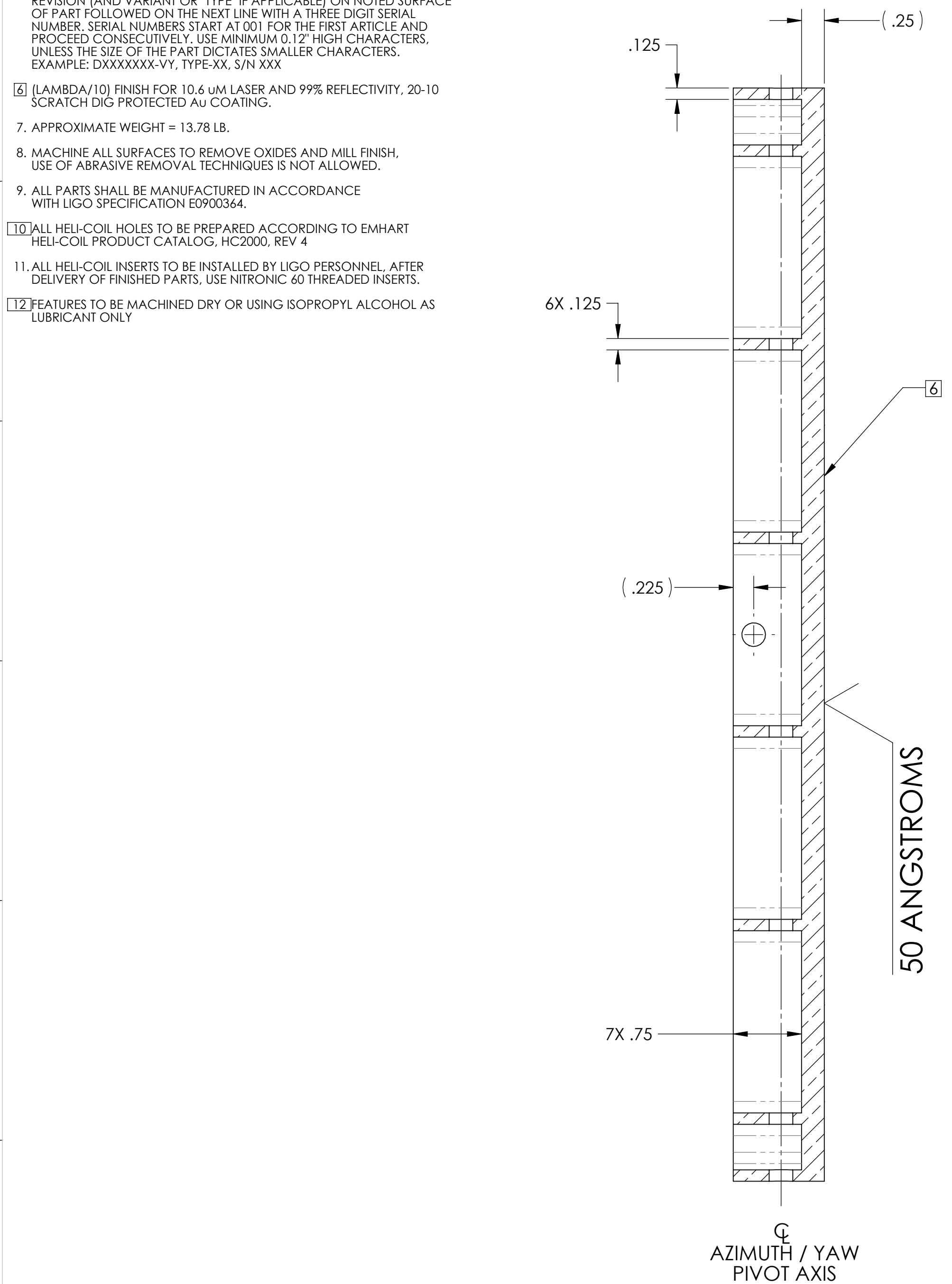
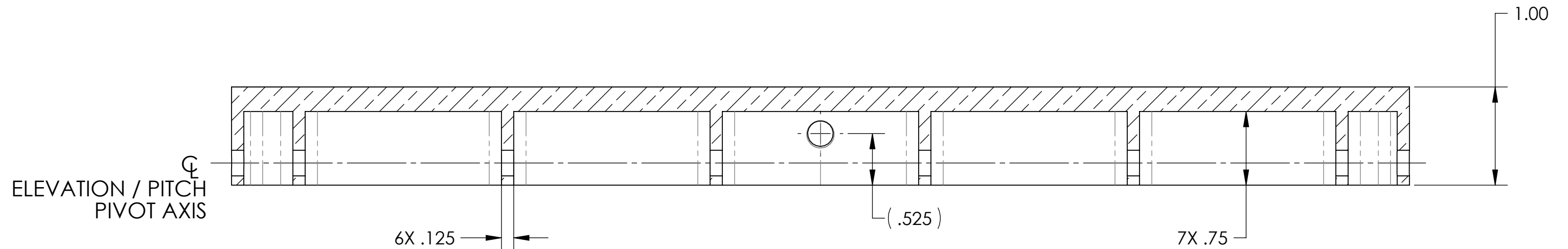
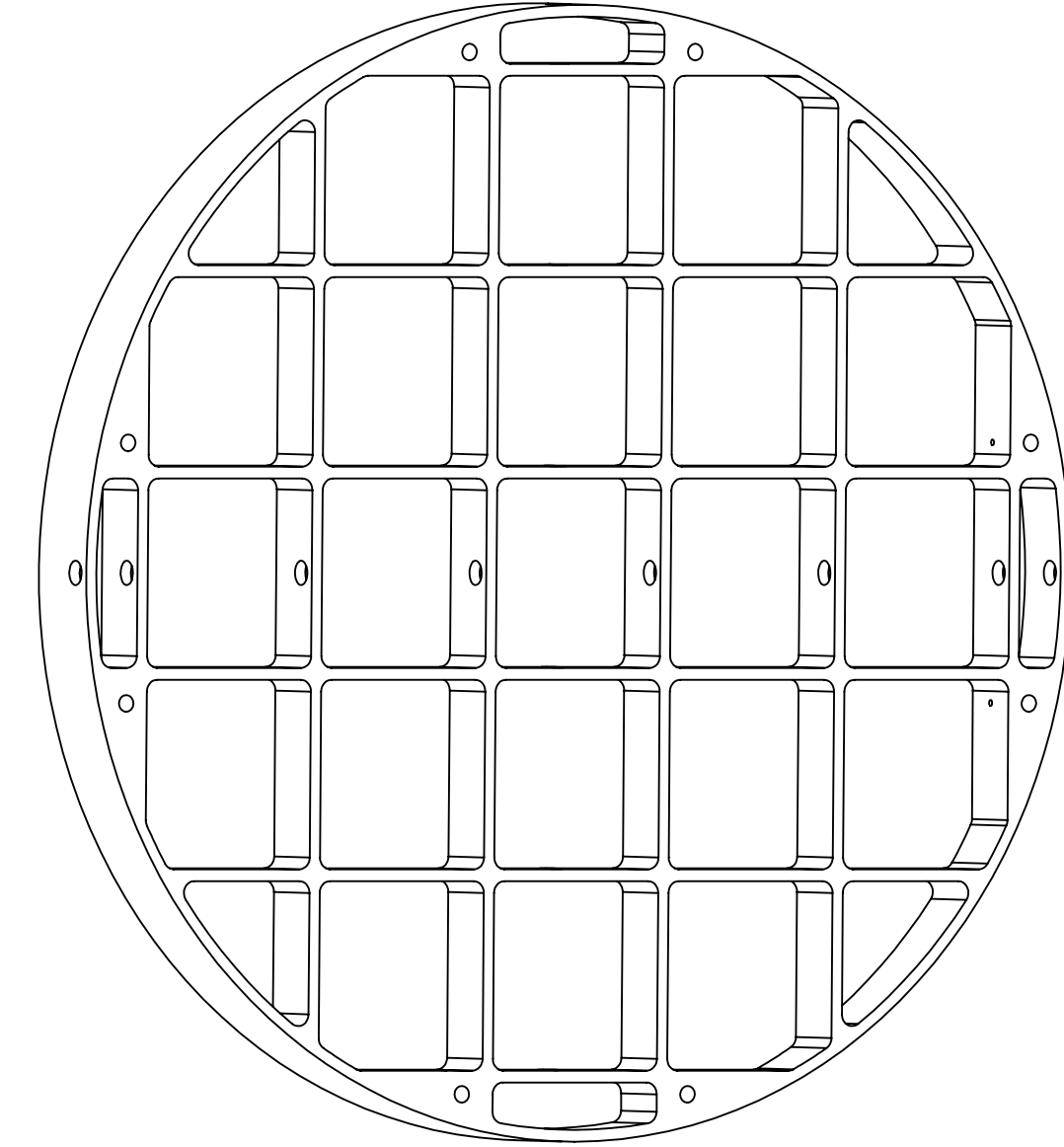
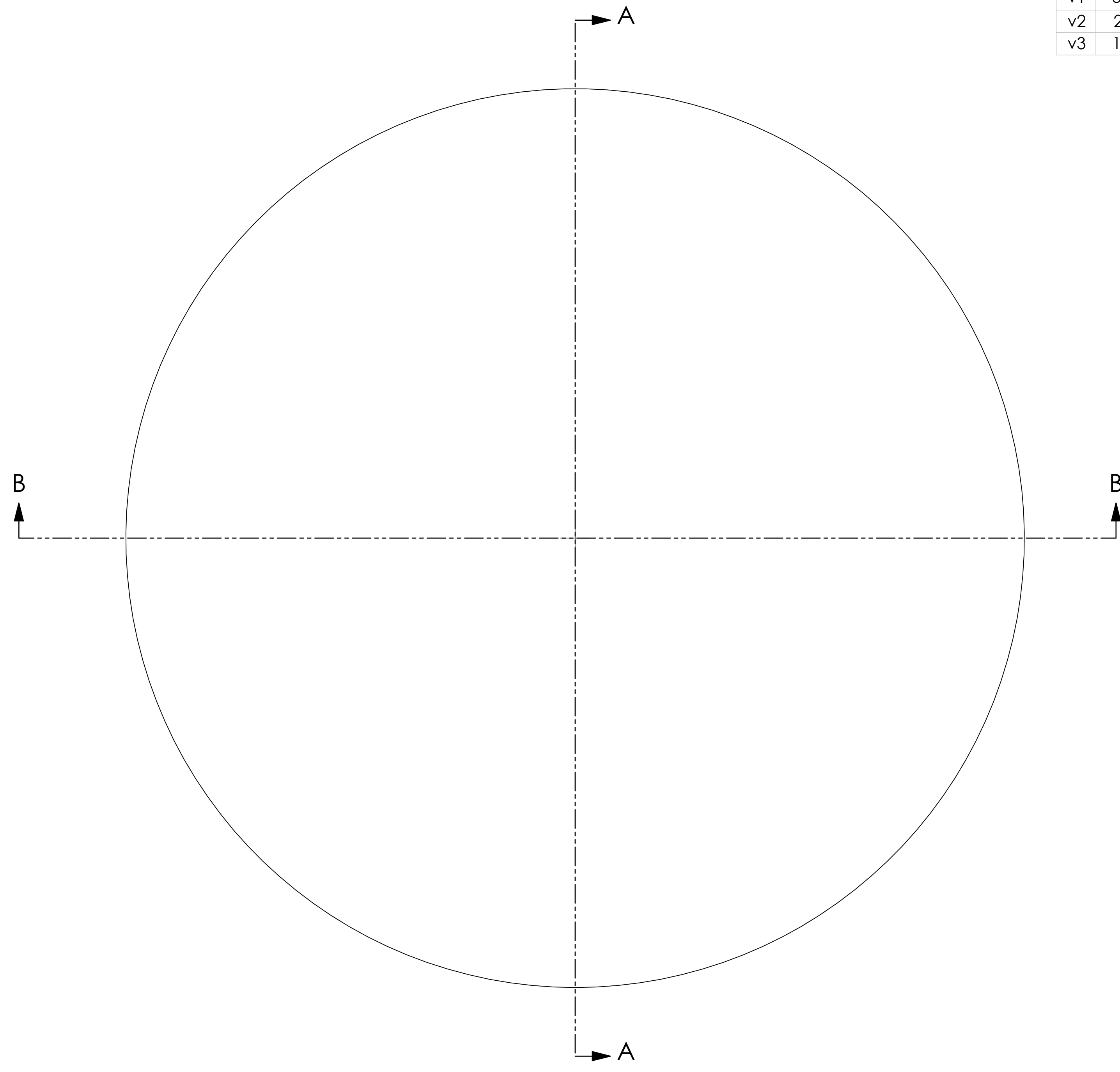


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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. (LAMBDA/10) FINISH FOR 10.6 μm LASER AND 99% REFLECTIVITY, 20-10 SCRATCH DIG PROTECTED Au COATING.
 - 7. APPROXIMATE WEIGHT = 13.78 LB.
 - 8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 - 9. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - 10. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
 - 11. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.
 - 12. FEATURES TO BE MACHINED DRY OR USING ISOPROPYL ALCOHOL AS LUBRICANT ONLY

REV.	DATE	DCN #	DRAWING TREE #
v1	30-AUG-2010	-	-
v2	22-DEC-2010	E1000883-v1	E1000884-v1
v3	17-AUG-2011	E1100771-v1	-



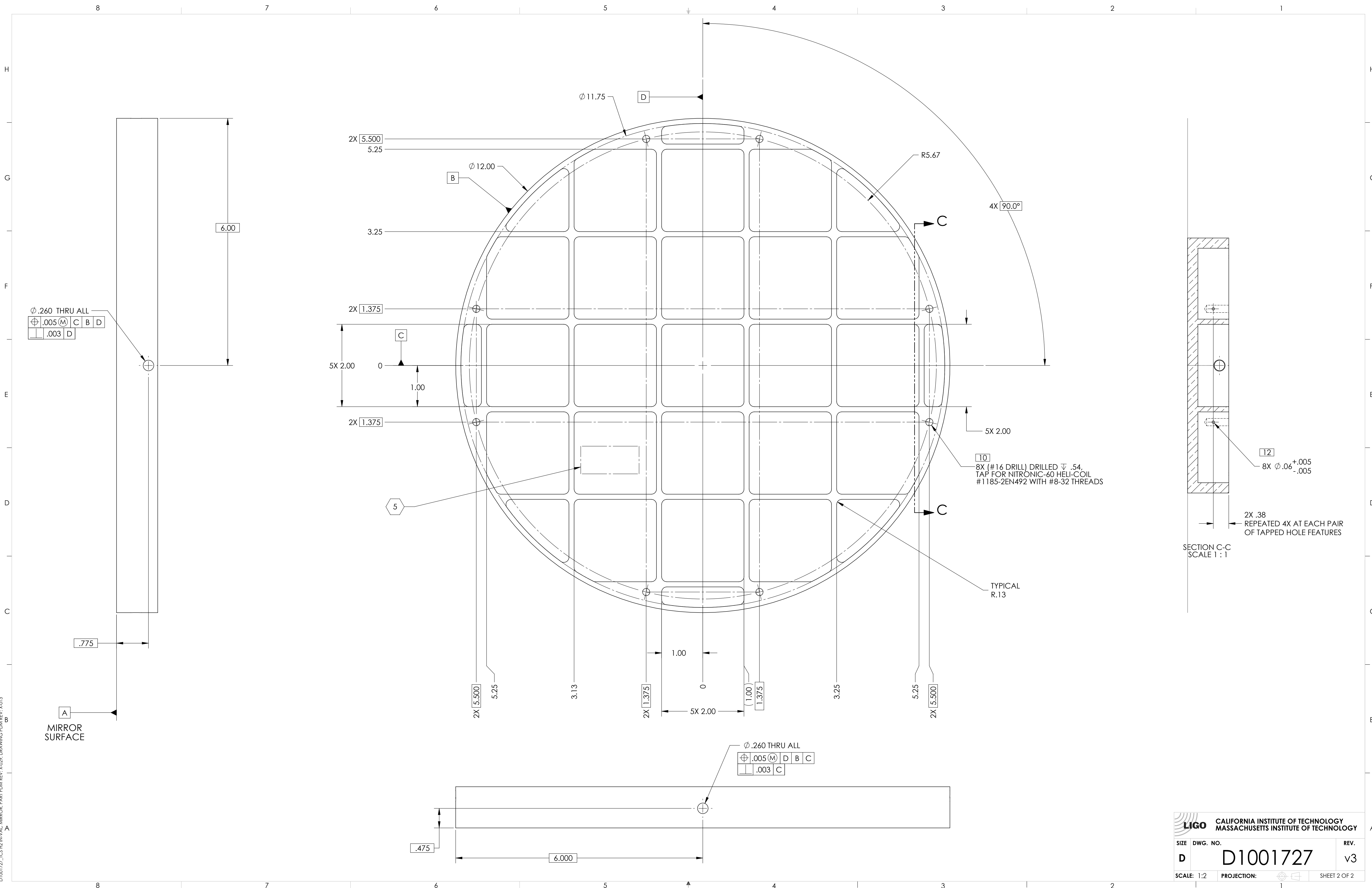
SECTION A-A
SCALE 1 : 1



SECTION B-B
SCALE 1 : 1

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± .01 .XXX ± .005		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .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.		ADVANCED LIGO AOS		aLIGO TCS H2 IN-VAC MIRROR	
ANGULAR ± 0.1°		MATERIAL: Copper, 110 ALLOY		FINISH: 63 μinch		DESIGNER: M. JACOBSON 08 JUL 2010 SIZE: D DWG. NO. D1001727	
		NEXT ASSY: D1001742		DRAFTER: A. COLE 30-AUG-2010 CHECKER: C. TORRIE 06 JAN 2011		REV. v3	
				APPROVAL: P. WILLEMS 06 JAN 2011 SCALE: 1:2 PROJECTION:		SHEET 1 OF 2	

D1001727_TCS H2 IN-VAC MIRROR PART PDM REV: X-029; DRAWING PDM REV: X-013



ϕ .260 THRU ALL
 \oplus .005 (M) C B D
 .003 D

10
 8X (#16 DRILL) DRILLED ∇ .54,
 TAP FOR NITRONIC-60 HELI-COIL
 #1185-2EN492 WITH #8-32 THREADS

12
 8X ϕ .06 $\begin{matrix} +.005 \\ -.005 \end{matrix}$
 2X .38
 REPEATED 4X AT EACH PAIR
 OF TAPPED HOLE FEATURES
 SECTION C-C
 SCALE 1 : 1

ϕ .260 THRU ALL
 \oplus .005 (M) D B C
 .003 C

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY
 SIZE DWG. NO. **D1001727** REV. **v3**
 SCALE: 1:2 PROJECTION: SHEET 2 OF 2

D1001727_TCS1021N_VAC_MIRROR_PART_PDM_REV_K029_DRAWING_PDM_REV_X013