

8

7

6

5

4

3

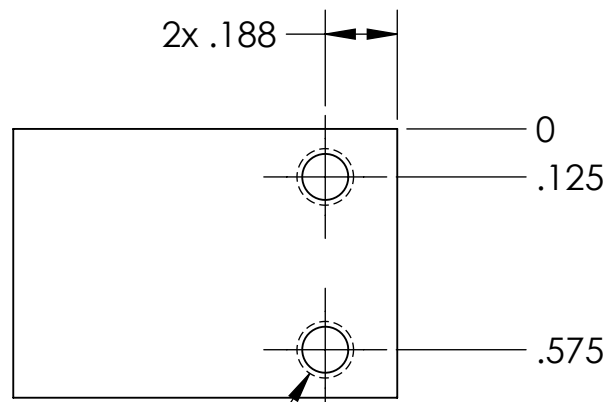
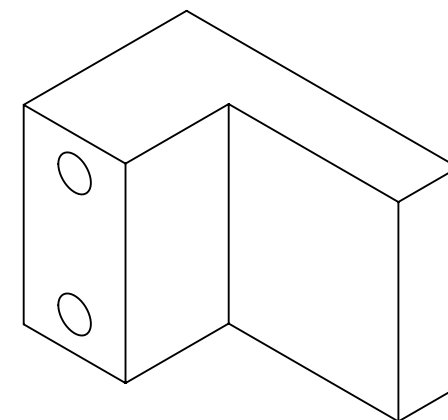
2

1

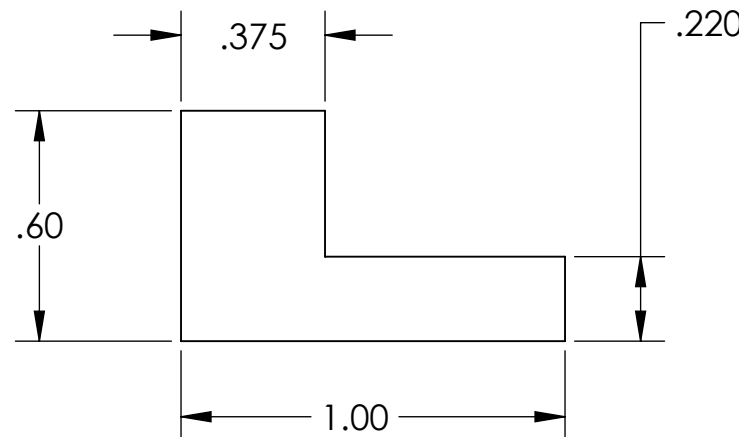
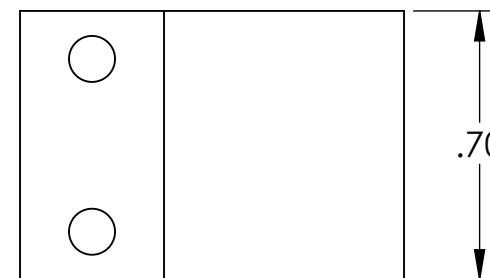
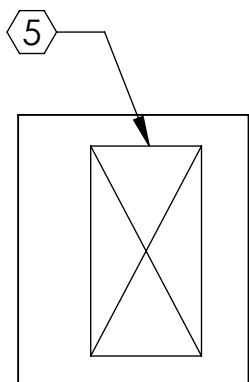
NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED.
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. APPROXIMATE WEIGHT = 0.01 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. MACHINE DRY (NO COOLANT)

REV.	DATE	DCN #	DRAWING TREE #
v1	04 DEC 2012	E1201080-x0	-
-	-	-	-
-	-	-	-



2x #4-40 STI ∇ .25
PILOT DRILL THRU



D1201521 PAD, CORNER, OMC TRANSPORT FIXTURE, PART PDM REV: X-003, DRAWING PDM REV: X-001

D

C

B

A

D

C

B

A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE INCHES
 TOLERANCES:
 .XX \pm .01
 .XXX \pm .005
 ANGULAR \pm 1°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES .005-.015
 3. DO NOT SCALE FROM DRAWING.
 4. SEE NOTE 11

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME
PAD, CORNER, OMC TRANSPORT FIXTURE

SYSTEM
ADVANCED LIGO

SUB-SYSTEM
ISC

DESIGNER J.LEWIS 03 DEC 2012
 DRAFTER J.LEWIS 04 DEC 2012

SIZE DWG. NO.
B D1201521

REV.
v1

MATERIAL
PEEK 450G

FINISH
63 μ inch

NEXT ASSY
D1201515

SCALE: 2:1 PROJECTION: SHEET 1 OF 1

8

7

6

5

4

3

2

1