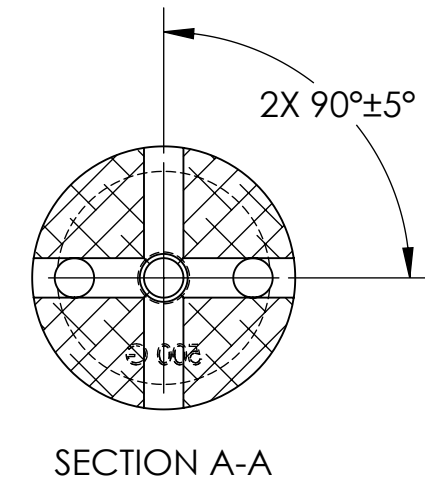
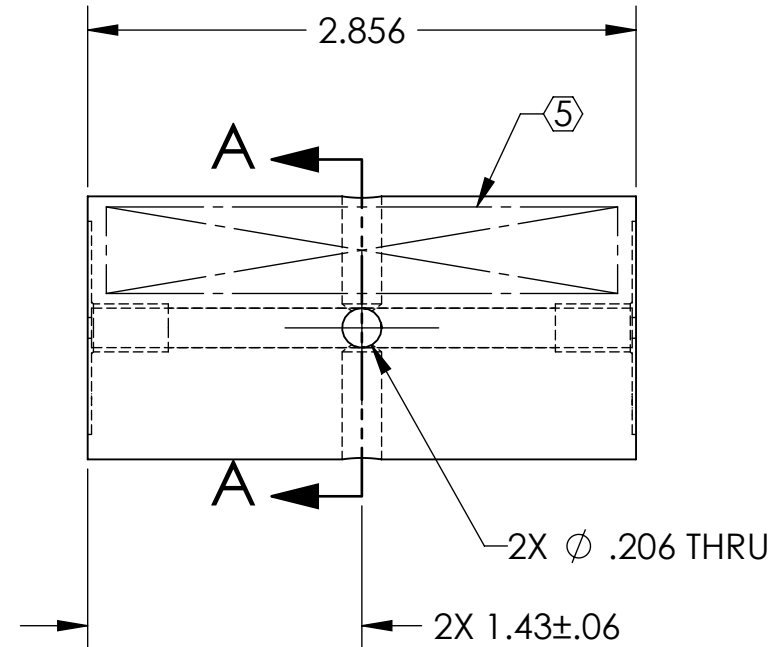
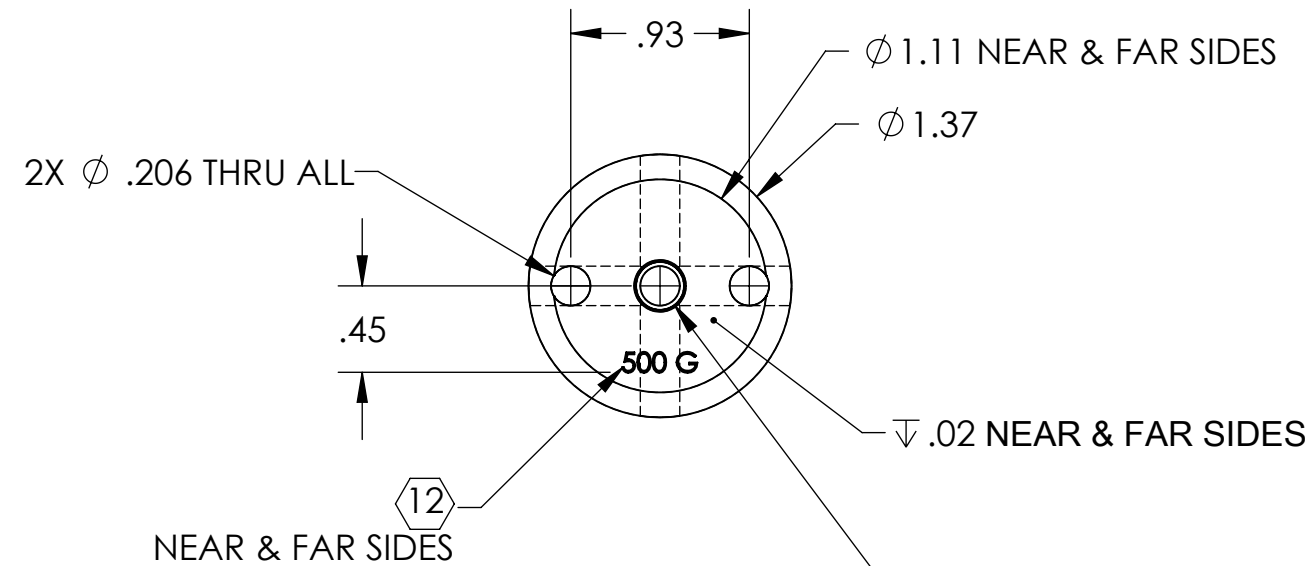
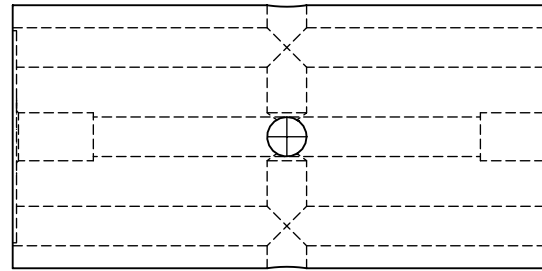
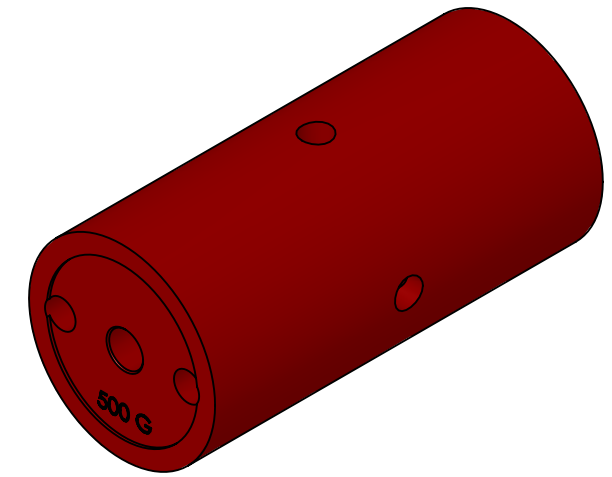


D1200470 aLIGO TMS Optics Table Cylinder Mass, PART PDM REV: X-000, DRAWING PDM REV: X-002

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. MASS: 500 G [1.10 LB].
- 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 PART SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.
- 11. TAPPED HOLES: .005 OVERSIZE BOTH DRILL AND TAP.
- 12. SCRIBE, ENGRAVE, LASER MARK, OR MECHANICALLY STAMP (NO INKS OR DYES), "500 G" APPROXIMATELY CENTER JUSTIFIED AS SHOWN. CHARACTER HEIGHT 0.10-0.15. NEAR & FAR SIDES.

REV.	DATE	DCN #	DRAWING TREE #
v1	19 MAR 2012	E1101214	-
-	-	-	-
-	-	-	-



2X 1/4-20 UNC - 2B, H11, ∇ .40, NEAR & FAR SIDES
 (0.005 OVERSIZE BOTH DRILL & TAP) 11
 TAP DRILL THRU
 \sphericalangle ϕ .27 X 90°, NEAR & FAR SIDES

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX \pm .01 .XXX \pm .005	
ANGULAR \pm 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	FINISH
304 S316	63 μ inch Ra

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

NEXT ASSY: VARIOUS

PART NAME: aLIGO TMS OPTICS TABLE CYLINDER MASS

DESIGNER	K. MAILAND	15 MAR 2012	SIZE	DWG. NO.	REV.
DRAFTER	C. CONLEY	19 MAR 2012	B	D1200470	v1
CHECKER	SEE DCN				
APPROVAL	SEE DCN				

SCALE: NONE PROJECTION: SHEET 1 OF 1