



DOCUMENT CHANGE NOTICE (DCN)

DOCUMENT No. (DOC-REV-GP. ID)	TITLE	NEW REV.
D990513-00	ETM Alignment Bracket - Slotted	A
D990521-00	ETM Alignment X-Beam	A
D990522-00	ETM Alignment Vertical Support	A
D990523-00	ETM Alignment Bracket	A
D990526-00	ETM Alignment Tooling Installation	A
D990534-00	ETM Alignment Backplate	A

CHANGE DESCRIPTION (FROM/TO):

D990534: Changed overall length from 7.61 to 8.00. Changed verticle hole dimension from 7.00 to 7.39.

Others: No change for release.

ACTION: Incorporate change Attach DCN to drawing(s) Other action (specify):

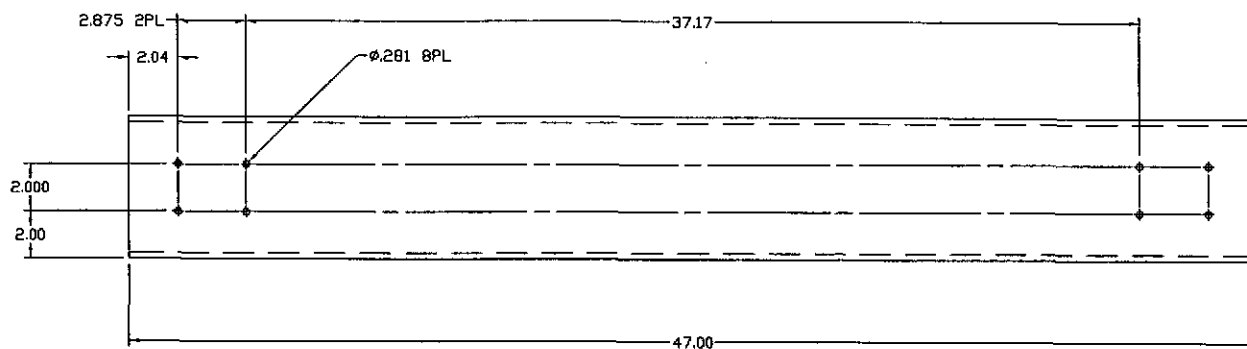
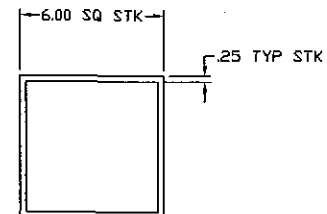
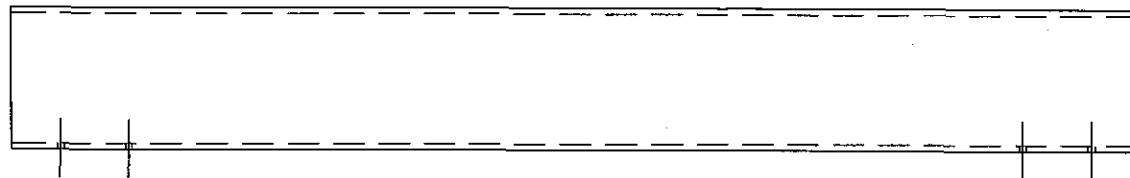
DISPOSITION OF HARDWARE (IDENTIFY SERIAL NUMBERS)	DCN DISTRIBUTION (X=incl. docs)
<input type="checkbox"/> No hardware affected (record change only)	<input checked="" type="checkbox"/> Althouse <input type="checkbox"/> Barish <input type="checkbox"/> Coles
<input type="checkbox"/> List S/Ns which comply already:	<input type="checkbox"/> Coyne <input type="checkbox"/> Lazzarini <input type="checkbox"/> Lindquist
<input type="checkbox"/> List S/Ns to be reworked or scrapped:	<input checked="" type="checkbox"/> Sanders <input type="checkbox"/> Shoemaker <input type="checkbox"/> Stapfer
<input type="checkbox"/> List S/Ns to be built with this change:	<input type="checkbox"/> Tyler <input type="checkbox"/> Weiss <input type="checkbox"/> Whitcomb
<input type="checkbox"/> List S/Ns to be retested per this change:	<input type="checkbox"/> Camp <input checked="" type="checkbox"/> Conley
<input type="checkbox"/>	<input checked="" type="checkbox"/> Jones <input checked="" type="checkbox"/> Smith
<input type="checkbox"/>	
<input type="checkbox"/>	
<input type="checkbox"/>	

SAFETY, COST, SCHEDULE, REQUIREMENTS IMPACT? No Yes (if yes, enter Change Request number)

APPROVALS:	DATE	OTHER APPROVALS (specify)	DATE
ORIGINATOR: C. Conley	10-8-99		
TASK LEADER: <i>Michael R. Smith</i>	<i>10/8/99</i>		
GROUP LEADER: <i>Jordan Camp</i>			
DCC RELEASE: <i>[Signature]</i>	<i>11-15-99</i>		

NOTES: (UNLESS OTHERWISE SPECIFIED)

- THIS IS A UVV APPLICATION AND ALL STOCK METAL SURFACES ARE TO BE CLEANED. NO MILL IDENT. MARKS OR FORMING DISCOLORATION IS PERMISSIBLE ON FINISHED PART. SCOTCH-BRITE, JITTERBUG, SKIN CUT, TUMBLING, OR CAUSTIC ETCH AND "B1" RINSE ARE ACCEPTABLE METHODS OF CLEANING. IN ADDITION, ELECTROPOLISH IS ACCEPTABLE FOR STAINLESS STEEL.

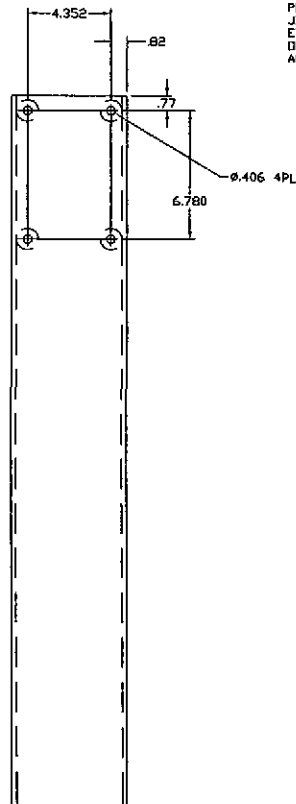
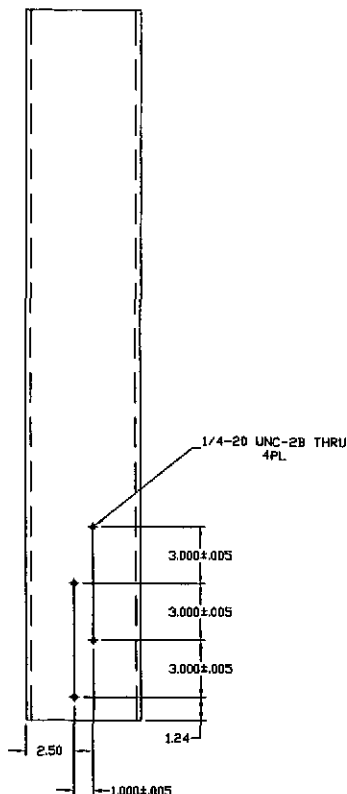
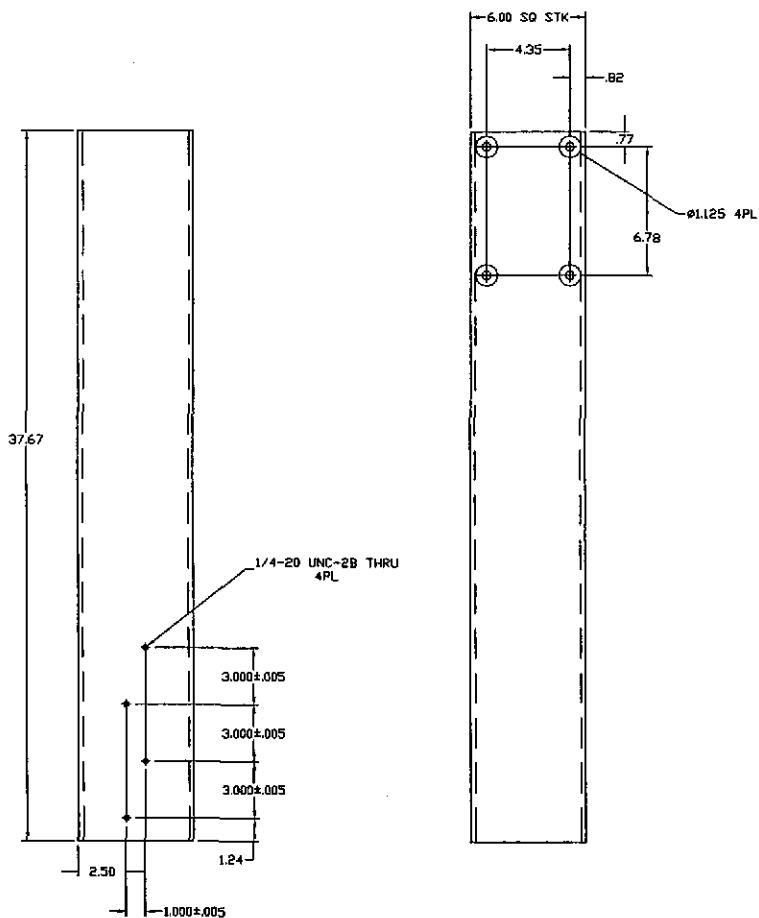


ELECTRONIC COPY

		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES						LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASON/NETS WORTHY OF TECHNOLOGY	
		TOLERANCES: FRACTIONAL ± ANGULAR ±1° ANGULAR SURF ± BOND ± TWO PLACE DECIMAL .002	THREE PLACE DECIMAL ±.010 FINISHED SURFACE BOND SEAM CORNERS ON CUT: .005-.010 REMOVE ALL BURRS					ETM ALIGNMENT X-BEAM	
		MATERIAL: 6061-T6 ALU TUBING 6" OD, 1/4" WALL	HEAT TREAT: T6	FINISH:		A E990319		Conley 10-7-99	
		USED ON	NEXT ASSY			DO PRE-RELEASE		Conley 9-29-99	
DRG. NO.	DESCRIPTION			REV	DESCRIPTION	APPR'D	CHECK	DRWN	DATE
REFERENCE DRAWING									
								SCALE	1:1
								DATE	9-29-99
								ISSUE NO.	3
								DRG. TALK	D990521-A
								SHEET	1 OF 1

NOTES: UNLESS OTHERWISE SPECIFIED:

1. THIS IS A UHV APPLICATION AND ALL STOCK METAL SURFACES ARE TO BE CLEANED. NO MILL IDENT. MARKS OR FORMING DISCOLORATION IS PERMISSIBLE ON FINISHED PART. SCOTCH-BRITE, JITTERBUG, SKIN CUT, TUMBLING, OR CAUSTIC ETCH AND "DI" RINSE ARE ACCEPTABLE METHODS OF CLEANING. IN ADDITION, ELECTROPLISH IS ACCEPTABLE FOR STAINLESS STEEL.

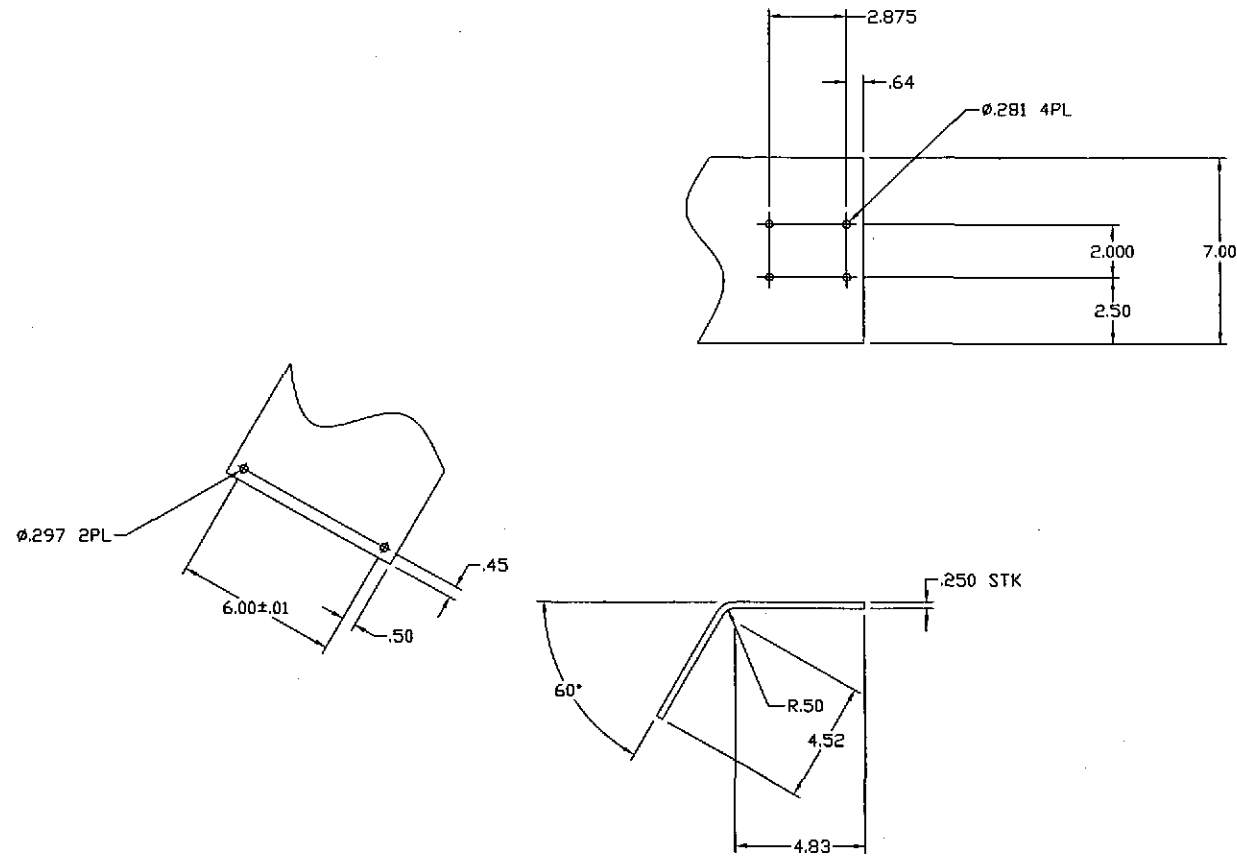


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		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES				1690 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
TOLERANCES: FRACTIONAL ± ANGULAR ± HOLE/ANNUS & BEND ± TWO PLACE DECIMAL ±.02		THREE PLACE DECIMAL ±.010 FINISHED SURFACE RING BREAK CORNERS IN (.01) .005-.010 REMOVE ALL BURRS				Con'try 10-7-99	
MATERIAL: 6061-T6 ALUM. TUBING 6" SQ, 1/4" WALL		HEAT TREAT: FINISH:		A E990210		Con'try 8-23-99	
DRAWING NO.		DESCRIPTION		REV		DATE	
REFERENCE DRAWINGS		NEXT ASS'Y: 9990143		ISSUE DESCRIPTION		SCALE 2990522-A.dwg	
						D990522-A	
						1 OF 1	

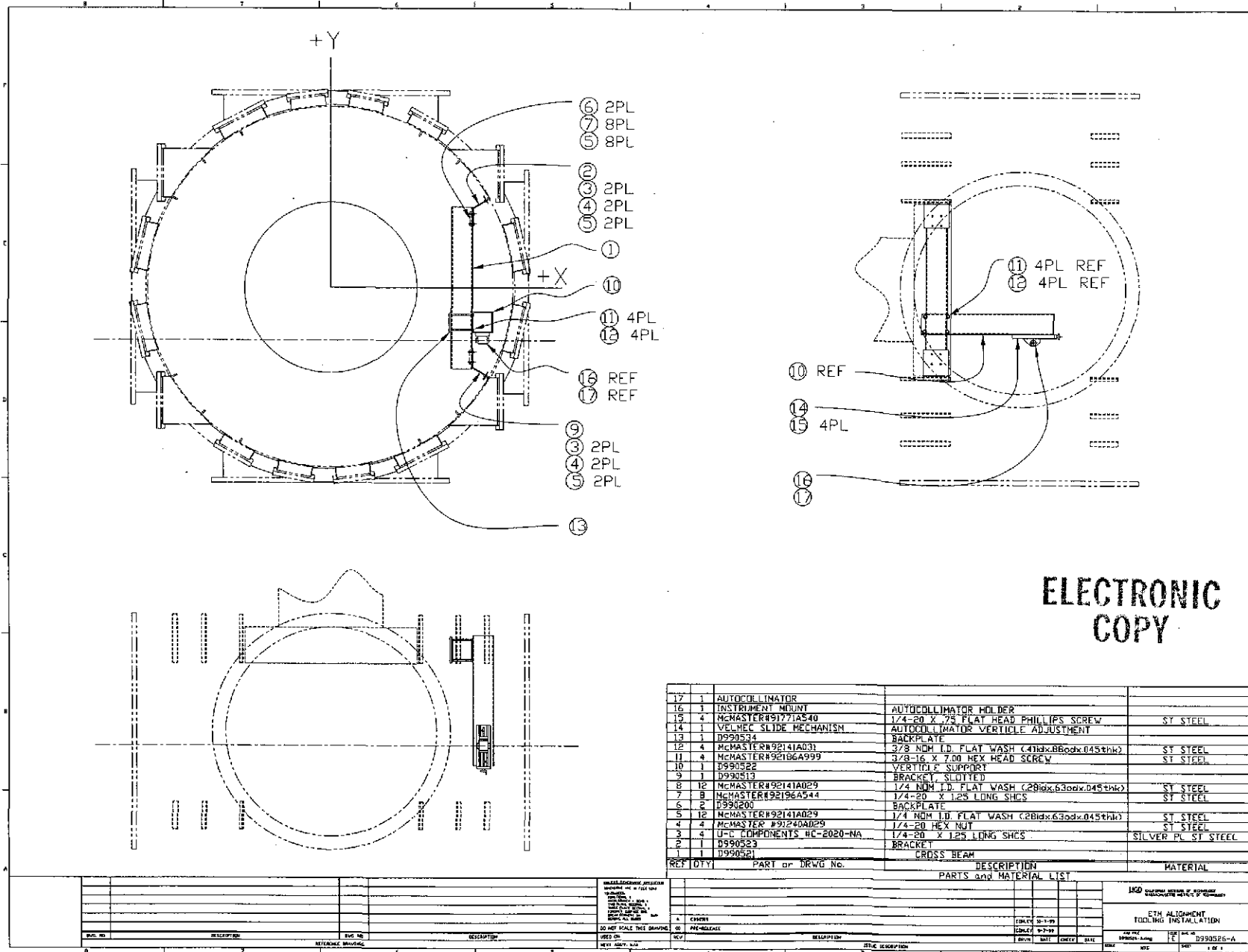
NOTES: (UNLESS OTHERWISE SPECIFIED)

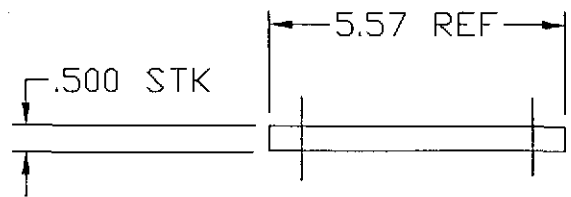
1. THIS IS A UNV APPLICATION AND ALL STOCK METAL SURFACES ARE TO BE CLEANED. NO MILL IDENT. MARKS OR FORMING DISCREPANCY IS PERMISSIBLE ON FINISHED PART. SCOTCH-BRITE, JITTERBUG, SKIN CUT, TUMBLING, OR CAUSTIC ETCH AND "DI" RINSE ARE ACCEPTABLE METHODS OF CLEANING. IN ADDITION, ELECTROPOLISH IS ACCEPTABLE FOR STAINLESS STEEL.



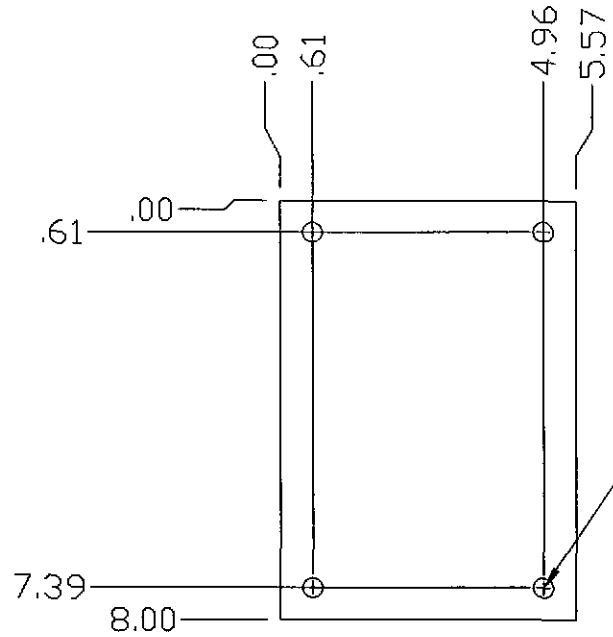
**ELECTRONIC
COPY**

		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES						1160 CALIFORNIA INSTITUTE OF TECHNOLOGY MICHIGAN STATE INSTITUTE OF TECHNOLOGY	
		TOLERANCES: FRACTIONAL ± ANGULAR ± ANGULARMACH ± BEND ± TWO PLACE DECIMAL ±.03	THREE PLACE DECIMAL ±.010 FINISHED SURFACE SING BREAK CORNERS IN DFN .005-.010 REMOVE ALL BLAGS					ETM ALIGNMENT BRACKET	
		MATERIAL: 300 SERIES STAINLESS STEEL .250 THICK	HEAT TREAT:	FINISH:		A C990319		Conley 10-7-99	
						80 PRE-RELEASE		Conley 8-23-99	
ING. NO.	DESCRIPTION	USED ON	NEXT ASSY: D990230	REV	DESCRIPTION	APPR'S	CHECK	DRWN	DATE
6	REFERENCE DRAWINGS	3	4	3	ISSUE DESCRIPTION	2		1	
						APP FILE		D99023-A.dwg	
						SCALE		D990523-A	
						NTS		1 OF 1	

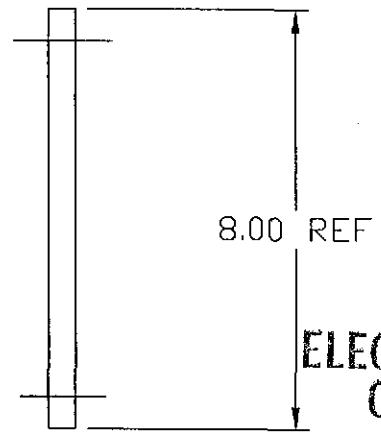




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.312 DIA THRU
 TAP 3/8-16 UNC-2B THRU
 (4) PLCS



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		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES						LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
		TOLERANCES: FRACTIONAL * DECIMAL * ANGLES & ANGULARS * BEND * TWO PLACE DECIMAL *20		THREE PLACE DECIMAL *20 FINISHED SURFACE RAZ BREAK CORNERS BY DIM. *0.05-.010 REMOVE ALL BURRS				ETM ALIGNMENT BACKPLATE	
		MATERIAL: 6061-T6 ALUMINUM .500 THICK		HEAT TREAT:		FINISH:		DATE: 10-7-99	
DWG. NO.		DESCRIPTION		REV		APPROV		DATE: 9-4-99	
REFERENCE DRAWINGS		UNLESS OTHERWISE SPECIFIED		NEXT ASSY: D990230		ISSUE DESCRIPTION		D990534-Asm	
								D990534-A	
								1 OF 1	