

D0902251 Stage1-2 Vertical Sensor Target Mount, PART PDM REV: X-009, DRAWING PDM REV: X-002

REV.	DATE	DCN #	DRAWING TREE #
v1	01 Mar. 2010	E1000049	E1000025

NOTES CONTINUED:

5. SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED.
EXAMPLE DXXXXXX-VV, TYPE-XX, S/N XXX.

6. APPROXIMATE WEIGHT = 0.72 LB.

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

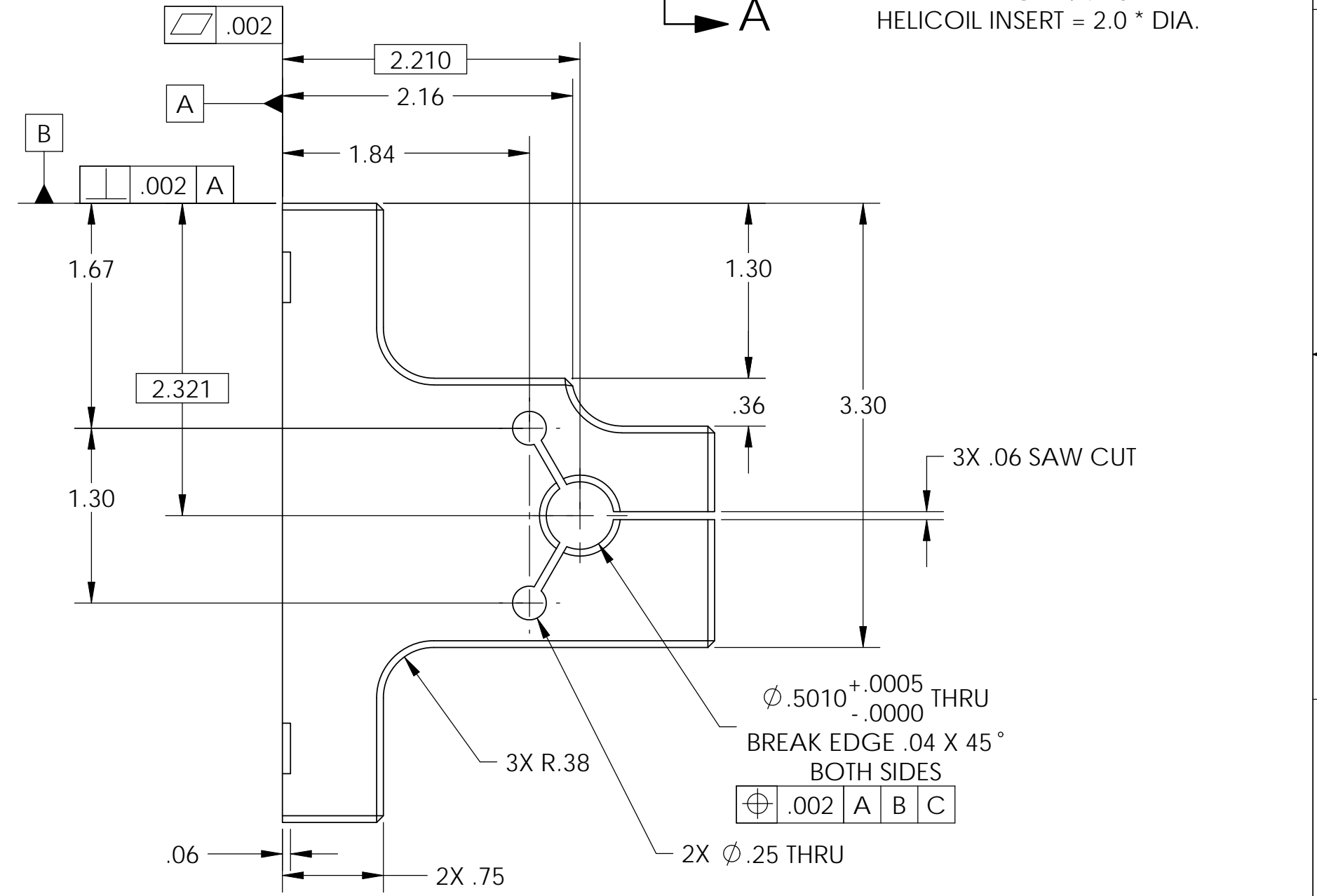
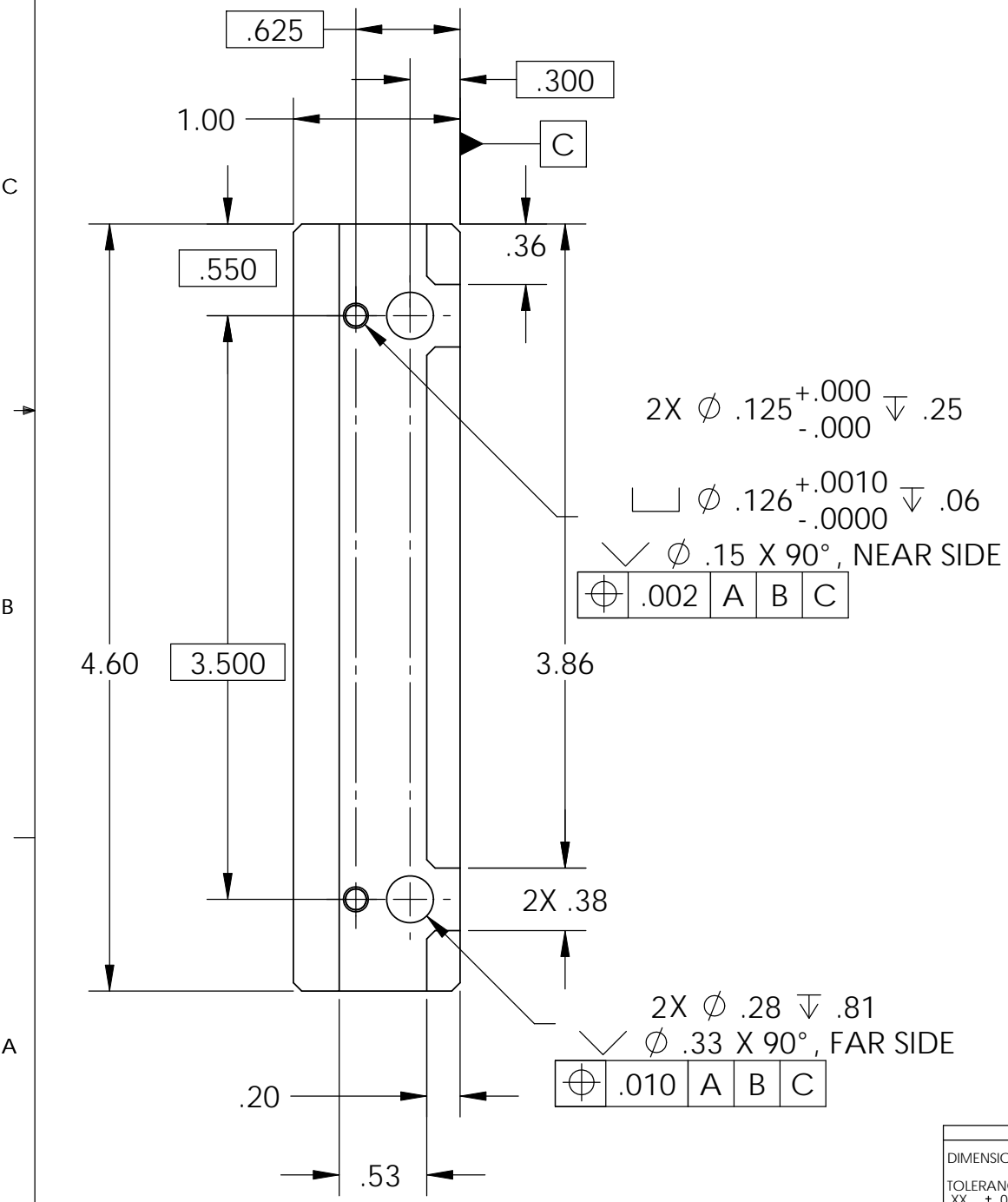
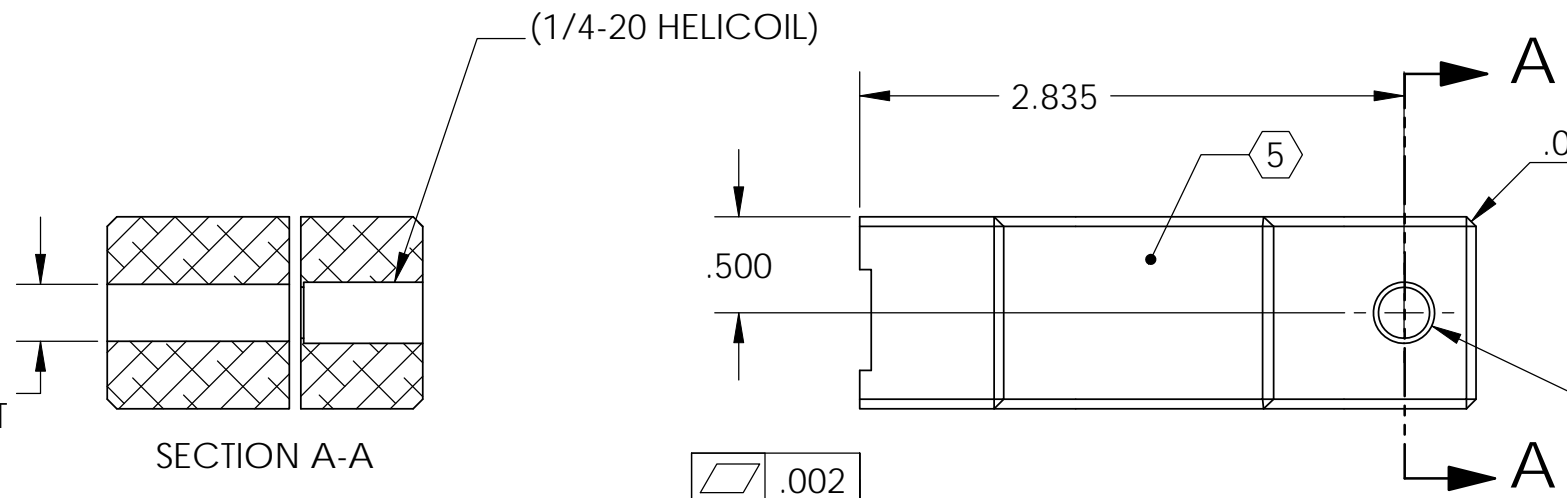
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.

10. A TRUE POSITION TOLERANCE OF $\phi .010$ IS - THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.

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NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± .5°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. BREAK ALL CORNERS AND EDGES .03 X 45°. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		STAGE 1-2, VERTICAL SENSOR TARGET MOUNT	
MATERIAL		FINISH		NEXT ASSY		DESIGNER	
6061-T6 Al		32 μ inch		D0902534		S.BARNUM	
						01 Mar. 2010	
						M.HILLARD	
						01 Mar. 2010	
						F.MATICHARD	
						01 Mar. 2010	
						K.MASON	
						01 Mar. 2010	
				SYSTEM		SUB-SYSTEM	
				ADVANCED LIGO		SEI	
				DRAWN		CHECKED	
				M.HILLARD		F.MATICHARD	
				01 Mar. 2010		01 Mar. 2010	
				APPROVAL		APPROVAL	
				K.MASON		K.MASON	
				01 Mar. 2010		01 Mar. 2010	
				SCALE: 1:1		PROJECTION:	
						FIRST ANGLE	
						SHEET 1 OF 1	

8 7 6 5 4 3 2 1