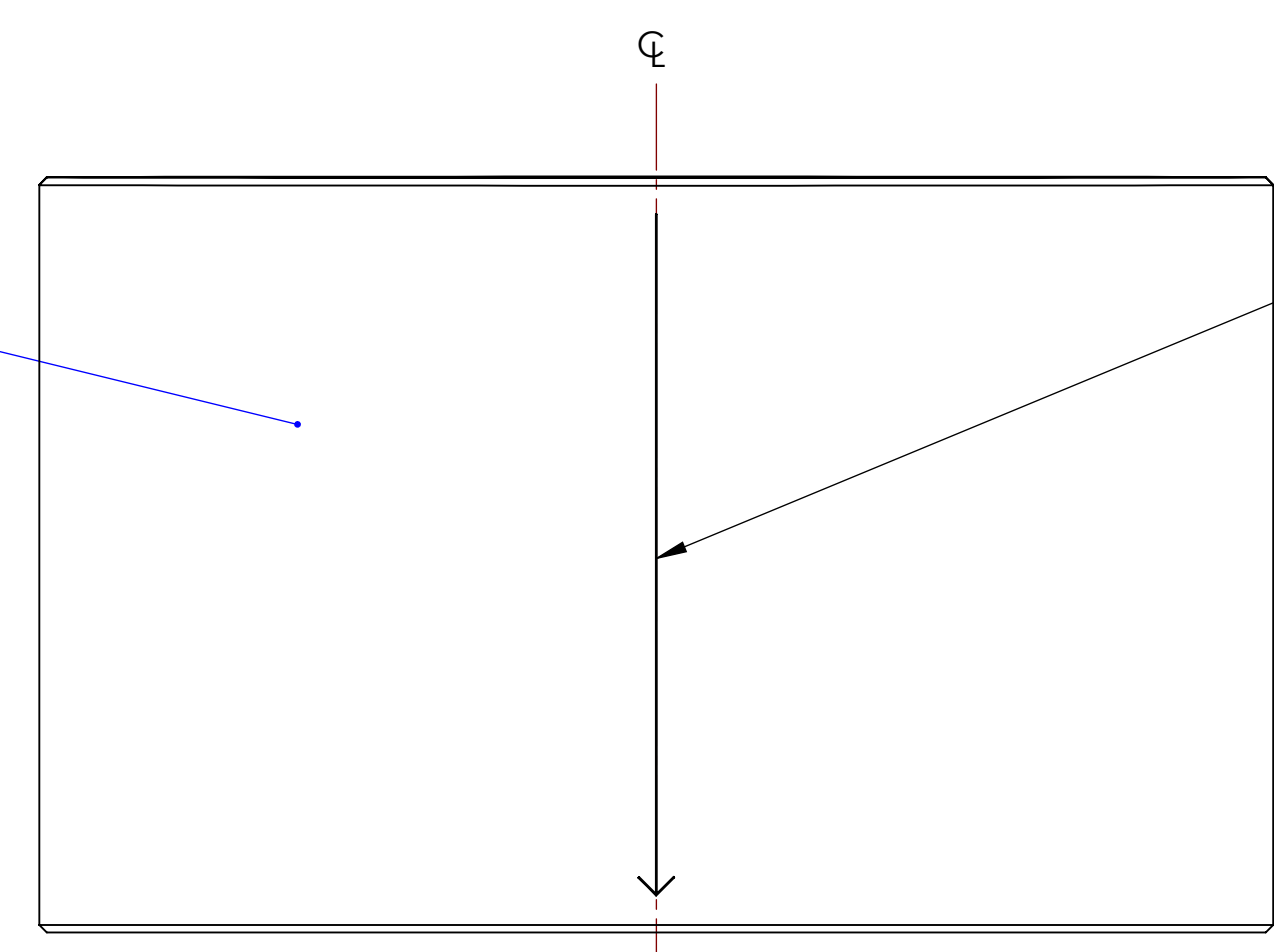
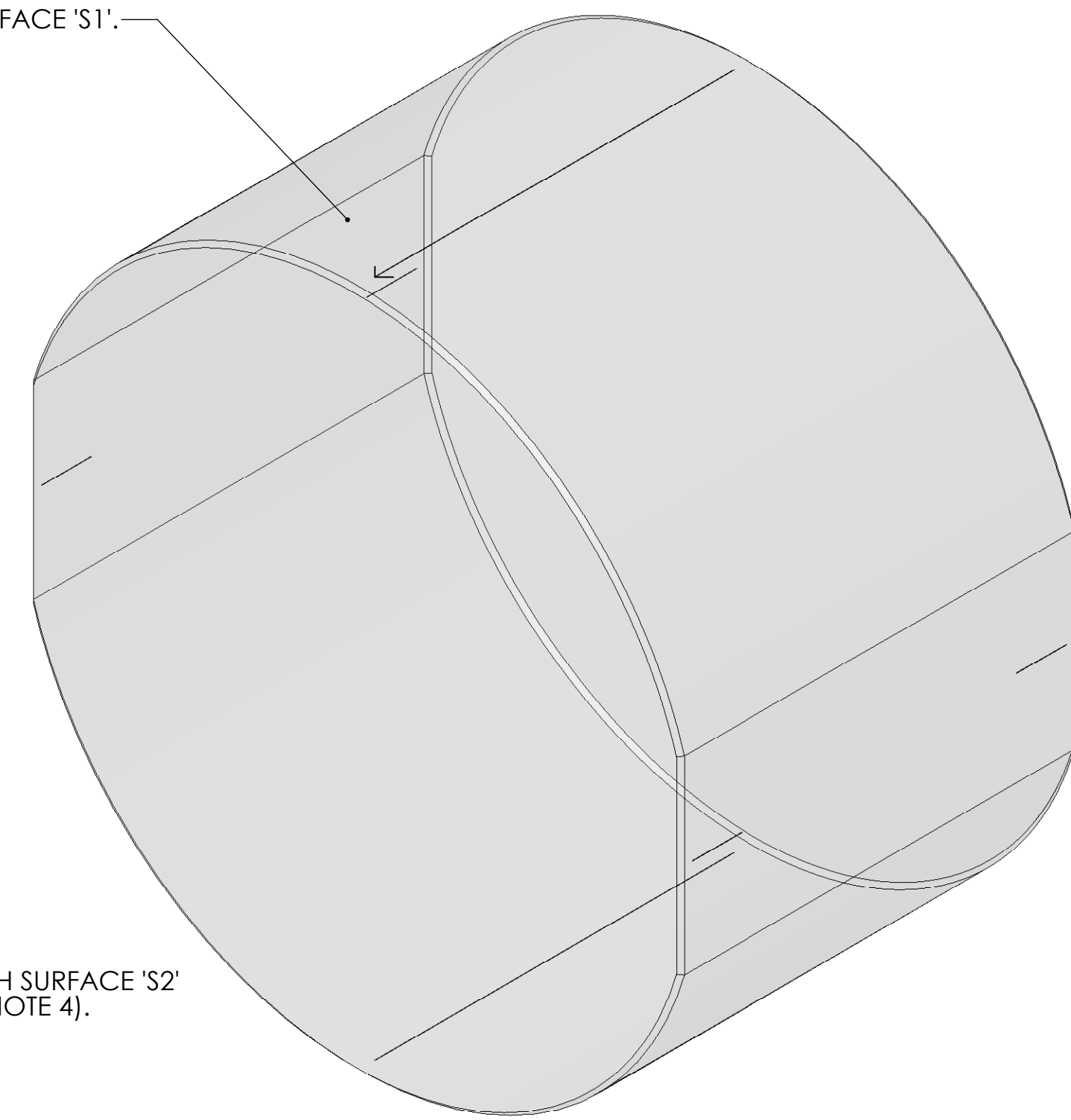


REV.	DATE	DCN #	DRAWING TREE #
v1	11th Jul 2019	LIGO-E1900200-v1	
v2			
v3			
v4			

SUBSTRATE IS SHOWN IN SUSPENDED STATE WITH VERTICAL WEDGE (THICK SIDE DOWN). THE ARROWED LINE IS SHOWN ON THE THIN SIDE, AND AS STATED POINTS TO SURFACE 'S1'.



TOP VIEW

ETCH OR GRIND LEGIBLE REFERENCE GROOVE (0.25mm ± 0.05mm WIDE) ALONG Φ WITHIN ±1° CLOCKING ANGLE (WITH RESPECT TO DATUM FEATURE -A-), PARALLEL TO THE CYLINDRICAL AXIS (DEFINED BY DATUM FEATURE -A-) WITH ARROW POINTING TO SURFACE 'S1' WITHIN ±0.1mm

BARREL (SIDE) AND BEVEL POLISH (SEE NOTE 3)

0.6 C (REFER TO NOTE 8.)

2X, 29.0 ± 0.5 ON BOTH FLATS

2X, 6.0

Φ 340.00 ± 0.25
0.1
0.25 C

S6 POLISH SURFACE 'S6' (SEE NOTE 3).

POLISH SURFACE 'S1' (SEE NOTE 4).

S2 POLISH SURFACE 'S2' (SEE NOTE 4).

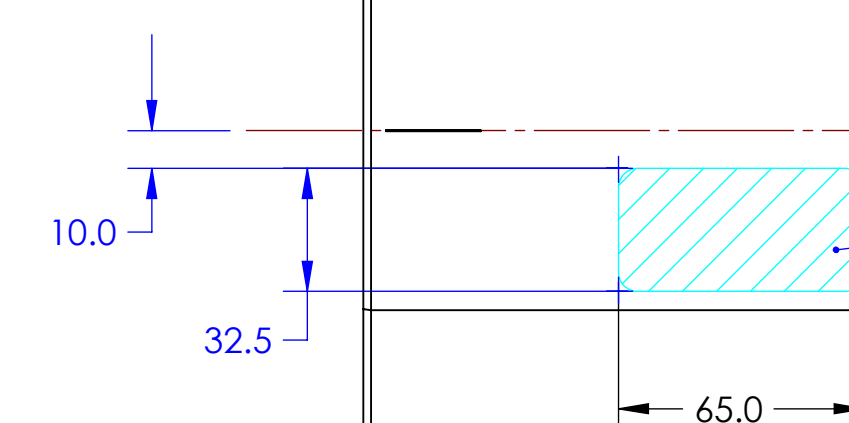
ETCH OR GRIND SERIAL NUMBER, APPROX. WHERE SHOWN, LETTERING APPROX. 4mm HIGH (SEE NOTE 7 FOR FURTHER DETAILS)

POLISH CROSS HATCHED AREA SEE NOTE 6 (REPEAT ON SURFACE 'S3').

POLISH SURFACE 'S4' SEE NOTE 5 (REPEAT ON SURFACE 'S3')

4X, R5 TYP

2X, 2.0 ± 0.2 x 45° ± 5° CHAMFER, ALL AROUND



(2X, 95 TYP)

90.0°

0.25 C

0.25 B
0.25 C

S5 POLISH SURFACE 'S5' (SEE NOTE 3).

326.5 ± 0.2 -TBD

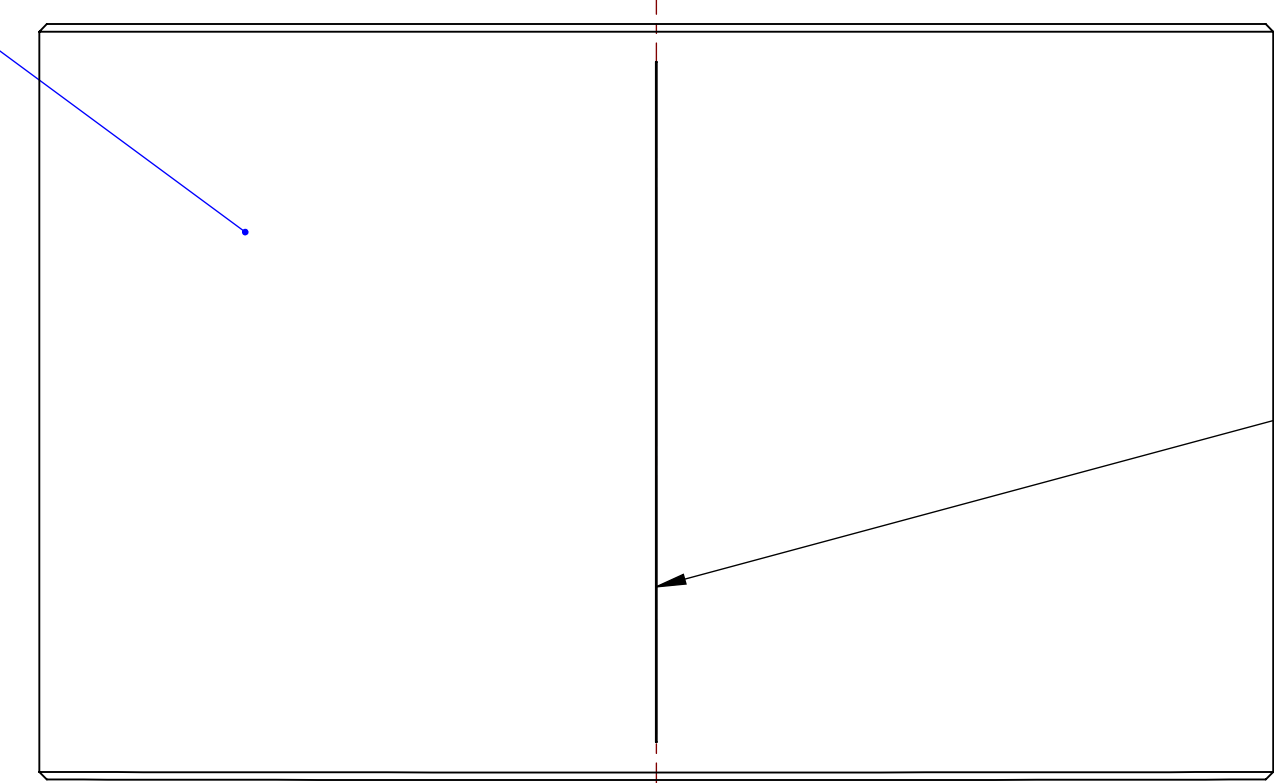
0.2 A

.07° +.03°
-.00°
WEDGE ANGLE

BARREL (SIDE) AND BEVEL POLISH (SEE NOTE 3)

2X, ETCH OR GRIND LEGIBLE REFERENCE GROOVE (WIDTH 0.25mm ± 0.05mm) ALONG Φ, PARALLEL TO THE CYLINDRICAL AXIS (DEFINED BY DATUM FEATURE -A-). REPEAT ON SURFACE 'S4' WITHIN ±0.1mm

ETCH OR GRIND LEGIBLE REFERENCE GROOVE (0.25mm ± 0.05mm WIDE) ALONG Φ WITHIN ±1° CLOCKING ANGLE (WITH RESPECT TO DATUM FEATURE -A-), PARALLEL TO THE CYLINDRICAL AXIS (DEFINED BY DATUM FEATURE -A-) WITHIN ±0.1mm



BOTTOM VIEW

DRAFT
v1 is a draft for purposes of solicitation of proposals for re-polishing. We anticipate the tolerance at locations C8 and B5 of LIGO-D1900269 will change after negotiation with the successful bidder

MANUFACTURE NOTES:

- DO NOT SCALE FROM DRAWING.
- INTERPRET DRAWING AS PER ANSI Y14.5M 1994.
- BARREL (SIDE) AND BEVEL POLISH PER E1900199.
- FINISH SURFACES 'S1' AND 'S2' AS PER E1900199.
- FINISH (FLAT) SURFACES 'S3' AND 'S4' AS PER E1900199.
- FINISH CROSS HATCHED AREA ON 'S3' & 'S4' AS PER E1900199.
- REFER TO E1900199 FOR INFORMATION ON SERIAL NUMBER.
- INTENDED TO CAPTURE ALLOWABLE WEDGE ANGLE CLOCKING TOLERANCE OF ±5°.
- APPLY COATING PER E1900199.

PARTS LIST

NOTES: (UNLESS OTHERWISE SPECIFIED):
DIMENSIONS ARE IN MILLIMETERS

TOLERANCES:
X ± 0.1
XX ± 0.05
ANGULAR ± 0.1°

MATERIAL:
REF E080047-v1

FINISH: SEE NOTES

PART NAME: ETM SUBSTRATE

NAME	DATE	SIZE	DWG. NO.	REV.
DRAWN: C. TORRE	14 Nov 08	D	D1900269	v1
CHECKED: D. COVINE	19 Nov 08			
CHECKED: E. GOSWAMI	19 Nov 08			
APPROVED: D. COVINE	17 Dec 08			

SCALE: 1:2 PROJECTION: FIRST ANGLE SHEET 1 OF 1