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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 = 35.96 LB [16.31 KG].

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

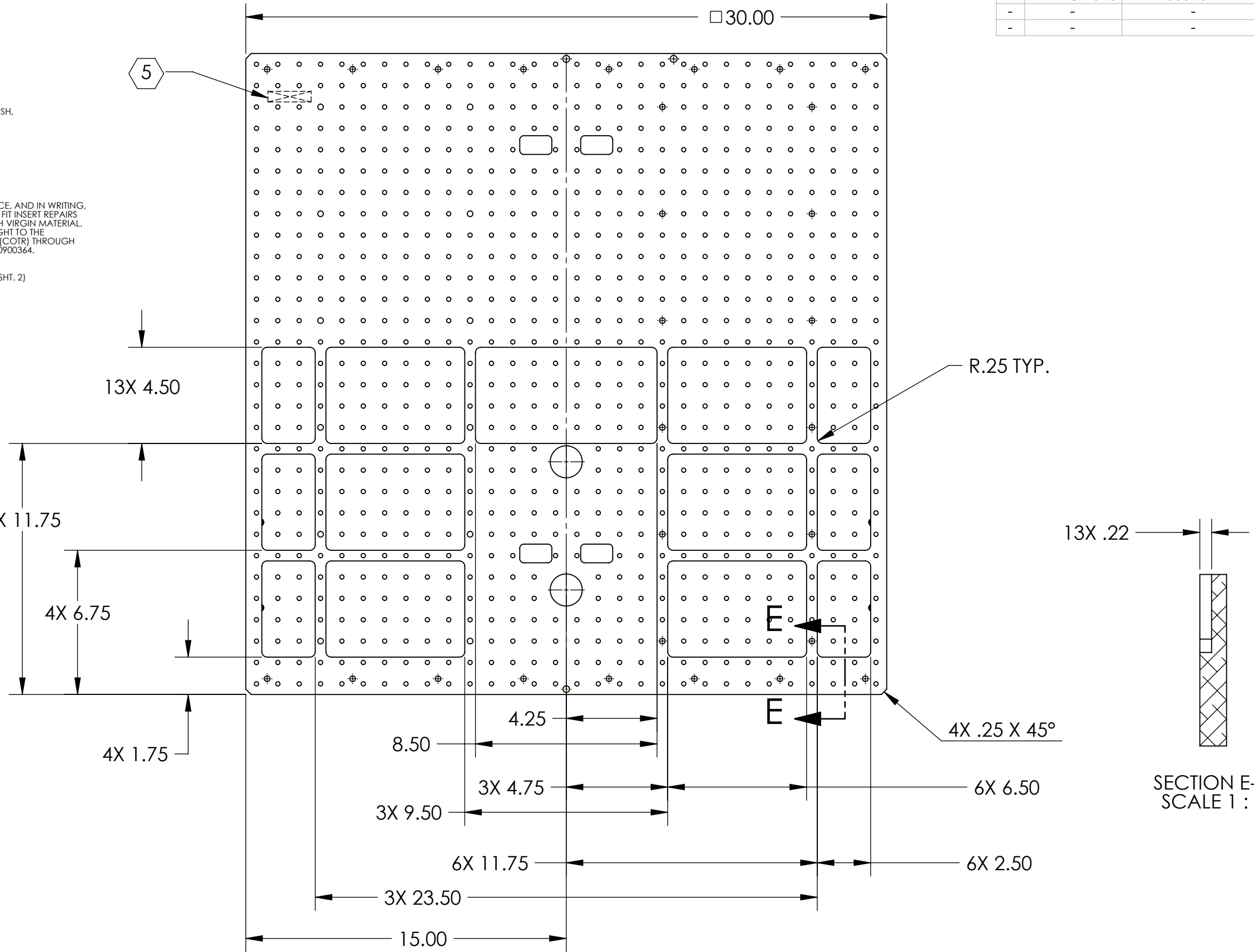
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

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. (SHT. 2)

REV.	DATE	DCN #	DRAWING TREE #
v1	22 DEC 2010	E1000762-v1	-
-	-	-	-
-	-	-	-



D1001129 aLIGO ETM OPTICAL TABLE, PART PDM REV: X-063, DRAWING PDM REV: X-069

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, 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.
MATERIAL 6061-T6 Al
FINISH 63 μinch Ra

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SYSTEM ADVANCED LIGO SUB-SYSTEM AOS
NEXT ASSY D1001160

PART NAME		DESIGNER		DATE		SIZE		DWG. NO.		REV.	
aLIGO ETM OPTICAL TABLE		K. MAILAND		10/09/2010		B		D1001129		v1	
DRAFTER		M. MILLER		11/09/2010		SCALE: 1:5		PROJECTION:		SHEET 1 OF 3	
CHECKER											
APPROVAL											

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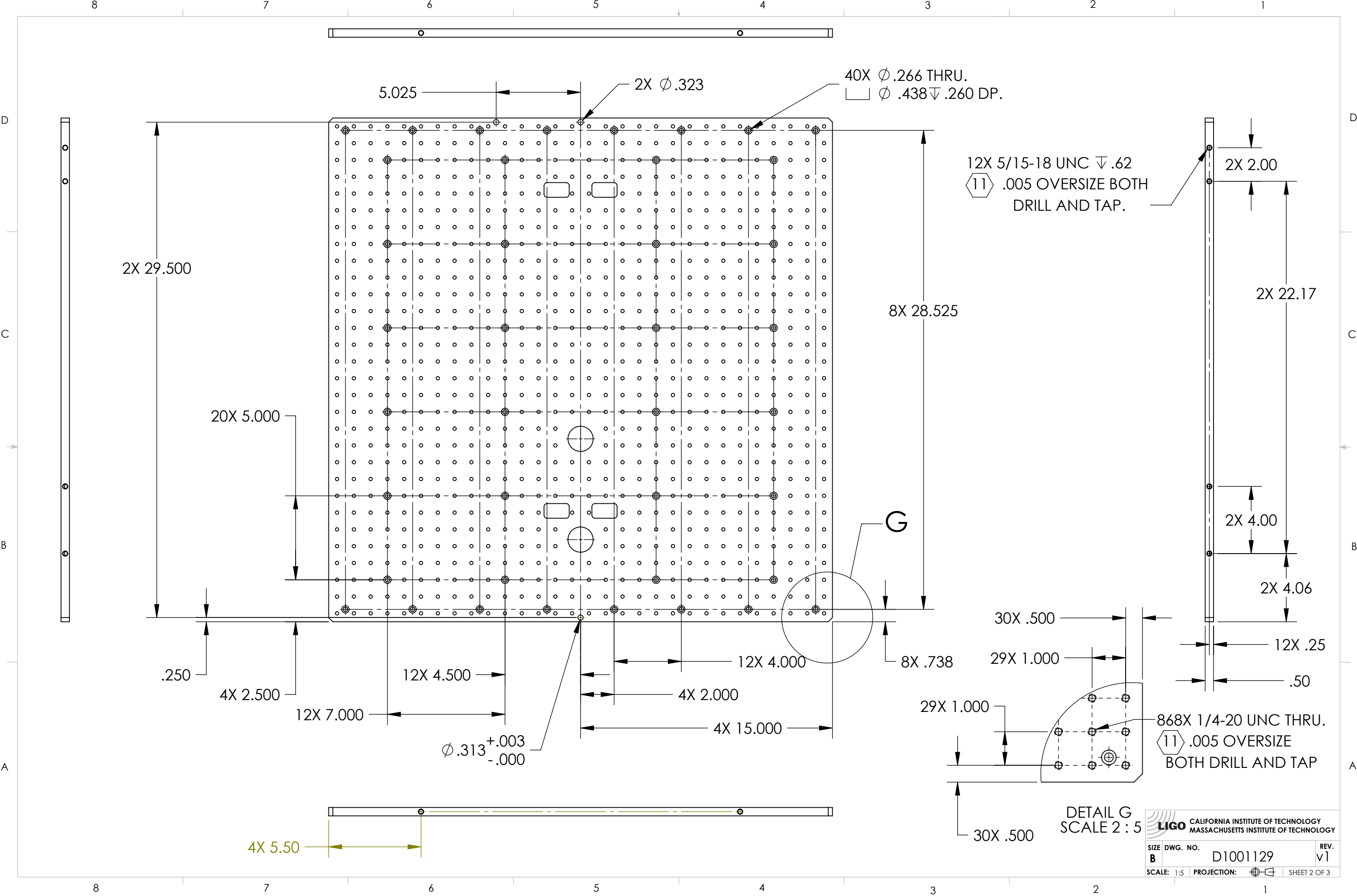
4

3

2

1

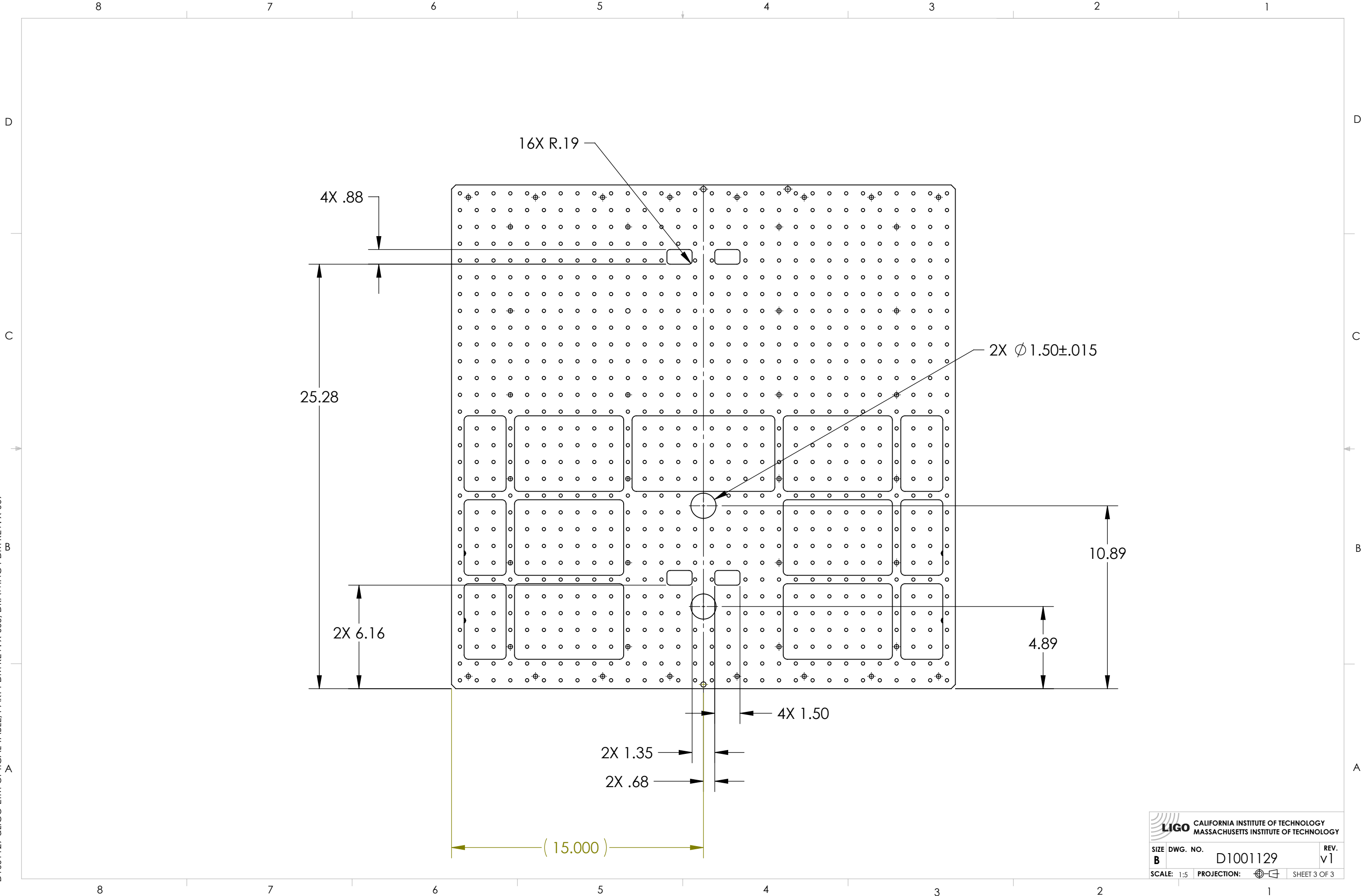
D1001129 dLIGO EIM OPTICAL TABLE, PART PDM REV: X-063, DRAWING PDM REV: X-069



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SIZE	DWG. NO.	REV.
B	D1001129	v1
SCALE: 1:5	PROJECTION:	SHEET 2 OF 3

D1001129 dLIGO EIM OPTICAL TABLE, PART PDM REV: X-063, DRAWING PDM REV: X-069



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SIZE	DWG. NO.	REV.
B	D1001129	v1
SCALE: 1:5	PROJECTION:	SHEET 3 OF 3