

D1001109 dLIGO ETM TELESCOPE BRIDGE SUPPORT TEE PLATE, PART PDM REV: X-032, DRAWING PDM REV: X-037

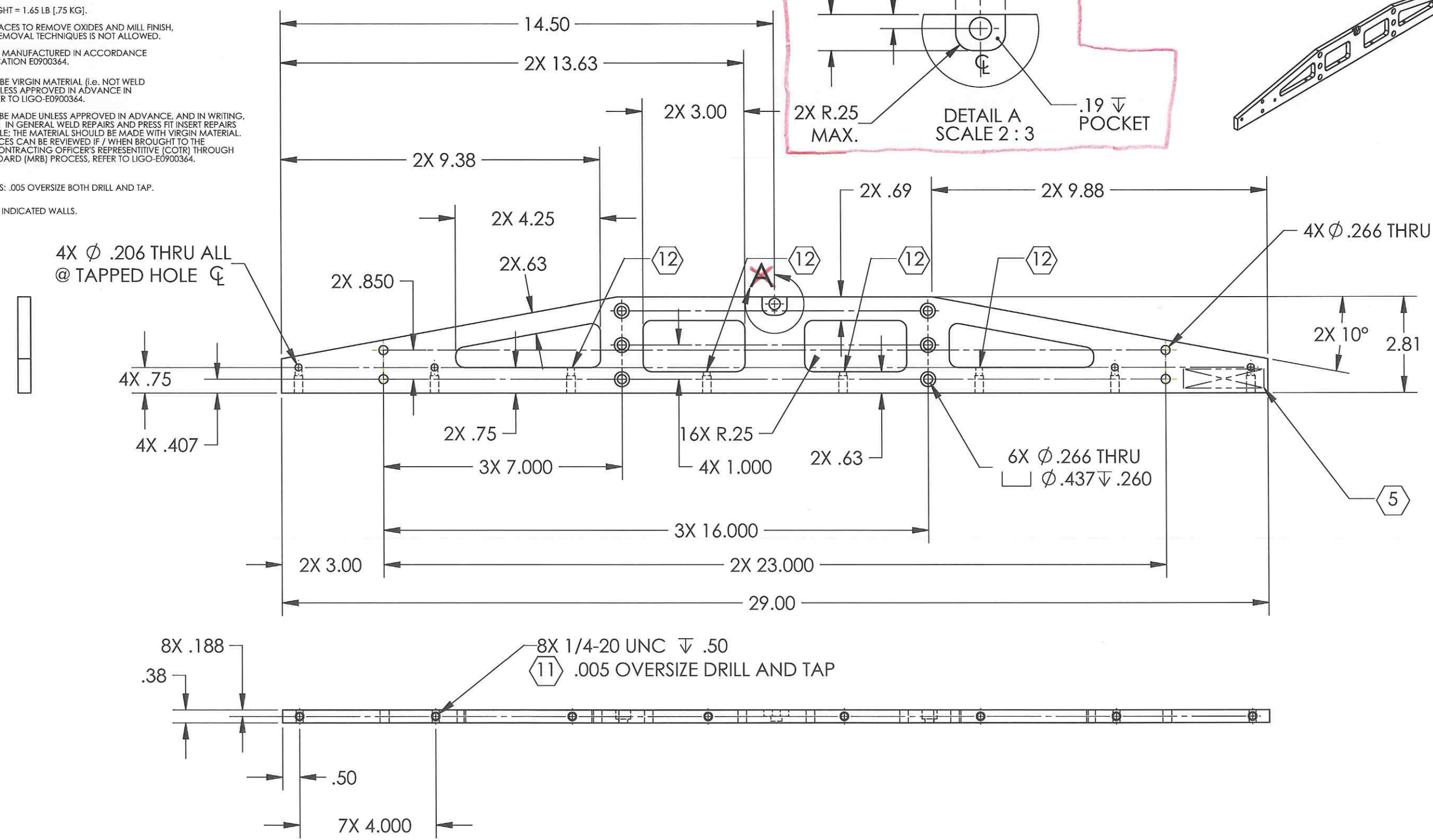
NOTES CONTINUED:

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 = 1.65 LB [.75 KG].
- 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 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.
- 10. 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.

- 11. ALL TAPPED HOLES: .005 OVERSIZE BOTH DRILL AND TAP.
- 12. BREAK DRILL THRU INDICATED WALLS.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 DEC 2010	E1000762-v1	-
v2	10 MAR 2011	E1100080-v1	-
v3	24 MAR 2012	E1200317-x0	-
V4 4-25-12			



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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, .005 - .015.
 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 Al
 FINISH: 63 μinch Ra

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: LIGO ETM TELESCOPE BRIDGE SUPPORT TEE PLATE, BACK	
SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	DESIGNER: K. MAILAND 11/01/2010	SIZE: B
NEXT ASSY: D1001160	DRAWER: M. MILLER 11/02/2010	CHECKER: SEE DCC	DWG. NO.: D1001109
	APPROVAL: SEE DCC	SCALE: 1:3	PROJECTION: 1st ANGLE
			SHEET 1 OF 1

V4