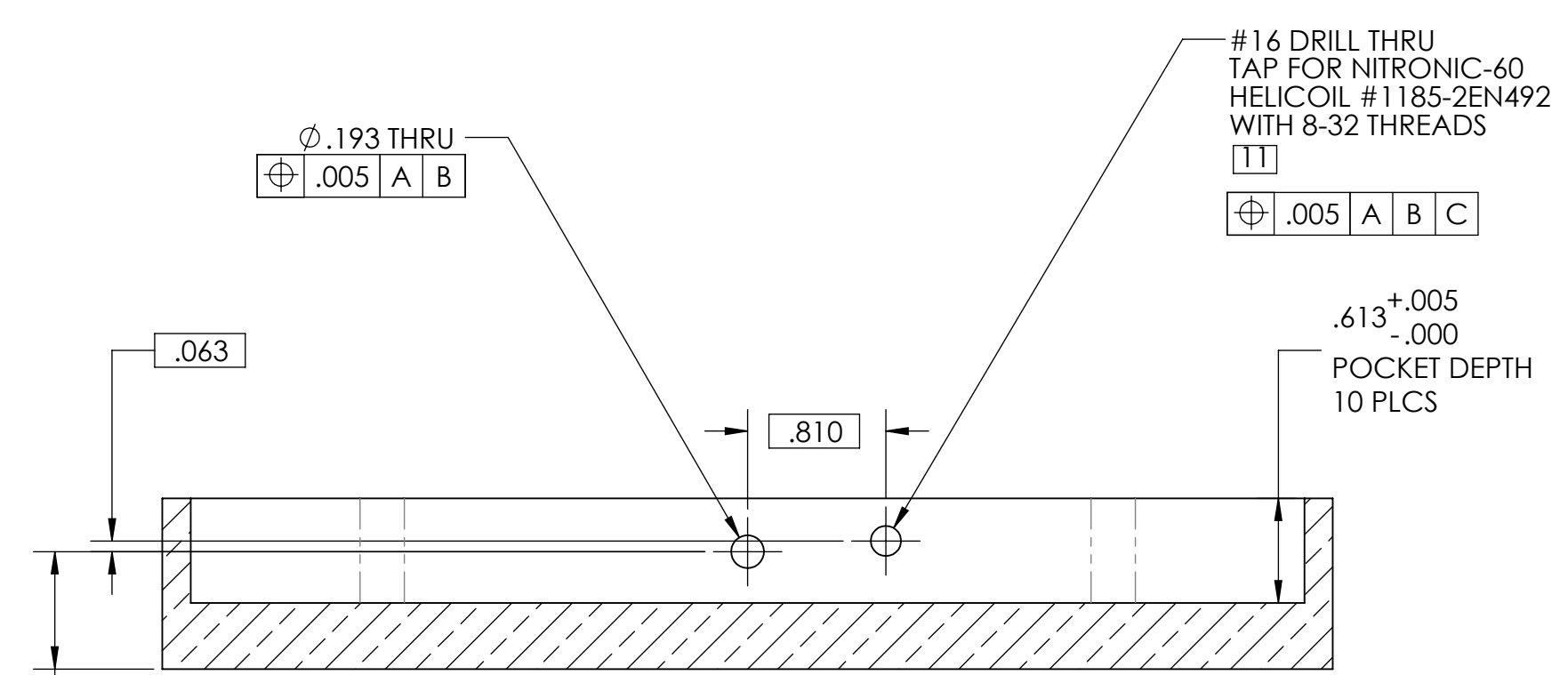


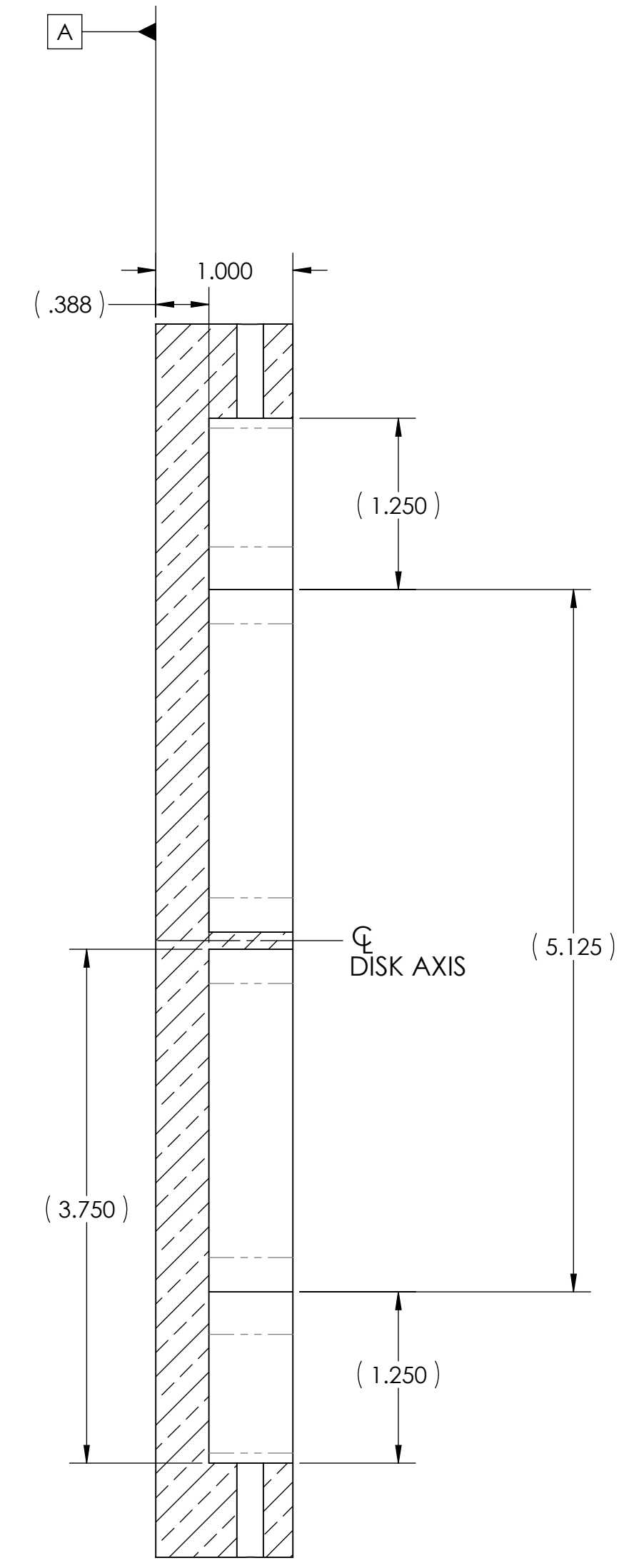
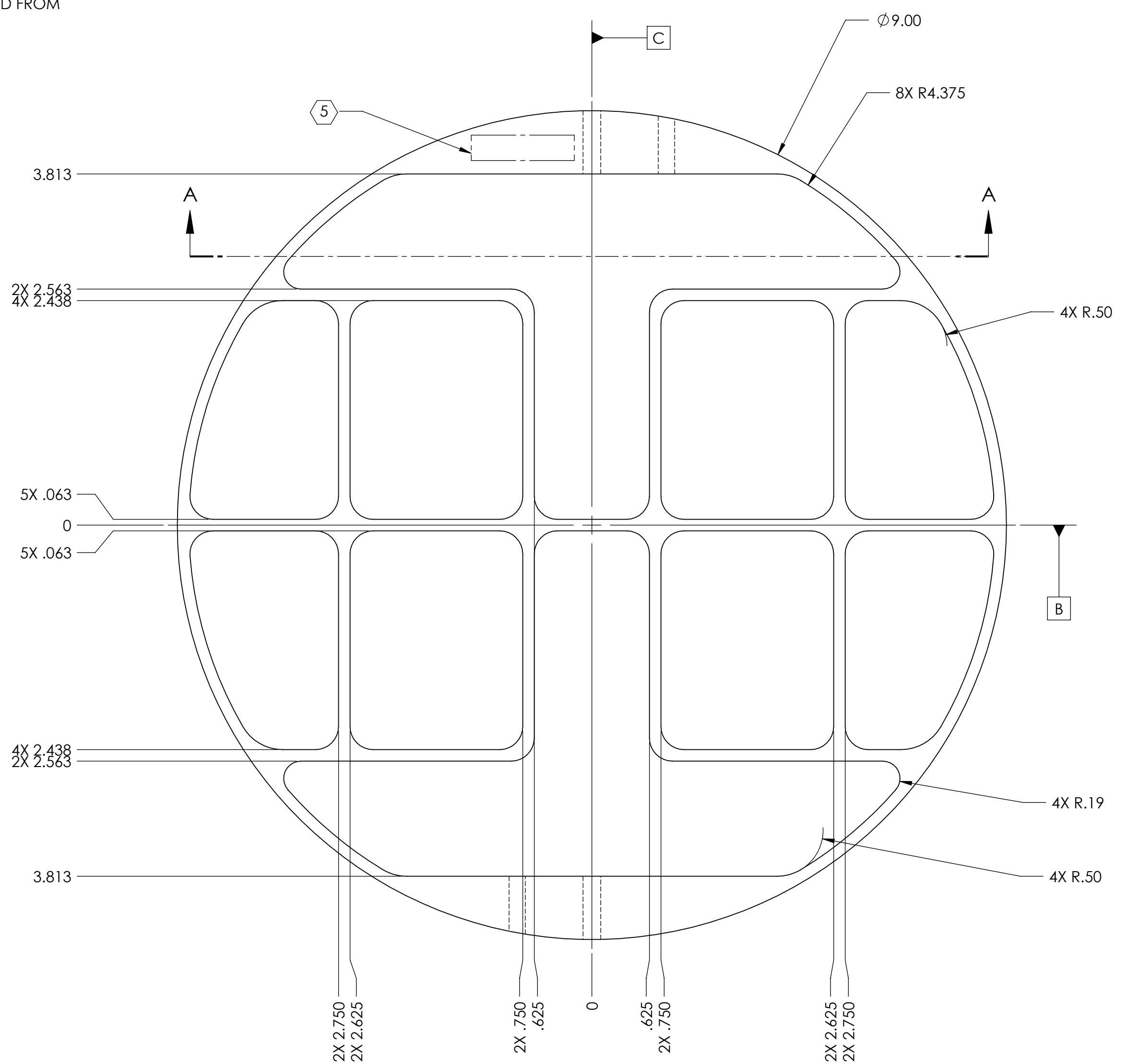
NOTES CONTINUED:
 5) SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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 = 9.0 LB
- 7 ALL RADIUS FEATURES ARE .25 UNLESS OTHERWISE NOTED
- 8 MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 9 (LAMBDA/10) FINISH FOR 10.6 um LASER 99% REFLECTIVITY, 20-10 SCRATCH-DIG HARD GOLD COATING
- 10 ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 11 ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
- 12 ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
- 13 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.
- 14 SUBSTRATE MATERIAL SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

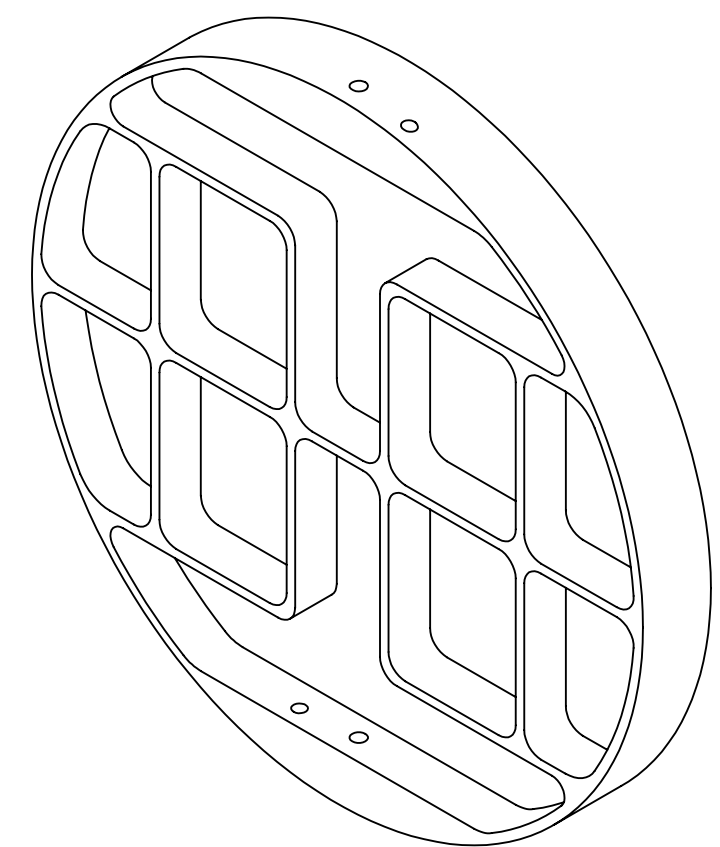
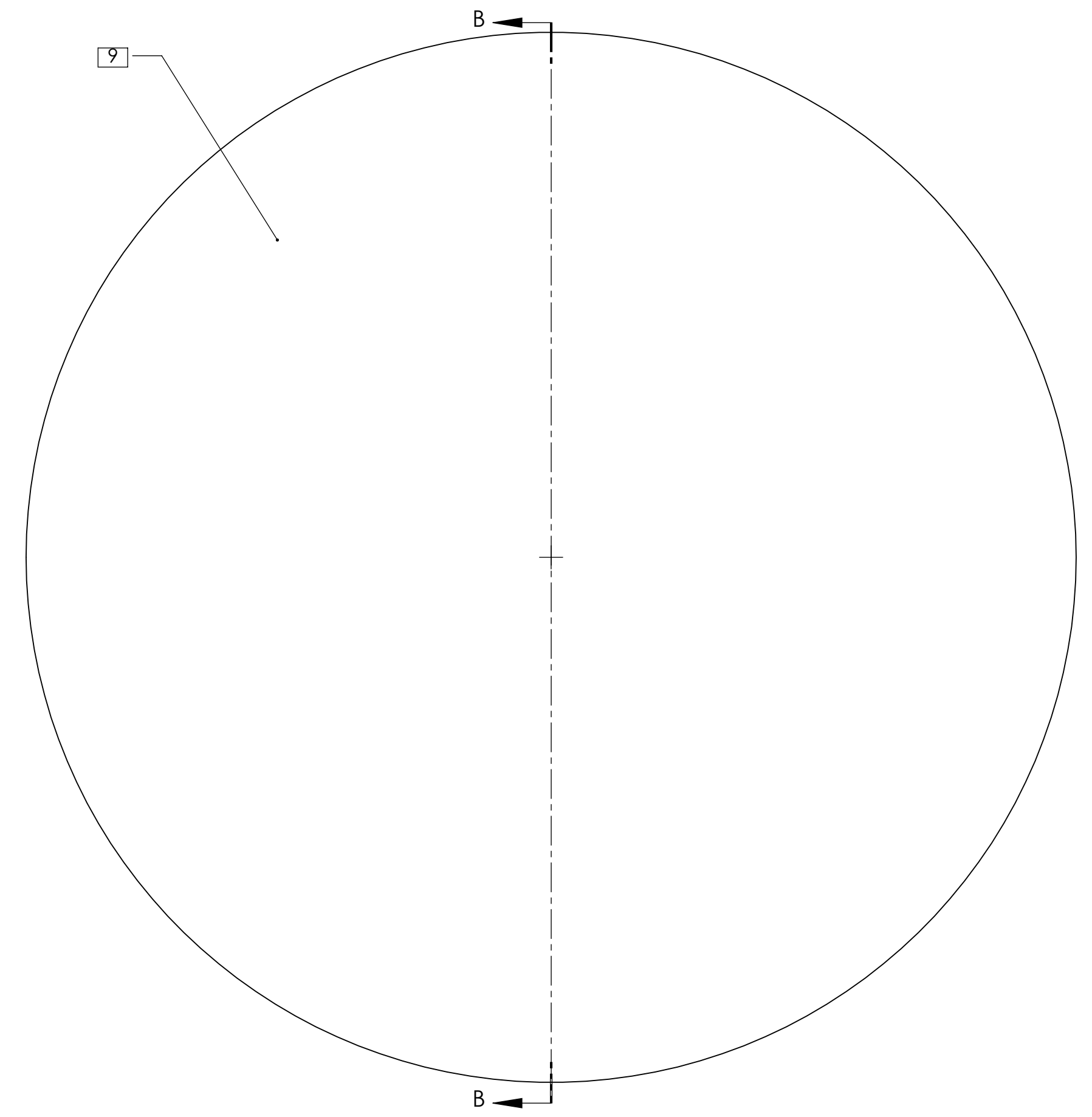
REV.	DATE	DCN #	DRAWING TREE #
v4	10-SEPT-2011	E1100682-v1	



SECTION A-A
 SCALE 1 : 1
 2X
 FEATURES REVOLVED ABOUT DISK AXIS OF PART



SECTION B-B
 SCALE 1 : 1



DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± .02 .XXX ± .004		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.		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
ANGULAR ± 1.0°		MATERIAL		NEXT ASSY		DESIGNER M. JACOBSON 27 MAY 2011 DRAFTER M. JACOBSON 25 AUG 2011 CHECKER J. LEWIS 26 AUG 2011 APPROVAL A. BROOKS 25 AUG 2011	
		Cu, 110 ALLOY		D1101013		SIZE DWG. NO. D D1101014	
		63 μinch				REV. v4	
						SCALE: 1:4 PROJECTION: SHEET 1 OF 1	

D1101014_LIGO TCS CO2P STEERING MIRROR 1, H1-L1, PART PDM REV: X-032, DRAWING PDM REV: X-018

25 AUG 2011