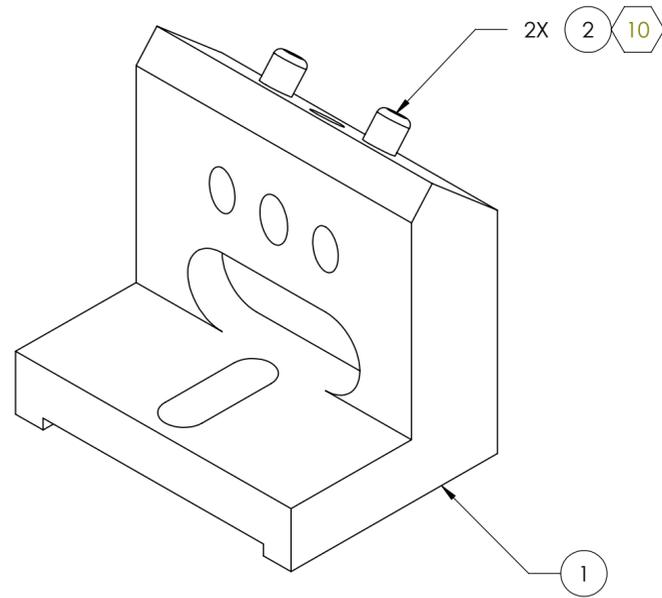


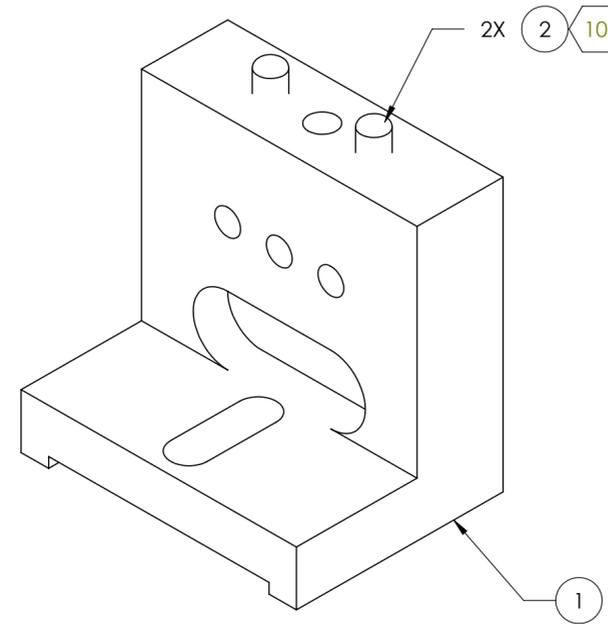
NOTES CONTINUED:

- 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 = SEE FIELD OF DRAWING.
- 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-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. DOWEL PINS TO BE INSTALLED BY LIGO PERSONEL, AFTER DELIVERY OF FINISHED PARTS.

REV.	DATE	DCN #	DRAWING TREE #
V1	25 OCT 2012	E1200962-V1	
V2	28 NOV 2012	E1200962-V2	



**D1200172-1,2,3**  
WEIGHT: .10 LBS



**D1200172-4**  
WEIGHT: .10 LBS

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	SUPPLIER
2	2	90145A505	HDW, PIN, DOWEL, .188 DIA X .50LG, SST	MCMMASTER- CARR
1	1	D1200172-X	ALIGO, PCAL MIRROR MOUNT BASE, ETM BEAM	
PARTS LIST				

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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.
- 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**  
AL ALLOY 6061-T6

**FINISH**  
63 μinch

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**SYSTEM**  
ADVANCED LIGO

**SUB-SYSTEM**  
AOS

**NEXT ASSY**  
D1200174

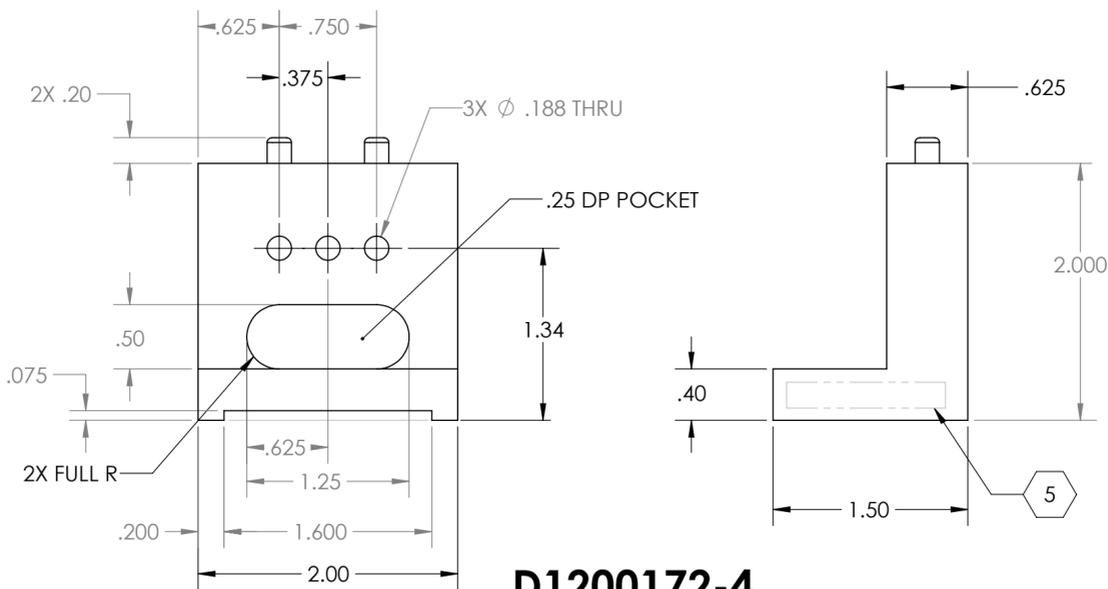
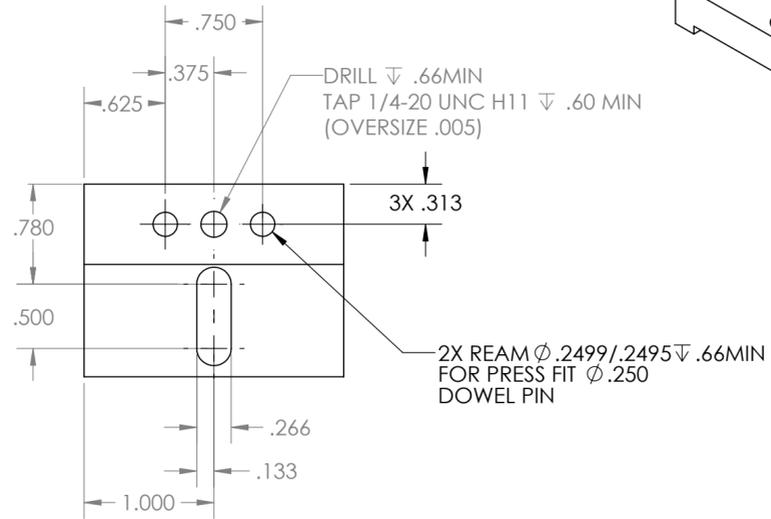
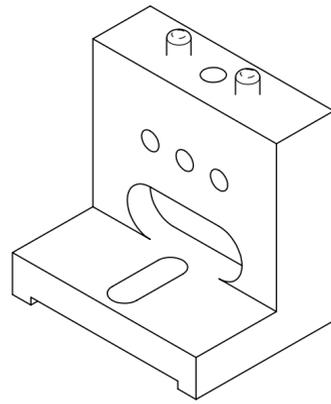
**PART NAME**  
ALIGO, PCAL, MIRROR MOUNT BASE, ETM BEAM

**DESIGNER** S. SHANKLE 25 OCT 2012  
**DRAFTER** S. SHANKLE 25 OCT 2012  
**CHECKER** S. SHANKLE 25 OCT 2012  
**APPROVAL** S. SHANKLE 25 OCT 2012

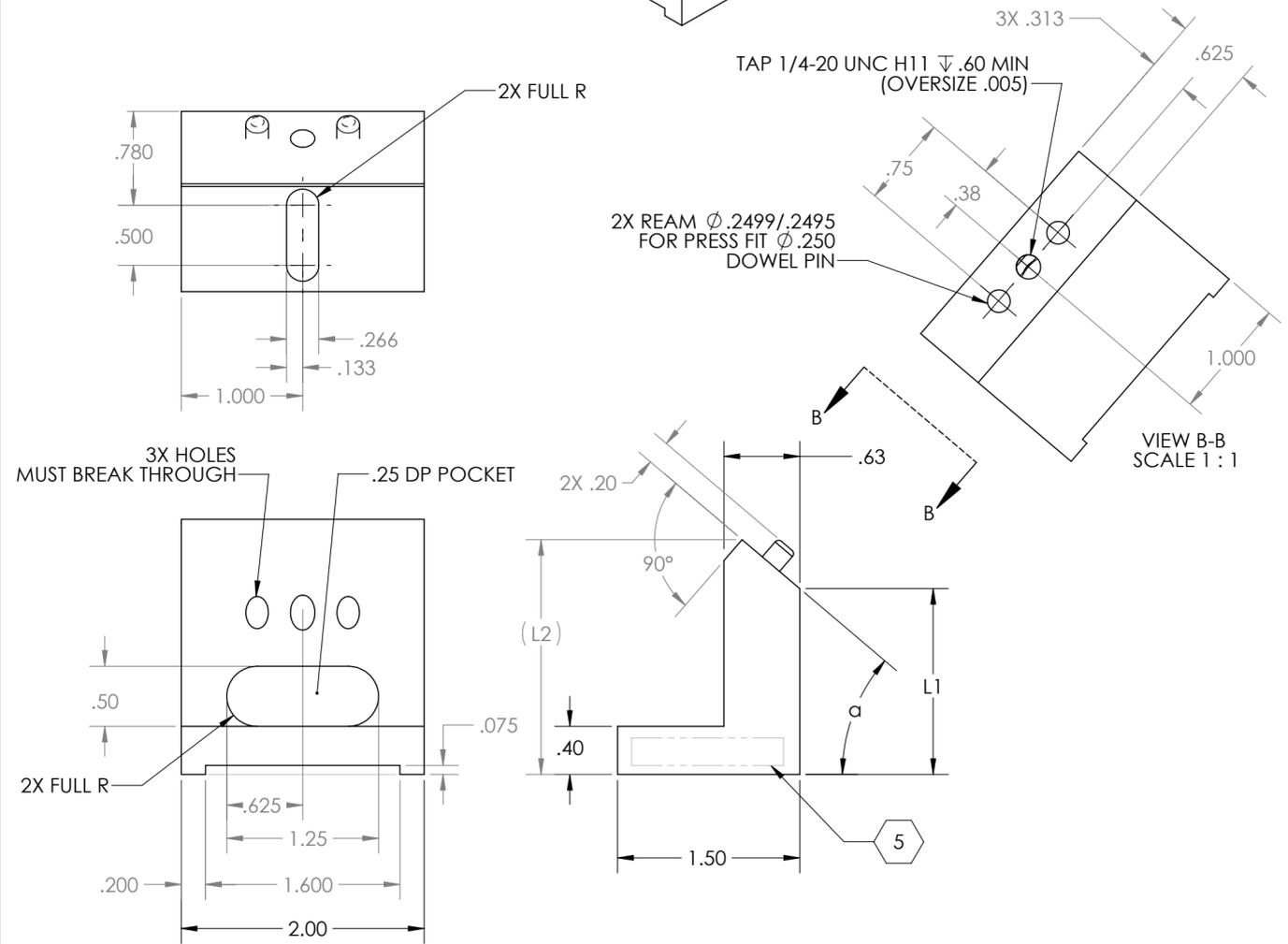
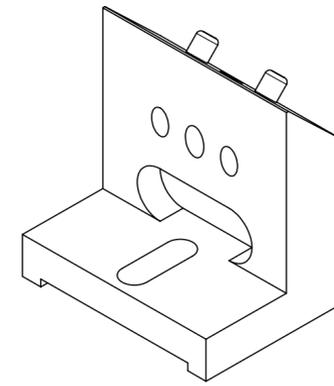
**SIZE** DWG. NO.  
c **D1200172**

**REV.**  
v2

**SCALE:** 2:1 **PROJECTION:** SHEET 1 OF 2



**D1200172-4**



**D1200172-X**

TABLE 1

P/N	"L1" in.	"L2" in.	" $\alpha$ " deg
D1200172-1	1.547	(1.953)	40.63
D1200172-2	1.550	(1.982)	43.72
D1200172-3	1.573	(2.047)	49.38

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SIZE **C** DWG. NO. **D1200172** REV. **v2**

SCALE: 2:1 PROJECTION: SHEET 2 OF 2