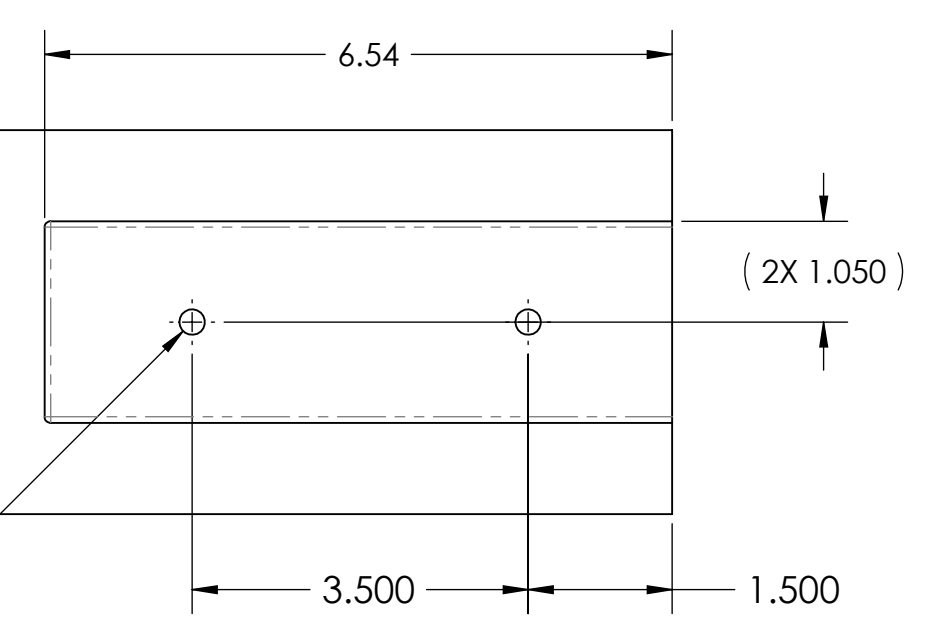
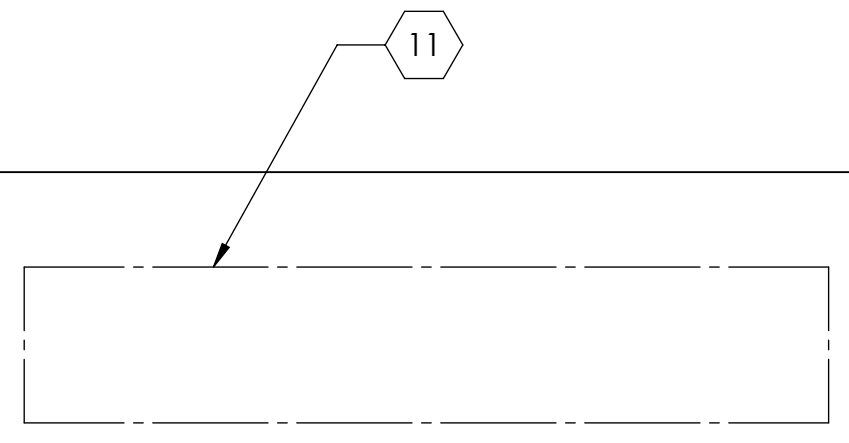
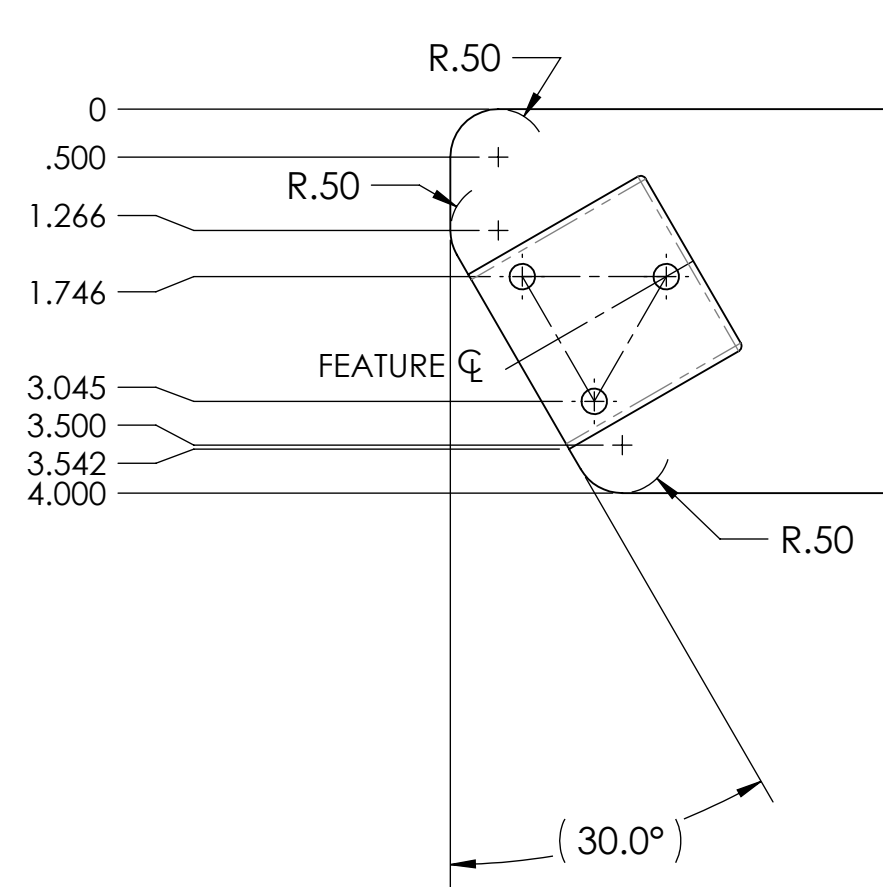
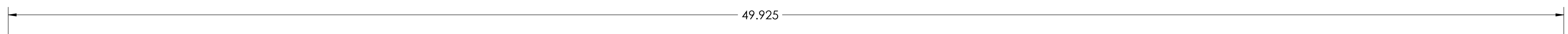
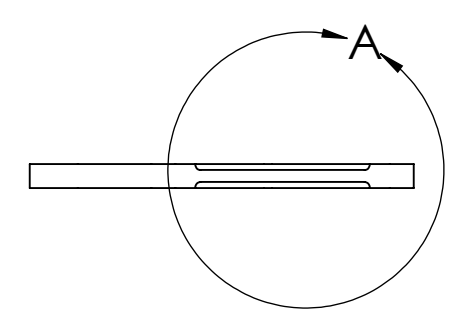
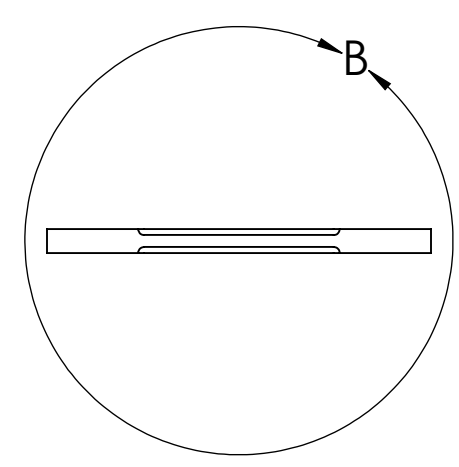
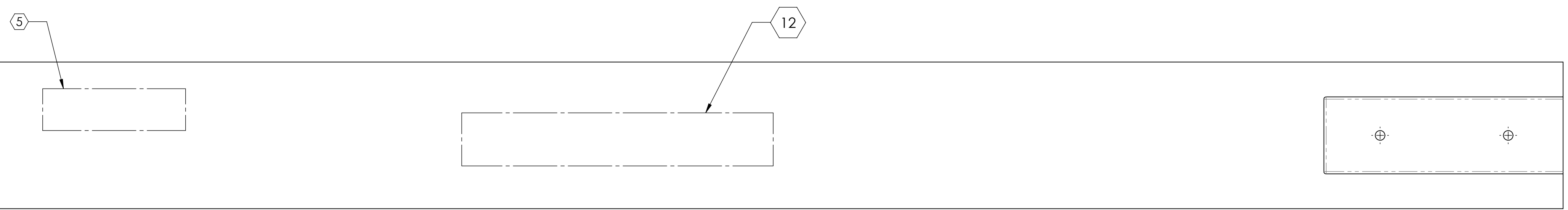
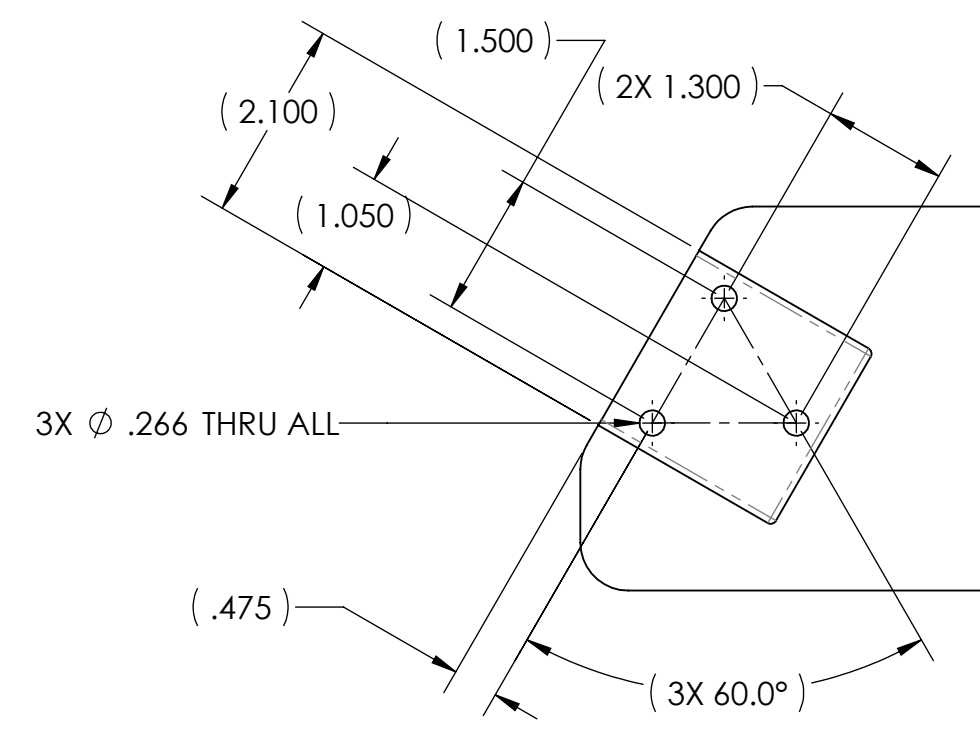
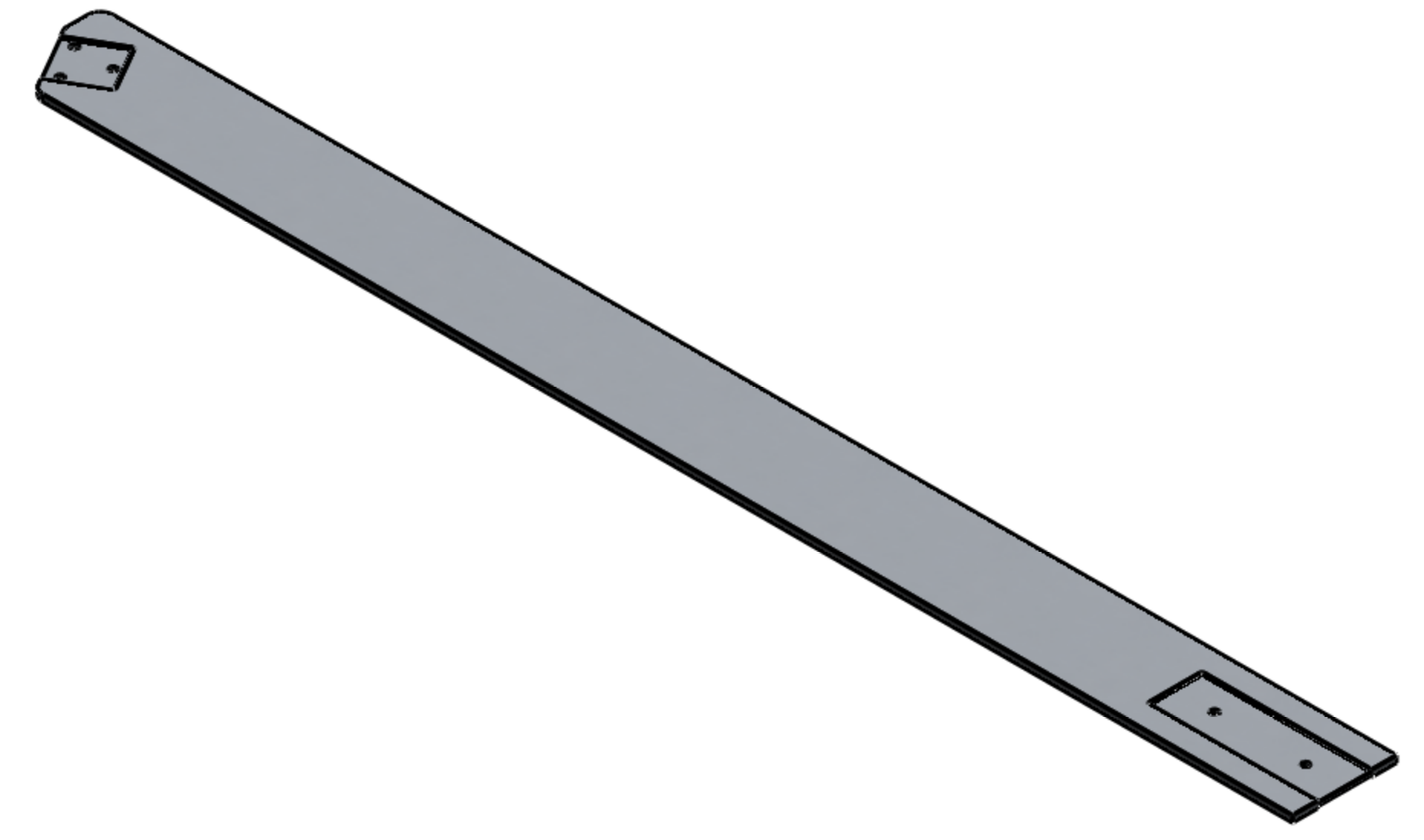
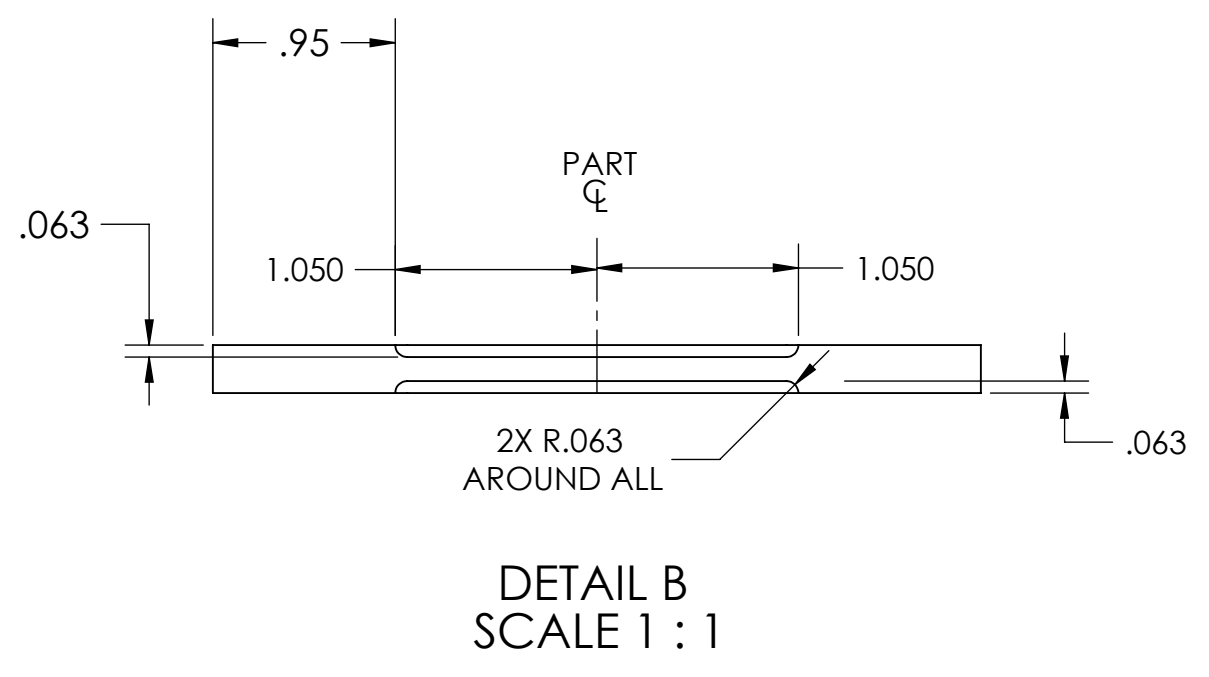
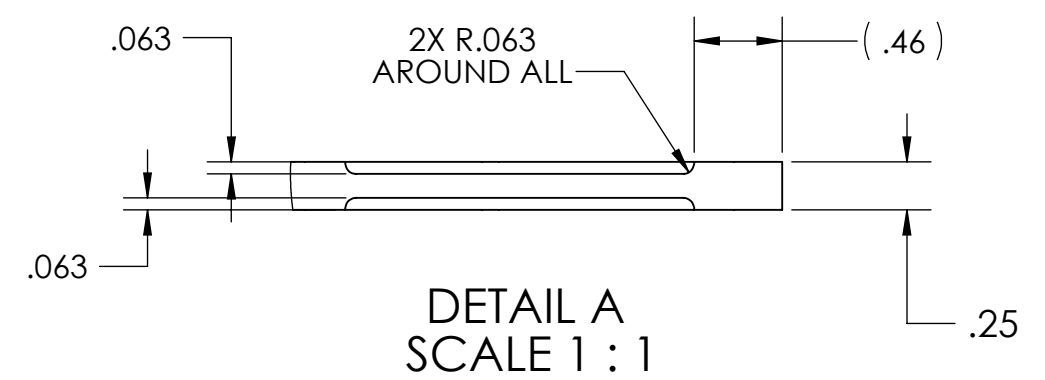


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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 = 4.596 LB.
 - 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 TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
 - 11. SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP THE FOLLOWING TEXT: "THIS SIDE UP, B5C8" USE MINIMUM 0.25" HIGH CHARACTERS
 - 12. SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP THE FOLLOWING TEXT: "THIS SIDE UP, B5C7" USE MINIMUM 0.25" HIGH CHARACTERS

REV.	DATE	DCN #	DRAWING TREE #
v2	16 FEB 2011	E1000883-v2	E1000884-v2



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME			
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED 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.		ADVANCED LIGO		αLIGO TCS LONG BASE TEMPLATE	
MATERIAL 6061 Alloy		FINISH 63 μinch		SYSTEM AOS		DESIGNER M. JACOBSON	
ANGULAR ± 0.5°		NEXT ASSY D1100293		CHECKER J. LEWIS		DATE 14 FEB 2011	
DIMENSIONS ARE IN INCHES		SCALE 1:8		APPROVAL P. WILLEMS		PROJECTION 	
DIMENSIONS ARE IN INCHES		SIZE D		DWG. NO. D1100297		REV. v2	
DIMENSIONS ARE IN INCHES		DATE 16 FEB 2011		SCALE 1:8		SHEET 1 OF 1	

D1100297_αLIGO TCS LONG BASE TEMPLATE PART PDM REV: X-002 DRAWING PDM REV: X-003