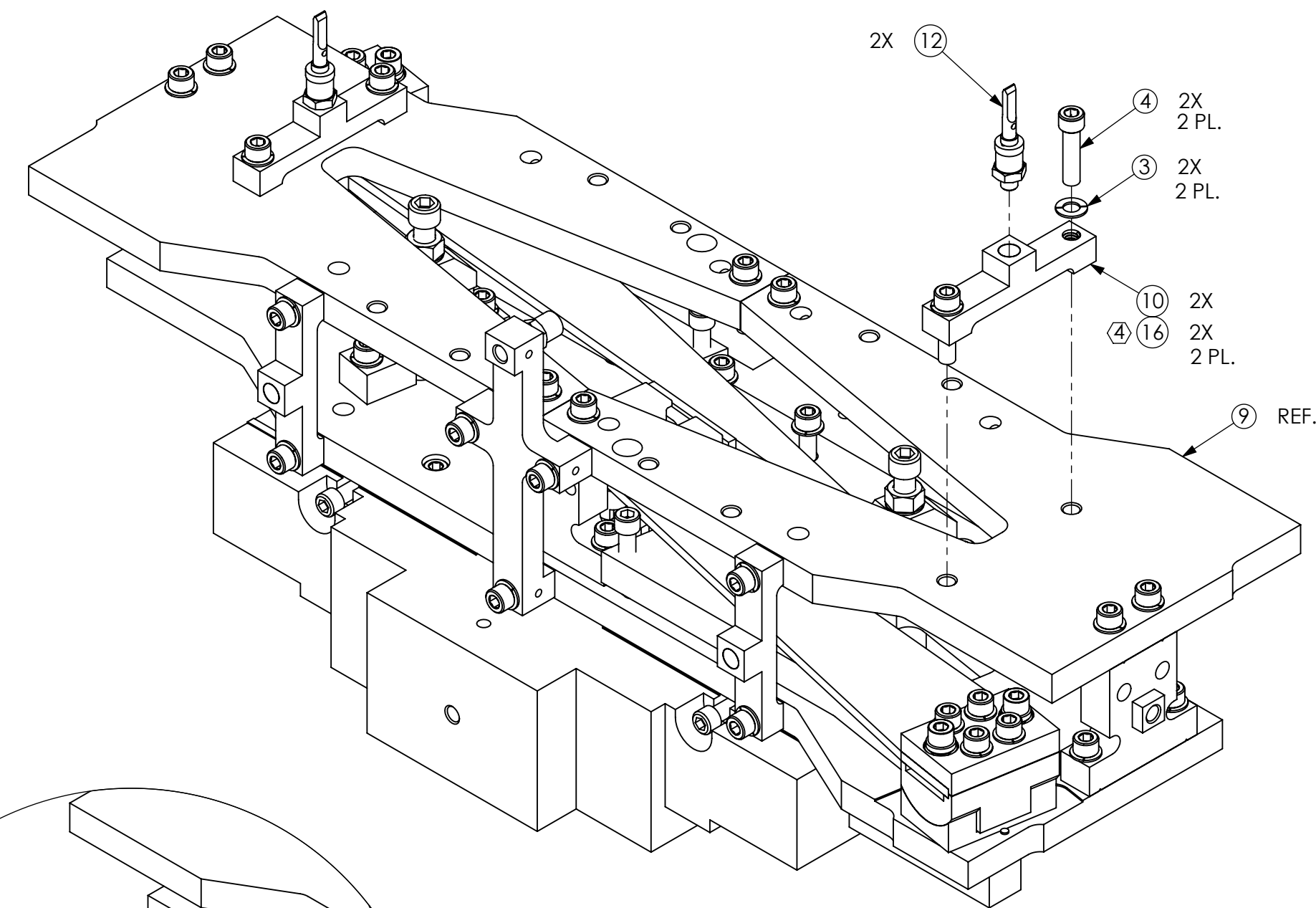
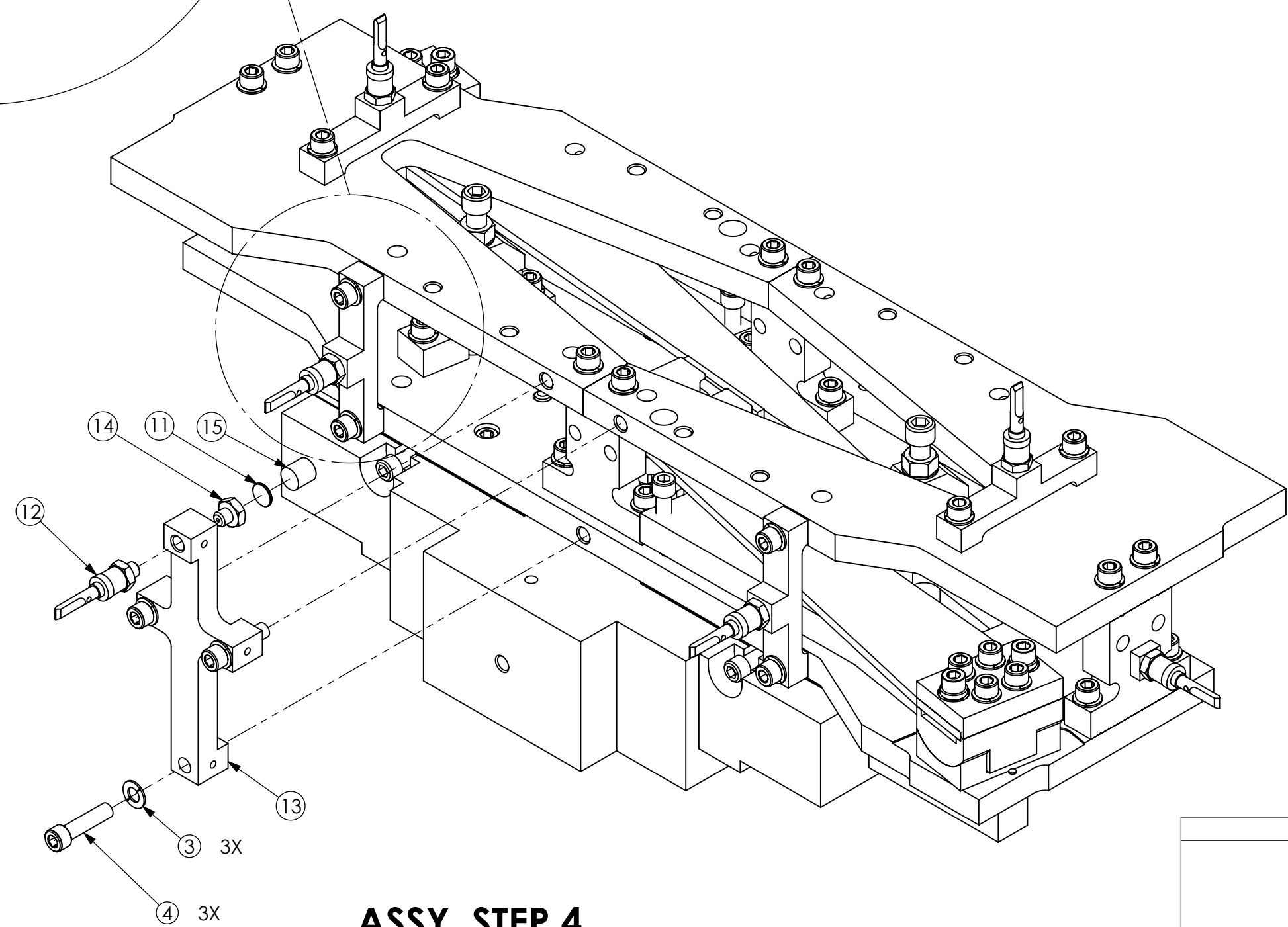
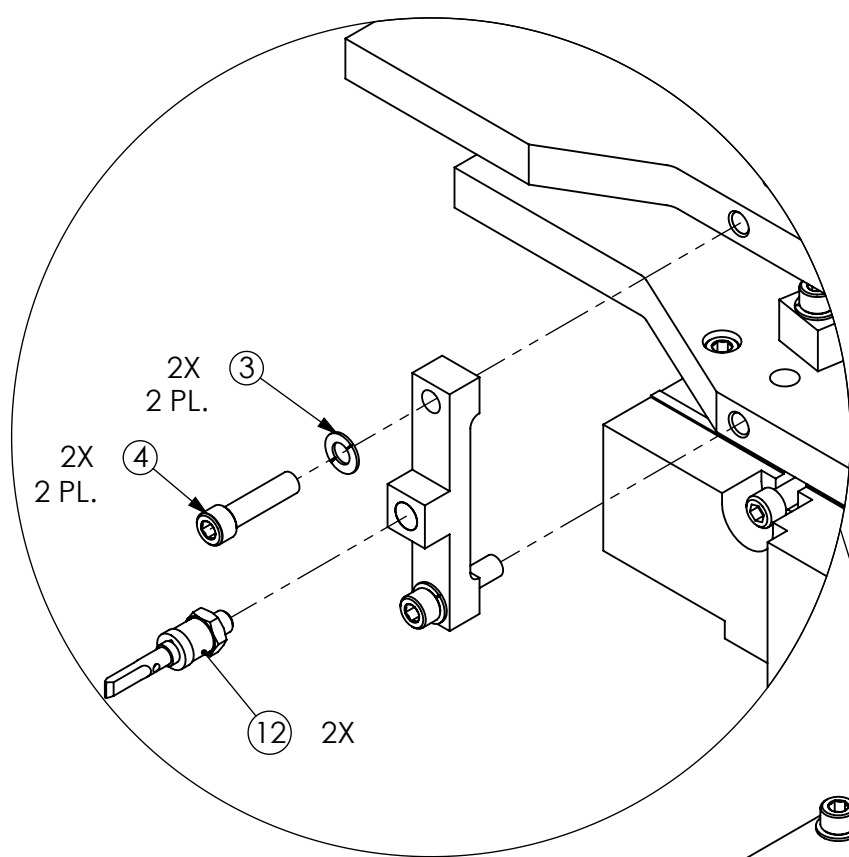


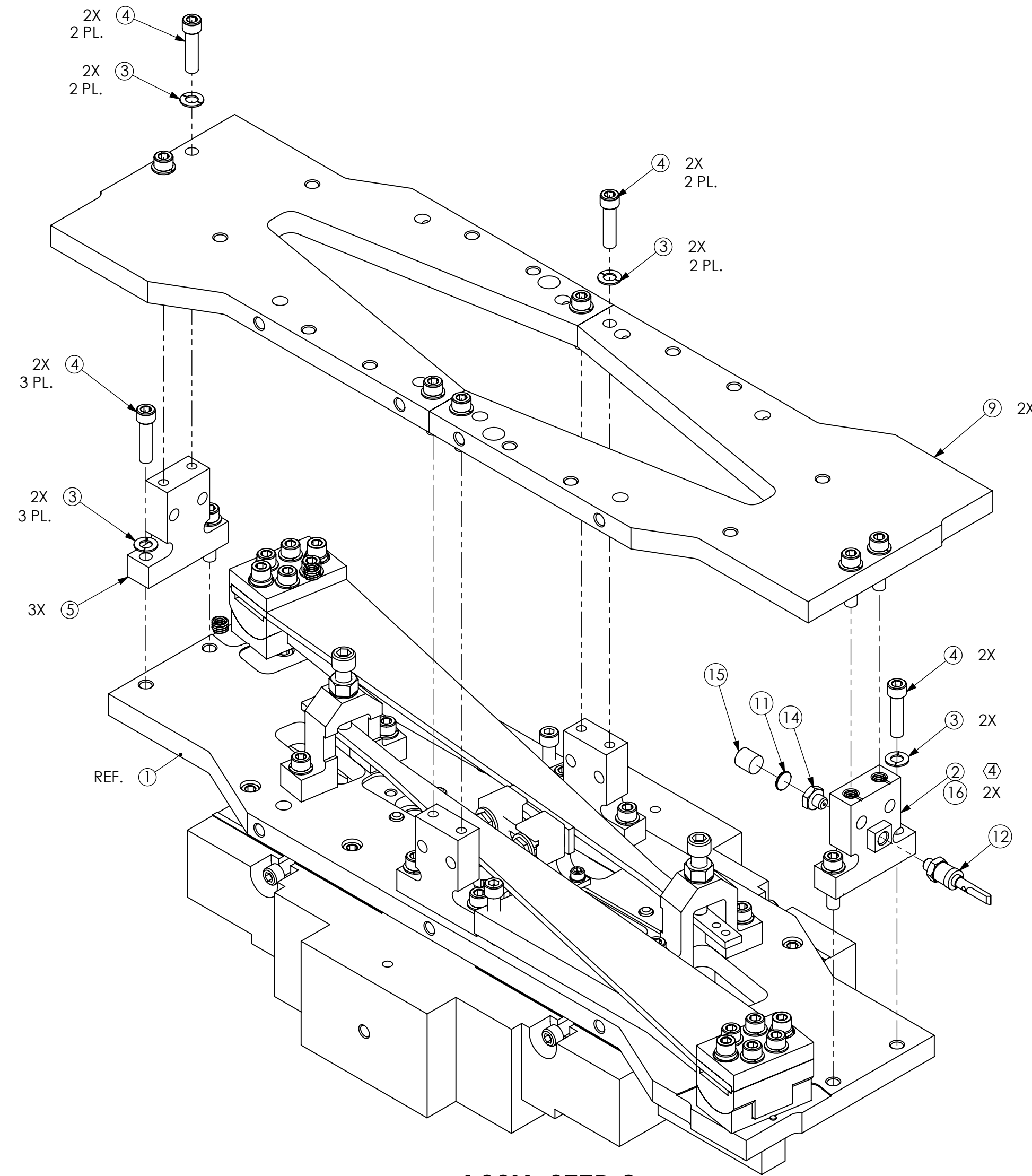
- NOTES CONTINUED:**
1. SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR TYPE (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
EXAMPLE (PART): 001-v1
EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD
 2. MASS: APPROX. 69.32 LBS
 3. INDICATED COMPONENT UNIQUE TO TMS. NOT USED ACROSS MULTIPLE SUB-SYSTEMS.
 4. INSTALL HELICOILS PRIOR TO ASSEMBLY. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL.



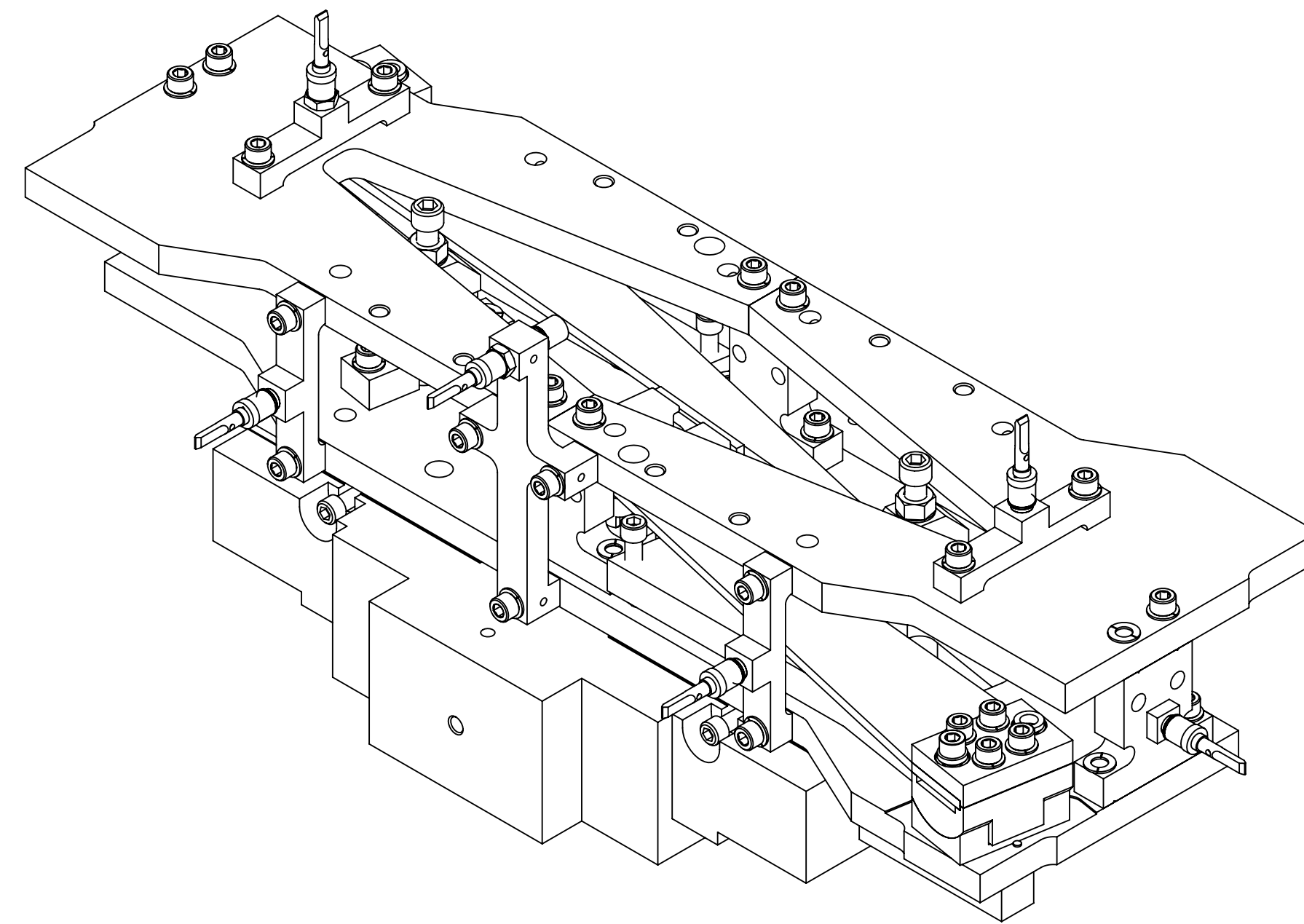
ASSY. STEP 3



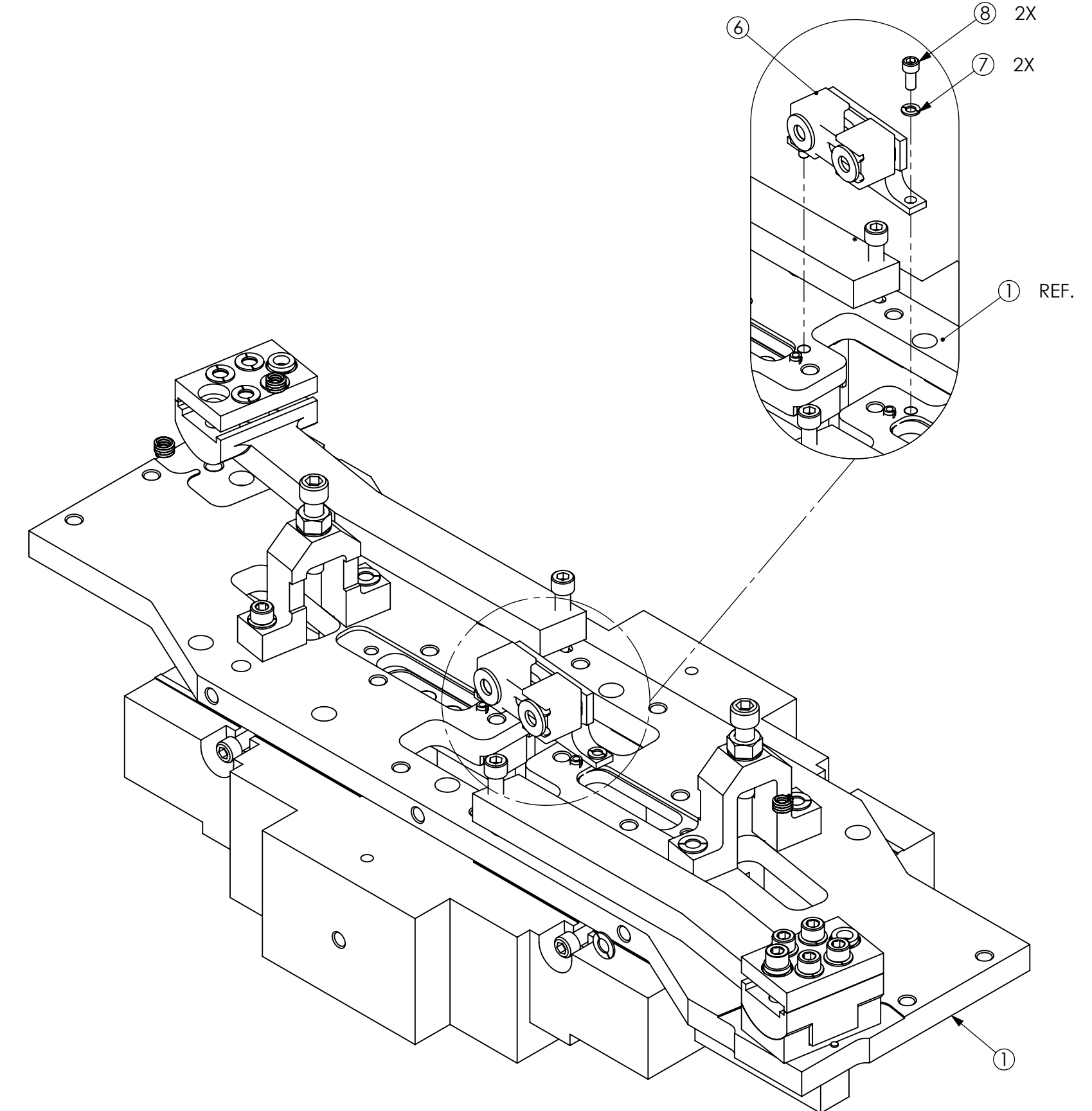
ASSY. STEP 4



ASSY. STEP 2



ISO VIEW



ASSY. STEP 1
(SPRING BLADES HIDDEN FOR CLARITY)

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.
16	1185-4EN250 EMHART OR EQ.	HELICOIL, 1/4-20 X .25 LG.	NITRONIC 60	6
15	D394394N35UHP	SINTERED NdFeB MAGNET, Ni-PLATED, 10 mm X 10 mm (MMG MAGDEV P/N OR EQUIVALENT)	NEO 35 (NdFeB)	2
3 14	D1001697	MAGNET RETAINER, BOSEM	316 SSSL	2
3 13	D1200328	ALIGO SUS BOSEM FLAG CENTER BRACKET	6061-T6 Al	1
3 12	D1001695	MAGNET AND FLAG ASSY, BOSEM	N/A	6
3 11	D1001534	MAGNETIC PLUG	416 SSSL	2
4 3 10	D1200327	ALIGO SUS BOSEM FLAG BRACKET	6061-T6 Al	4
3 9	D1101511	ALIGO TMS INTERMEDIATE MASS TOP PLATE	304 SSSL	2
8	C-806-N UC COMPONENTS OR EQ.	SCREW, SHCS, 8-32 X .375 LG.	300 SSSL	2
7	#8 VENT FL WSHR	.169 ID, .304 OD, .032 TH	18-8 SSSL	2
3 6	D1200421	ALIGO TMS MASS CABLE CLAMP ASSEMBLY	N/A	1
3 5	D1000395	ALIGO INTERMEDIATE TOP MASS SPACER	304 SSSL	3
4	C-2016-NA	SOCKET HEAD CAP SCREW, SHC, 1/4-20 x 1" L	Ag-PLATED 18-8 SSSL	27
3	WFV-25 UC COMPONENTS OR EQ.	.255 ID, .468 OD, .032 TH	18-8 SSSL	27
4 3 2	D1200356	ALIGO TMS MASS SPACER	304 SSSL	1
3 1	D1200525	ALIGO TMS MASS BASE ASSEMBLY	N/A	1

PARTS LIST

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

MATERIAL N/A FINISH N/A μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
SYSTEM ADVANCED LIGO SUB-SYSTEM AOS
NEXT ASSY D1101526

PART NAME
ALIGO TMS MASS SECONDARY ASSEMBLY
DESIGNER K. MAILAND 28 FEB 2012 SIZE DWG. NO. D1101527 REV. v6
DRAFTER C. CONLEY 26 MAR 2012
CHECKER k mailand 1-25-13
APPROVAL SEE DCN SEE DCN SCALE: 1:2 PROJECTION: SHEET 1 OF 1

D1101527 ALIGO TMS Mass Secondary Assembly, PART PDM REV-X-116, DRAWING PDM REV. X-007