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: DXXXXXXX-VY, TYPE-XX, S/N XXX
6. APPROXIMATE WEIGHT = 13.09 LB [5.94 kg].
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. 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 MATERIAL SHOUL DBE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTITIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

⟨10⟩ ALL TAPPED HOLES- USE .005 OVERSIZE BOTH DRILL & TAP.

MANUFACTURING PROCESS (DOES NOT PERTAIN TO .0003 T.I.R. COPLANAR REGIONS, SHEET 4):

PURCHASE 3/4" ALUM. ALLOY 6061-T651 PLATE.

ROUGH BLANCHARD GRIND, EQUAL AMOUNTS FROM STOCK FROM EACH SIDE OF ALUM. PLATES.

COLD STABILIZE PLATES.

FINISH GRIND BOTH SIDES TO: .535 THICKNESS WITH A FLATNESS OF .002 ACROSS ENTIRE FACE.

RE-CLAMP, MACHINE & ENGRAVE BALANCE OF PART IN THE FLAT.

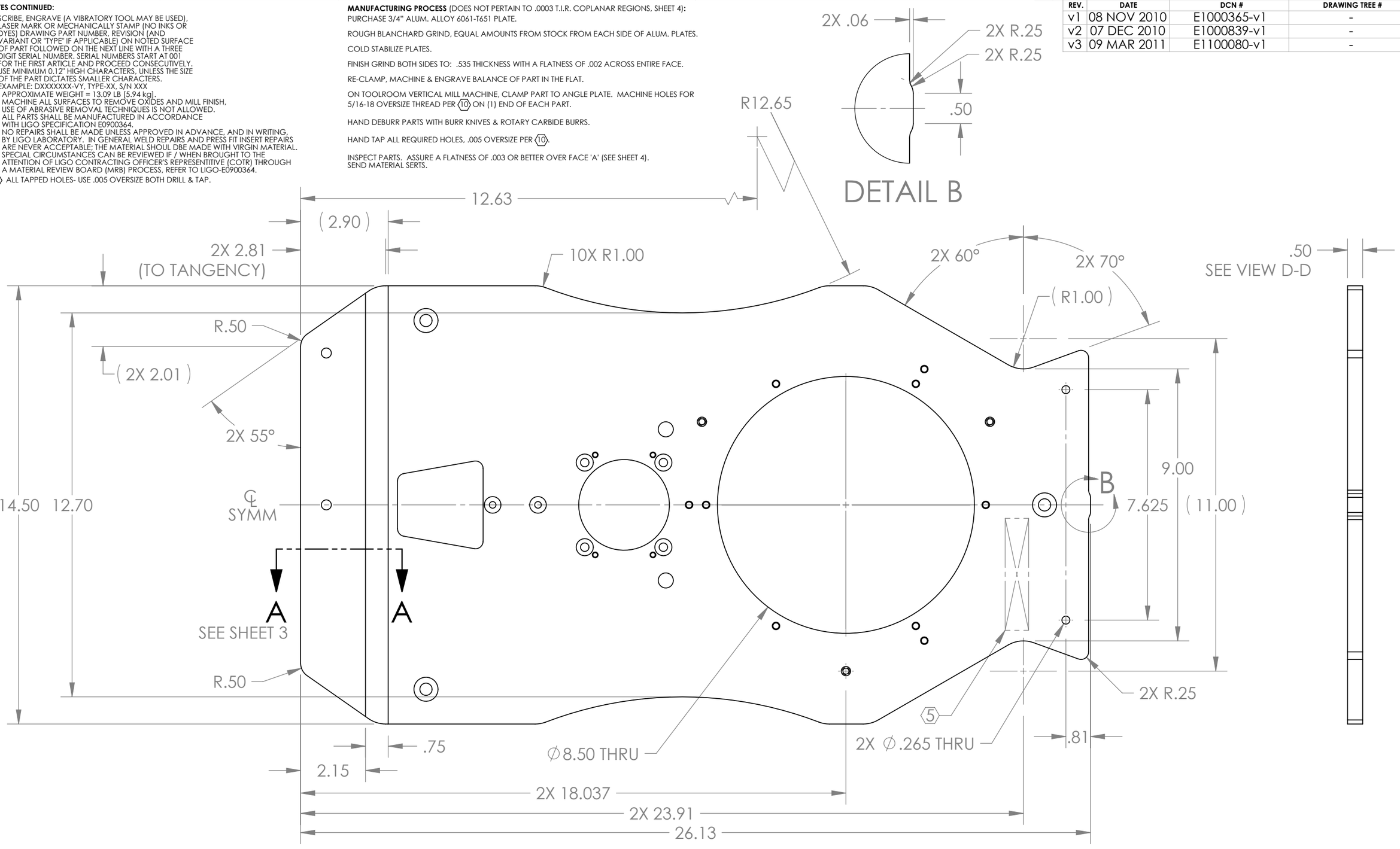
ON TOOLROOM VERTICAL MILL MACHINE, CLAMP PART TO ANGLE PLATE. MACHINE HOLES FOR 5/16-18 OVERSIZE THREAD PER ⟨10⟩ ON (1) END OF EACH PART.

HAND DEBURR PARTS WITH BURR KNIVES & ROTARY CARBIDE BURRS.

HAND TAP ALL REQUIRED HOLES, .005 OVERSIZE PER ⟨10⟩.

INSPECT PARTS. ASSURE A FLATNESS OF .003 OR BETTER OVER FACE 'A' (SEE SHEET 4). SEND MATERIAL SERTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	08 NOV 2010	E1000365-v1	-
v2	07 DEC 2010	E1000839-v1	-
v3	09 MAR 2011	E1100080-v1	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± 0.5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, R.02 MIN.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL: 6061-T6 Al
FINISH: 63 µinch Ra

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SYSTEM: ADVANCED LIGO
SUB-SYSTEM: AOS
NEXT ASSY: D1003120

PART NAME	TRANSMON TELE END PLATE ENTRY 3 TUBE	
DESIGNER	K. MAILAND	21 JUN 2010
DRAFTER	C. CONLEY	08 NOV 2010
CHECKER	K MAILAND	04 MAY 2010
APPROVAL	K MAILAND	04 MAY 2010

SIZE: B | DWG. NO.: D1000071 | REV.: v3
SCALE: NONE | PROJECTION: | SHEET 1 OF 5

D1000071 TRANSMON_TELE_END_PLATE_ENTRY_3_TUBE, PART PDM REV: X-100, DRAWING PDM REV: X-026

2X 5/16-18 UNC - 2B ↧ .63 (10)
.005 OVERSIZE BOTH DRILL & TAP
⌵ 90° TO MAJOR ∅
ONE ON ℄ ±.005

A

.25

D

(2X 18.037)

20.460

13.890

10.19

7.34

1.500

.85

2X ∅ .221 THRU
⌵ ∅ .55 X 82°

(∅8.50 THRU)

5.025

5.025

℄ SYMM

12.20

60°
6 EQL SP ±.005

℄ SYMM

2.40

1.58

2X
∅ .332 THRU

C

D

C

2.33

5.79

9X 1/4-20 UNC - 2B THRU (10)
.005 OVERSIZE BOTH DRILL & TAP
⌵ 90° TO MAJOR ∅ BOTH SIDES

B

3X ∅ .406 THRU
⌵ ∅ .80 X 82°

∅9.250

∅10.375

∅11.000

3X 1/4-20 UNC - 2B THRU ALL (10)
⌵ ∅ .31 X 90°, NEAR SIDE
⌵ 90° TO MAJOR ∅, FAR SIDE
EQL SP ±.005

A

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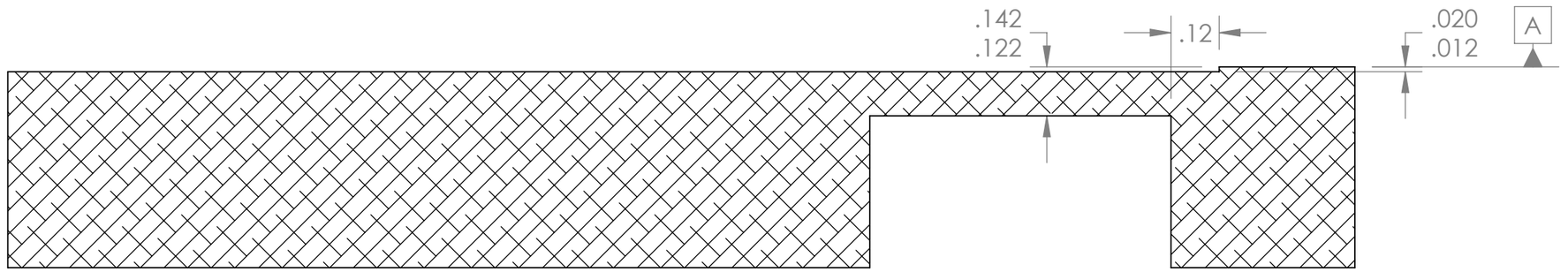
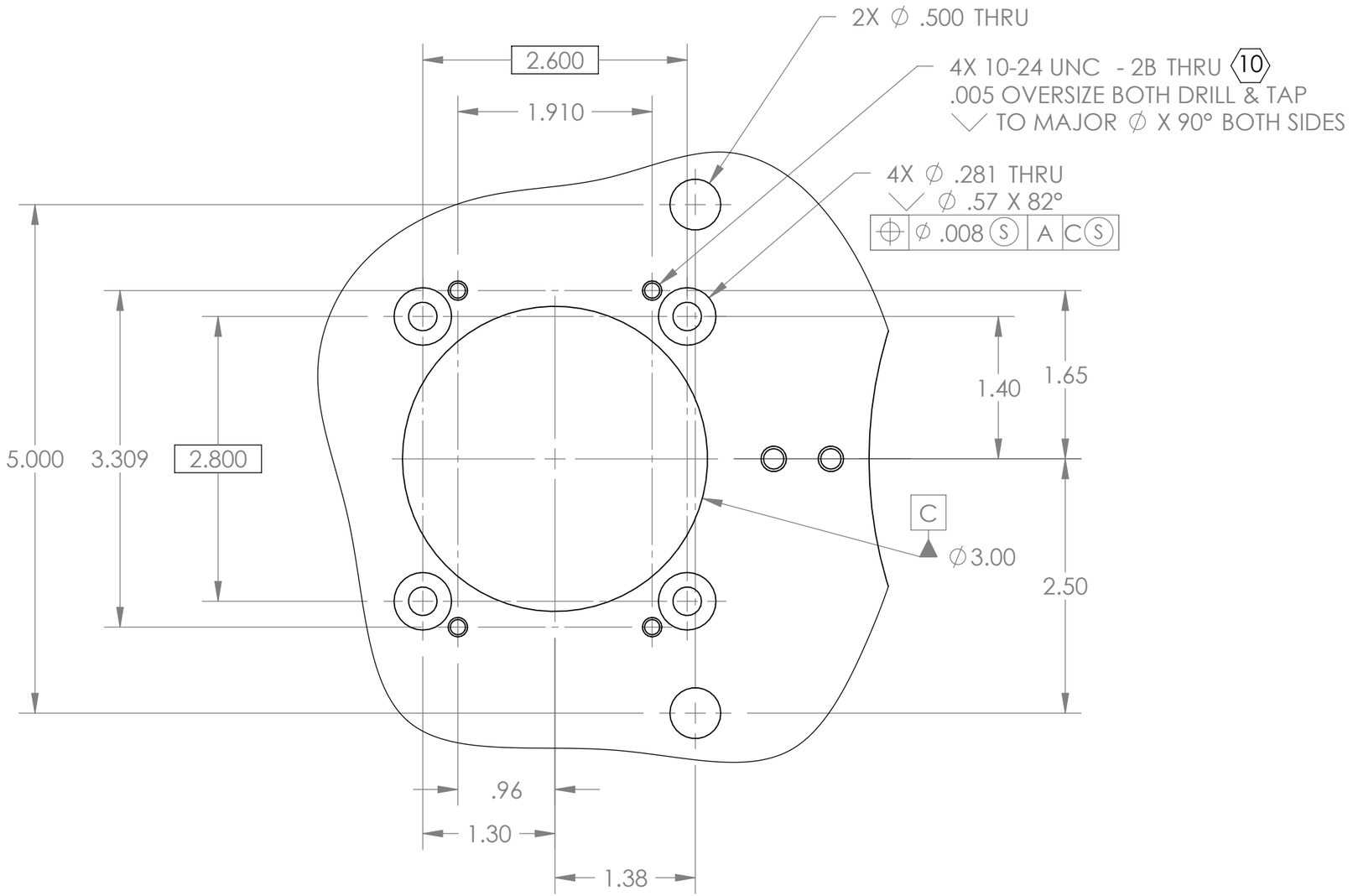
SIZE	DWG. NO.	REV.
B	D1000071	v3

SCALE:NONE PROJECTION: SHEET 2 OF 5

D1000071 TRANSMON_TELE_END_PLATE_ENTRY_3_TUBE, PART PDM REV: X-100, DRAWING PDM REV: X-026



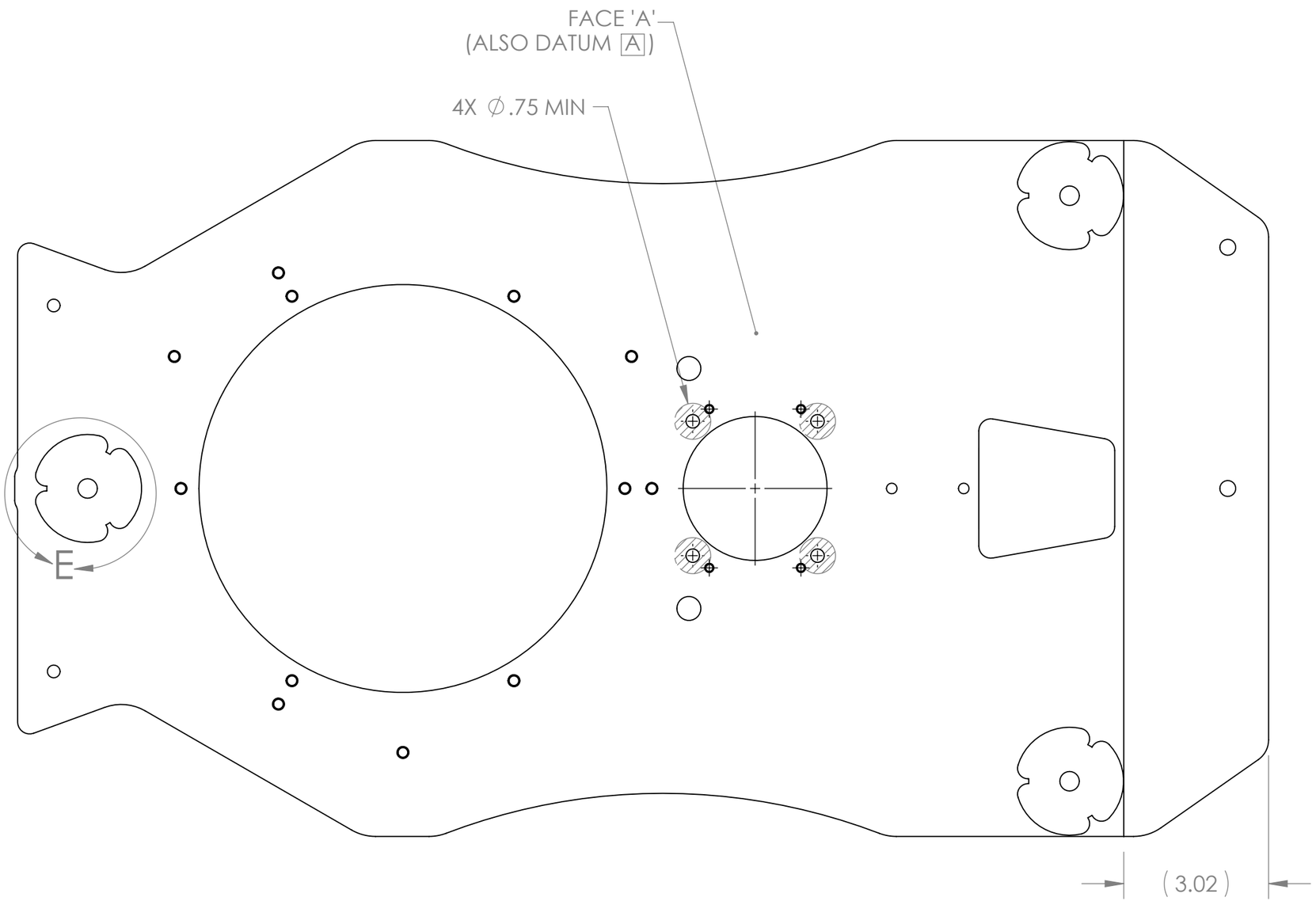
SECTION A-A



DETAIL C

D1000071 TRANSMON_TELE_END_PLATE_ENTRY_3_TUBE, PART PDM REV: X-100, DRAWING PDM REV: X-026

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE B	DWG. NO. D1000071	REV. v3
SCALE:NONE	PROJECTION:	SHEET 3 OF 5



VIEW D-D

ALL HATCHED AREAS .0003 T.I.R. COPLANAR
INCLUDING 9 AREAS ON FEATURES DETAIL E, SEE SHEET 5

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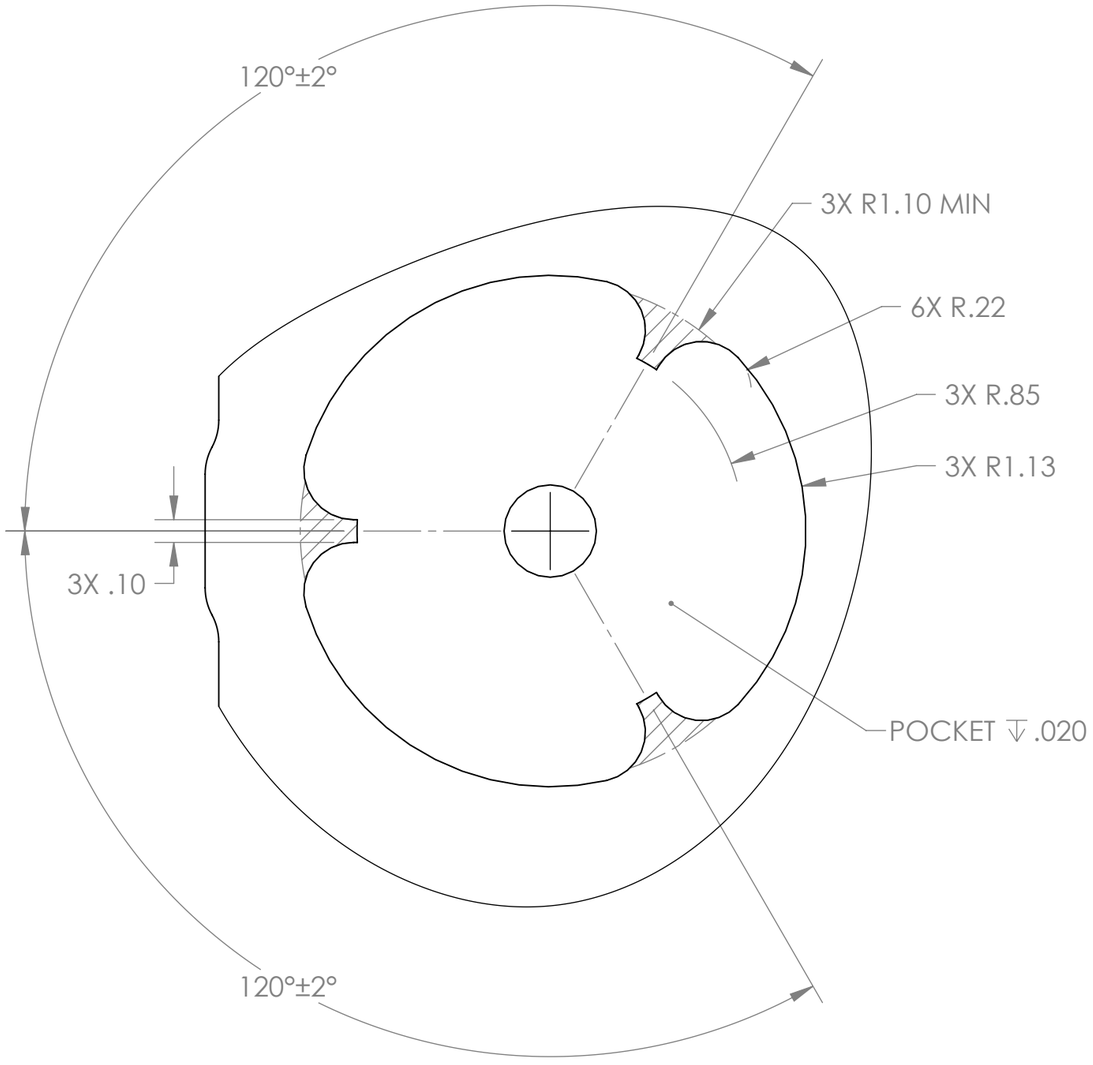
SIZE	DWG. NO.	REV.
B	D1000071	v3

SCALE:NONE PROJECTION: SHEET 4 OF 5

D1000071 TRANSMON_TELE_END_PLATE_ENTRY_3_TUBE, PART PDM REV: X-100, DRAWING PDM REV: X-026



DETAIL E

3 PLACES
9 HATCHED AREAS .0003 T.I.R. COPLANAR
WITH HATCHED AREAS ON PARENT VIEW

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SIZE	DWG. NO.	REV.
B	D1000071	v3

SCALE:NONE PROJECTION: SHEET 5 OF 5

D1000071 TRANSMON_TELE_END_PLATE_ENTRY_3_TUBE, PART PDM REV: X-100, DRAWING PDM REV: X-026