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 = .18 LB [.08 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.

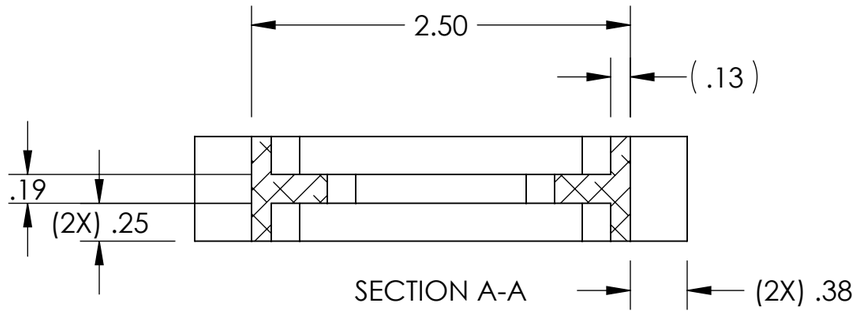
9. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOUL DBE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTITIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

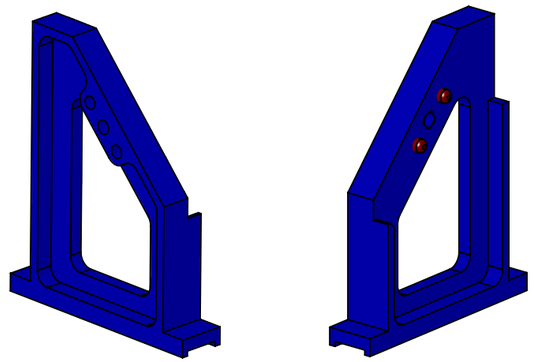
10. NOTED HOLE: .005" OVERSIZE BOTH DRILL & TAP.

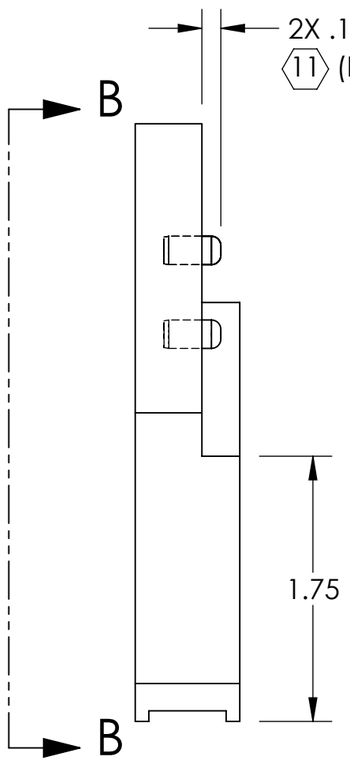
11. AT NOTED LOCATIONS, DRILL THRU FOR 3/16 DOWEL PIN, LIGHT PRESS FIT (LPF). PINS TO BE INSTALLED BY LIGO, AS NOTED, POST CLEAN & BAKE. INSTALL MCMASTER-CARR P/N 97395A455 OR EQUIVALENT.

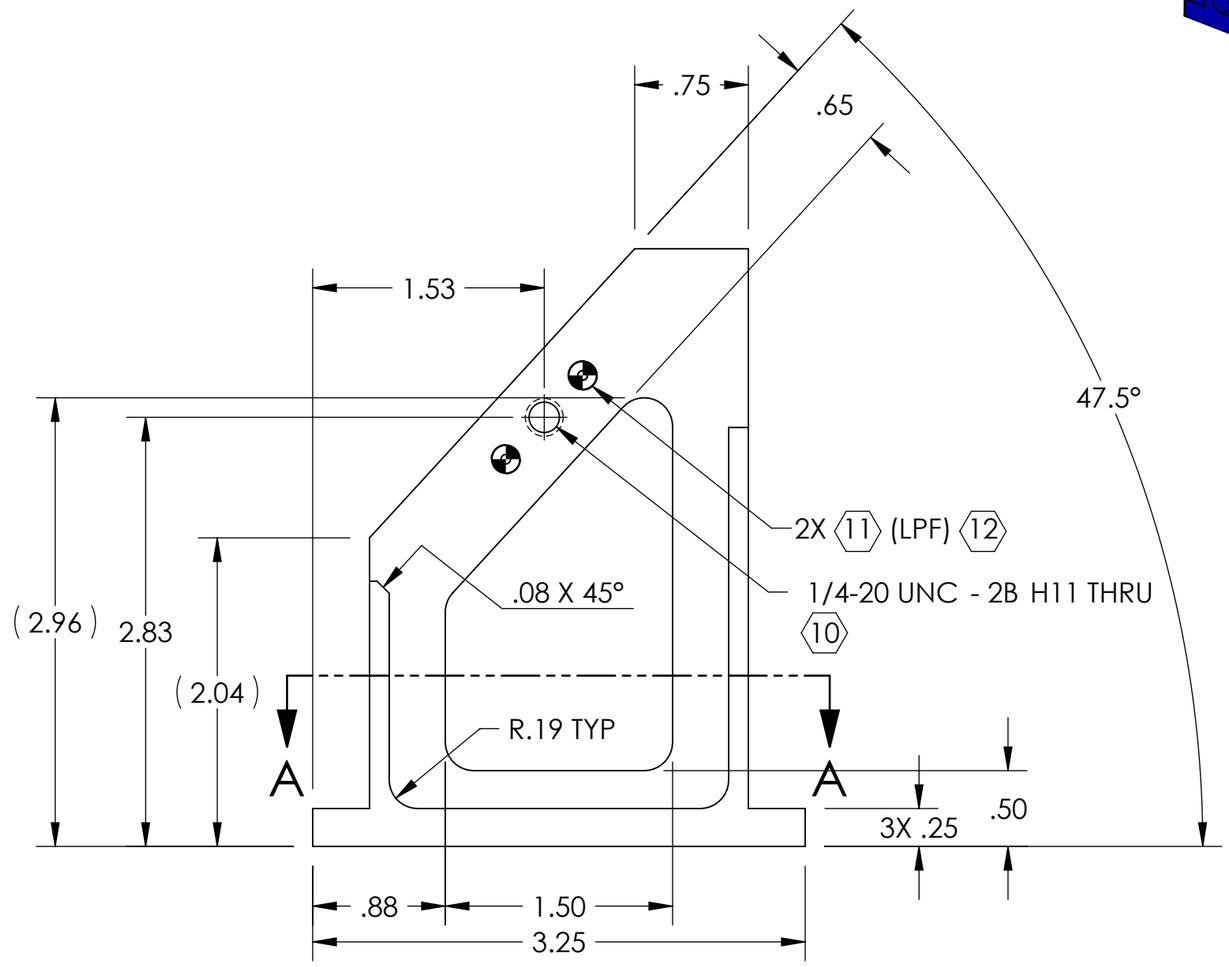
12. FOR FIRST ARTICLE (S/N 001): PINS ARE PRE-INSTALLED (BEFORE CLEAN & BAKE). DO NOT REMOVE.

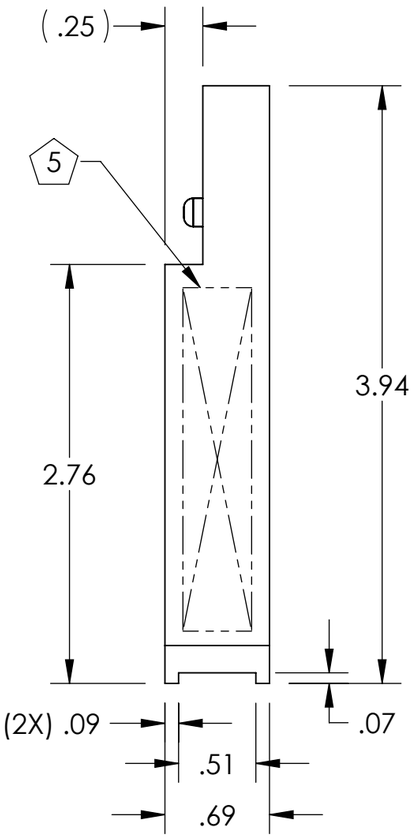
REV.	DATE	DCN #	DRAWING TREE #
v1	25 APR 2011	E1100351-v1	-
-	-	-	-
-	-	-	-







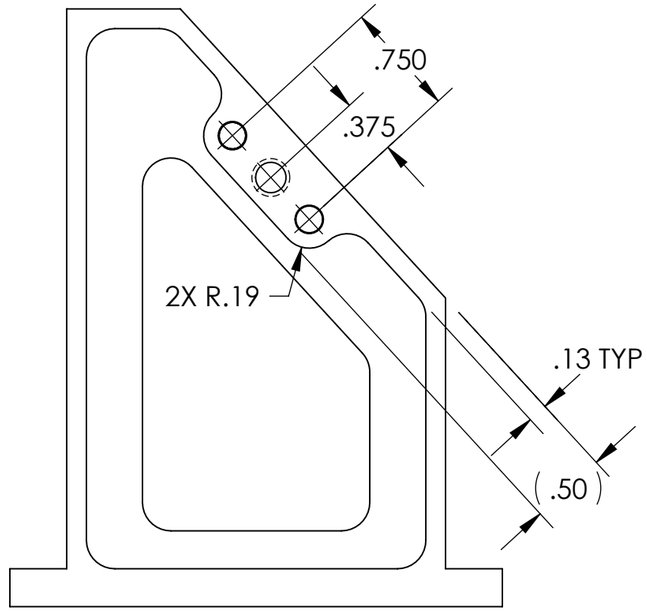




NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)							
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	MATERIAL: 6061-T6 Al	FINISH: 63 µinch Ra	LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	NEXT ASSY: D1000484

PART NAME: TMS, SISKIYOU MOUNT BRACKET, LOWER INBOARD					
DESIGNER	I. ROMERO	23 SEP 2010	SIZE	DWG. NO.	REV.
DRAFTER	M. MILLER	25 APR 2011	B	D1001435	v1
CHECKER					
APPROVAL			SCALE: NONE	PROJECTION:	SHEET 1 OF 2

D1001435 TMS, SISKIYOU MOUNT BRACKET, LOWER INBOARD, PART PDM REV: X-021, DRAWING PDM REV: X-015



VIEW B-B

D1001435 TMS, SISKIYOU MOUNT BRACKET, LOWER INBOARD, PART PDM REV: X-021, DRAWING PDM REV: X-015

LIGO	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE B	DWG. NO. D1001435		REV. v1
SCALE:NONE	PROJECTION:	SHEET 2 OF 2	