

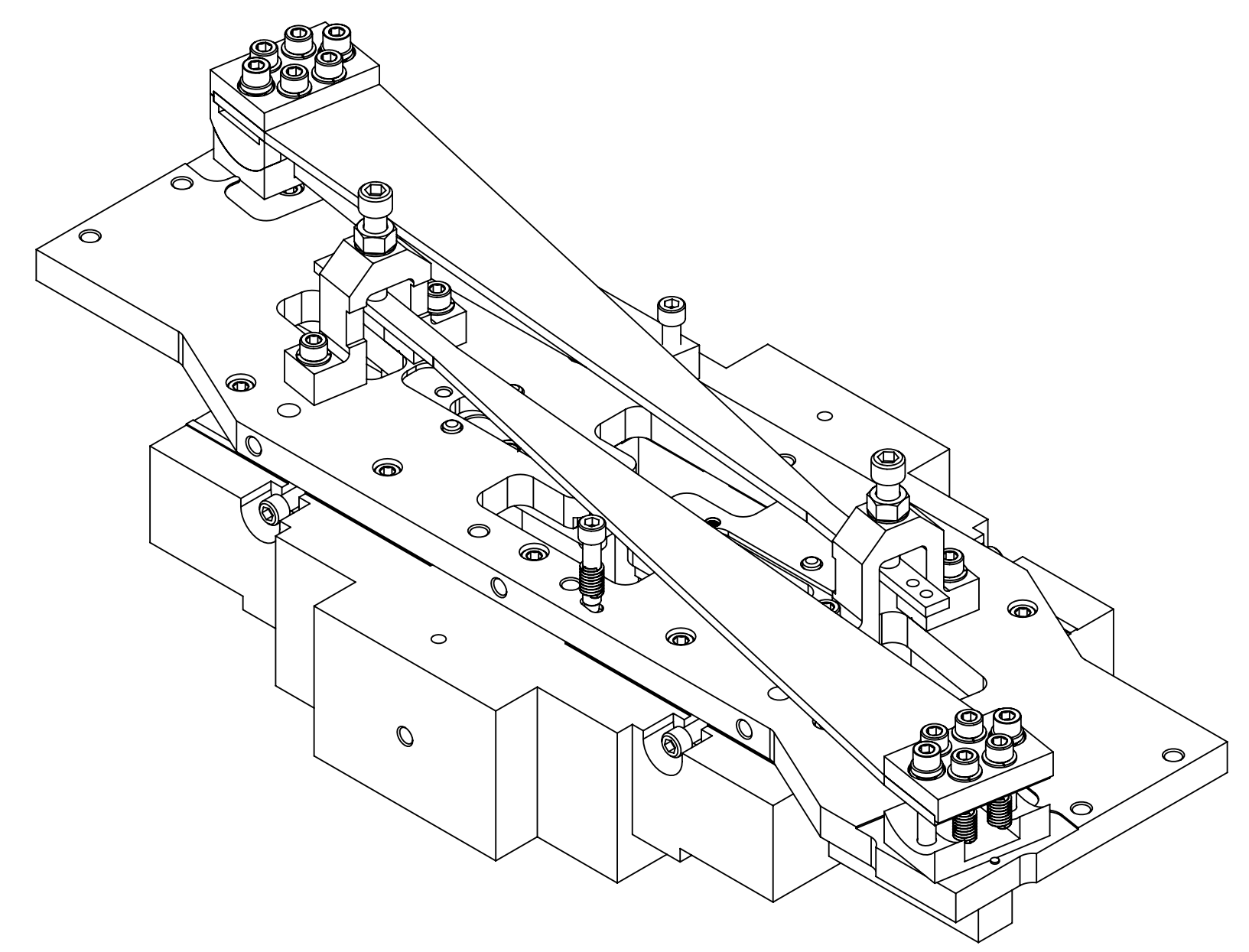
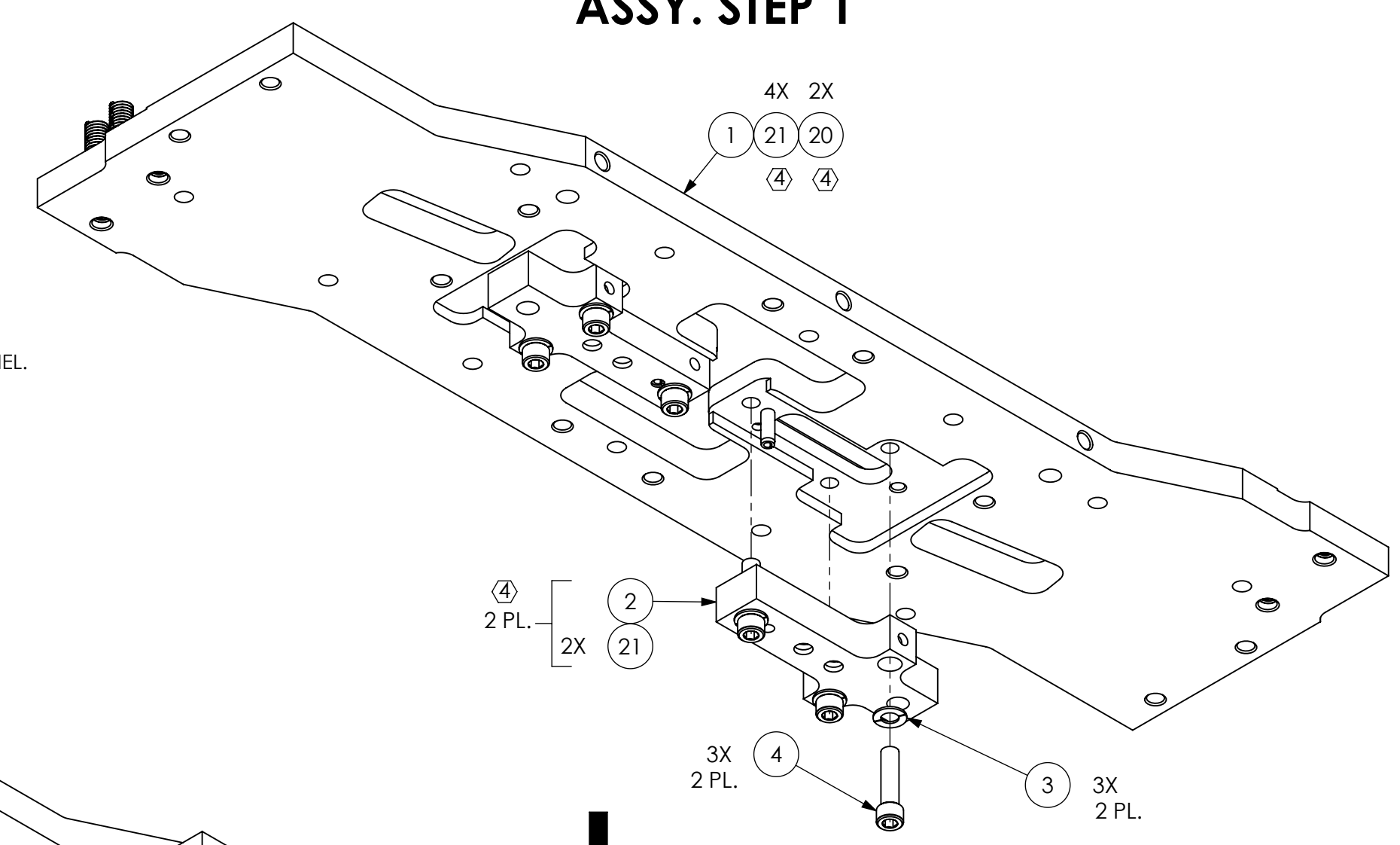
NOTES CONTINUED:
 1. SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR 'TYPE' (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
 EXAMPLE (PART): 001-v1
 EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD

2. MASS: APPROX. 25.16 LBS

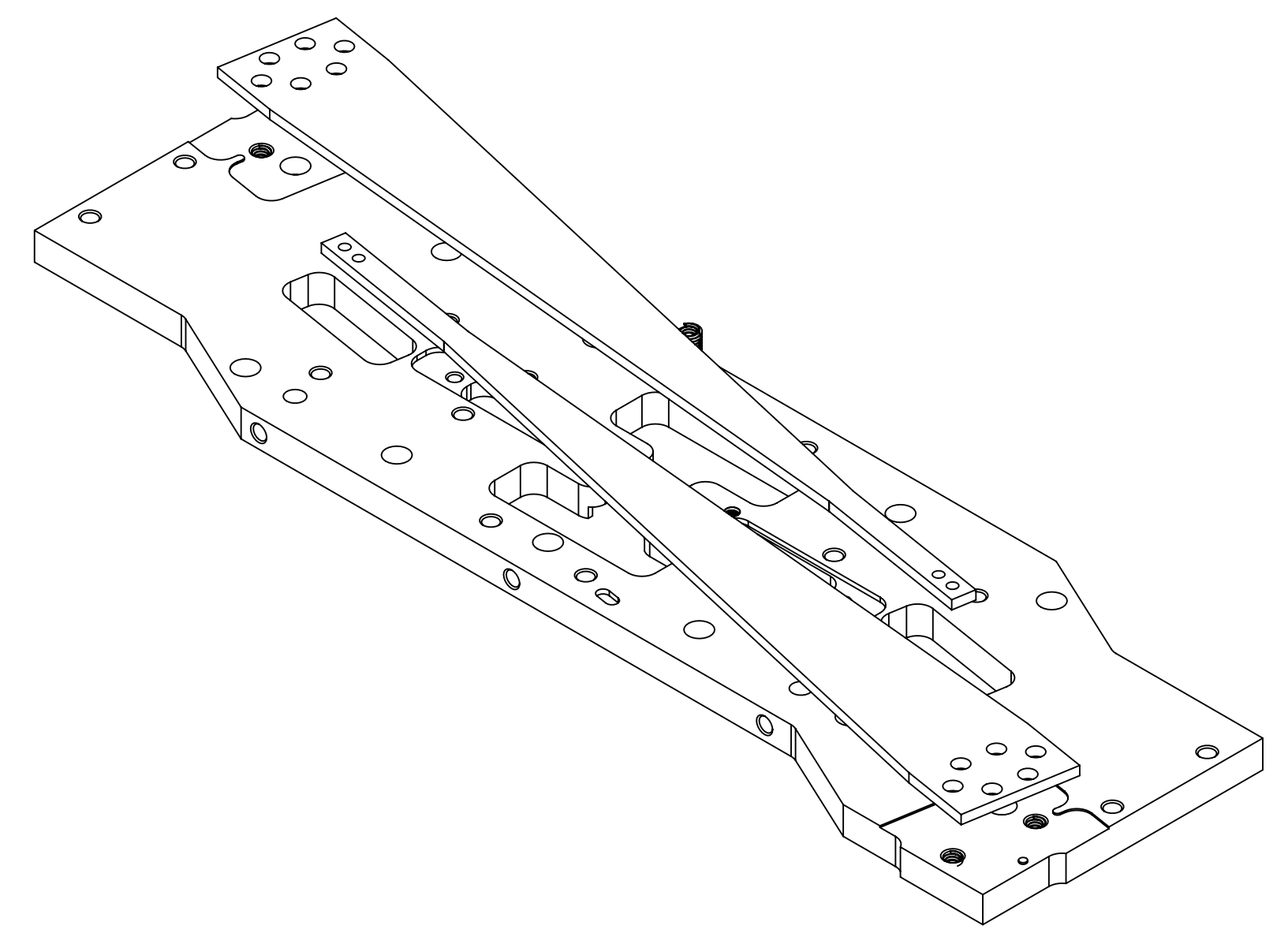
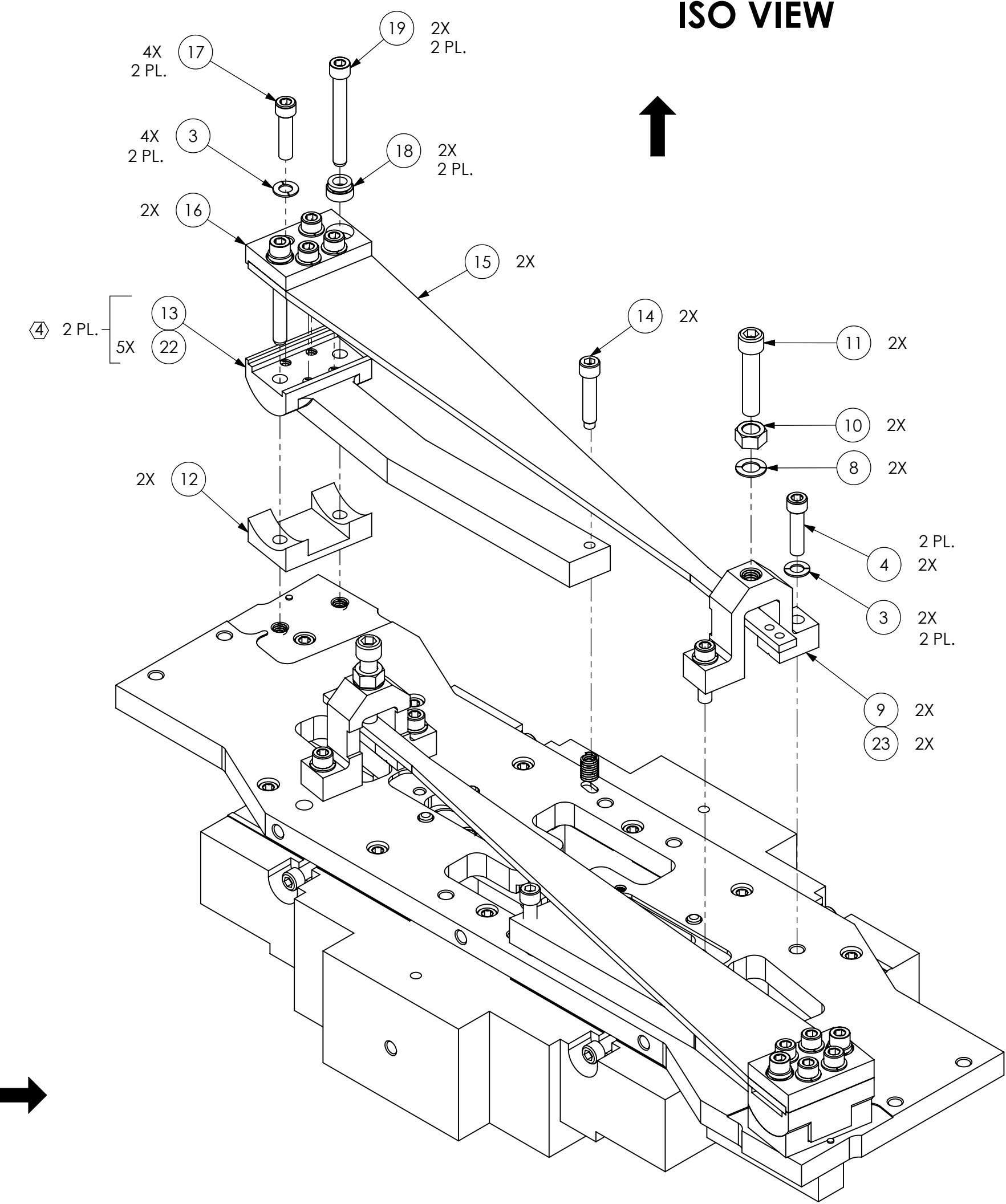
③ INDICATED COMPONENT UNIQUE TO TMS. NOT USED ACROSS MULTIPLE SUB-SYSTEMS.

④ INSTALL HELICOILS PRIOR TO ASSEMBLY. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL.

ASSY. STEP 1

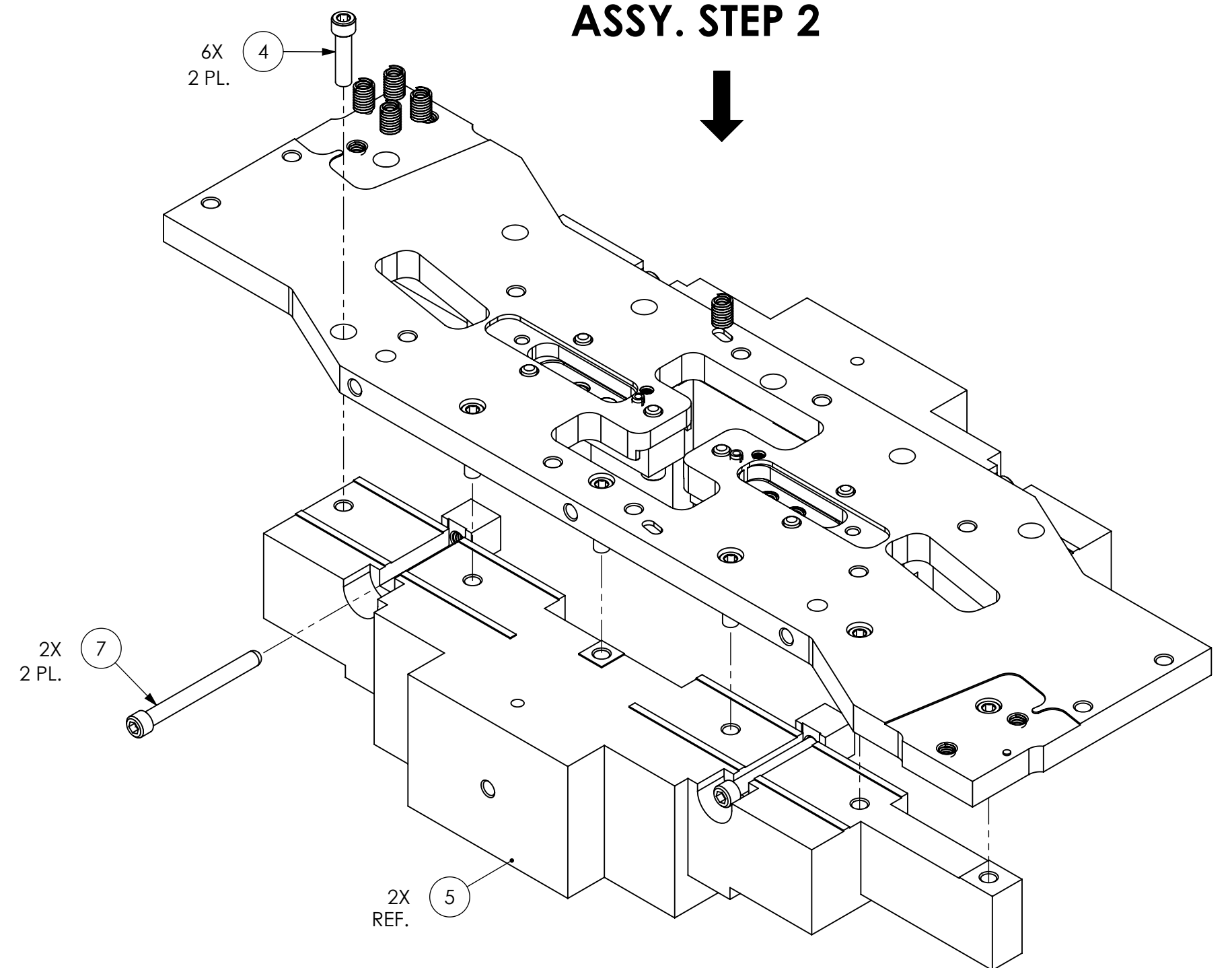


ISO VIEW



CREEP BAKE CONFIG.

ASSY. STEP 2



ASSY. STEP 3

ASSY. STEP 4

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.
23	1185-5EN469 EMHART OR EQ.	HELICOIL, 5/16-18 X .469 LG.	NITRONIC 60	2
22	1185-4EN500 EMHART OR EQ.	HELICOIL, 1/4-20 X .50 LG.	NITRONIC 60	14
21	1185-4EN375 EMHART OR EQ.	HELICOIL, 1/4-20 X .375 LG.	NITRONIC 60	8
20	1185-2EN246 EMHART OR EQ.	HELICOIL, 8-32 X .246 LG.	NITRONIC 60	2
19	C-2032-N	SHCS, 1/4-20 x 2" L, 18-8 SSSL	18-8 SSSL	4
18	91944A028 (McM-Carr) or equiv	LEVELING WASHER, 1/4" SCREW SIZE	18-8 SSSL	4
17	C-2016-N	SOCKET HEAD CAP SCREW, SHC, 1/4-20 x 1" L	18-8 SSSL	8
16	D060380	αLIGO, SUS, QUAD N-PTYPE UI MASS, BLADE CLAMP (TOP HALF)	304 SSSL	2
③ 15	D1200117	αLIGO TMS LOWER STAGE BLADE SPRING	MARAGING STEEL C250	2
③ 14	D1200404-1	αLIGO TMS LOWER STAGE SPRING ADJUSTER SCREW, Ag PLATED	Ag-PLATED 18-8 SSSL	2
④ 13	D060378	αLIGO, SUS, QUAD N-PTYPE UI MASS, BLADE TIP Z POSITION ADJ (BTM HALF)	304, 316 OR 302 SSSL	2
12	D060377	αLIGO, SUS, QUAD N-PTYPE UI MASS, BLADE TIP Z POSITION ADJ (BTM HALF PART 2)	6061-T6 Al	2
③ 11	D1200406	αLIGO TMS SPRING STOP SCREW	300 SSSL	2
10	90810A030 McMaster-Carr OR EQ.	HEX NUT, 5/16-18, Ni-Cu	NICKEL-COPPER ALLOY 400	2
④ ③ 9	D1101273	αLIGO SUS TOP MASS STOP BRIDGE	6061-T6 Al	2
8	WFV-31 UC COMPONENTS OR EQ.	.328 ID, .562 OD, .032 TH	18-8 SSSL	2
7	D030021	SCREW, SOCKET HEAD CAP, 1/4-20 UNC-3A X 2.5 LONG, FULLY THREADED, ROUNDED END	300 SSSL	4
④ ③ 6	D1200427	αLIGO TMS UPPER SUS WIRE ADJUSTER	6061-T6 Al	4
③ 5	D1200312	αLIGO TMS TOP ADD MASS BAR	304 SSSL	2
4	C-2016-NA	SOCKET HEAD CAP SCREW, SHC, 1/4-20 x 1" L	Ag-PLATED 300 SSSL	30
3	.250 VENT FL WSHR	.255 ID, .468 OD, .032 TH	18-8 SSSL	26
④ ③ 2	D1200426	αLIGO TMS MASS WIRE CLAMP ADJUSTMENT BLOCK	6061-T6 Al	2
④ ③ 1	D1200469	αLIGO TMS UPPER MASS BOTTOM PLATE ASSEMBLY	N/A	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

MATERIAL		FINISH		NEXT ASSY		PART NAME		DESIGNER		DRAFTER		CHECKER		APPROVAL	
N/A		N/A μinch		D1101527		αLIGO TMS MASS BASE ASSEMBLY		K. MAILAND 25 MAR 2012		C. CONLEY 26 MAR 2012		SEE DCC		SEE DCC	
SYSTEM				SUB-SYSTEM				SIZE		DWG. NO.		REV.		SCALE	
ADVANCED LIGO				AOS				D		D1200525		v6		1:2	
PROJECTION				SHEET 1 OF 1				SCALE		PROJECTION		SHEET 1 OF 1		SCALE	

D1200525 αLIGO TMS Mass Base Assembly, PART PDM REV. X-045, DRAWING PDM REV. X-009