NOTES CONTINUED:

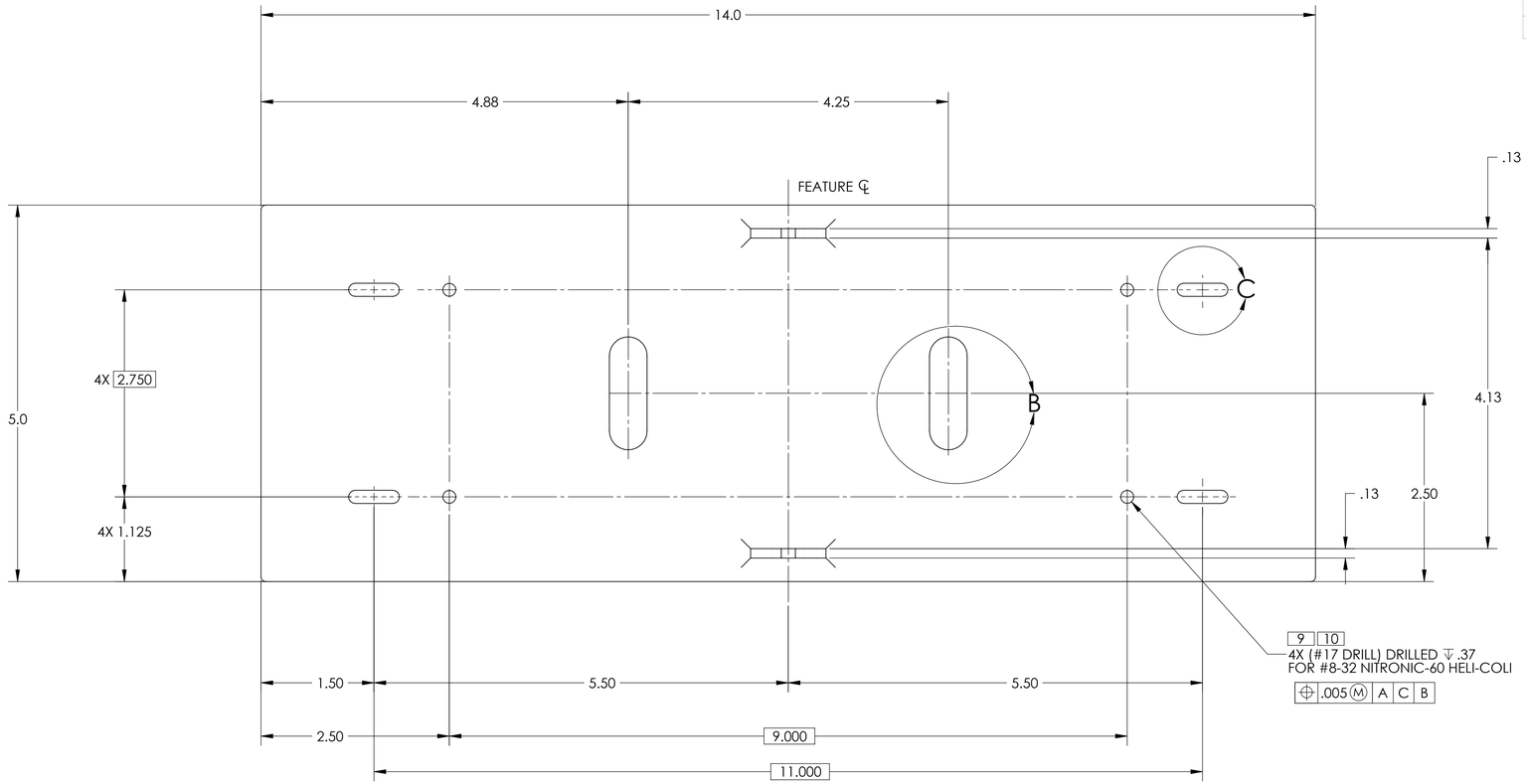
Ⓢ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

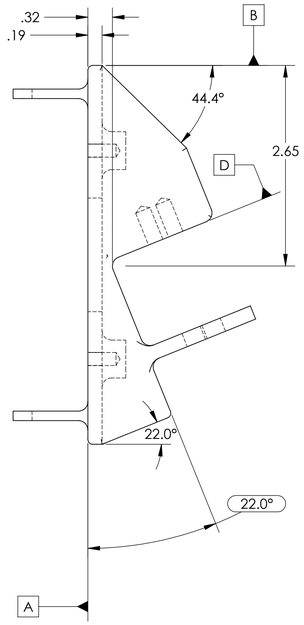
6. APPROXIMATE WEIGHT = 1.930 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

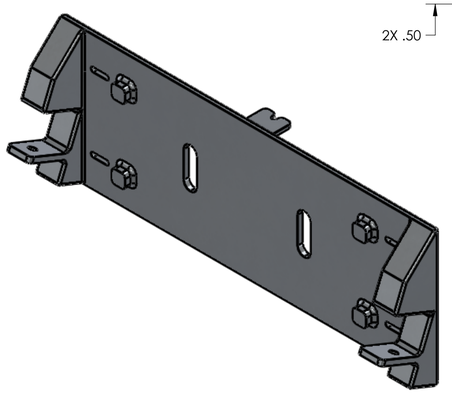
[9] ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

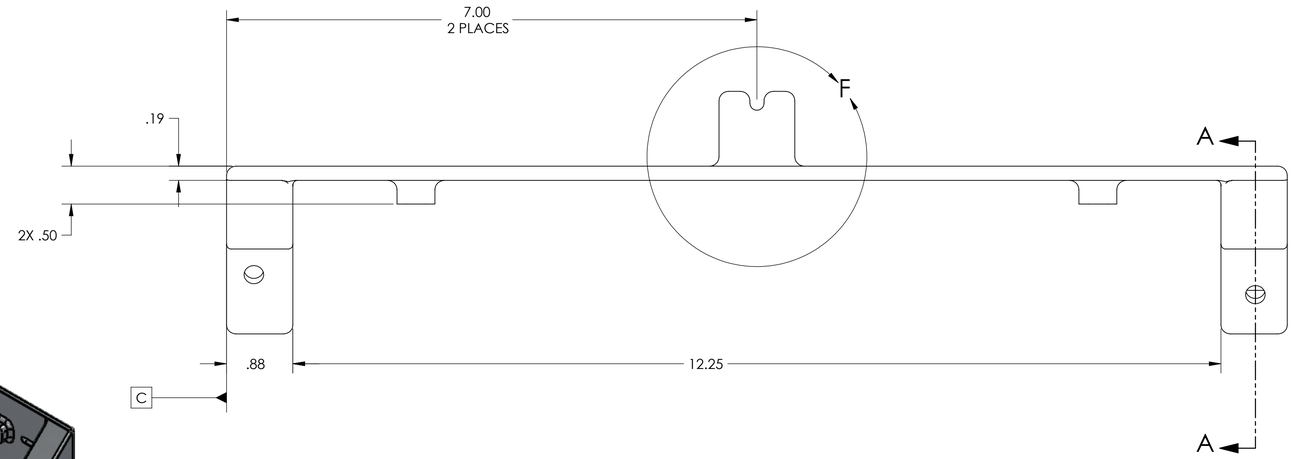
[10] ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

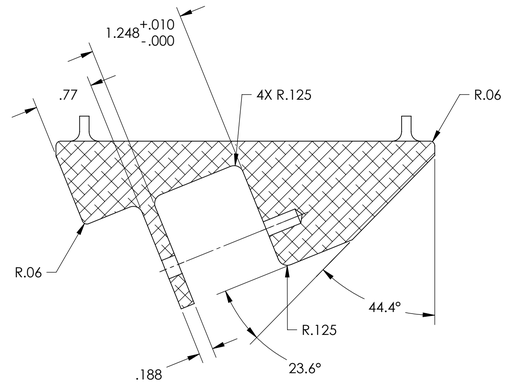
REV.	DATE	DCN #	DRAWING TREE #
v1	22-AUG-2010	-	-
-	-	-	-
-	-	-	-









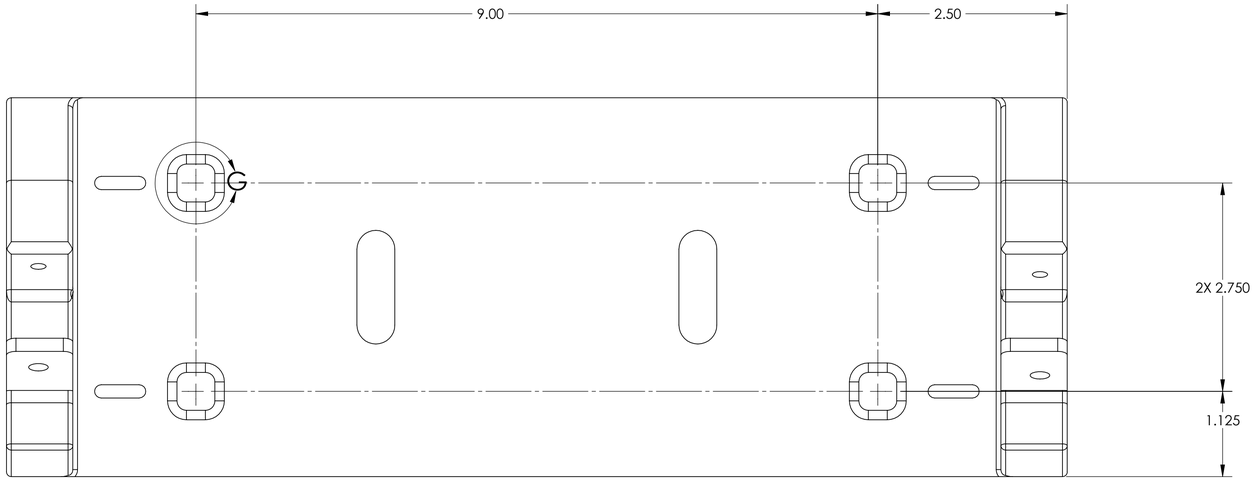


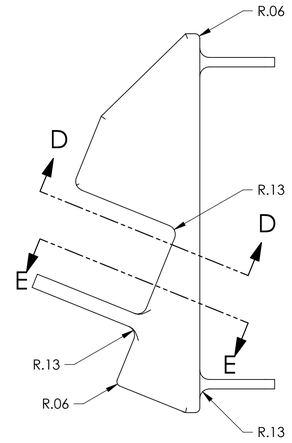
SECTION A-A

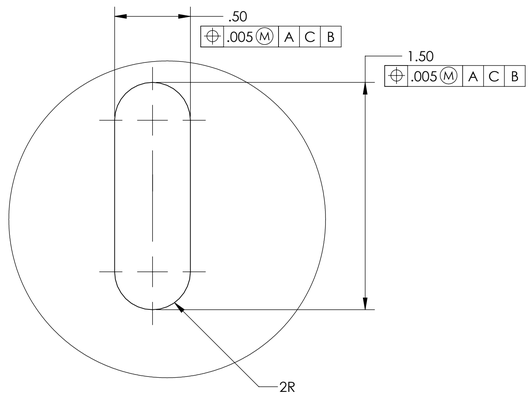
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.1°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	PART NAME: AZ FINE ADJUST PIVOT PLATE	
	MATERIAL: 6061-T6 (SS)	FINISH: 32 µinch	SYSTEM: ADVANCED LIGO / SUB-SYSTEM: AOS	NEXT ASSY: D1001742	

DESIGNER	M. JACOBSON	08 JUL 2010	SIZE: D	DWG. NO.: D1002312	REV.: v1
DRAFTER	A.COLE	22-AUG-2010			
CHECKER	M.JACOBSON	22-AUG-2010			
APPROVAL	C.TORRIE	22-AUG-2010	SCALE: 1:1	PROJECTION:	SHEET 1 OF 3

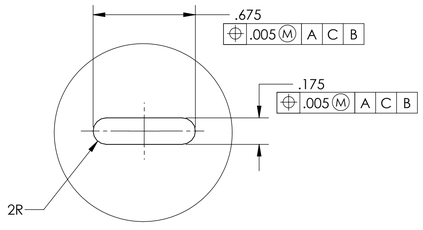
D1002312_TCS UHV AZ FINE ADJUST PIVOT PLATE, PART PDM REV. X-X19_DRAWING PDM REV. X-X13



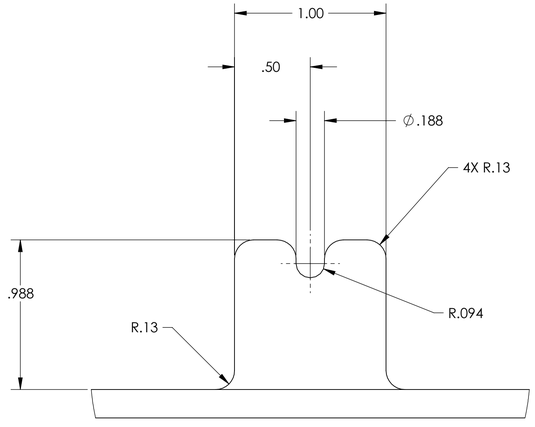




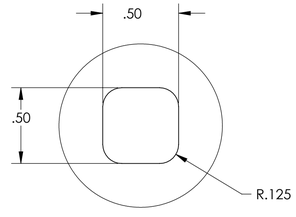
2X
DETAIL B
SCALE 2 : 1



4X
DETAIL C
SCALE 2 : 1



2X
DETAIL F
SCALE 2 : 1



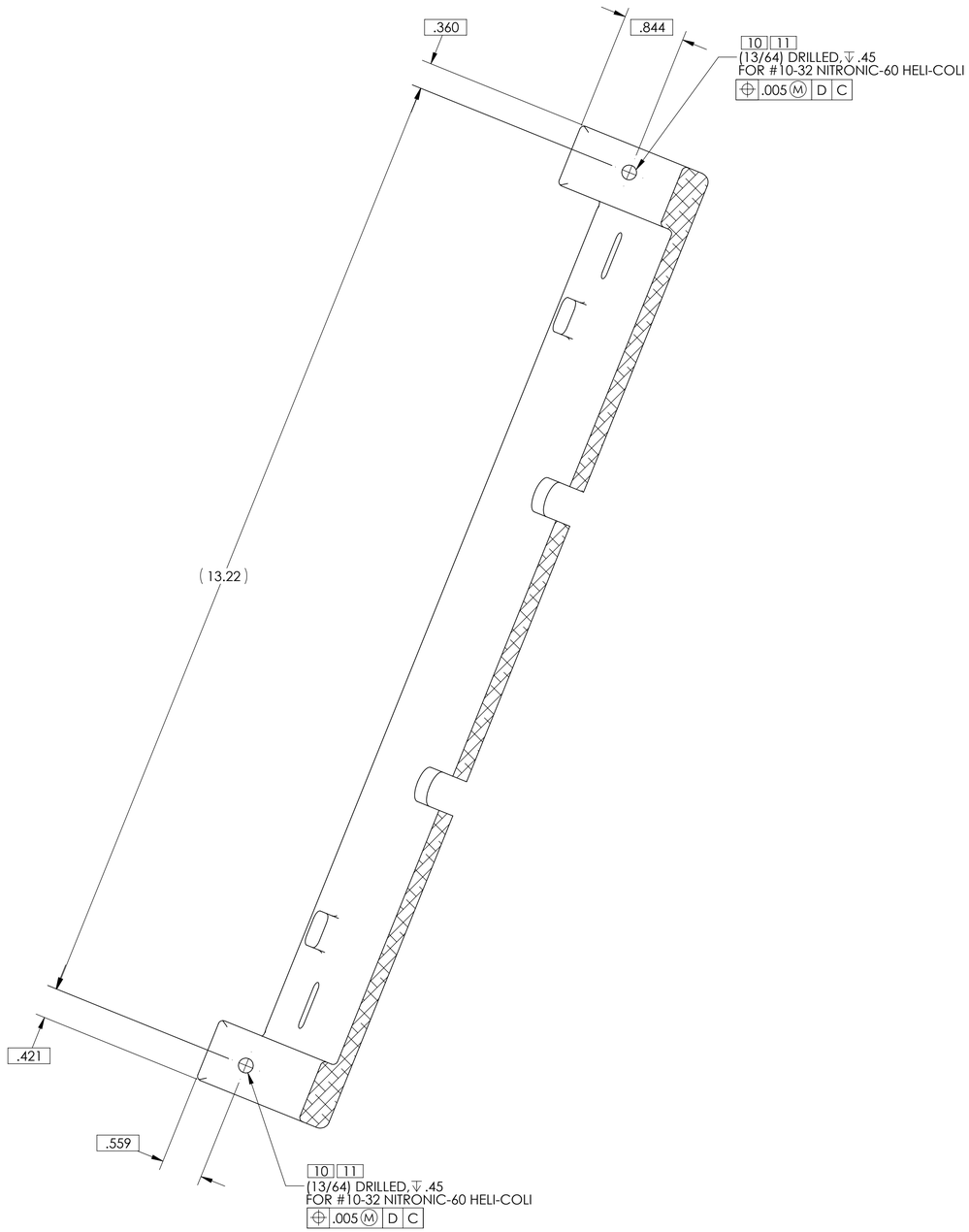
4X
DETAIL G
SCALE 2 : 1

D1002312_ICS UHV AZ RNE ADJUST PIVOT PLATE .PART PDM REV: X-019 .DRAWING PDM REV: X-013

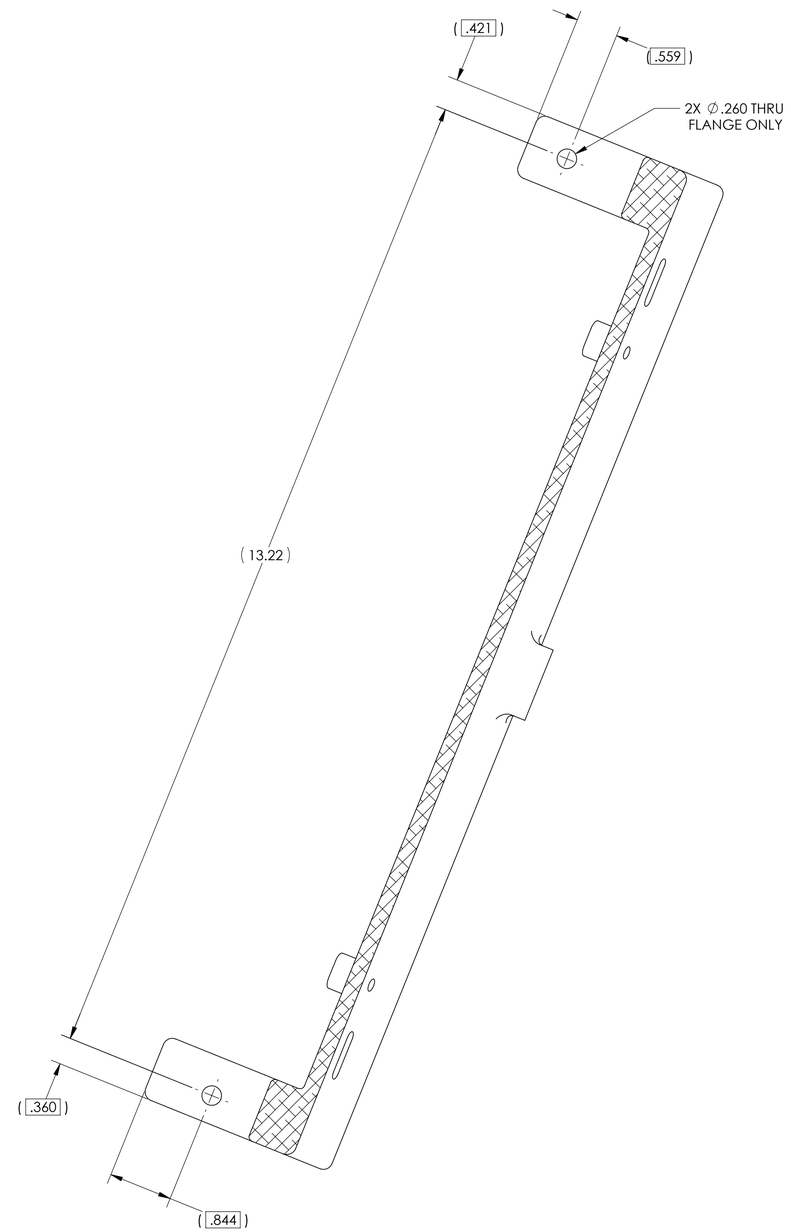
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
D	D1002312	v1

SCALE: 1:1 | PROJECTION: | SHEET 2 OF 3



SECTION D-D



SECTION E-E

LIGO	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.		REV.
D	D1002312		v1
SCALE: 1:1	PROJECTION:		SHEET 3 OF 3

D1002312_TCS UHV AJ FINE ADJUST PIVOT PLATE, PART PDM REV: X-019, DRAWING PDM REV: X-013