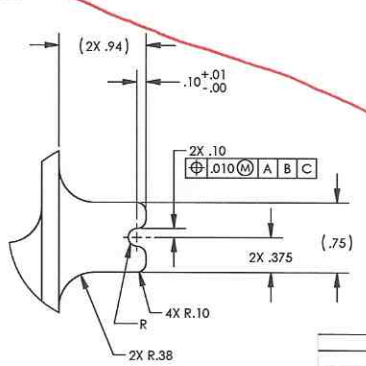
SECTION A-A



SECTION B-B

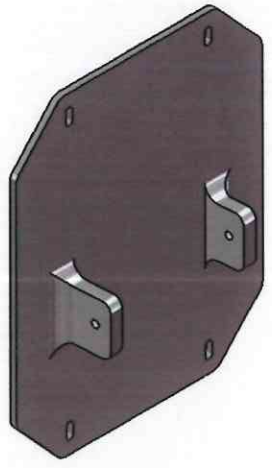


ISO REAR - RIGHT

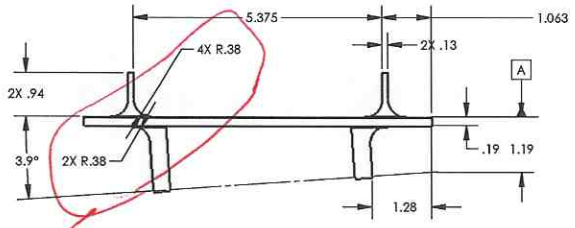


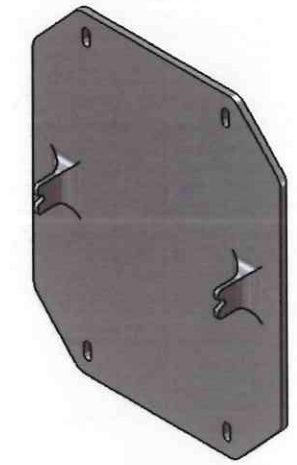
DETAIL D
SCALE 1 : 1
2 PL.

-02 CONFIGURATION

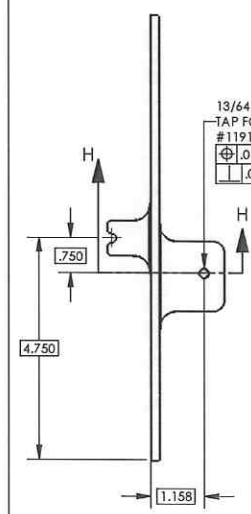


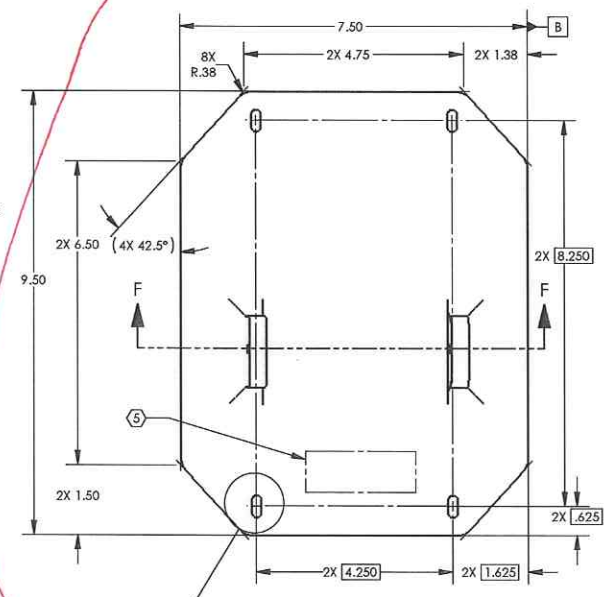
ISO FRONT - LEFT

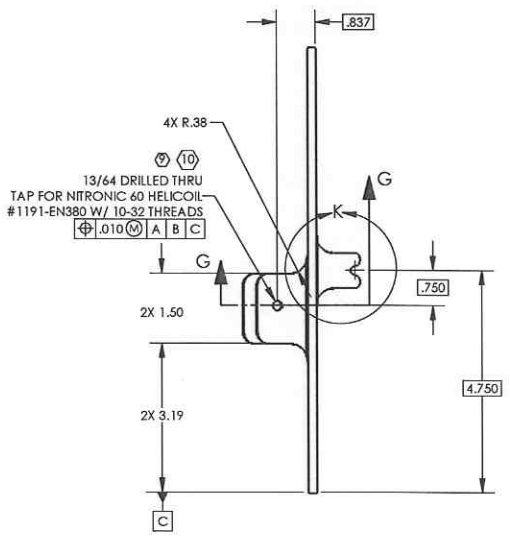




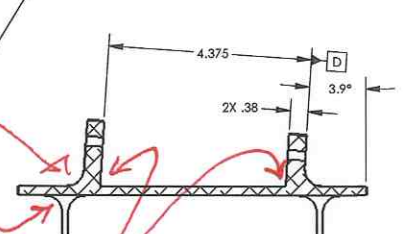
ISO REAR - LEFT



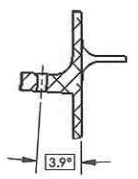




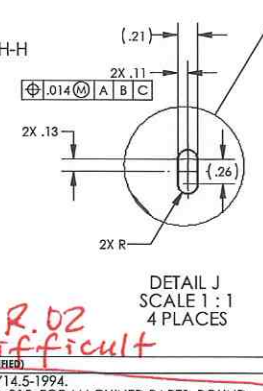
SECTION H-H



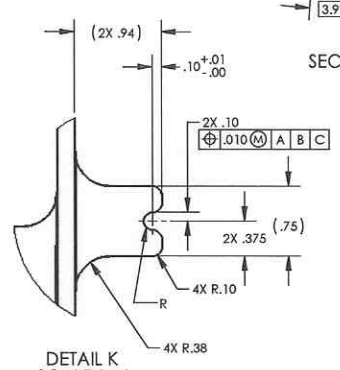
SECTION F-F



SECTION G-G



DETAIL J
SCALE 1 : 1
4 PLACES



DETAIL K
SCALE 1 : 1
2 PL.

Pls advise if R.02 is too difficult

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± 0.5°

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.

MATERIAL: 6061-T6 ALLOY
FINISH: 63 µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: AOS
NEXT ASSY: D1101851-1, D1101851-2

PART NAME: ELEVATION SUPPORT PLATE

DESIGNER	M. JACOBSON	20 DEC 2011
DRAFTER	E. SANCHEZ	27 JAN 2012
CHECKER	J. LEWIS	06-MAR-12
APPROVAL	A.HEPTONSTAL	05-MAR-12

SIZE: D | DWG. NO.: D1102413 | REV.: v1
SCALE: 1:2 | PROJECTION: | SHEET 1 OF 1

D1102413_ELEVATION SUPPORT PLATE, CO29F SW2, H1-L1, PART PDM REV: X-029, DRAWING PDM REV: X-011