

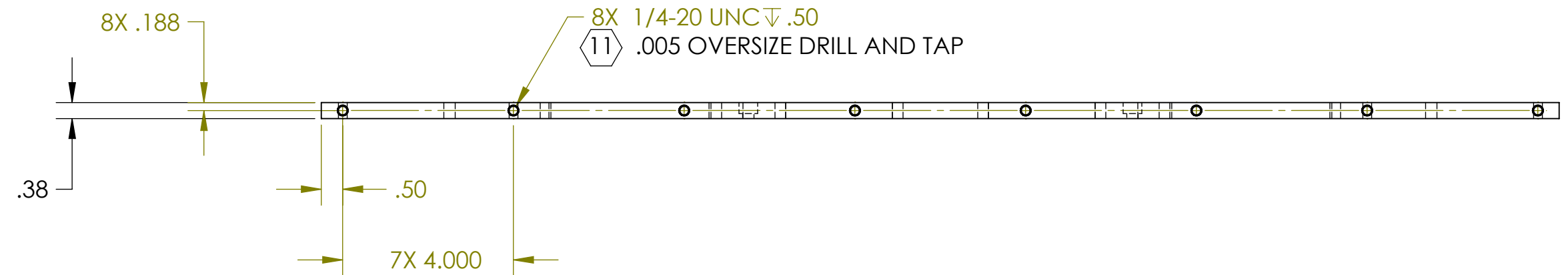
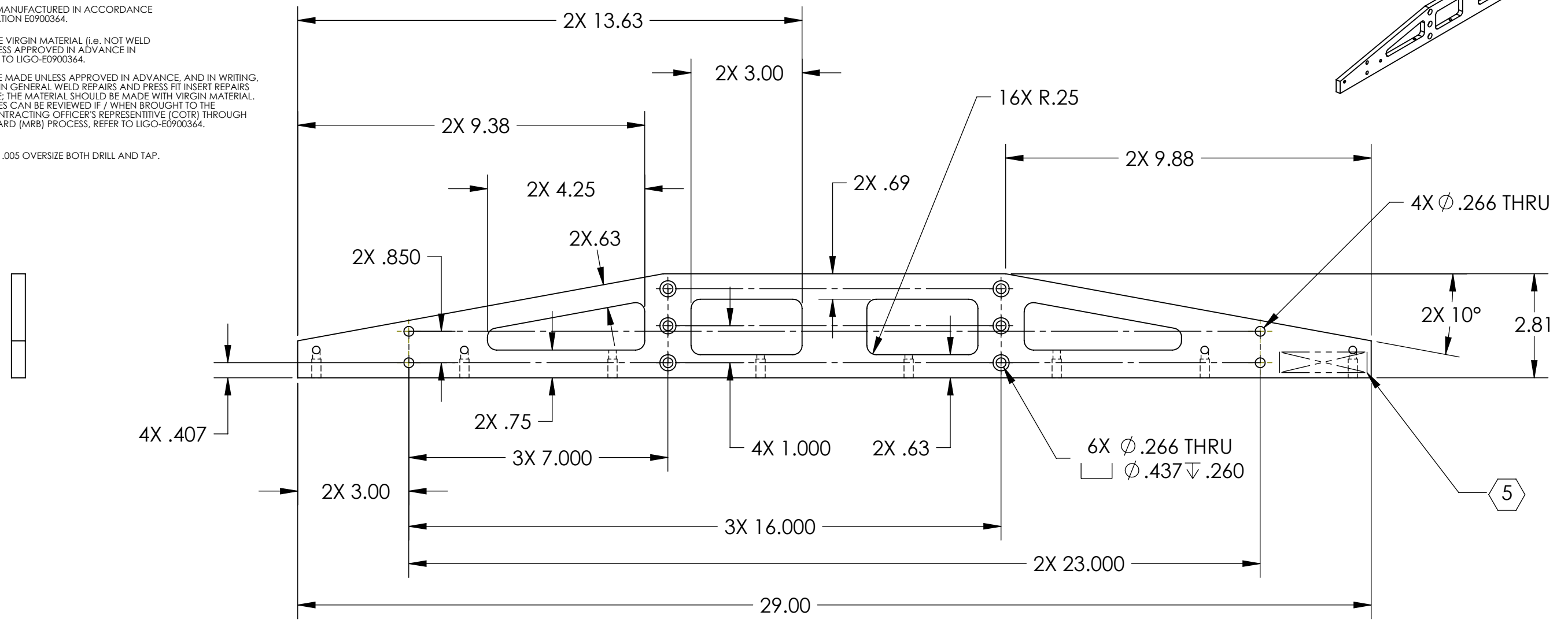
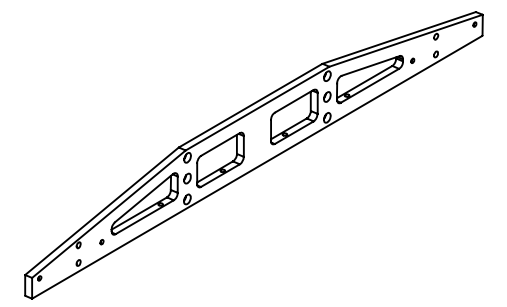
8 7 6 5 4 3 2 1

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

REV.	DATE	DCN #	DRAWING TREE #
v1	05 DEC 2011	E1101152	-
-	-	-	-
-	-	-	-

6. APPROXIMATE WEIGHT = 1.65 LB [.75 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. 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 REPRESENTATIVE (COIR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

11. ALL TAPPED HOLES: .005 OVERSIZE BOTH DRILL AND TAP.



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES, R.02 MIN.
 3. DO NOT SCALE FROM DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 1.0°

DIMENSIONS ARE IN INCHES

MATERIAL	6061-T6 Al	FINISH	63 μinch Ra
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
ADVANCED LIGO		aLIGO TMS TELESCOPE TABLE SUPPORT GUSSET	
DESIGNER	K. MAILAND	DATE	05 DEC 2011
DRAFTER		SIZE	DWG. NO.
CHECKER		B	D1102292
APPROVAL		SCALE	1:3
		PROJECTION	ASME
		SHEET	1 OF 1

D1102292 aLIGO TMS Telescope Table Support Gusset, PART PDM REV: X-005, DRAWING PDM REV: X-003

8 7 6 5 4 3 2 1