REV.	DATE	DCN #	BOM #
v1	22 JUN 2011	E1100351	E1100626
-	-	-	-
-	-	-	-

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: DXXXXXXX-VY, TYPE-XX, S/N XXX

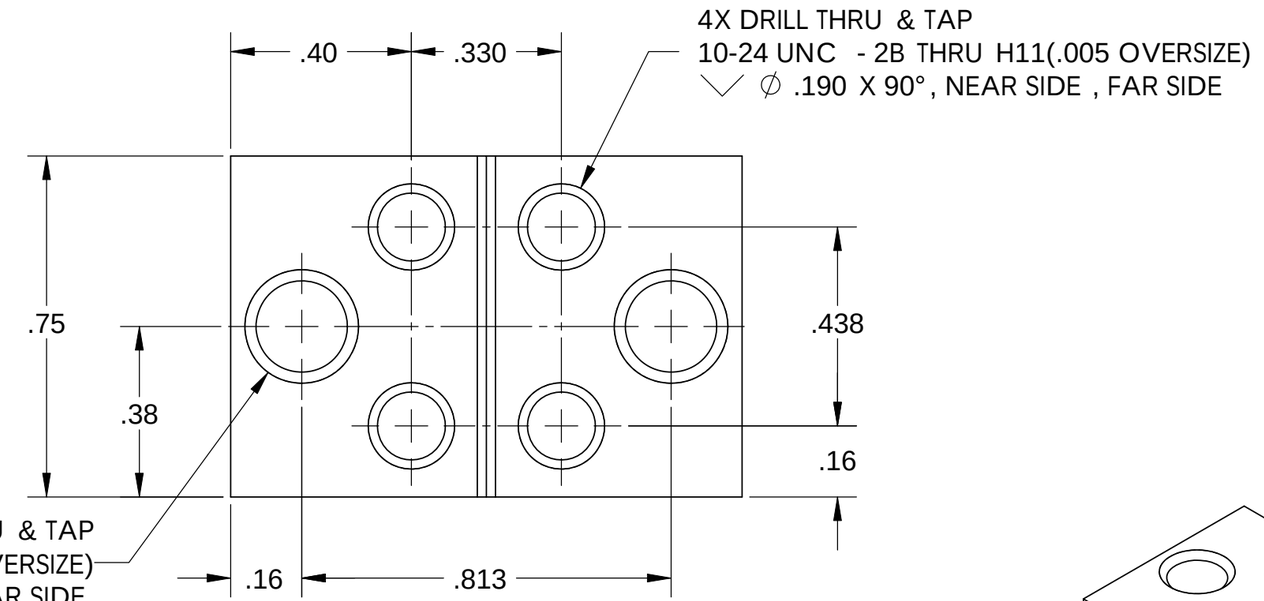
6. APPROXIMATE WEIGHT = 0.057 LBS

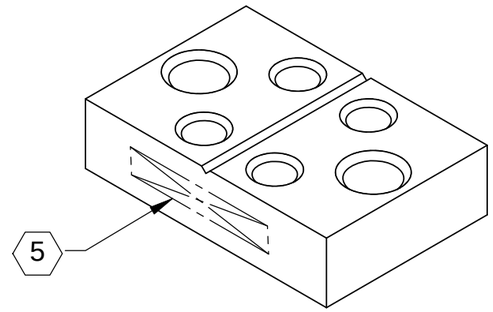
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

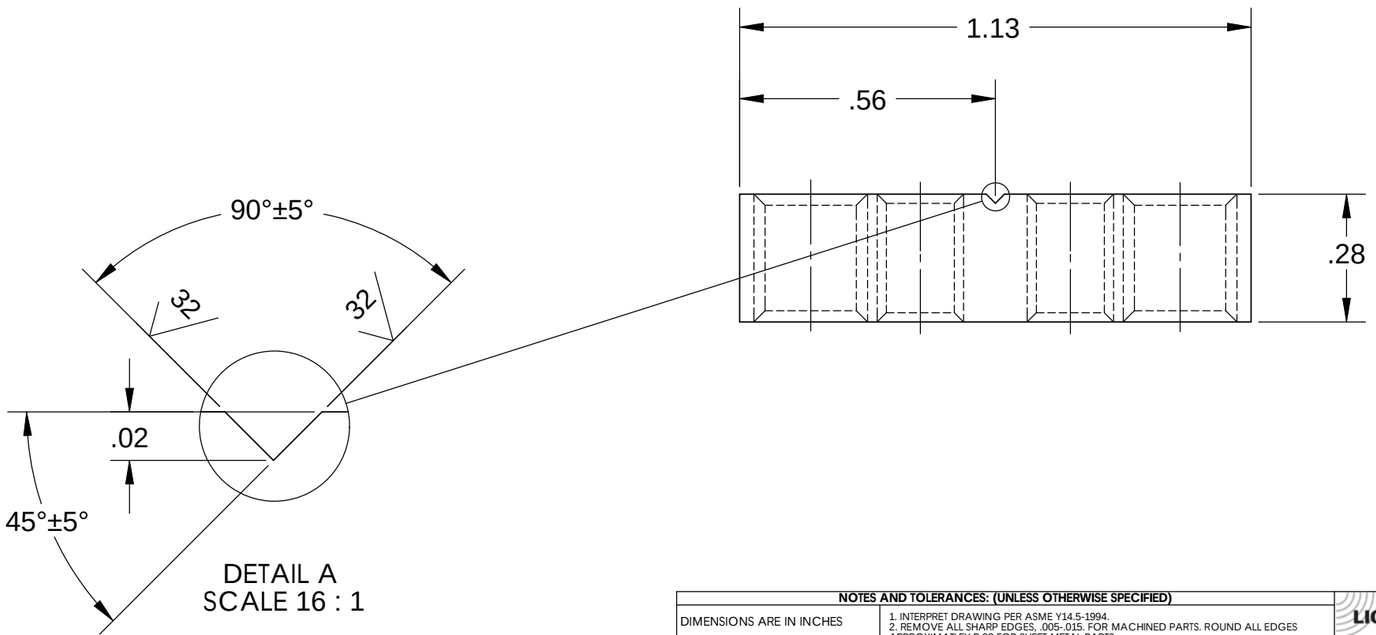
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

10. SURFACE FINISH ON ALL PART, TO BE 63 µinch Ra EXCEPT WHERE SPECIFIED.







DETAIL A
SCALE 16 : 1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)								
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .02 .XXX ± .010 ANGULAR ± 1.0°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATLEY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.			LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	aLIGO TMS TELESCOPE WIRE CLAMP BASE	
	MATERIAL: 304 SSTL	FINISH: 10 µinch Ra	NEXT ASSY: D1101162	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	DESIGNER: K. MAILAND 18 AUG 2010 DRAFTER: J. TERRAZAS 22 JUN 2011 CHECKER APPROVAL	SIZE: B DWG. NO.: D1002240 SCALE: 4:1 PROJECTION: SHEET 1 OF 1	REV.: v1

D1002240 aLIGO TMS Tele Wire Clamp Base, PART PDM REV: X-010, DRAWING PDM REV: X-000