

D1002504 TMS, SISKIYOU MOUNT BRACKET, LOWER OUTBOARD, PART PDM REV: X-014, DRAWING PDM REV: X-011

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 = .23 LB [.10 KG].

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

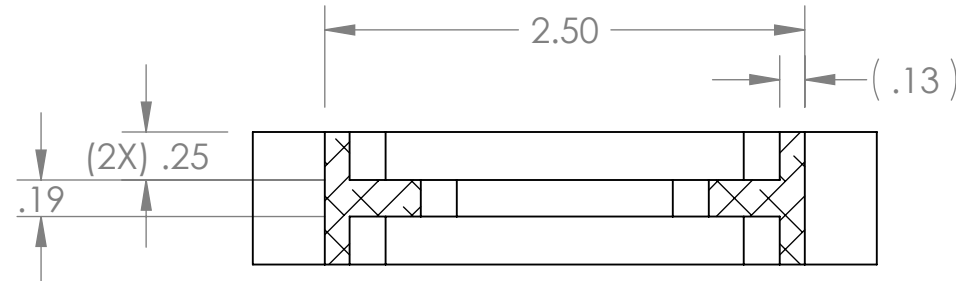
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. 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.

10. NOTED HOLE: .005" OVERSIZE BOTH DRILL & TAP.

11. AT NOTED LOCATIONS, DRILL THRU FOR 3/16 DOWEL PIN, LIGHT PRESS FIT (LPF). PINS TO BE INSTALLED BY LIGO, AS NOTED, POST CLEAN & BAKE. INSTALL MCMASTER-CARR P/N 97395A455 OR EQUIVALENT.

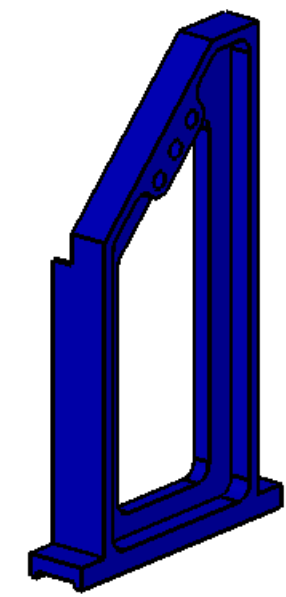
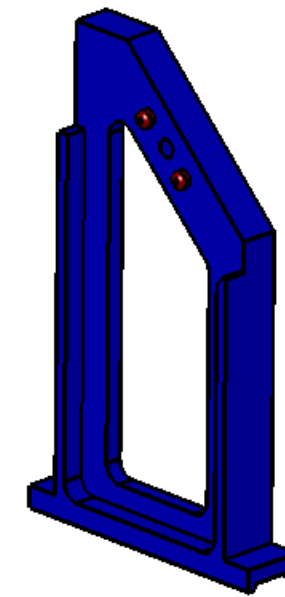
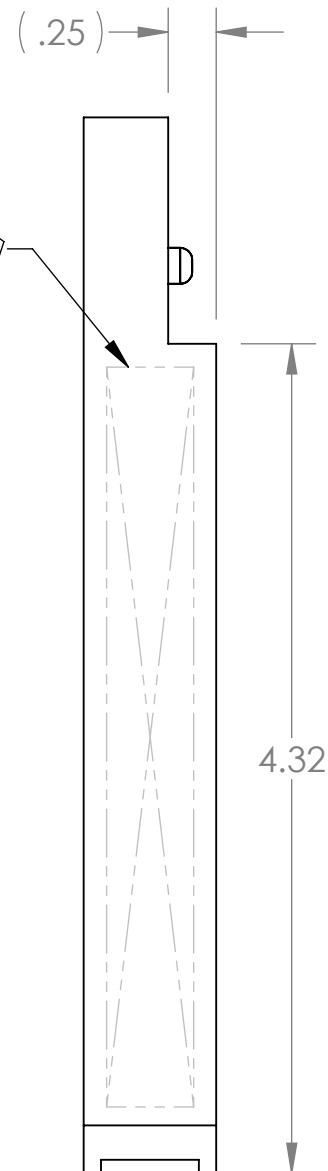
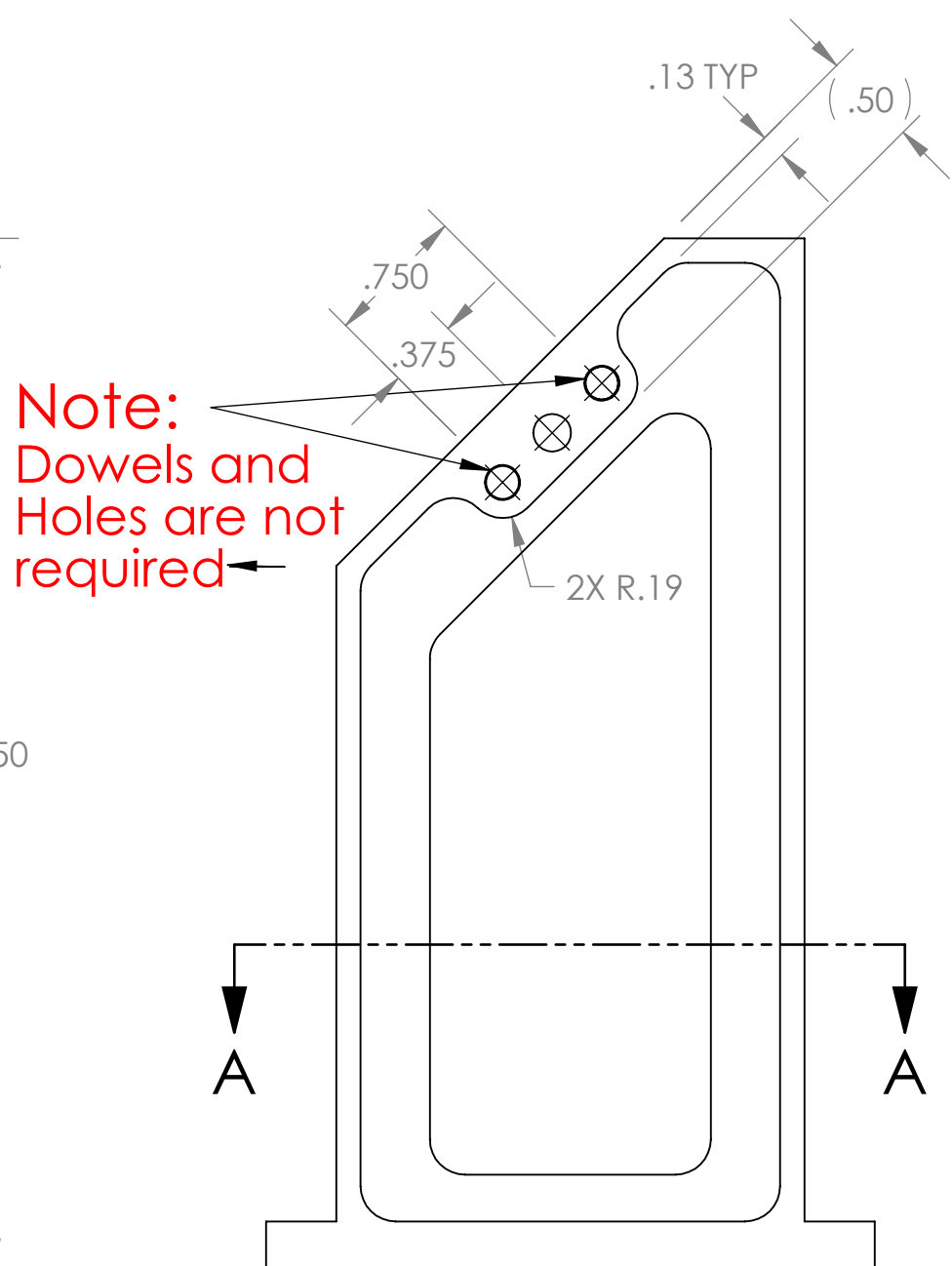
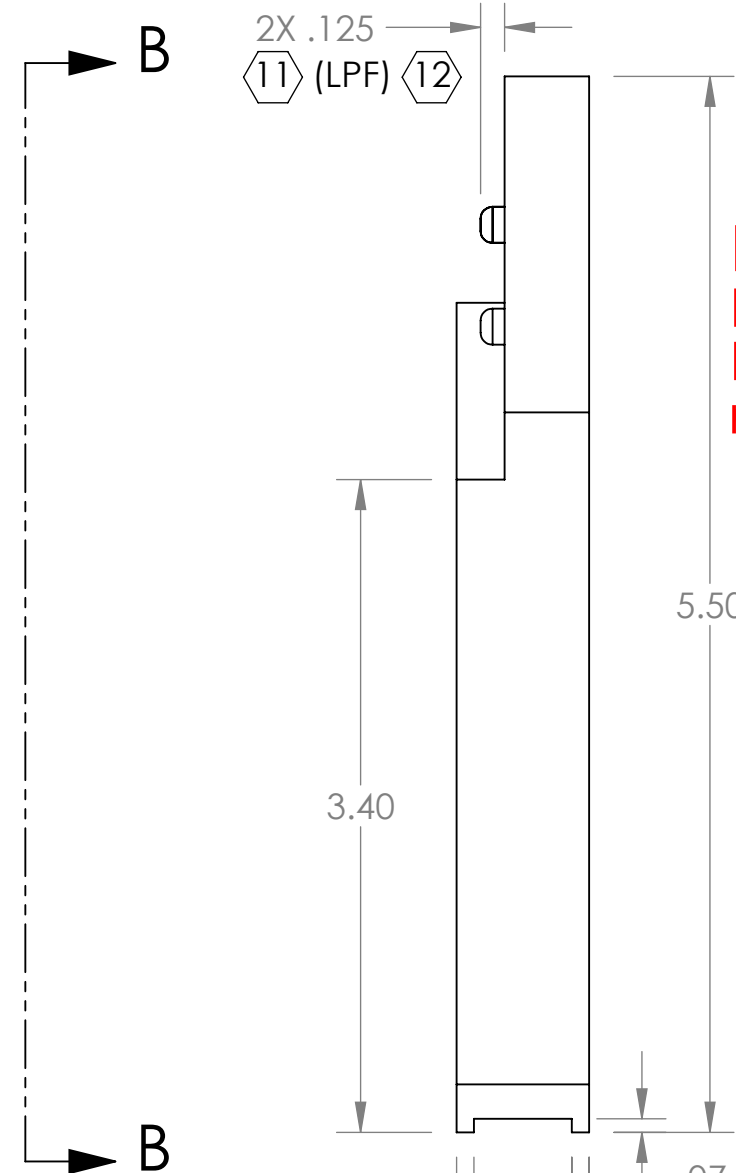
12. FOR FIRST ARTICLE (S/N 001): PINS ARE PRE-INSTALLED (BEFORE CLEAN & BAKE). DO NOT REMOVE.



SECTION A-A

(2X) .38

Note: Dowels and Holes are not required



REV.	DATE	DCN #	DRAWING TREE #
v1	25 APR 2011	E1100351-v1	-
v2	10-26-12	to follow	-
-	-	-	-

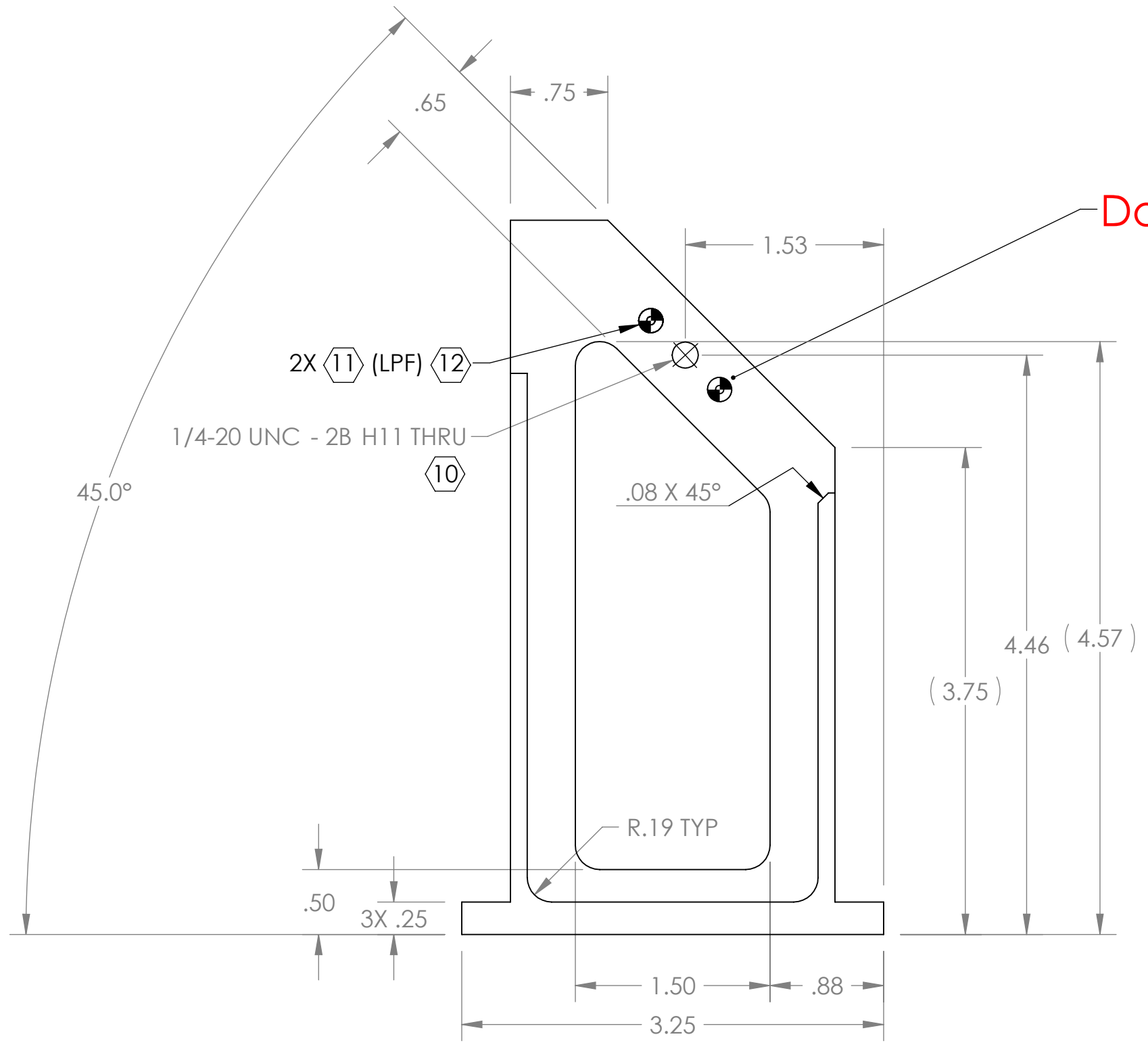
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± 0.5°	
MATERIAL	6061-T6 Al
FINISH	63 μinch Ra

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SYSTEM	ADVANCED LIGO
SUB-SYSTEM	AOS
NEXT ASSY	D1000484

PART NAME		TMS, SISKIYOU MOUNT BRACKET, LOWER OUTBOARD	
DESIGNER	I. ROMERO	23 SEP 2010	SIZE DWG. NO.
DRAFTER	M. MILLER	25 APR 2011	B D1002504
CHECKER	k mailand	10-26-12	REV.
APPROVAL			v2
SCALE: NONE		PROJECTION:	
		SHEET 1 OF 2	

D1002504 TMS, SISKIYOU MOUNT BRACKET, LOWER OUTBOARD, PART PDM REV: X-014, DRAWING PDM REV: X-011



Dowel pins not required

VIEW B-B

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SIZE	DWG. NO.	REV.
B	D1002504	v2
SCALE: NONE	PROJECTION:	SHEET 2 OF 2