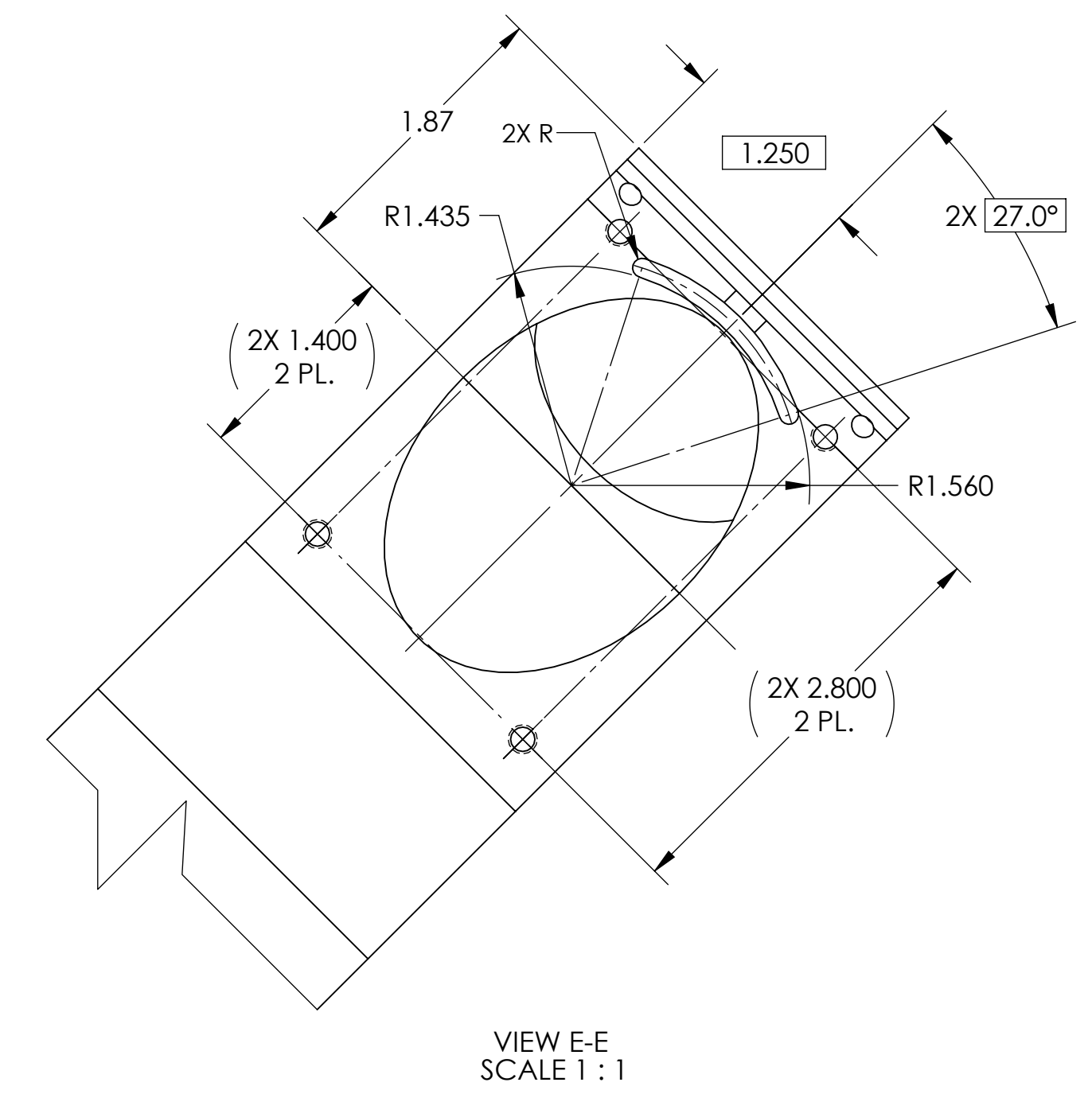
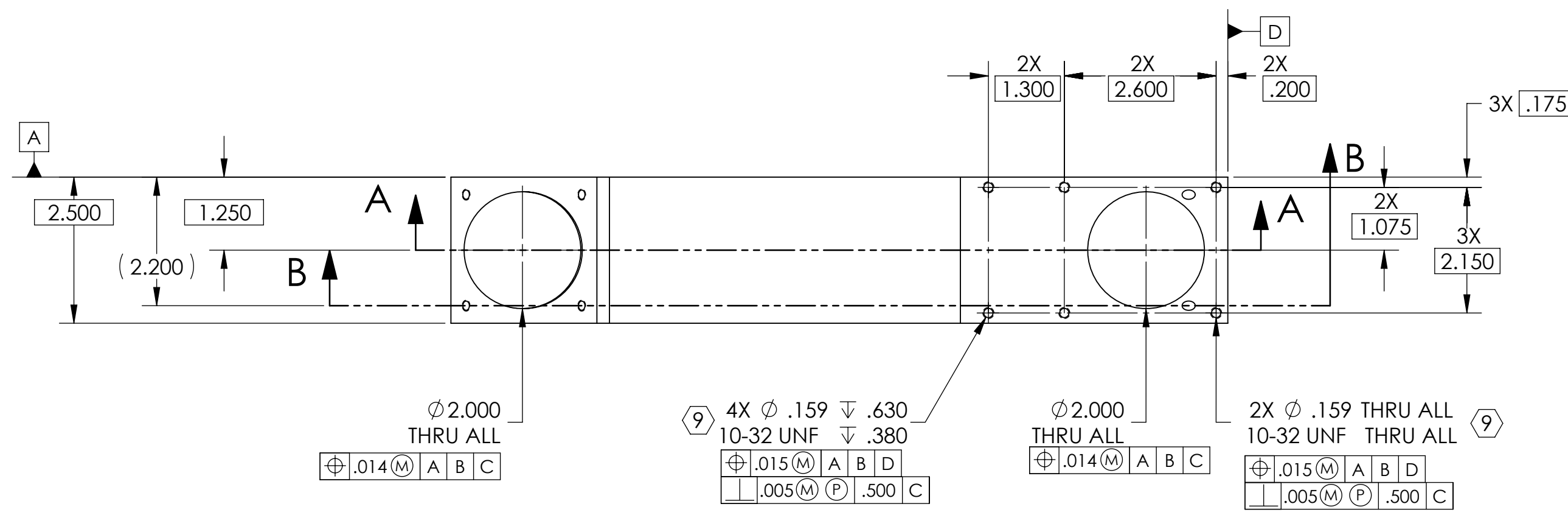
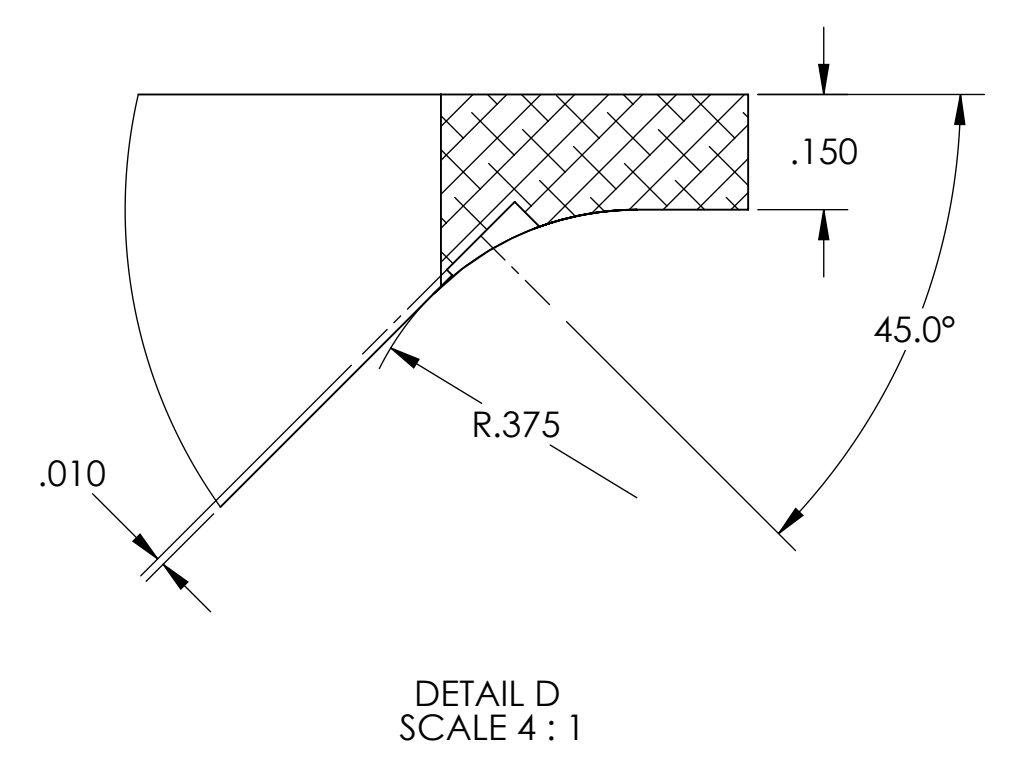
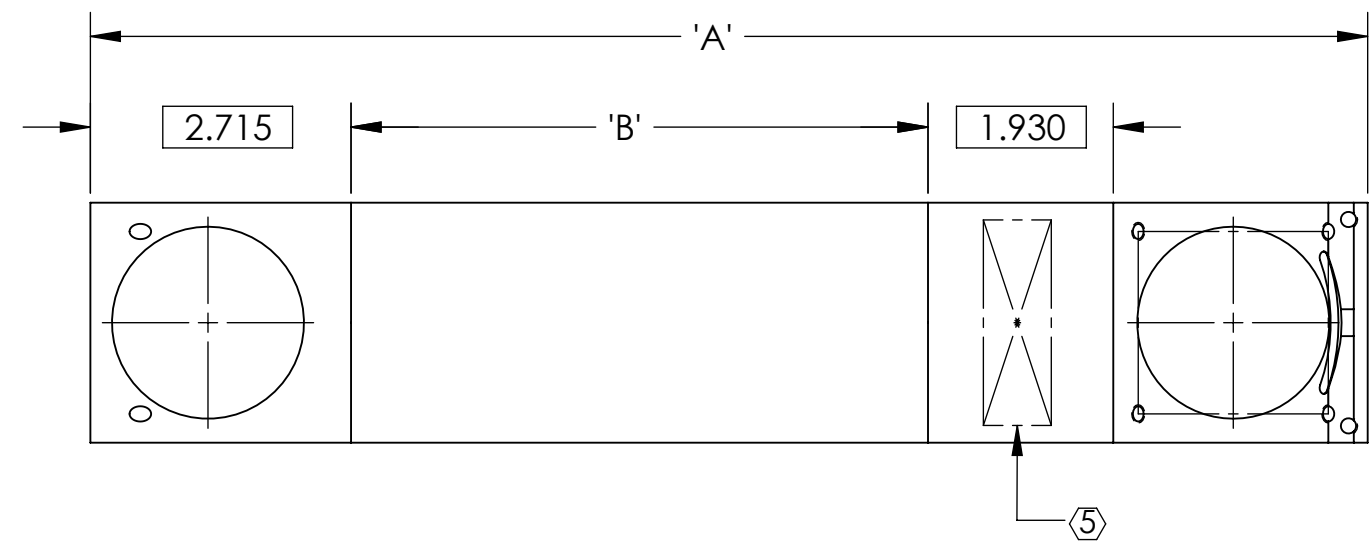
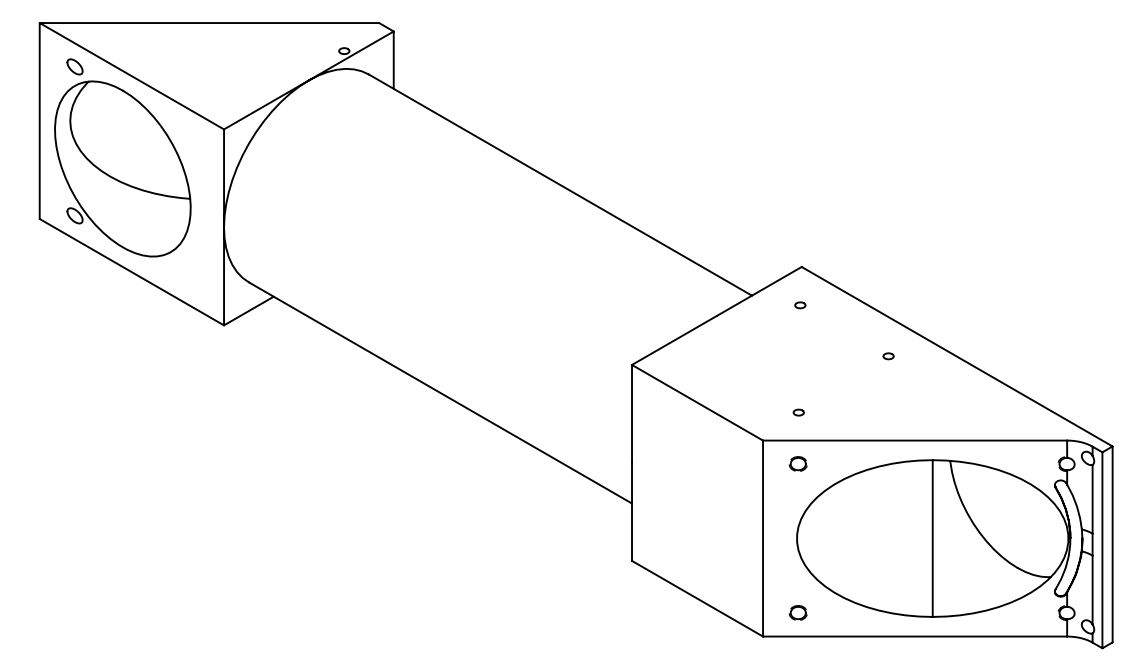
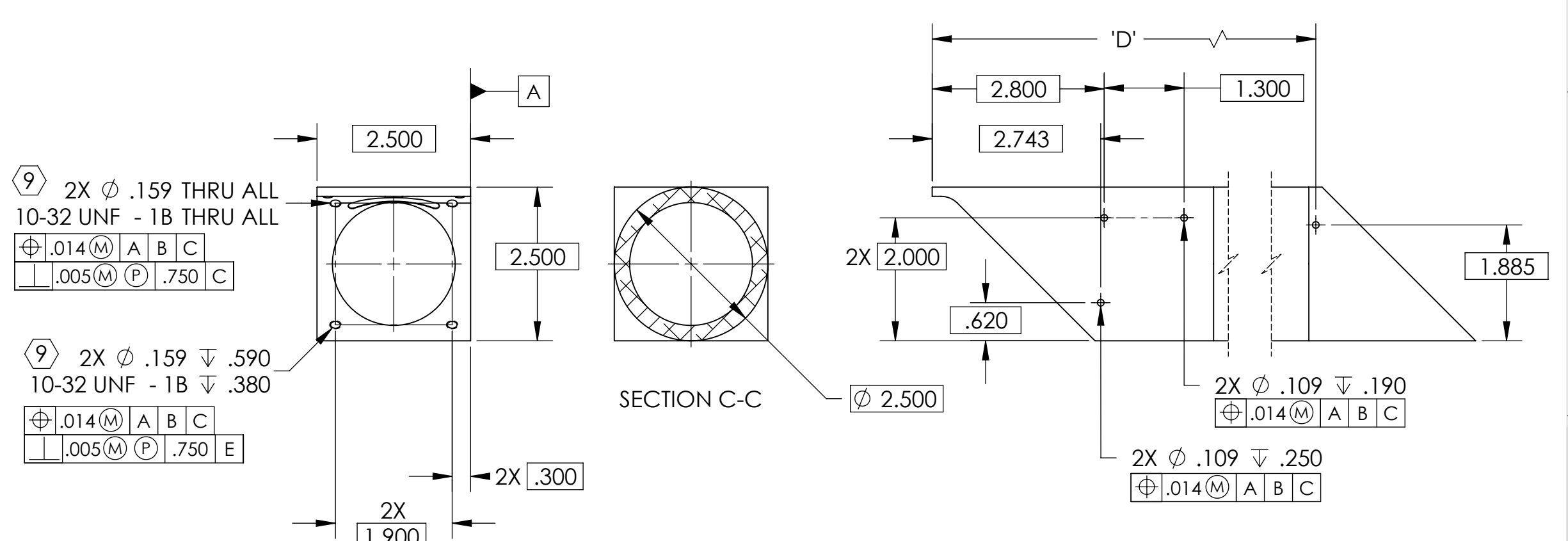
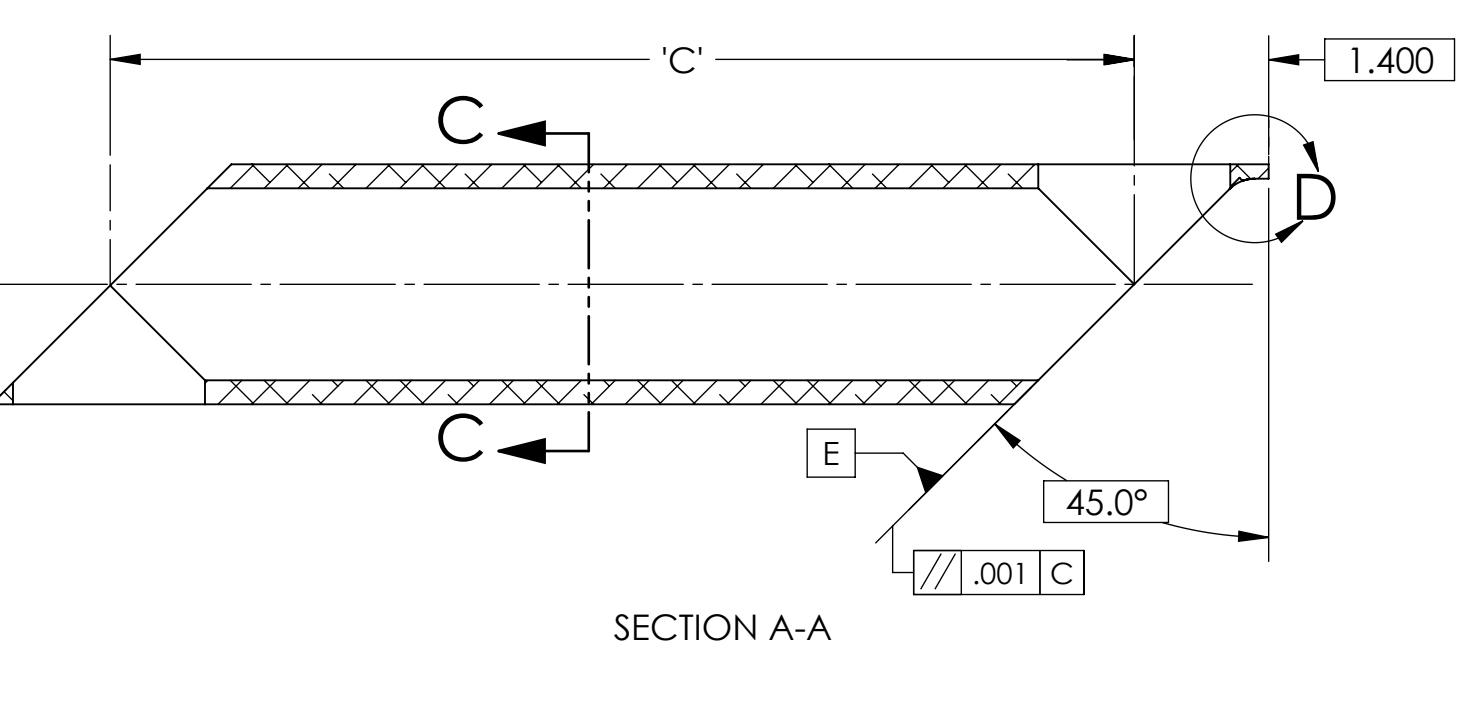
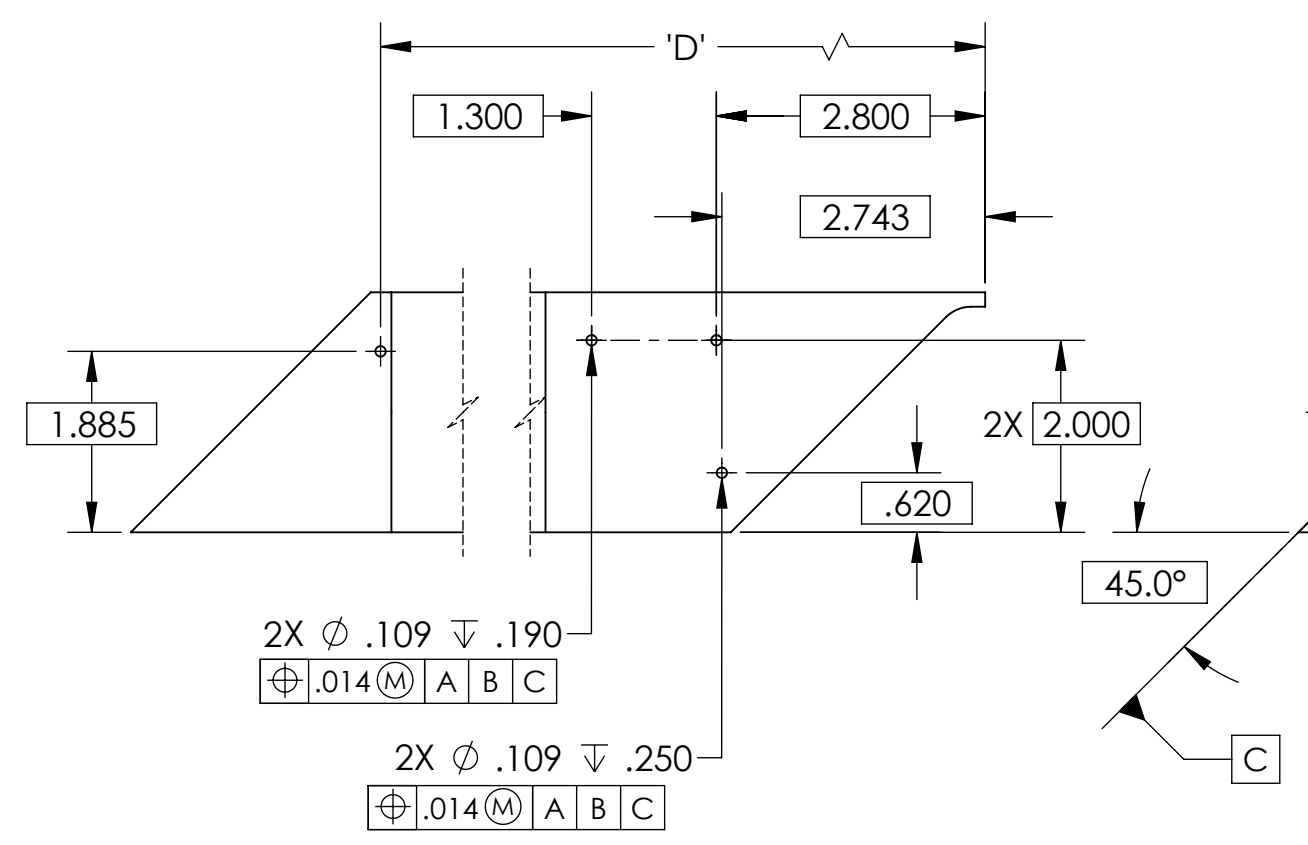
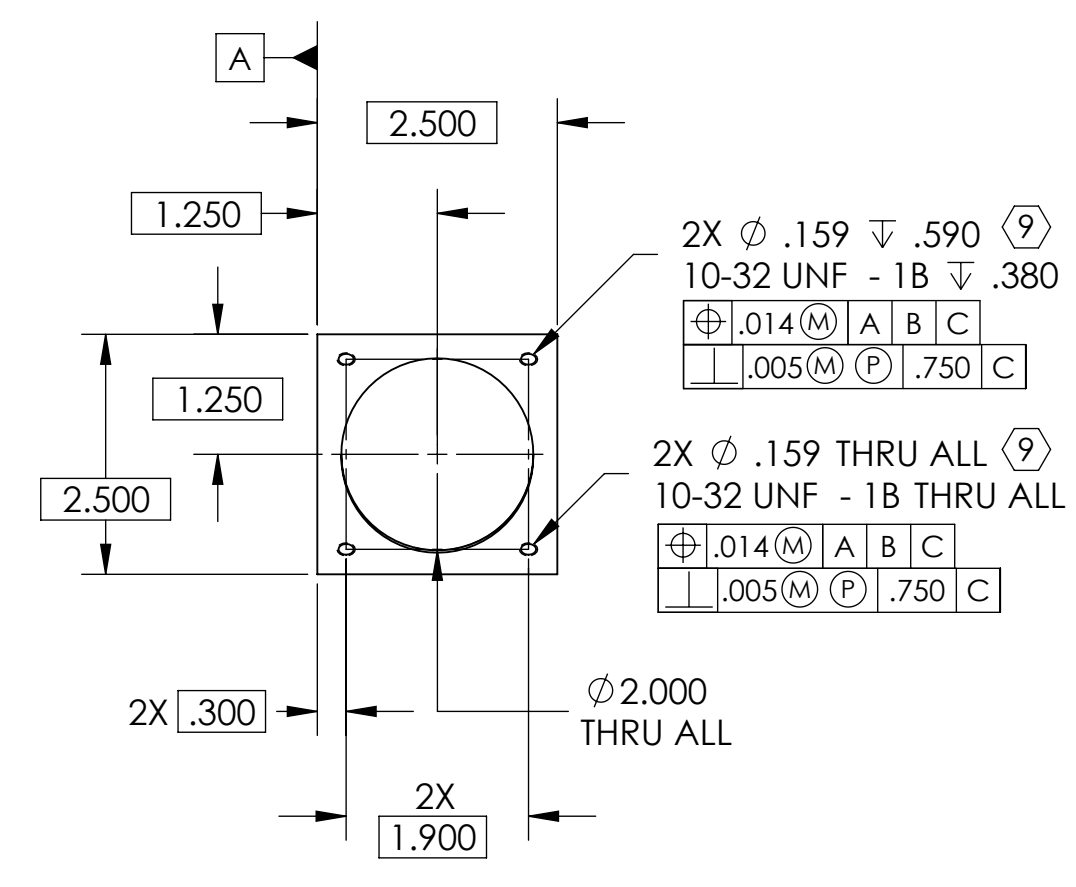
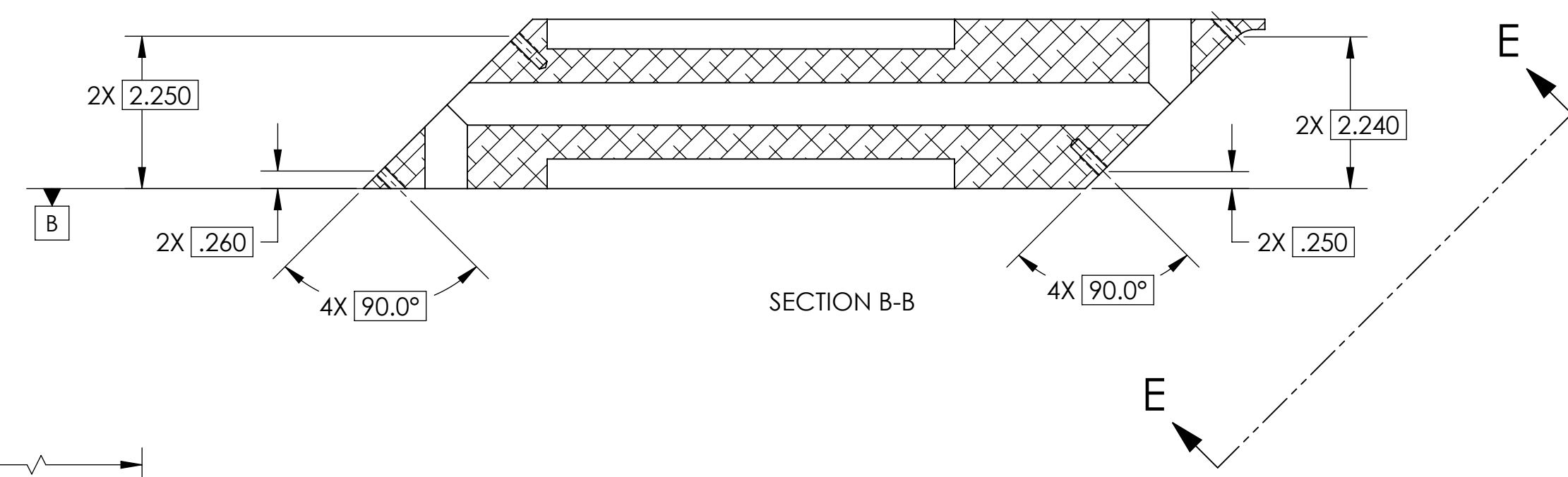


- NOTES CONTINUED:**
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 8. 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.
 9. INDICATED TAPPED HOLES .005 OVERSIZE BOTH DRILL AND TAP.
 10. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .015-.030.

REV.	DATE	DCN #	DRAWING TREE #
v1	13 APR 2010	E1100356-x0	-
-	-	-	-
-	-	-	-



PERISCOPE LENGTH & APPLICATION						
PART NO.	'A'	'B'	'C'	'D'	'USED ON'	APPROX. WIEGHT
D1002259	13.305	6.010	10.680	10.703	BSC2-L1, BSC2-H1	2.8 LB
D1002259-1	8.346	1.050	5.721	5.743	BSC4-H2	1.32 LB
D1002259-2	18.362	11.063	15.737	15.755	BSC7-H2, BSC8-H2	3.1 LB



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY 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.

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 1.0°

MATERIAL	6061-T6 (SS)	FINISH	63 μinch	SYSTEM	ADVANCED LIGO	SUB-SYSTEM	OPLEV	PART NAME	ALIGO, OPLEV, PERISCOPE, OPTICAL BOX		
NEXT ASSY	D1002260	DESIGNER	L.ROMERO	DATE	21 FEB 2011	SIZE	D	DWG. NO.	D1002259		
DRAFTER	E.SANCHEZ	DATE	04 APR 2011	CHECKER	J.LEWIS	DATE	10 MAY 2011	APPROVAL			
SCALE	1:2	PROJECTION			SHEET 1 OF 1						

D1002259-ALIGO OPLEV PERISCOPE BOX 2.5 IN SQ. X 12.1 PART PDM REV: X-008, DRAWING PDM REV: X-004