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 = .47 LB [.21 KG].

⟨7⟩ ELECTROPOLISH TO REMOVE .0005-.001 FROM ALL SURFACES.

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.

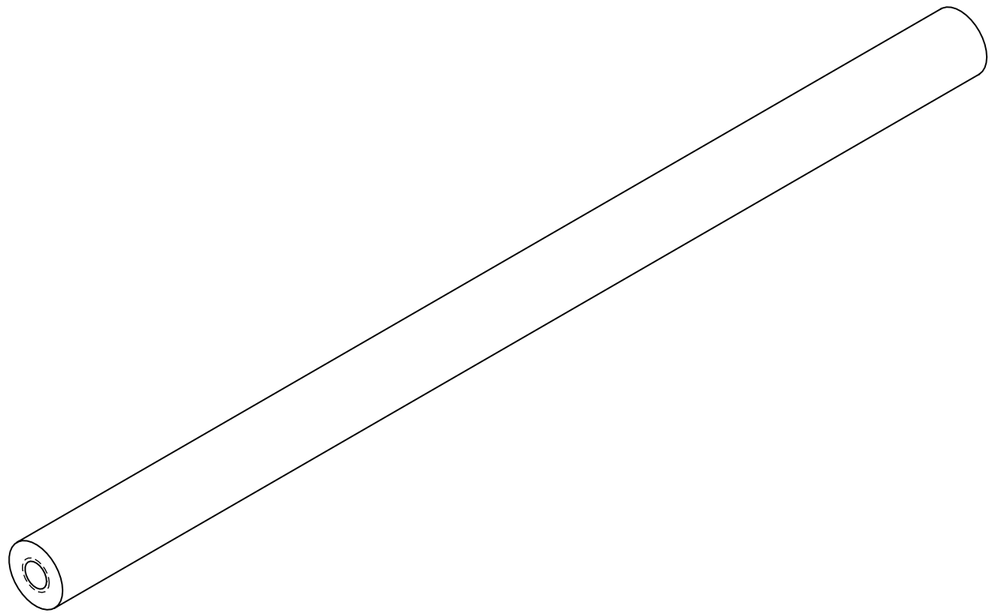
10. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTITIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

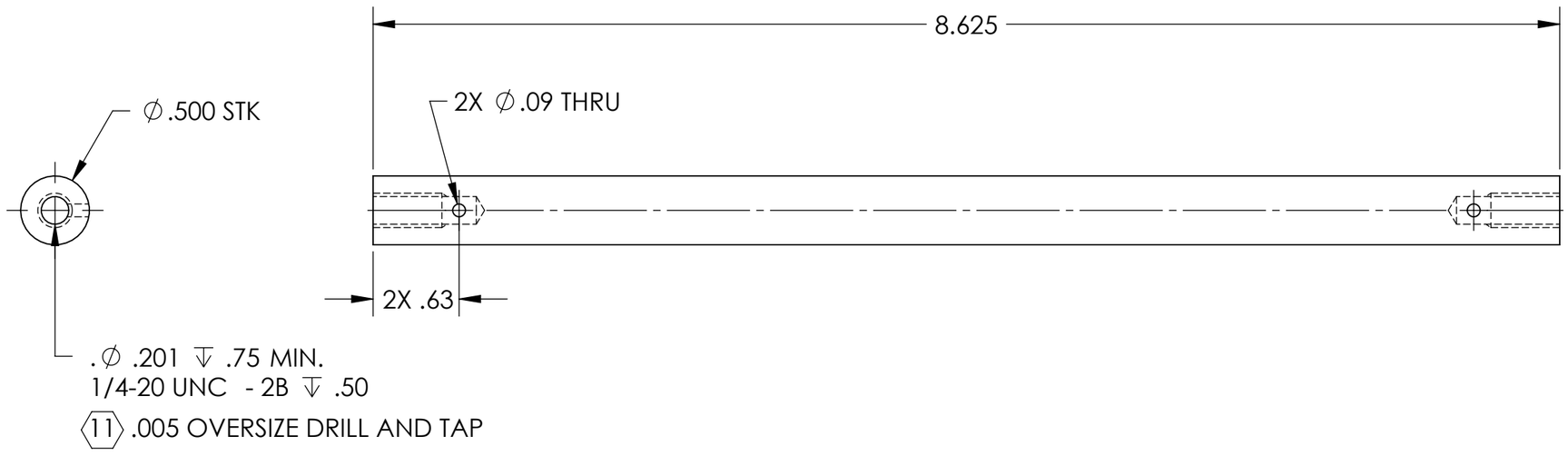
⟨11⟩ TAPPED HOLES: .005" OVERSIZE BOTH DRILL AND TAP.

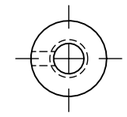
⟨12⟩ MATERIAL: MAKE FROM MCMASTER-CARR P/N 1255T34 (OR EQUIV)
Ø.5000" +0/-.0002" X 6', .006"/FT STRAIGHTNESS, TYPE 304 STAINLESS STEEL.

⟨13⟩ 63 µINCH Ra FINISH APPLIES ONLY TO 2 PLANAR END FACES.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 DEC 2010	E1000762-v1	-
v2	26 MAR 2012	E1200317-x0	-
-	-	-	-







NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1.0°	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.				
	MATERIAL ⟨12⟩	FINISH ⟨7⟩ ⟨13⟩	NEXT ASSY D1001160	SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME: aLIGO TMS TELESCOPE ROLL SLIDE ROD

DESIGNER	K. MAILAND	15 OCT 2010	SIZE: B	DWG. NO.: D1002755	REV.: v2
DRAFTER	M. MILLER	15 NOV 2010			
CHECKER	SEE DCC	SEE DCC			
APPROVAL	SEE DCC	SEE DCC	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1

D1002755 aLIGO_TMS_Telescope_Roll_Slide_Rod, PART PDM REV: X-013, DRAWING PDM REV: X-020