

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 = .28 LB [125 G].

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.

REV.	DATE	DCN #	DRAWING TREE #
v1	13 DEC 2010	E1000735-v1	-
v2	26 MAR 2012	E1200317-x0	-
-	-	-	-

D

D

C

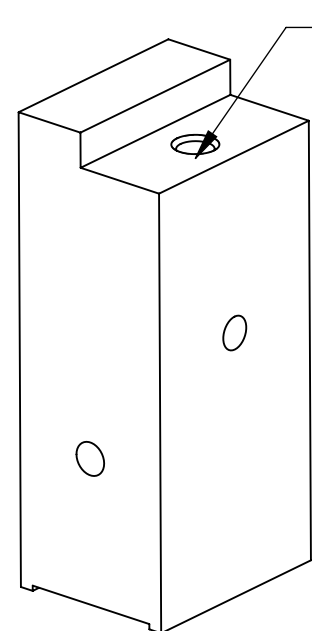
C

B

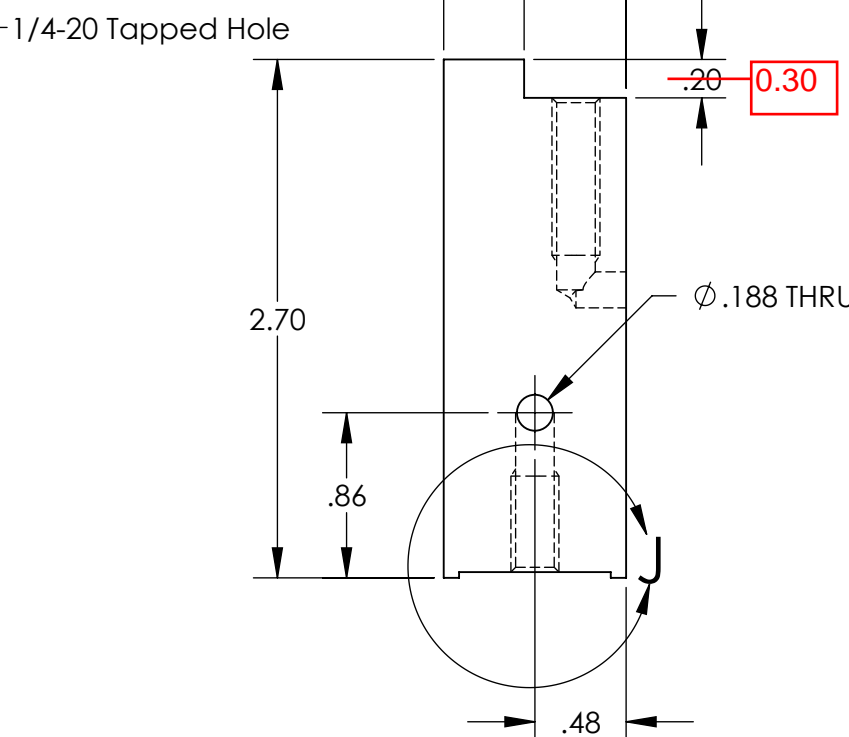
B

A

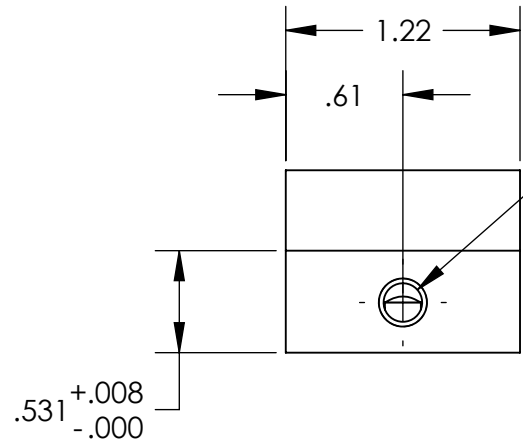
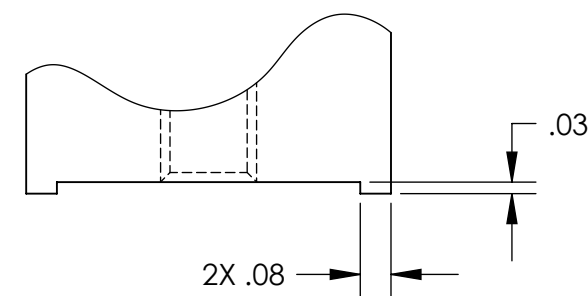
A



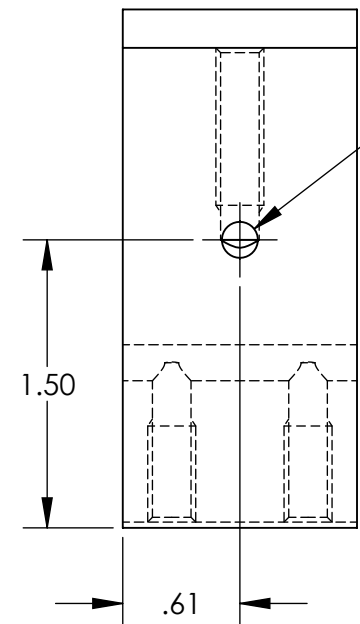
ISO VIEW



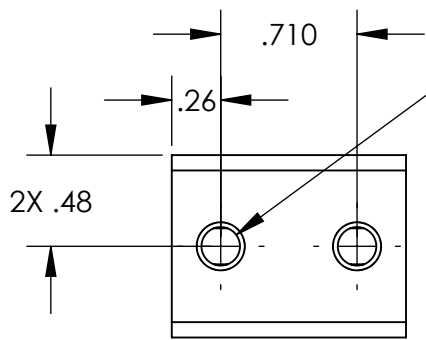
DETAIL J
SCALE 2 : 1



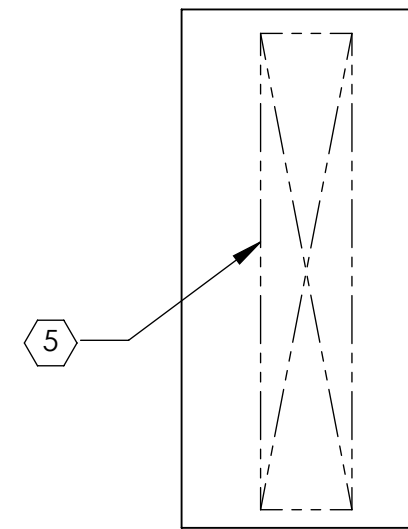
Ø .201 ± 1.00
 1/4-20 UNC - 1B ± .82
 ✓ Ø .25 X 90°, NEAR SIDE
 11.005 OVERSIZE BOTH DRILL AND TAP.



Ø .188 ± .26



2X Ø .20 ± .83
 1/4-20 UNC - 2B ± .50
 ✓ Ø .25 X 90°, NEAR SIDE
 11.005 OVERSIZE BOTH DRILL AND TAP.



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NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1.0°				LIGO		ALIGO TMS PRIMARY MIRROR SIDE CLAMP LOWER	
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.				ADVANCED LIGO		AOS	
MATERIAL: 6061-T6 Al				FINISH: 63 μinch Ra		NEXT ASSY: D1003120	
DESIGNER: K. MAILAND 14 OCT 2010		SIZE DWG. NO.		CHECKER: SEE DCC SEE DCC		REV.	
DRAFTER: M. MILLER 11/02/2010		B		D1002728		v3	
APPROVAL: SEE DCC SEE DCC		SCALE: 1:1		PROJECTION:		SHEET 1 OF 1	