

D1101096_aLIGO TMS OPT TABLE-TELE-SUPPORT BRIDGE CONNECTION, PART PDM REV: X-007, DRAWING PDM REV: X-003

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 = X.XXX LB.

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

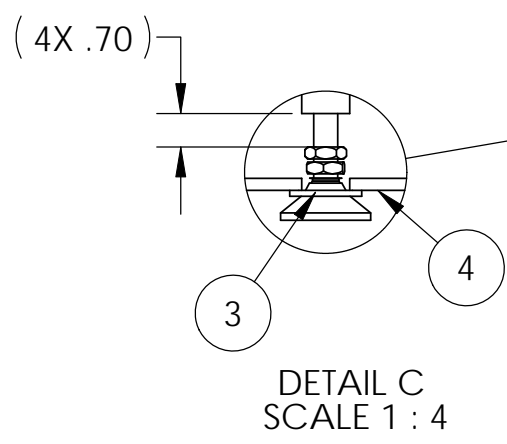
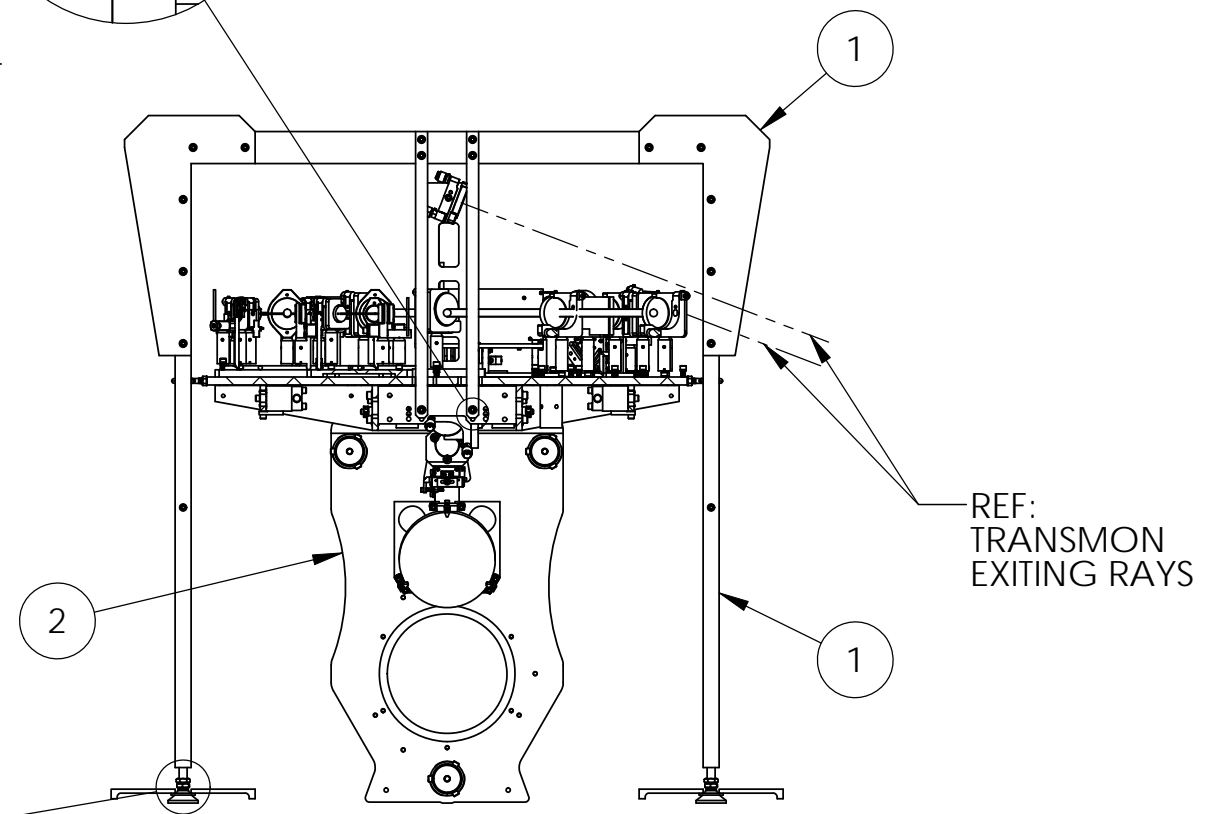
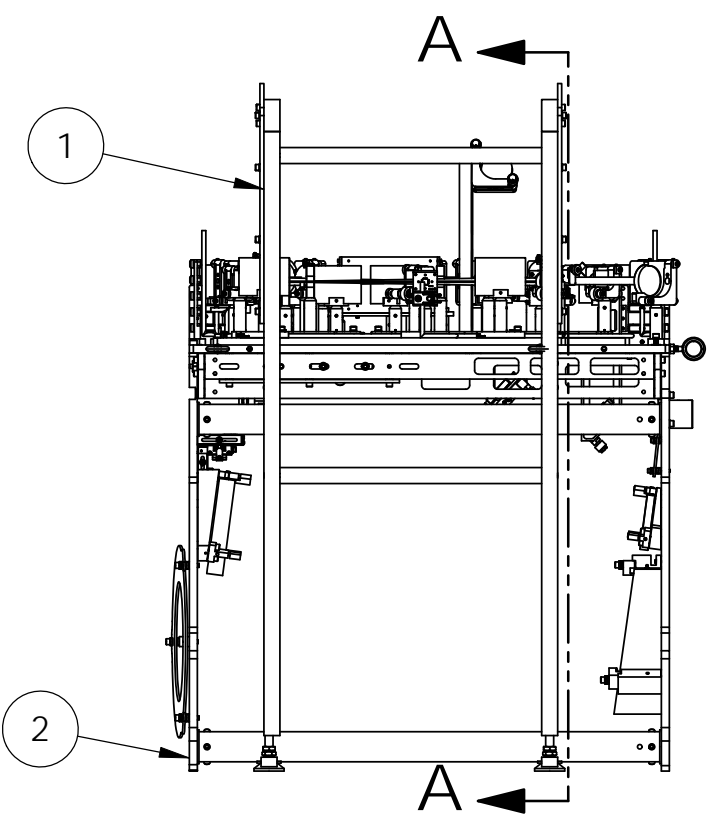
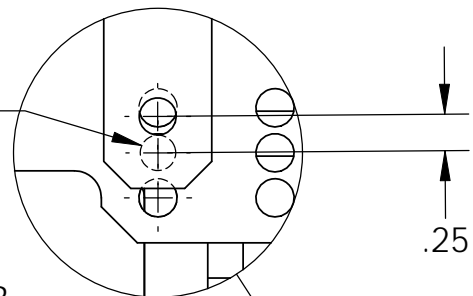
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

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.

REV.	DATE	DCN #	DRAWING TREE #
v1	09 JUN 2011	E1100355-v1	-
-	-	-	-
-	-	-	-

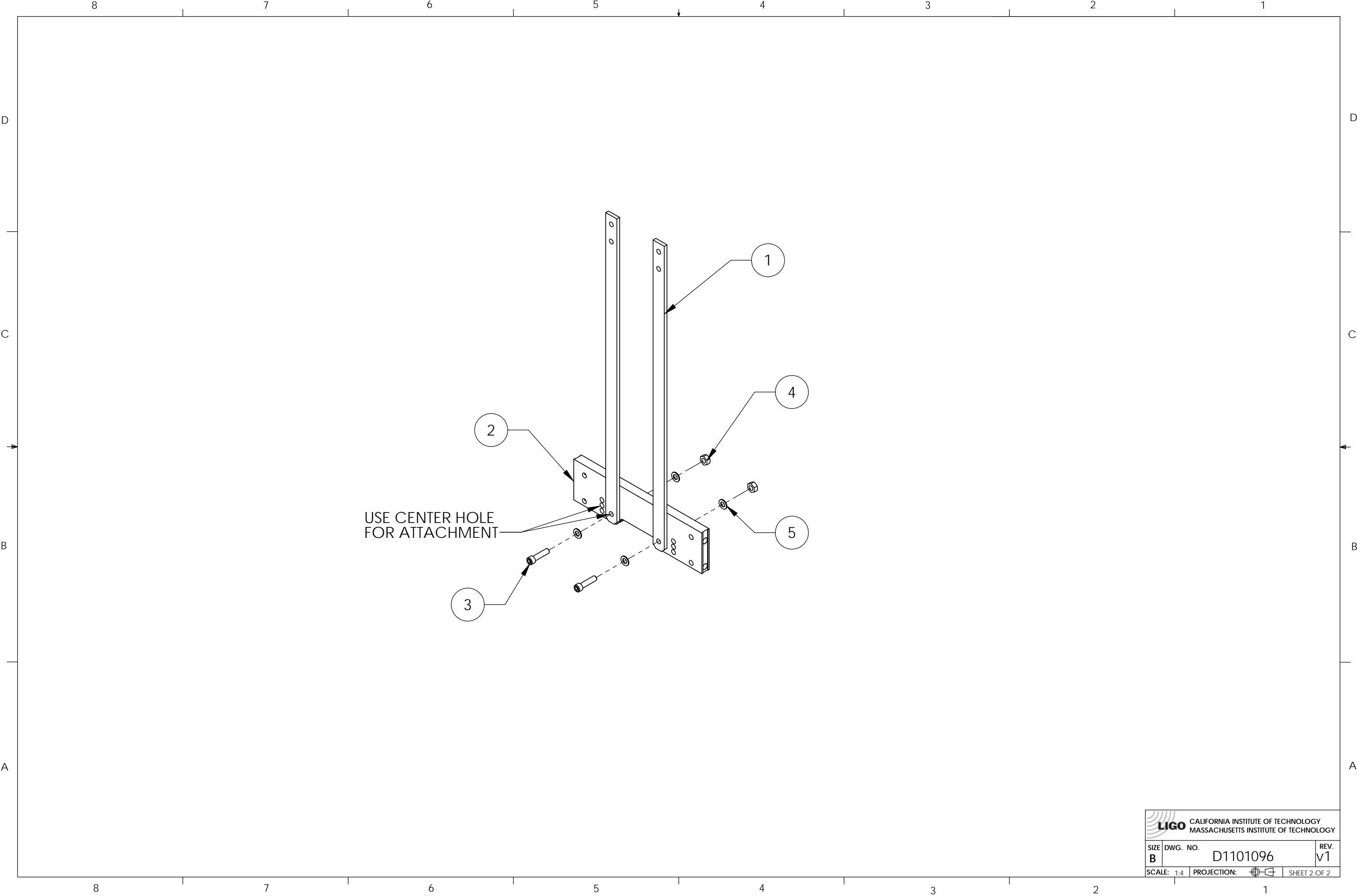
REF: SHEET (2)
USE CENTER HOLE
FOR ATTACHMENT




ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
7	90313A203	McMASTER, .266 I.D. X .50 O.D FLAT WASHER	18-8 SSSL	8		8
6	-	HEX NUT, 1/4-20	NICKEL-COPPER ALLOY 400	4		4
5	92185A542	McMASTER, SHCS 0.25-20 X 1	18-8 SSSL	4		4
4		LOS DOG CLAMP	AISI 1020	8		8
3	98126A849	(McMASTER-CARR), WASHER, 1" ID X 1.5 OD X .12 T	18-8 SSSL	4		4
2	D1002460-02	aLIGO TMS TELESCOPE ASSEM, Y-ARM	N/A	1		1
1	D1100531	aLIGO TMS OPTICAL TABLE SUPPORT BRIDGE ASSY	N/A	1		1
PARTS LIST						

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME aLIGO TMS OPT TABLE TELE SUPPORT BRIDGE CONNECTION	
TOLERANCES: .XX ± .01 .XXX ± .005		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.		SYSTEM ADVANCED LIGO SUB-SYSTEM AOS		DESIGNER J. TERRAZAS 24 MAR 2011 DRAFTER J. TERRAZAS 22 JUN 2011	
ANGULAR ± 1.0°		MATERIAL N/A FINISH N/A μinch		NEXT ASSY TOOLING		SIZE DWG. NO. B D1101096	
				APPROVAL		SCALE: 1:12 PROJECTION: SHEET 1 OF 2	

D1101096_aLIGO TMS OPT TABLE-TELE-SUPPORT BRIDGE CONNECTION, PART PDM REV.: DRAWING PDM REV: X-003



 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
B	D1101096	V1
SCALE: 1:4	PROJECTION:	SHEET 2 OF 2