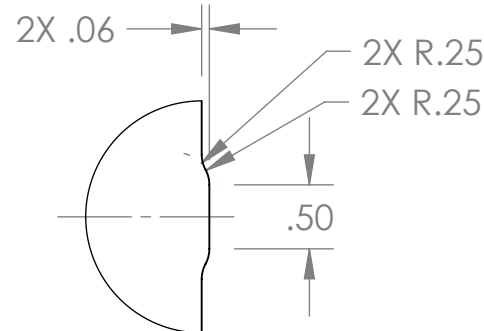


NOTES CONTINUED:

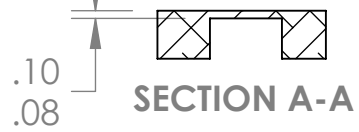
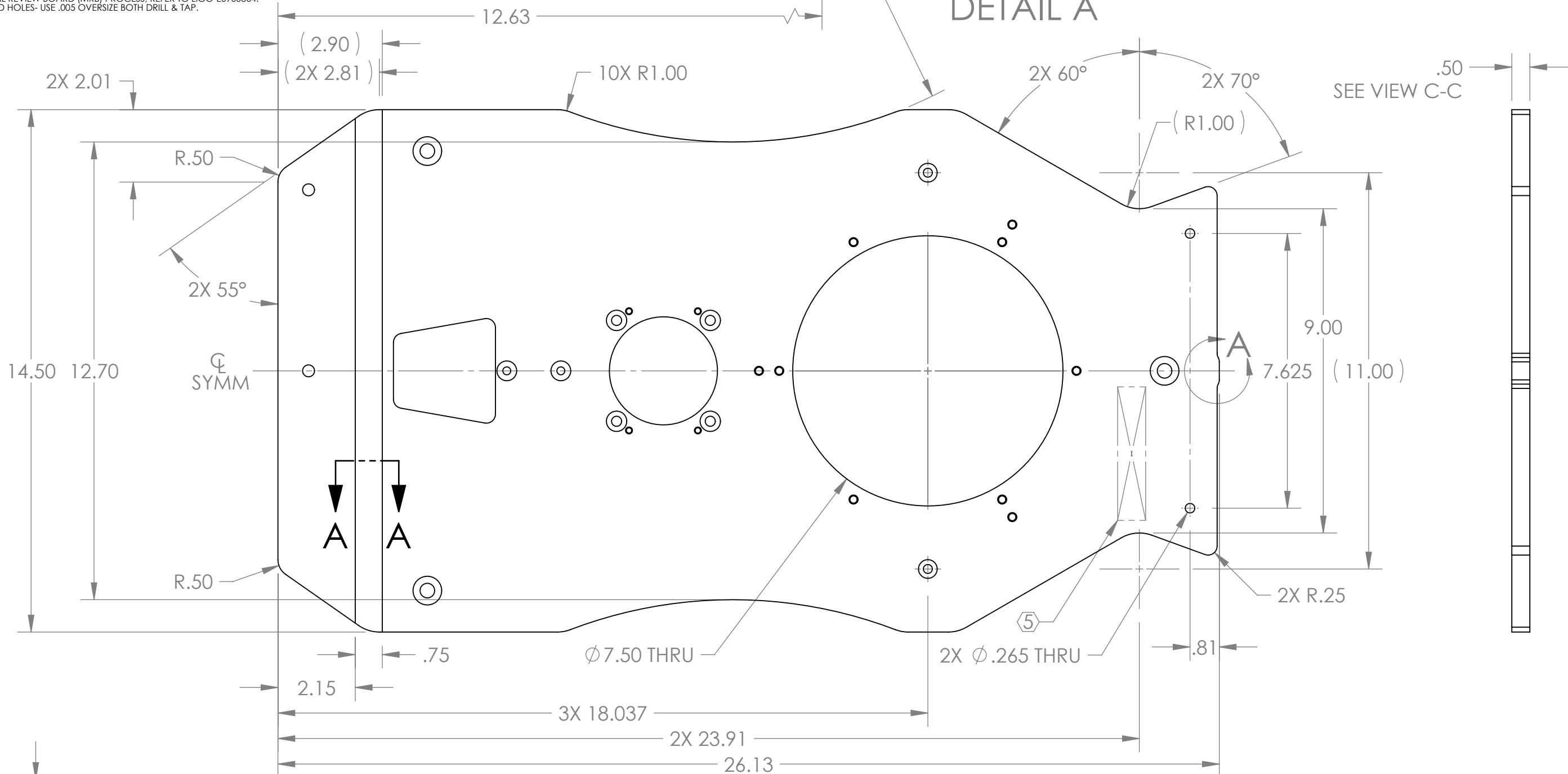
- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 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 = 13.09 LB [5.94 kg]
- 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- USE .005 OVERSIZE BOTH DRILL & TAP.

MANUFACTURING PROCESS (DOES NOT PERTAIN TO .0003 T.I.R. COPLANAR REGIONS, SHEET 4):
 PURCHASE 3/4" ALUM. ALLOY 6061-T651 PLATE.
 ROUGH BLANCHARD GRIND, EQUAL AMOUNTS FROM STOCK FROM EACH SIDE OF ALUM. PLATES.
 COLD STABILIZE PLATES.
 FINISH GRIND BOTH SIDES TO: .535 THICKNESS WITH A FLATNESS OF .002 ACROSS ENTIRE FACE.
 RE-CLAMP, MACHINE & ENGRAVE BALANCE OF PART IN THE FLAT.
 ON TOOLROOM VERTICAL MILL MACHINE, CLAMP PART TO ANGLE PLATE. MACHINE HOLES FOR 5/16-18 OVERSIZE THREAD PER (11) ON (1) END OF EACH PART.
 HAND DEBURR PARTS WITH BURR KNIVES & ROTARY CARBIDE BURRS.
 HAND TAP ALL REQUIRED HOLES. .005 OVERSIZE PER (11).
 INSPECT PARTS. ASSURE A FLATNESS OF .003 OR BETTER OVER FACE 'A' (SEE SHEET 4).
 SEND MATERIAL CERTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	08 NOV 2010	E1000365	-
-	-	-	-
-	-	-	-



DETAIL A



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± 0.5°	
MATERIAL	FINISH
6061-T6 Al	63 μinch Ra

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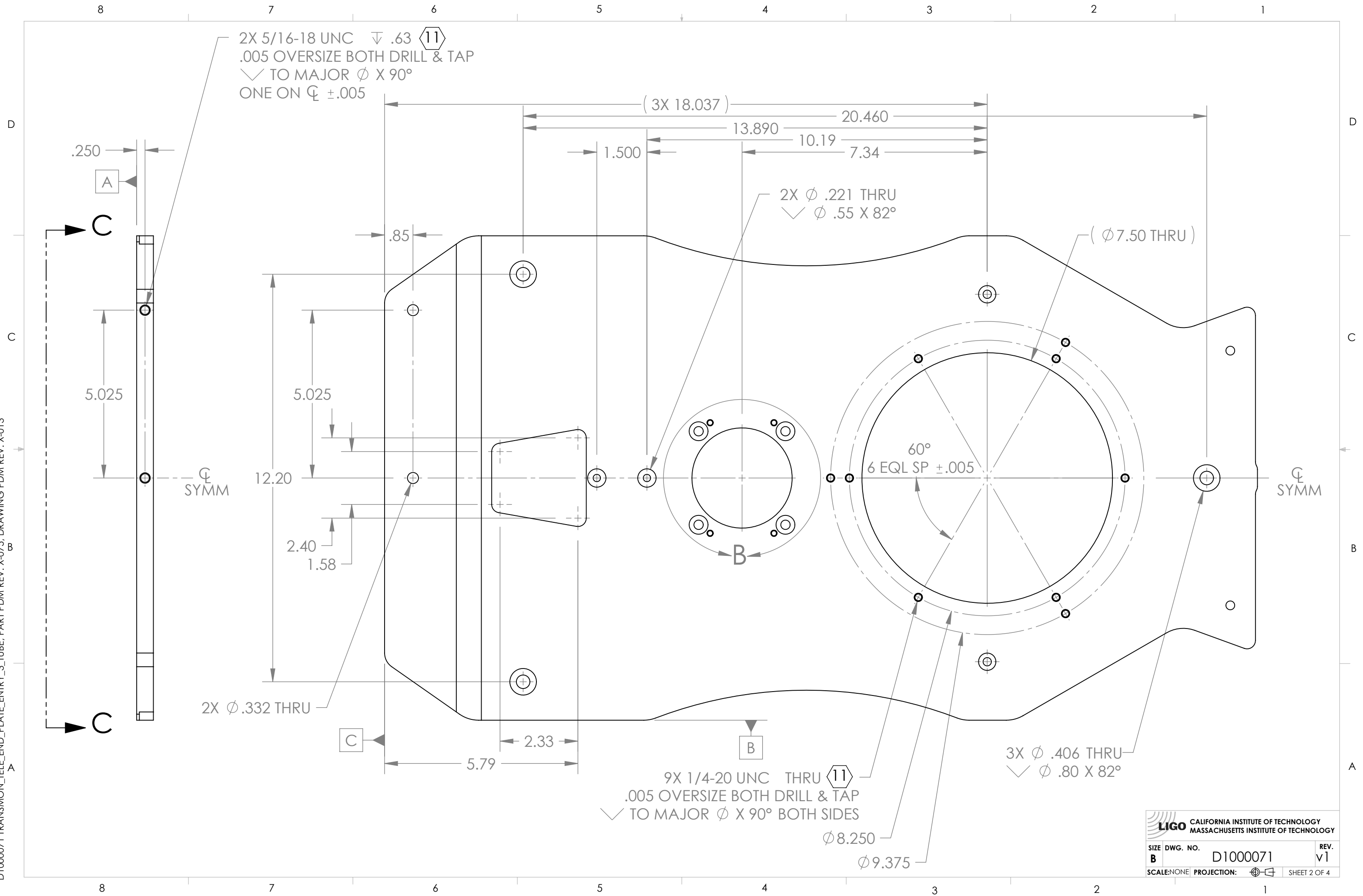
SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **AOS**

NEXT ASSY: **D1002296**

PART NAME		REV.	
TRANSMON TELE END PLATE ENTRY 3 TUBE		v1	
DESIGNER	K. MAILAND	21 JUN 2010	SIZE DWG. NO.
DRAFTER	C. CONLEY	08 NOV 2010	B
CHECKER	K. MAILAND	5/4/10	D1000071
APPROVAL	K. MAILAND	5/4/10	SCALE: NONE PROJECTION:
SHEET 1 OF 4			

D1000071 TRANSMON TELE END PLATE ENTRY 3 TUBE, PART PDM REV: X-075, DRAWING PDM REV: X-013

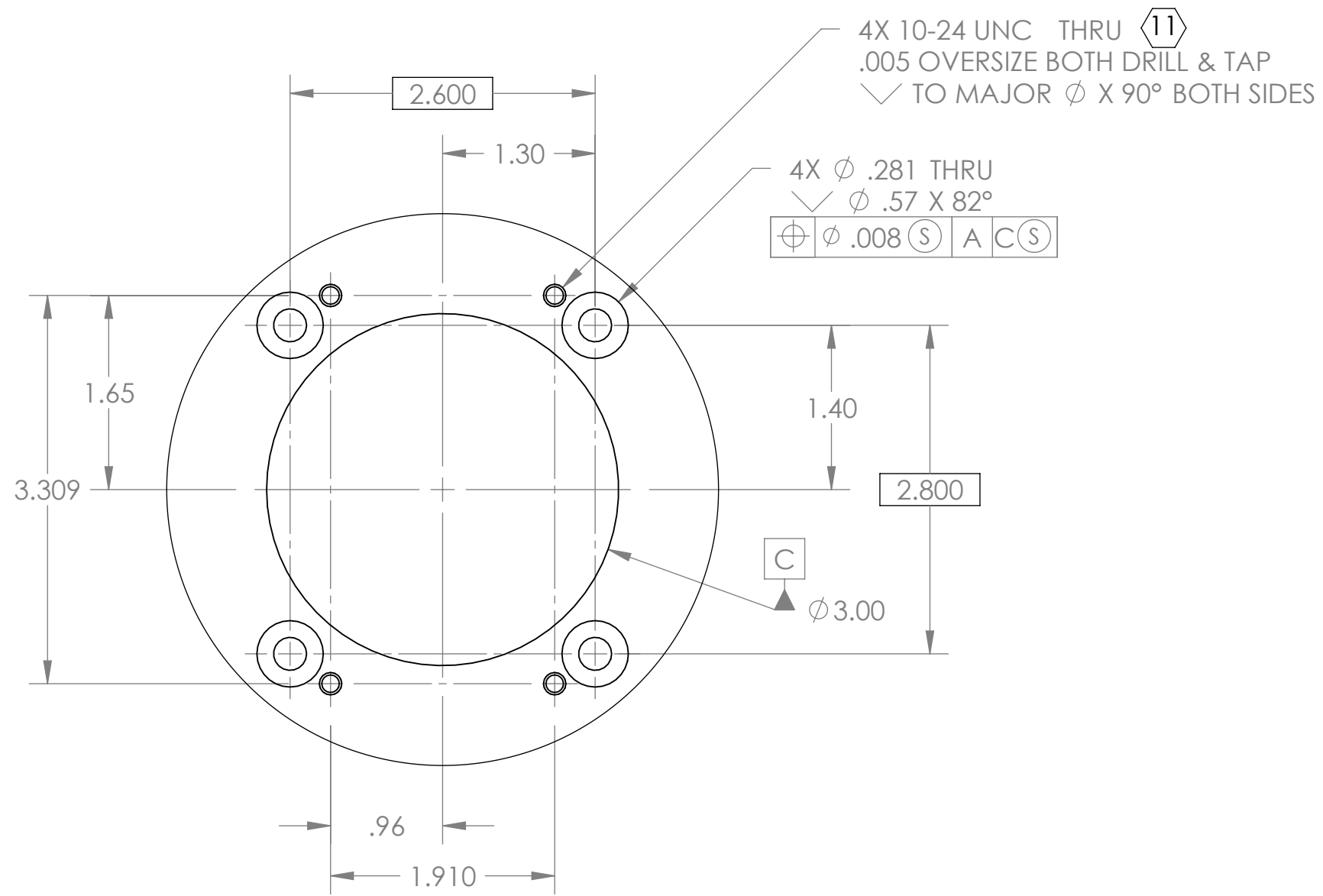
D1000071 TRANSMON_TEL_END_PLATE_ENTRY_3_TUBE, PART PDM REV: X-075, DRAWING PDM REV: X-013



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SIZE	DWG. NO.	REV.
B	D1000071	v1
SCALE: NONE	PROJECTION:	SHEET 2 OF 4

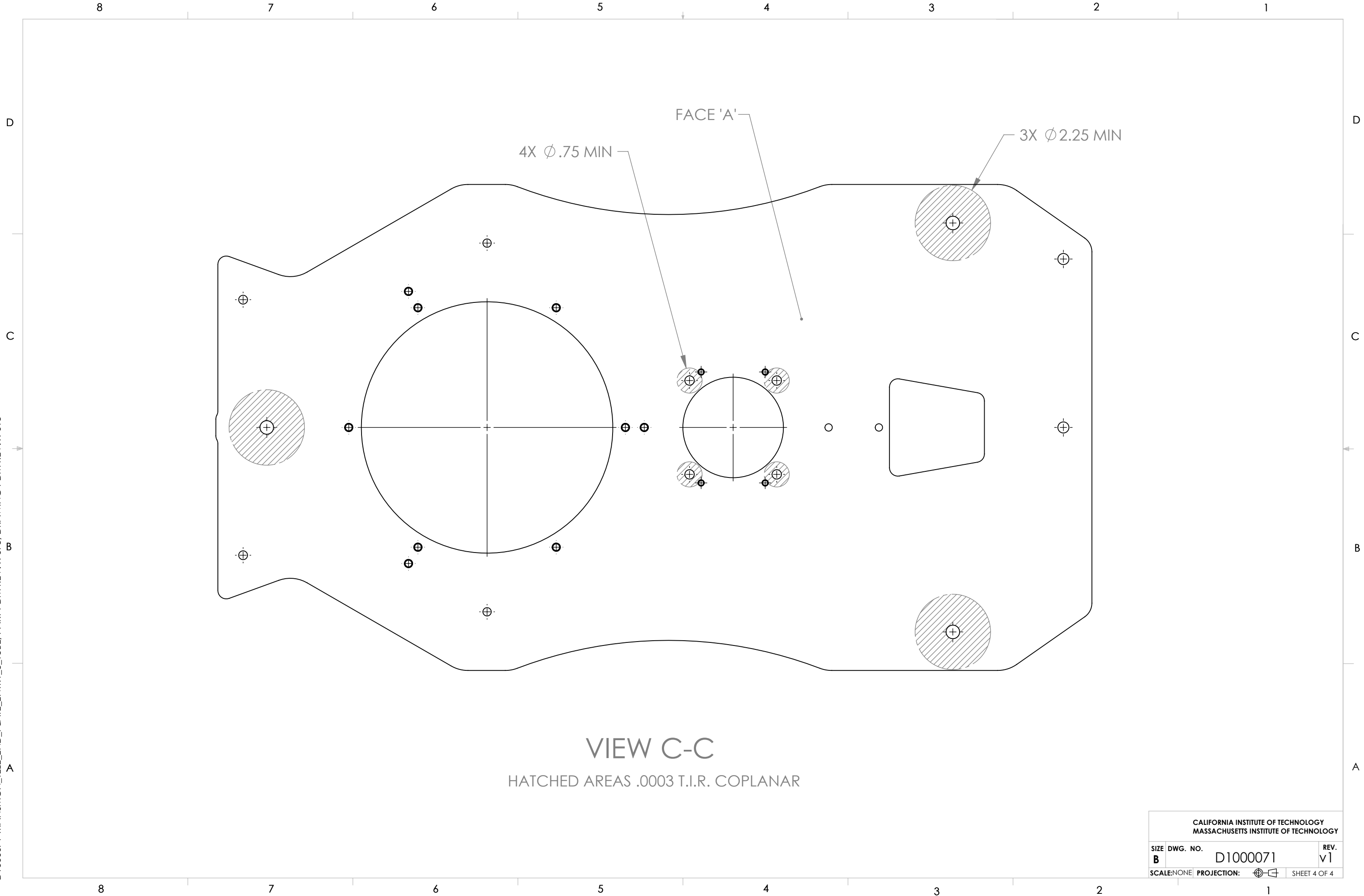
D1000071 TRANSMON_TLE_END_PLATE_ENTRY_3_TUBE, PART PDM REV: X-075, DRAWING PDM REV: X-013



DETAIL B

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SIZE	DWG. NO.	REV.
B	D1000071	v1
SCALE: NONE	PROJECTION:	SHEET 3 OF 4

D1000071 TRANSMON_TLE_END_PLATE_ENTRY_3_TUBE, PART PDM REV: X-075, DRAWING PDM REV: X-013



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SIZE B	DWG. NO. D1000071	REV. v1
SCALE: NONE	PROJECTION:	SHEET 4 OF 4