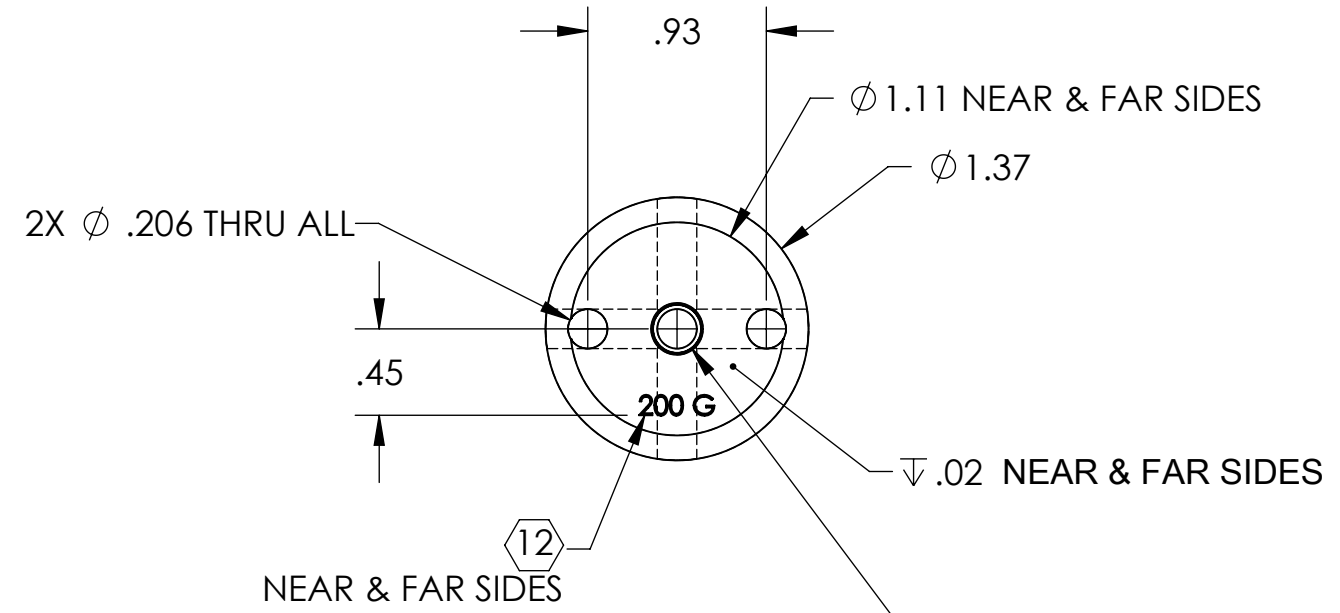
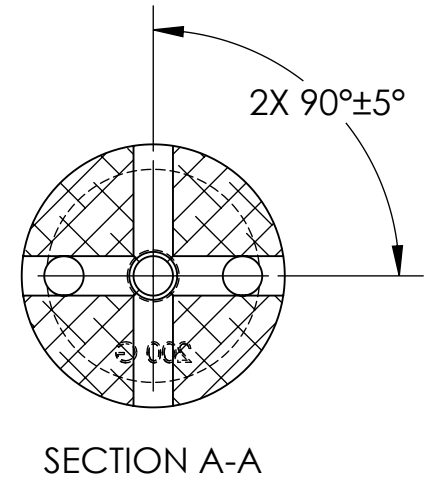
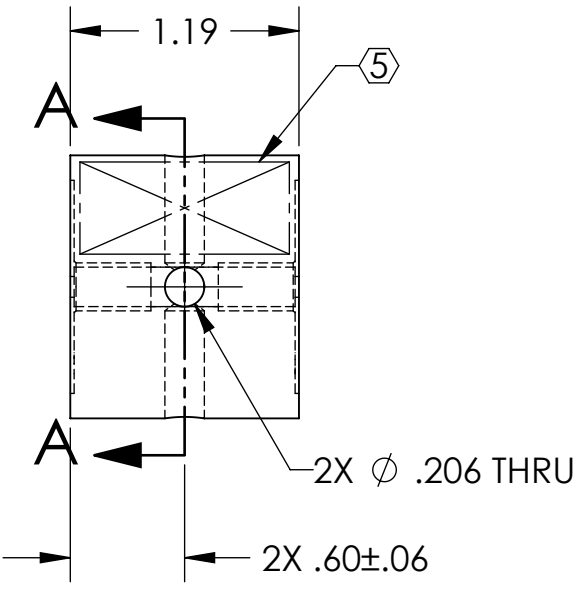
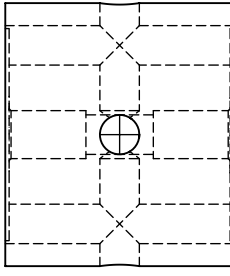
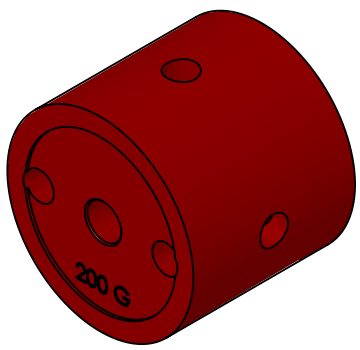


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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: 200 G [0.44 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), "200 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,  $\nabla$  .40, NEAR & FAR SIDES  
 (0.005 OVERSIZE BOTH DRILL & TAP) 11  
 TAP DRILL THRU  
 $\sphericalangle$   $\phi$  .27 X 90°, NEAR & FAR SIDES

D1200471 aLIGO TMS Optics Table Small Cylinder Mass, PART PDM REV: X-001, DRAWING PDM REV: X-001

| NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)                                    |  |                  |  | LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY   |  | PART NAME                                     |  |
|---|--|------------------|--|---|--|---|--|
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>.XX ± .01<br>.XXX ± .005<br>ANGULAR ± 1.0° |  |                  |  | 1. INTERPRET DRAWING PER ASME Y14.5-1994.<br>2. REMOVE ALL SHARP EDGES, .005-.015.<br>3. DO NOT SCALE FROM DRAWING.<br>4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. |  | aLIGO TMS<br>OPTICS TABLE SMALL CYLINDER MASS |  |
| MATERIAL  |  | FINISH           |  | SYSTEM  |  | SUB-SYSTEM                                    |  |
| 304 SSSL  |  | 63 $\mu$ inch Ra |  | ADVANCED LIGO   |  | AOS   |  |
| NEXT ASSY   |  |                  |  | DESIGNER  |  | DATE  |  |
| VARIOUS   |  |                  |  | K. MAILAND  |  | 15 MAR 2012                                   |  |
|   |  |                  |  | DRAFTER   |  | SIZE DWG. NO.                                 |  |
|   |  |                  |  | C. CONLEY   |  | B   |  |
|   |  |                  |  | CHECKER   |  | D1200471                                      |  |
|   |  |                  |  | SEE DCN   |  | REV.  |  |
|   |  |                  |  | APPROVAL  |  | v1  |  |
|   |  |                  |  | SEE DCN   |  | SCALE: NONE PROJECTION:  SHEET 1 OF 1         |  |