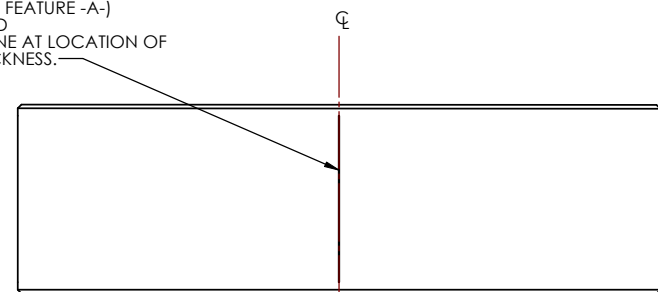
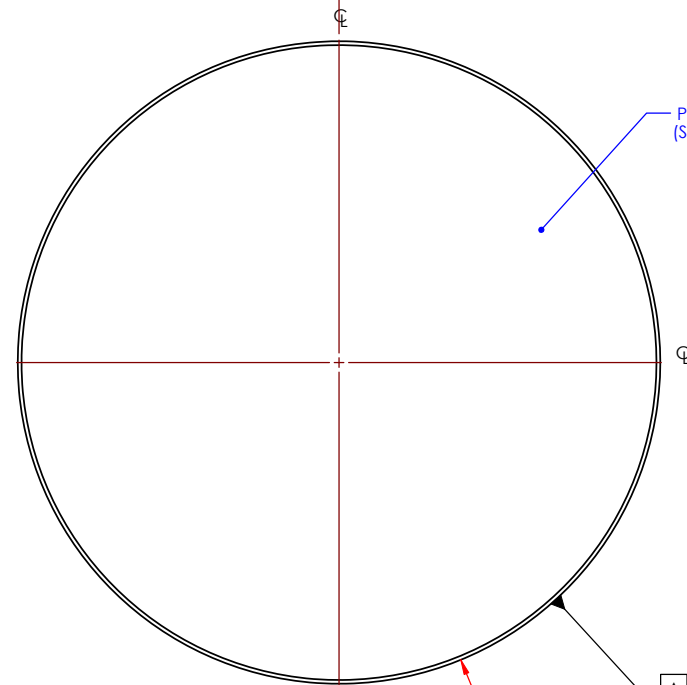


REV.	DATE	DCN #	DRAWING TREE #
v1	4/23/10	E1000139	
v2	28 MAY 2010	E1000188	
v3	26 JAN 2015	E1500025	

ETCH OR GRIND REGISTRATION MARKS
 0.25mm ±0.05mm WIDE x
 88mm ±3mm LONG MINIMUM LEGIBLE
 DEPTH LINE ALONG ϕ , CENTERED
 BETWEEN SURFACES 'S1' AND 'S2', PARALLEL
 TO THE CYLINDRICAL AXIS
 (DEFINED BY DATUM FEATURE -A-)
 WITHIN ±0.1mm AND
 90° FROM SCRIBE LINE AT LOCATION OF
 MINIMUM PART THICKNESS.



TOP VIEW



$\phi 340.00 \pm 0.25$
 0.1
 0.18 B

S3 BARREL SIDE AND BEVEL POLISH
 (SEE NOTE 3)

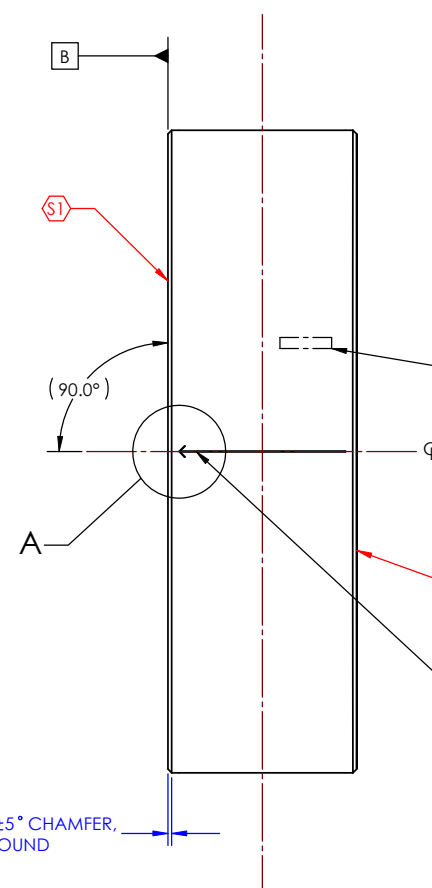
.04°^{+0.04°}
 -.03°
 WEDGE ANGLE

100.0 ± 0.5

BOTTOM VIEW

ETCH OR GRIND REGISTRATION MARKS
 0.25mm ±0.05mm WIDE x
 88mm ±3mm LONG MINIMUM LEGIBLE
 DEPTH LINE ALONG ϕ , CENTERED
 BETWEEN SURFACES 'S1' AND 'S2', PARALLEL
 TO THE CYLINDRICAL AXIS
 (DEFINED BY DATUM FEATURE -A-)
 WITHIN ±0.1mm AND
 90° FROM SCRIBE LINE AT LOCATION OF
 MINIMUM PART THICKNESS.

ETCH OR GRIND REGISTRATION MARKS
 0.25mm ±0.05mm WIDE x
 88mm ±3mm LONG MINIMUM LEGIBLE
 DEPTH LINE ALONG ϕ , CENTERED
 BETWEEN SURFACES 'S1' AND 'S2', PARALLEL
 TO THE CYLINDRICAL AXIS
 (DEFINED BY DATUM FEATURE -A-)
 WITHIN ±0.1mm AND
 180° FROM SCRIBE LINE AT LOCATION OF
 MINIMUM PART THICKNESS.

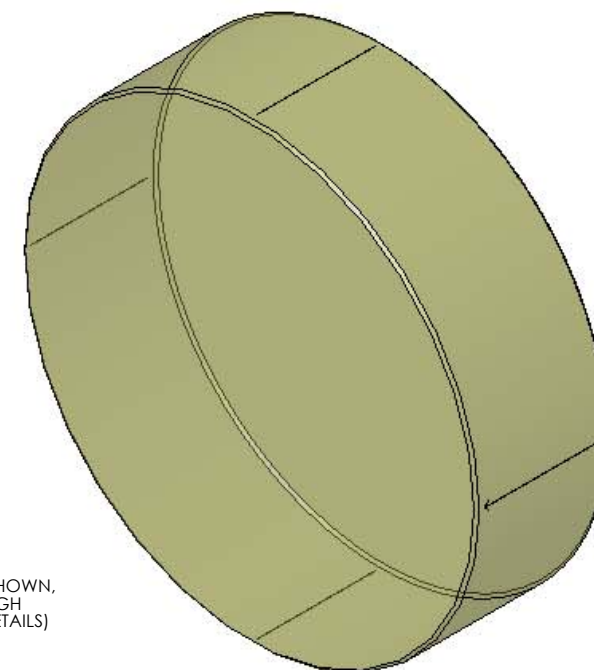


DETAIL A
 SCALE 1 : 1

ETCH OR GRIND SERIAL
 NUMBER, APPROX. WHERE SHOWN,
 LETTERING APPROX. 4mm HIGH
 (SEE NOTE 5 FOR FURTHER DETAILS)

S2 POLISH SURFACE 'S2'
 (SEE NOTE 4)

ETCH OR GRIND REGISTRATION MARKS
 0.25mm ±0.05mm WIDE x
 88mm ±3mm LONG MINIMUM LEGIBLE
 DEPTH LINE ALONG ϕ , CENTERED
 BETWEEN SURFACES 'S1' AND 'S2' AT
 LOCATION OF MINIMUM PART THICKNESS
 WITHIN ± 5° CLOCKING ANGLE
 (WITH RESPECT TO DATUM FEATURE -A-),
 AND PARALLEL TO THE CYLINDRICAL AXIS
 (DEFINED BY DATUM FEATURE -A-)
 WITHIN ±0.1mm, WITH ARROW POINTING
 TO SURFACE 'S1'.



"THIN COMPENSATION PLATE"
 TCP

MANUFACTURING NOTES:

- DO NOT SCALE FROM DRAWING.
- INTERPRET DRAWING AS PER ANSI Y14.5M 1994.
- BARREL SIDE AND BEVEL POLISH PER E1400394-v3.
- FINISH SURFACES 'S1' AND 'S2' AS PER E1400394-v3
- REFER TO E1000188 OR MORE INFORMATION ON SERIAL NUMBER.
- APPLY COATING PER E0900074-v3
- APPLY BARREL GOLD COATING PER E0900112.
- APPLY ESD GOLD COATING PER E0900113.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME THIN COMPENSATION PLATE (TCP) SUBSTRATE			
DIMENSIONS ARE IN MILLIMETERS		SEE MANUFACTURING NOTES		SYSTEM	ADVANCED LIGO	SUB-SYSTEM	COC
TOLERANCES: .X ± .10 .XX ± .25		MATERIAL		DESIGNER	K. BUCKLAND	DATE	4/23/10
ANGULAR ± 0.1°		FINISH		DRAFTER	K. BUCKLAND	DATE	22 APR 2010
		NEXT ASSY		CHECKER	C. TORRIE	DATE	5/4/10
		REFER TO E080037		APPROVAL	G. BILLINGSLEY	DATE	1/15/15
		SEE NOTES		SCALE	1:2	PROJECTION	AS SHOWN
		D1000980		DWG. NO.		D1000979	
				REV.		v3	
				SHEET 1 OF 1			

D1000979.dwg COC TCP SUBSTRATE, PART PDM, REV. X.003, DRAWING PDM, REV. X.002