

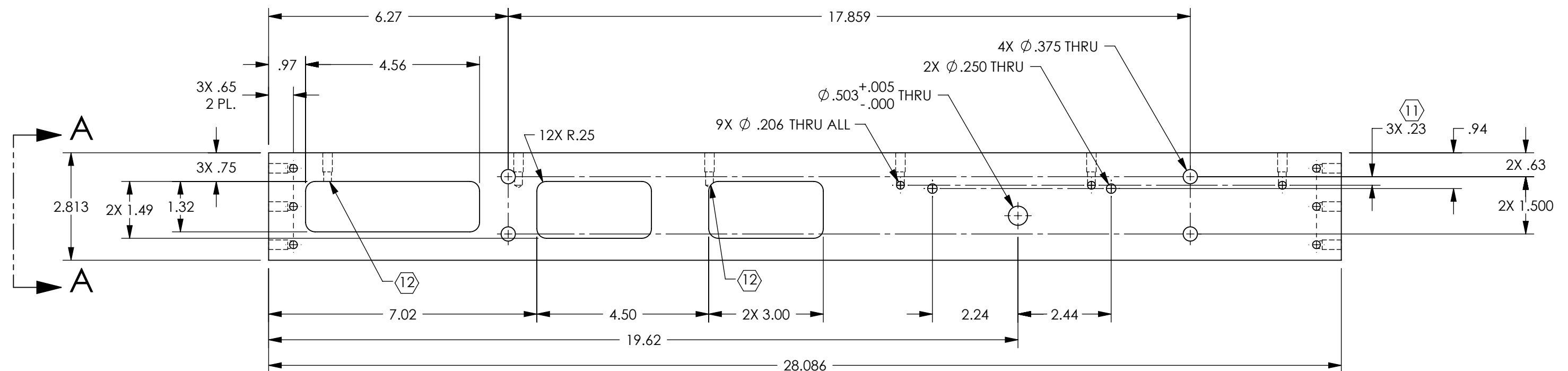
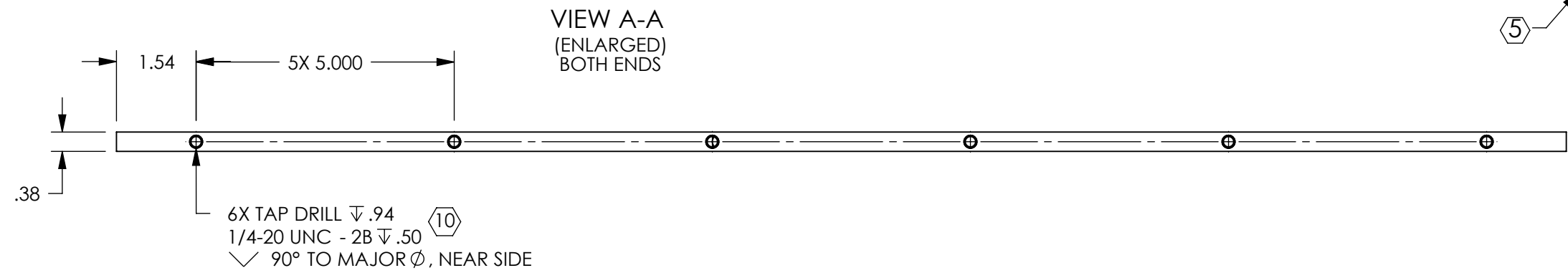
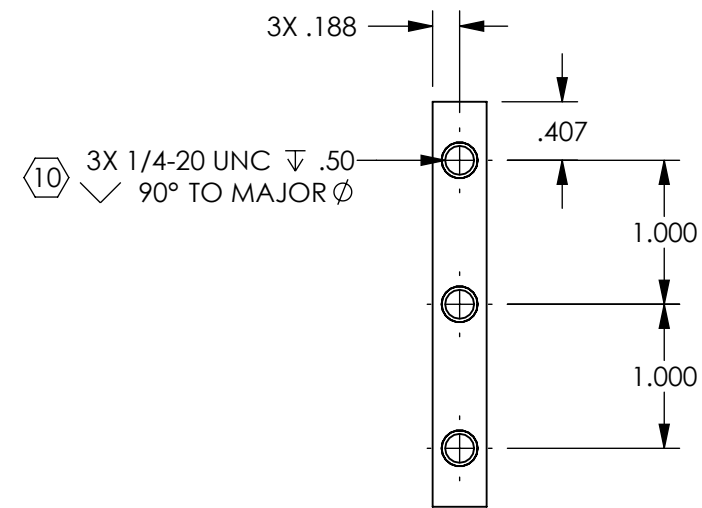
D1001163 aLIGO OPTICS TABLE GUSSET PLATE, LARGE., PART PDM REV: X-039, DRAWING PDM REV: X-054

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 = 2.27 LB [1.03 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. ALL TAPPED HOLES: OVERSIZE .005" BOTH DRILL AND TAP.
- 11. NOTED DIMENSION IS FROM ϕ .250 THRU HOLES.
- 12. BREAK DRILL THRU INDICATED WALL.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 DEC 2010	E1000762-v1	-
v2	28 FEB 2011	E1100080-v1	-
v3	24 MAR 2012	E1200317-x0	-



<p>NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)</p> <p>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.</p>		<p>LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY</p>		<p>PART NAME aLIGO OPTICS TABLE GUSSET PLATE, LARGE</p>	
<p>DIMENSIONS ARE IN INCHES</p> <p>TOLERANCES: .XX ± .01 .XXX ± .005</p> <p>ANGULAR ± 1.0°</p>		<p>MATERIAL 6061-T6 Al</p>		<p>FINISH 63 μinch Ra</p>	
<p>SYSTEM ADVANCED LIGO</p>		<p>SUB-SYSTEM AOS</p>		<p>DESIGNER K. MAILAND 11/01/2010 DRAFTER M. MILLER 11/01/2010 CHECKER SEE DCC SEE DCC APPROVAL SEE DCC SEE DCC</p>	
<p>NEXT ASSY D1001160</p>		<p>SIZE DWG. NO. B D1001163</p>		<p>REV. v3</p>	
		<p>SCALE: NONE PROJECTION: </p>		<p>SHEET 1 OF 1</p>	

8 7 6 5 4 3 2 1