

NOTES CONTINUED:

5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
 EXAMPLE (PART): 001-v1
 EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD

BAG AND TAG

- 6. APPROXIMATE WEIGHT = X.XXX 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.

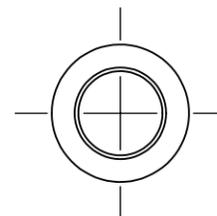
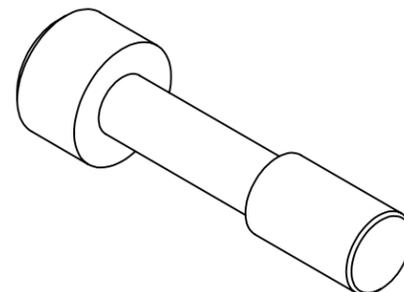
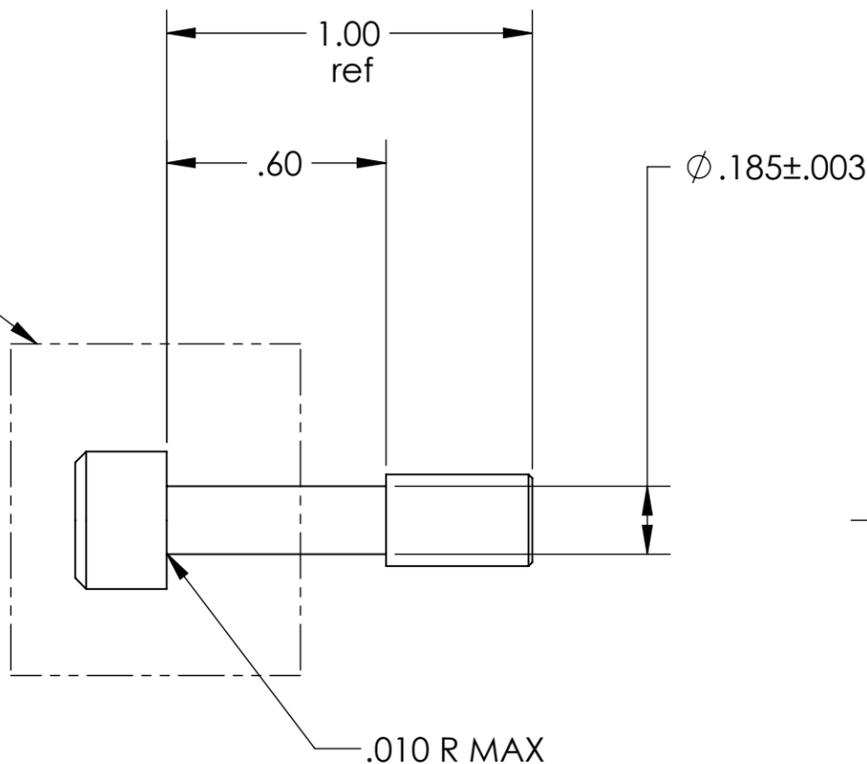
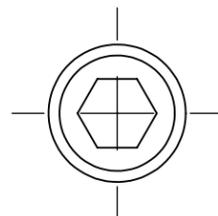
11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.

12. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE. THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

13. Basic Plating Specifications:

Silver plate finish
 Thickness: .0005" max
 Type II- Semi-Bright finish

Silver Plating Rack Zone



MAKE FROM MC MASTER CARR PART # 92196A542
 18-8 S STL. 1/4-20 X 1.00 LONG
 CAPTIVE SCREW FOR USE WITH #98408A122 RETAINER RING AND VENTED WASHER #96861A600

REV.	DATE	DCN #	DRAWING TREE #
V1	07-05-12	TO FOLLOW	-
-	-	-	-
-	-	-	-

D1200988 ALIGO CAPTIVE SCREW, TELE WIRE CLAMP, PART PDM REV: X-006, DRAWING PDM REV: X-001

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1.0°				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.		ALIGO CAPTIVE SCREW, TELE WIRE CLAMP	
MATERIAL AISI 304		FINISH see note silver plate		SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS	DESIGNER KEN MAILAND	DATE 07-05-12
NEXT ASSY D1200989				CHECKER KEN MAILAND	DATE 07-05-12	SIZE B	DWG. NO. D1200988
APPROVAL				SCALE 2:1	PROJECTION	REV. v1	
				SHEET 1 OF 1			