

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 = 59.5 LBS.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

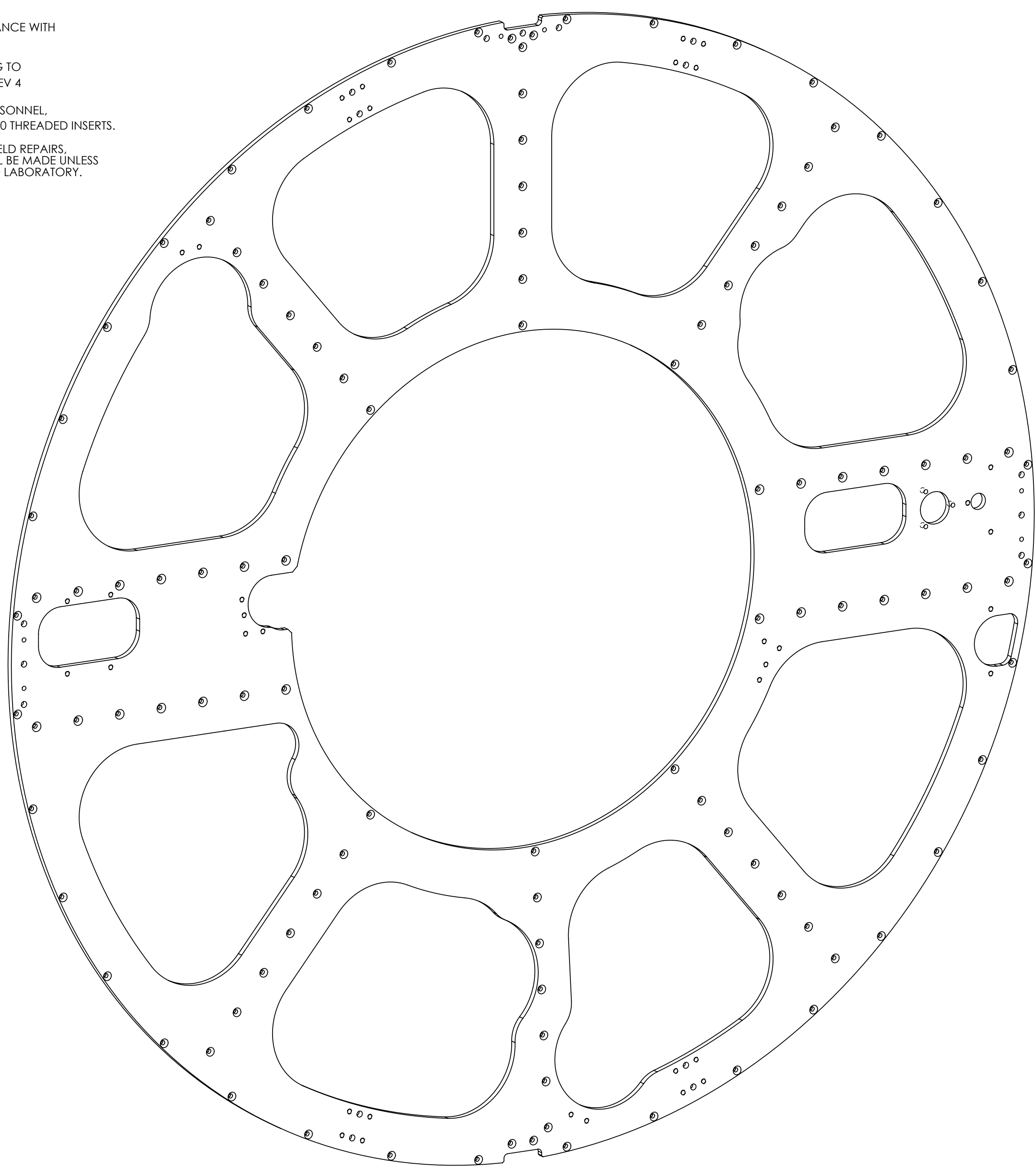
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

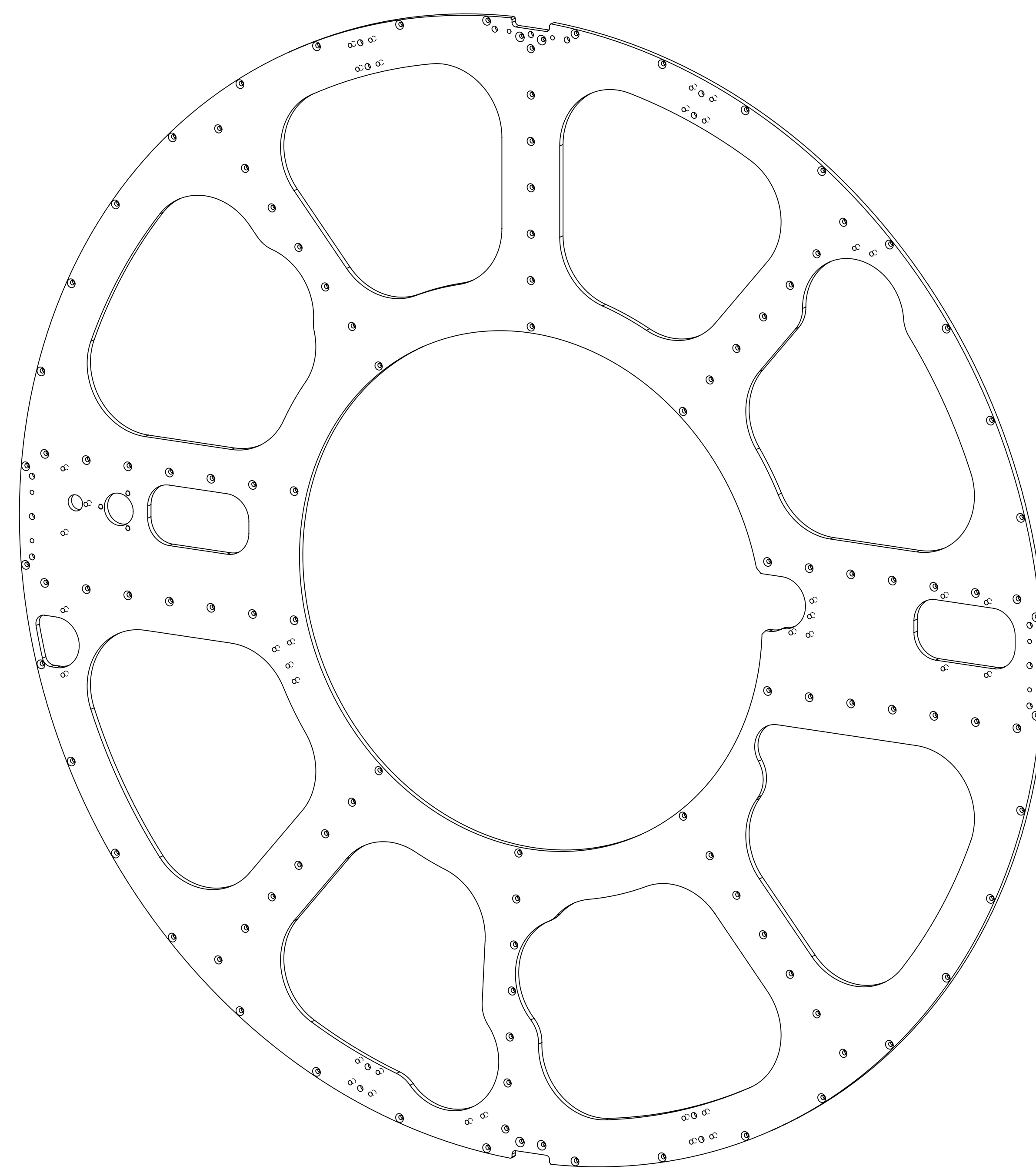
10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

11. 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.

REV.	DATE	DCN #	DRAWING TREE #
V1	26 JUN 2012	E1200700	
V2	13 JUL 2012	E1200700	
V3	20 AUG 2012	E1200700	
V4	03 SEP 2012	E1200700	
V5	23 SEP 2012	E1200700	
V6	28 SEP 2012	E1200700	
V7	12 SEP 2013	E1201028-x0	



**D1200726-1
 (COUNTERSINK OPPOSITE DATUM "A" SURFACE)**



**D1200726-2
 (COUNTERSINK ON DATUM "A" SURFACE)**

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	SUPPLIER
2	9	1185-4EN375	INSERT, HELI-COIL 1/4-20 X .38 LG NITRONIC 60	HELI-COIL
1	1	BASE PLATE CAMERA MOUNT	PCAL PLATE CAMERA MIRROR MTG	

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .05 .XXX ± .010	
ANGULAR ± 0.5°	
MATERIAL	6061-T6 Al
FINISH	63 μinch

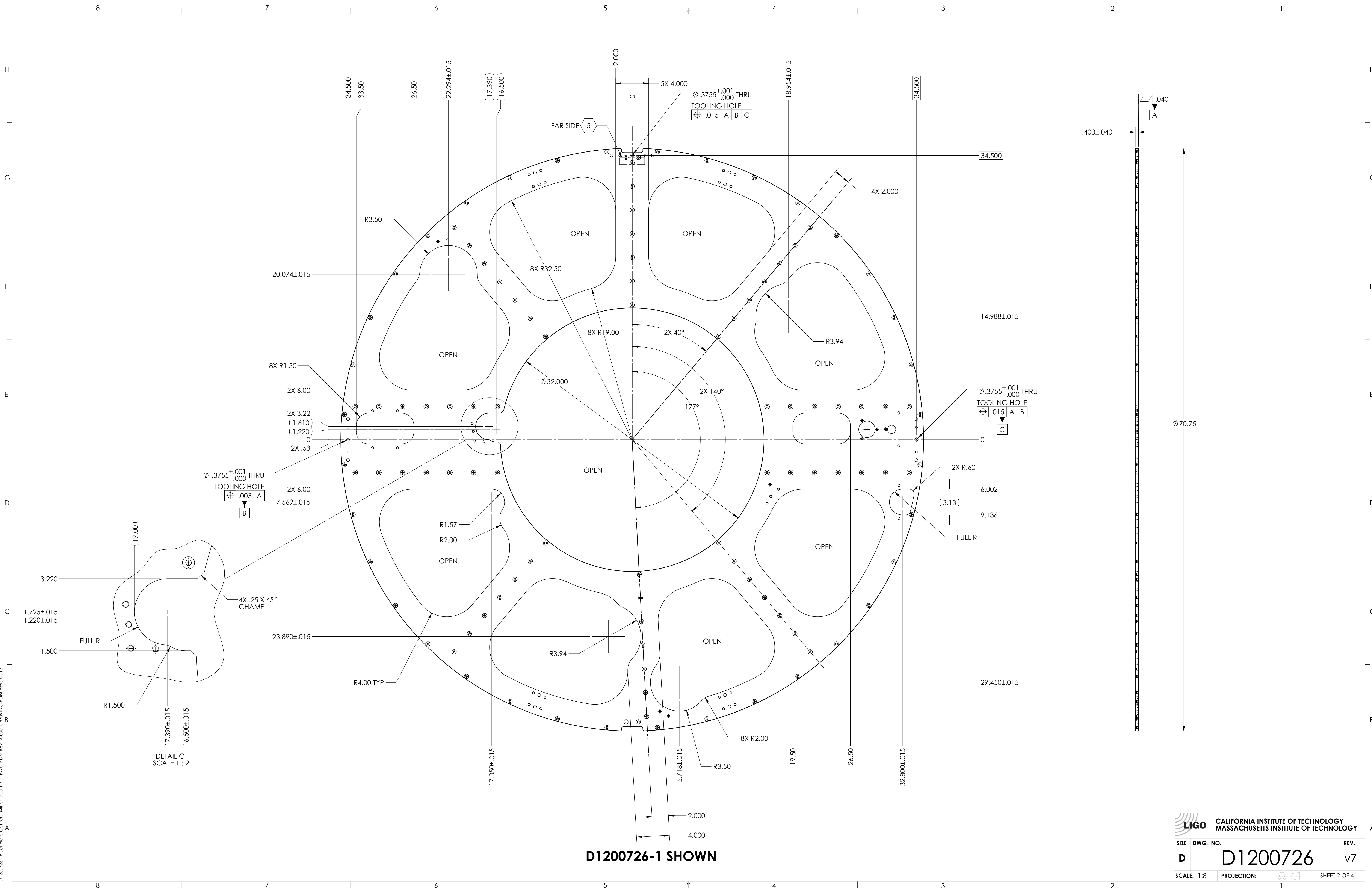
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 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **AOS**

NEXT ASSY: **D1200174**

PART NAME		DESIGNER		SIZE		DWG. NO.		REV.	
PCAL PLATE CAMERA MIRROR MTG		S. SHANKLE		10 JUN 2012		D		D1200726	
DRAFTER		S. SHANKLE		26 JUN 2012		SCALE: 1:8		SHEET 1 OF 4	
CHECKER		S. SHANKLE		26 JUN 2012		PROJECTION:		v7	
APPROVAL		S. SHANKLE		26 JUN 2012		PROJECTION:			

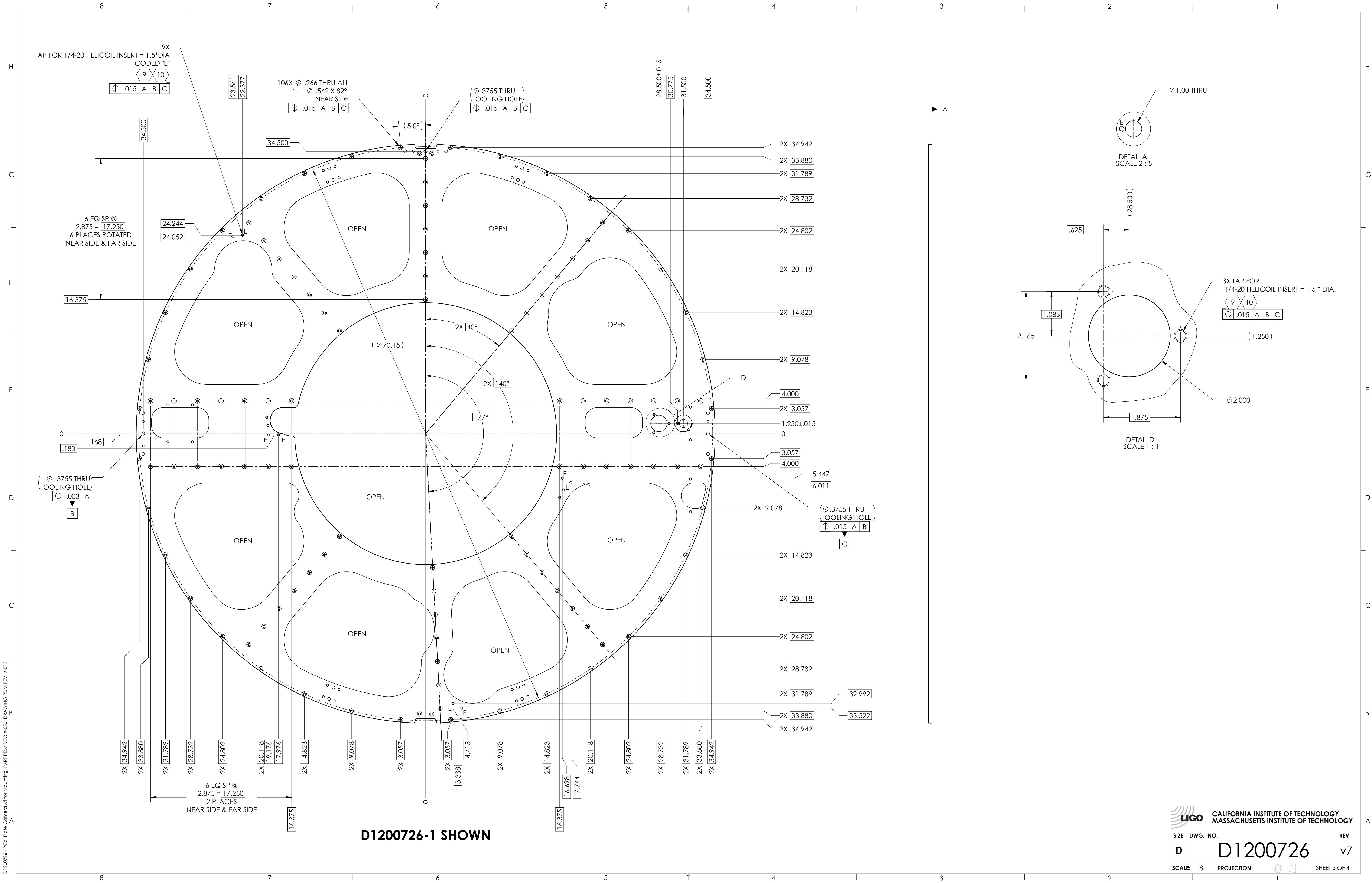
D1200726 - FCD Plate Camera Mirror Mounting, PART FDM REV: X-030, DRAWING FDM REV: X-013



D1200726-1 SHOWN

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE DWG. NO.	REV.
D D1200726	v7
SCALE: 1:8	PROJECTION:
SHEET 2 OF 4	

D1200726 - FCI Plate Camera Mirror Mounting, PAR FDM REV: X-030, DRAWING FDM REV: X-013

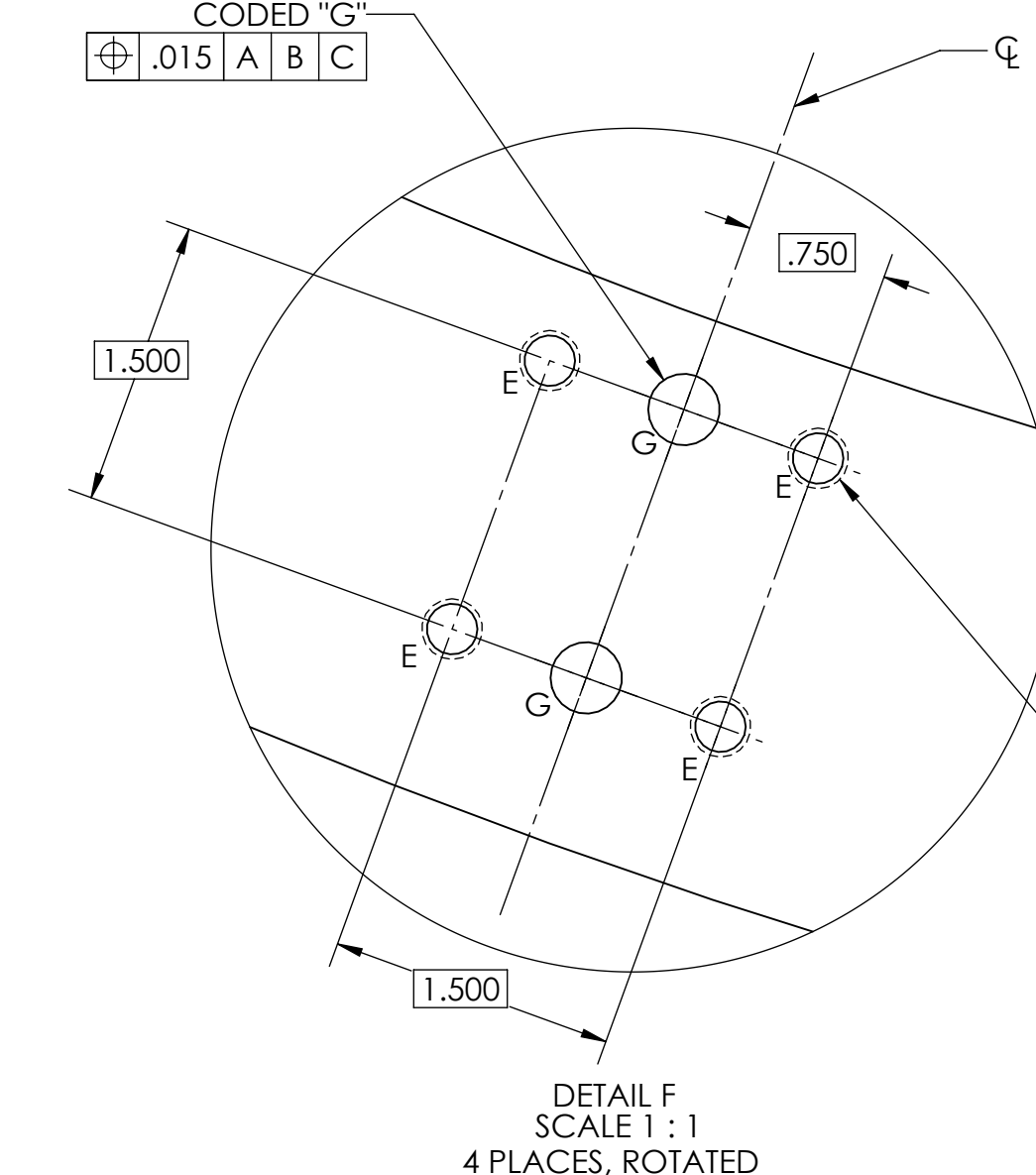
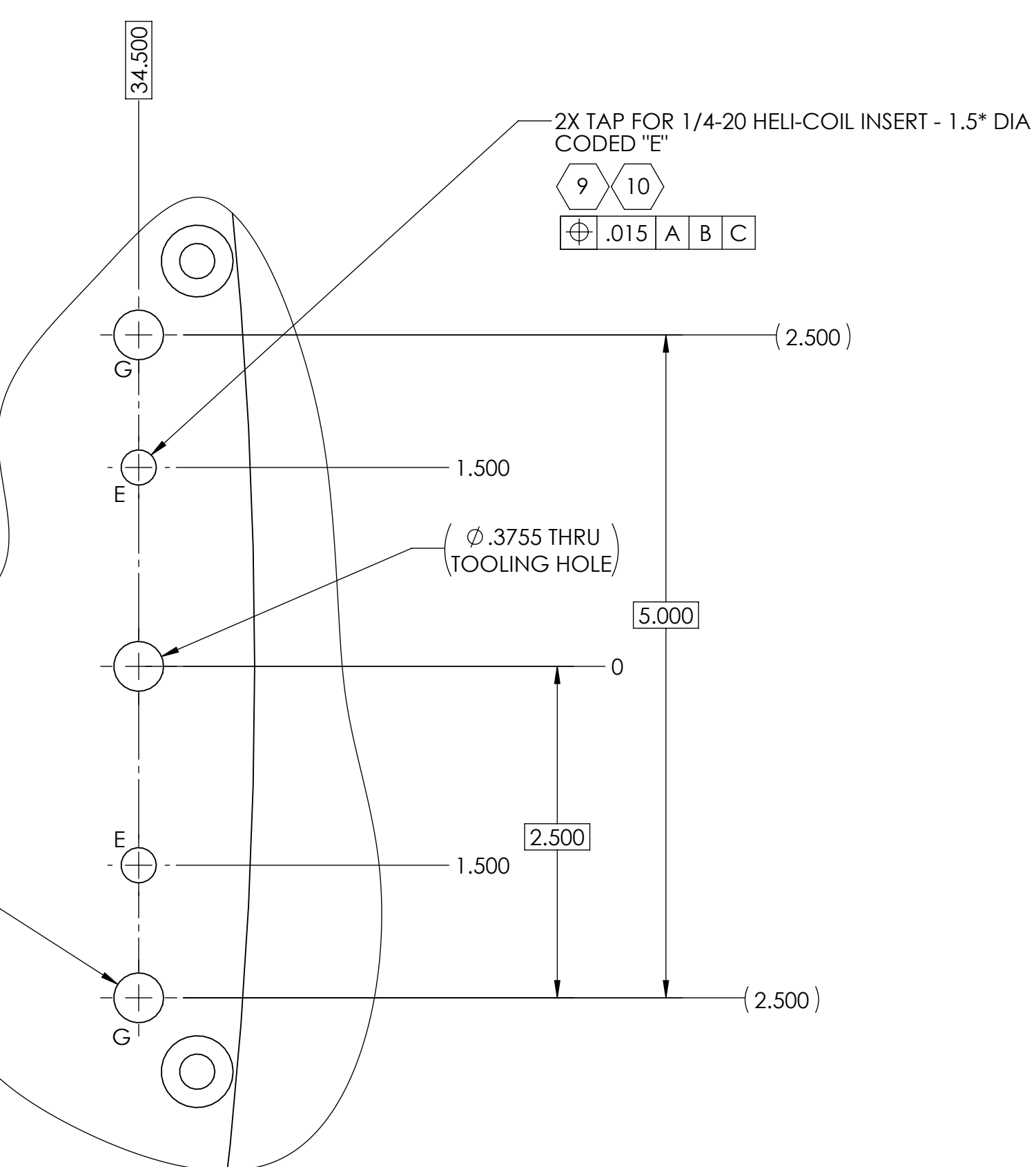
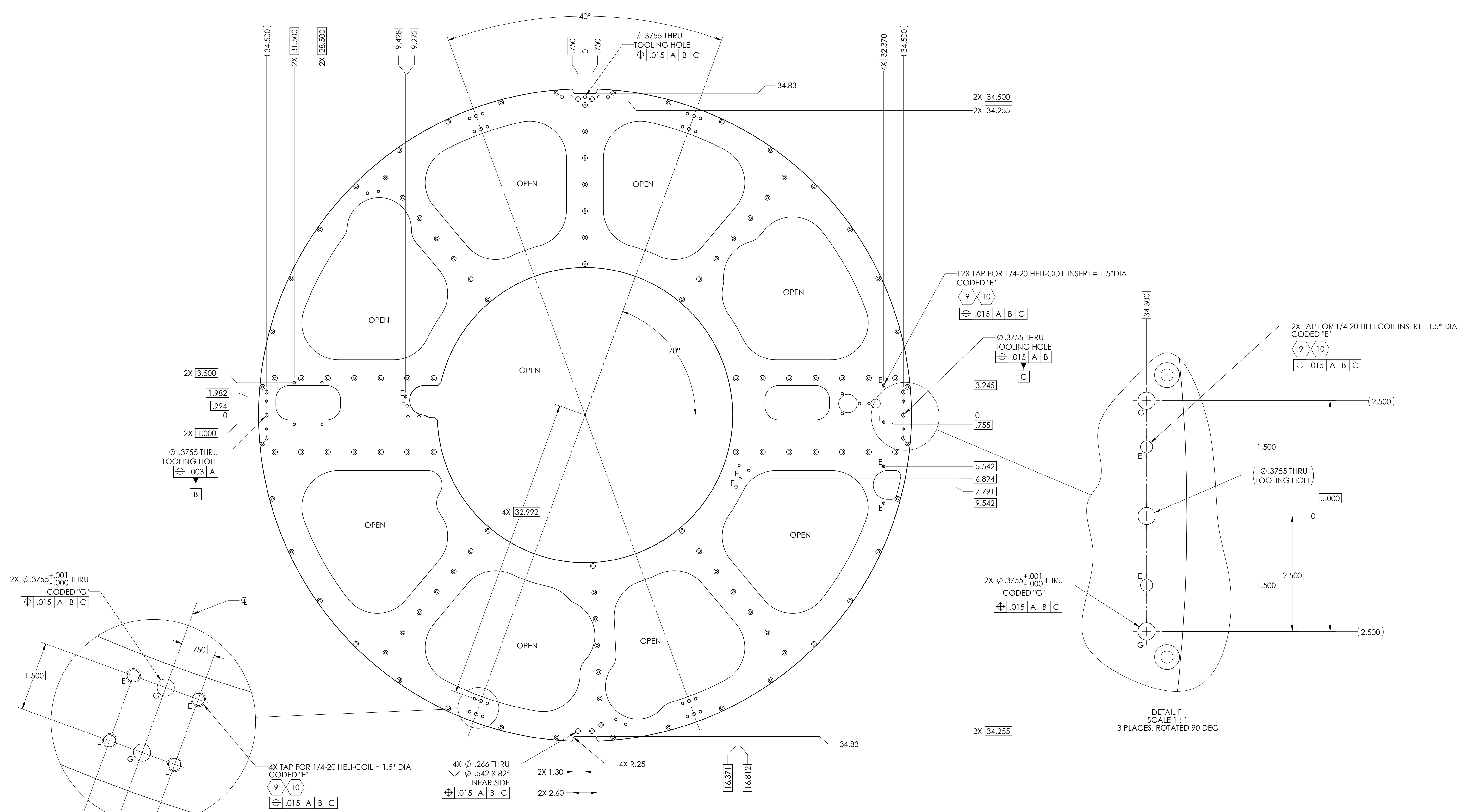


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SIZE	DWG. NO.	REV.
D	D1200726	v7
SCALE: 1:8	PROJECTION:	SHEET 3 OF 4

8 7 6 5 4 3 2 1

H G F E D C B A



D1200726-1 SHOWN

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SIZE DWG. NO.	REV.
D D1200726	v7
SCALE: 1:8	PROJECTION:
SHEET 4 OF 4	

8 7 6 5 4 3 2 1

H G F E D C B A

D1200726-1 FCB File Camera Mirror Mounting, PAR FDM REV. X-030, DRAWING PDM REV. X-013