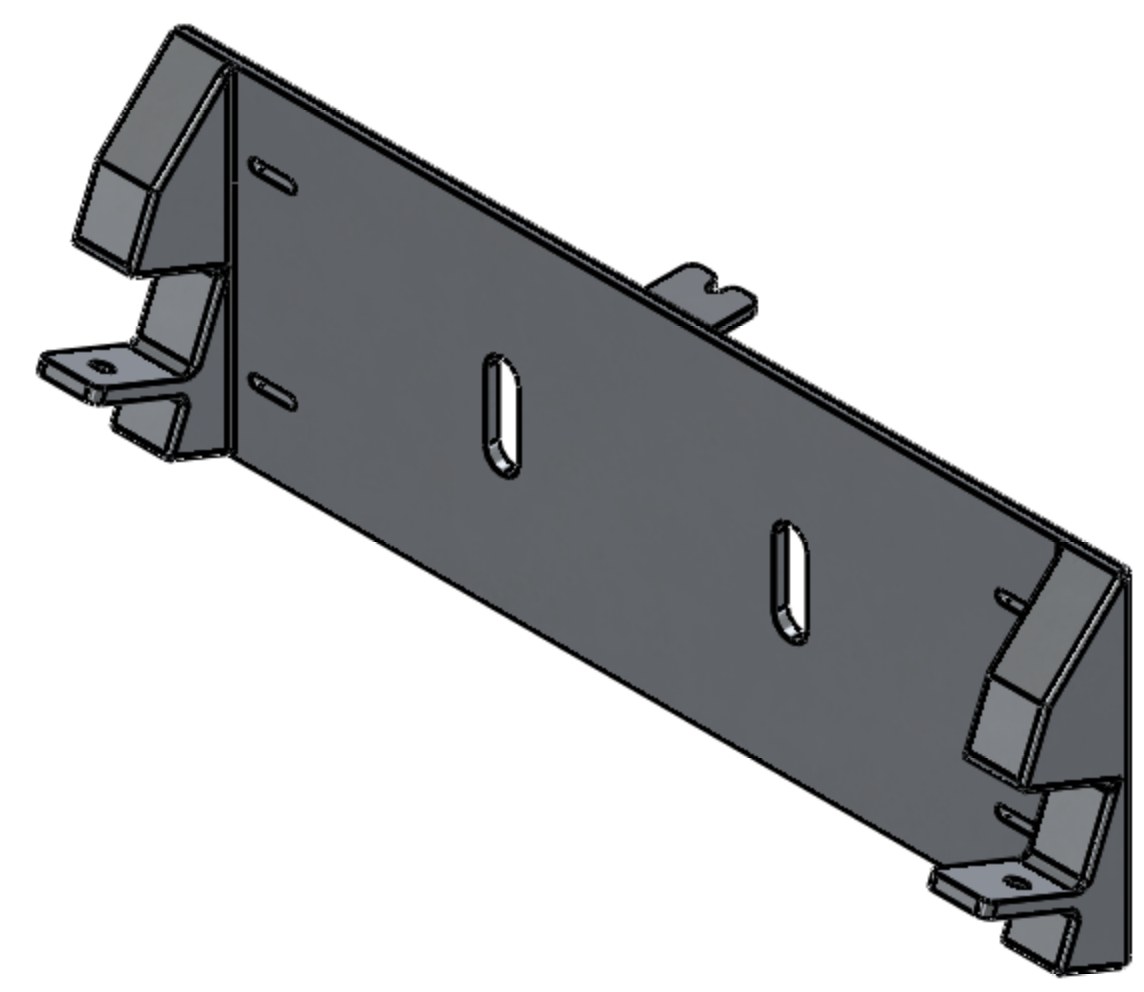
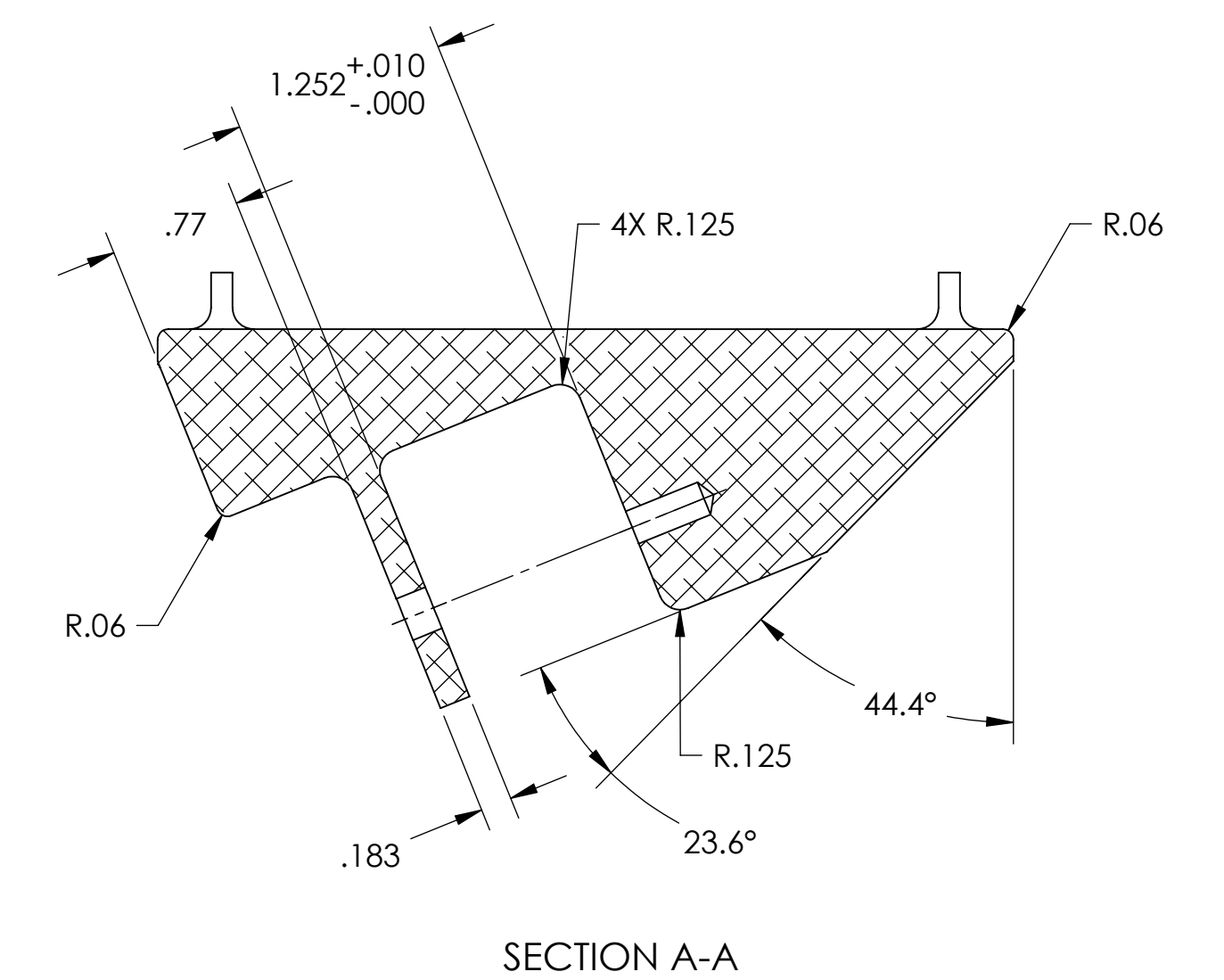
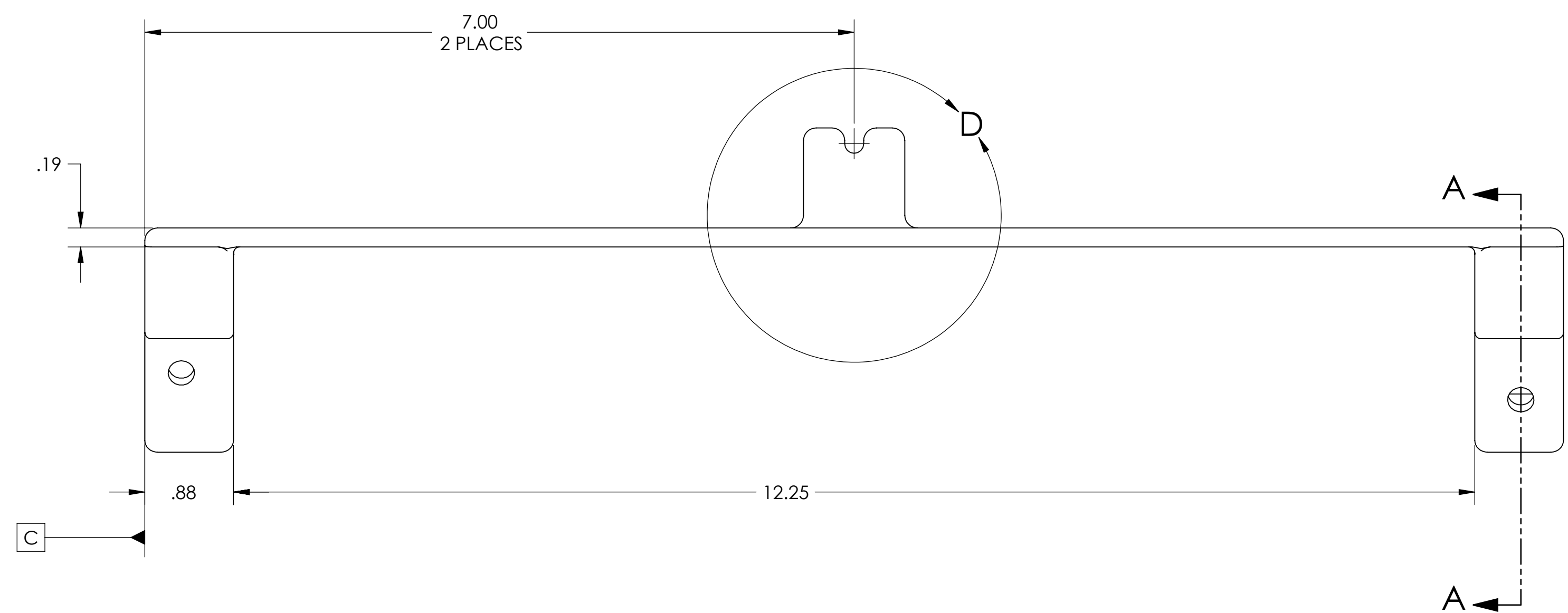
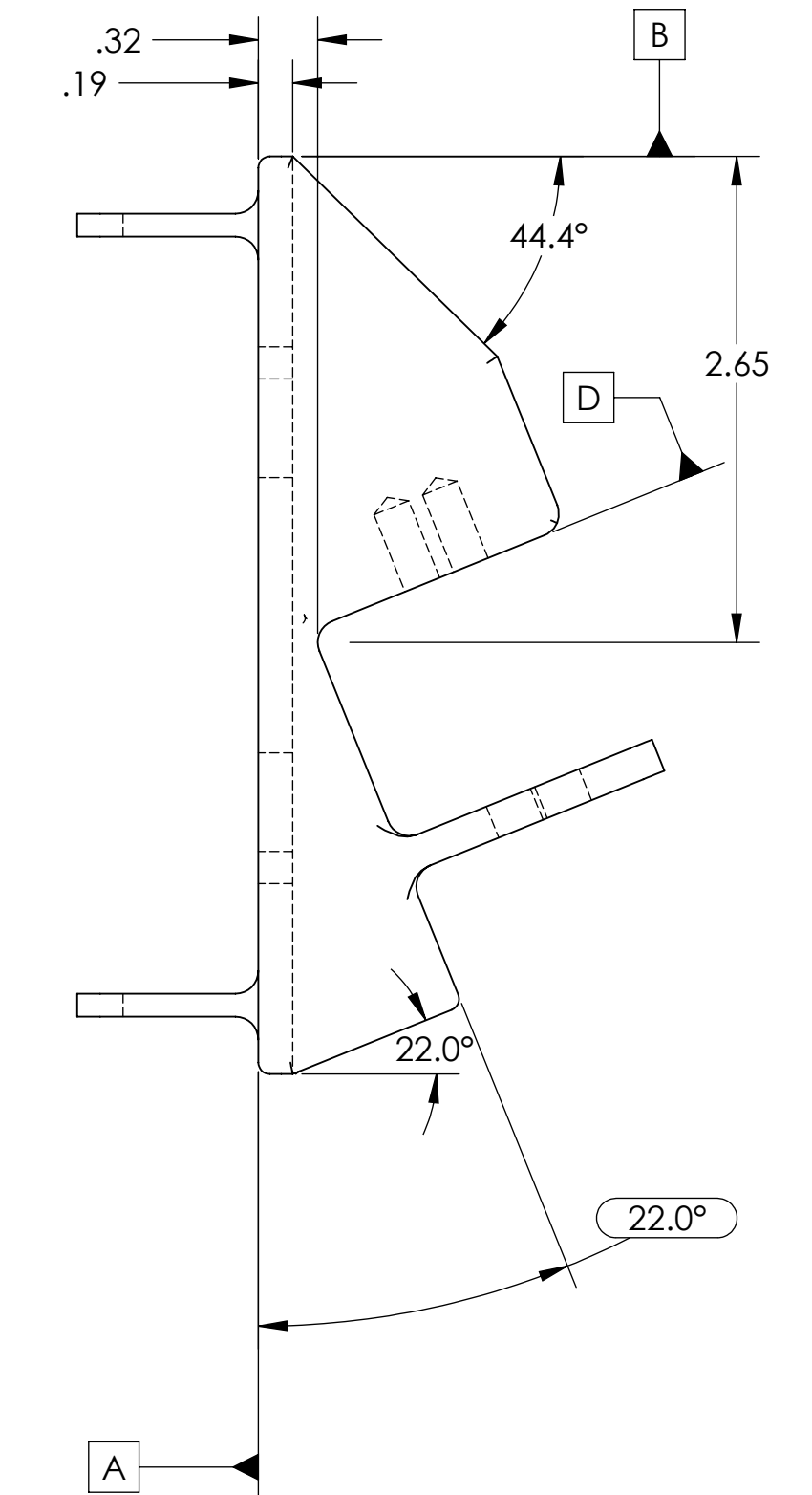
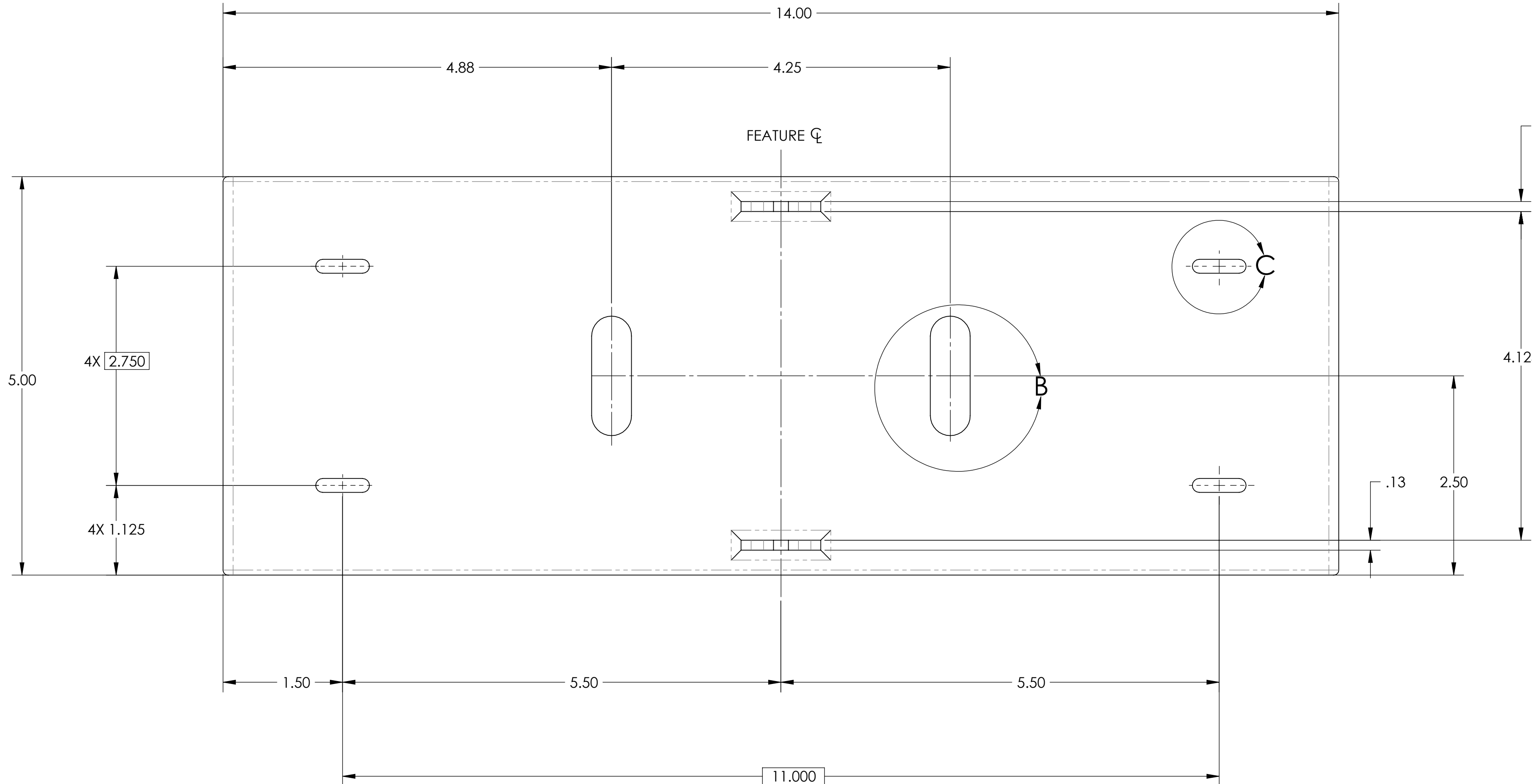


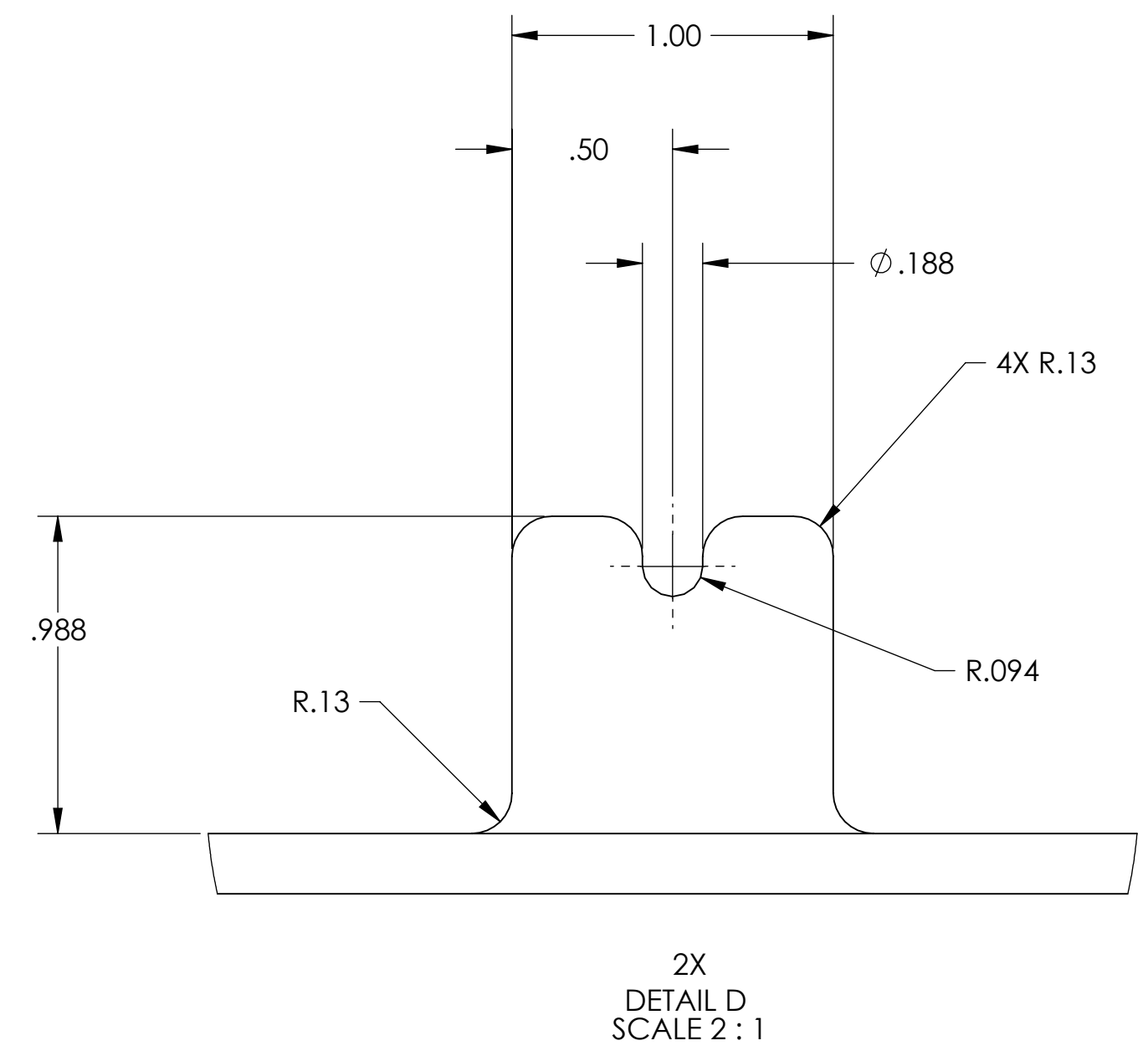
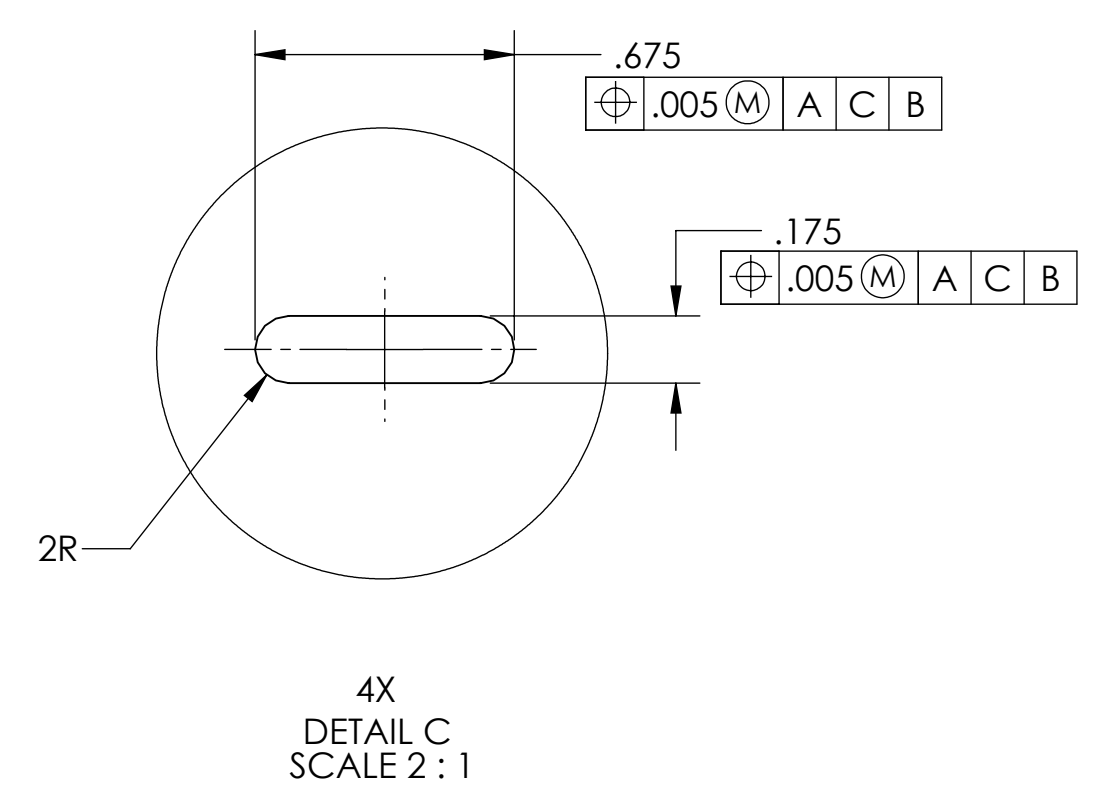
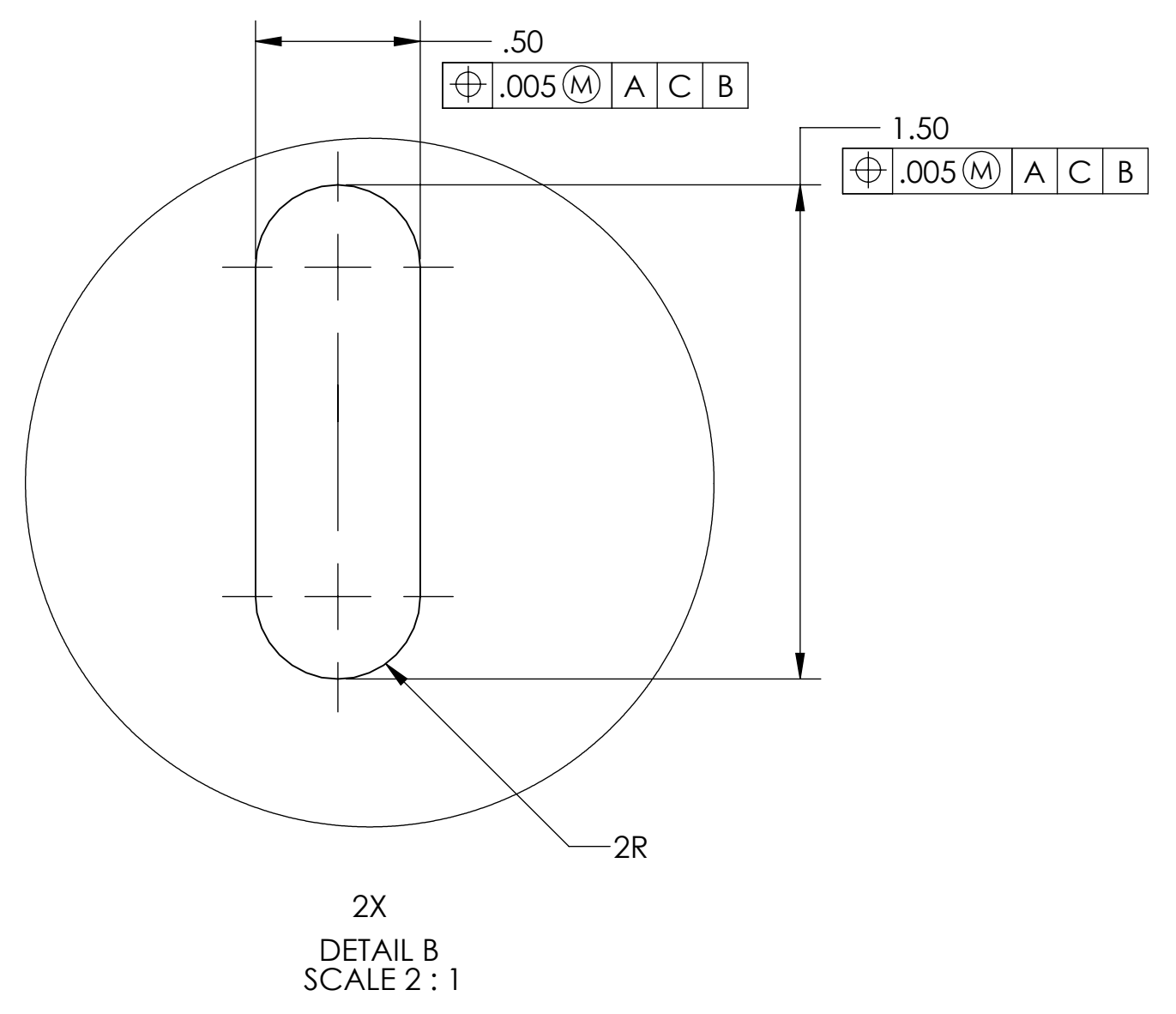
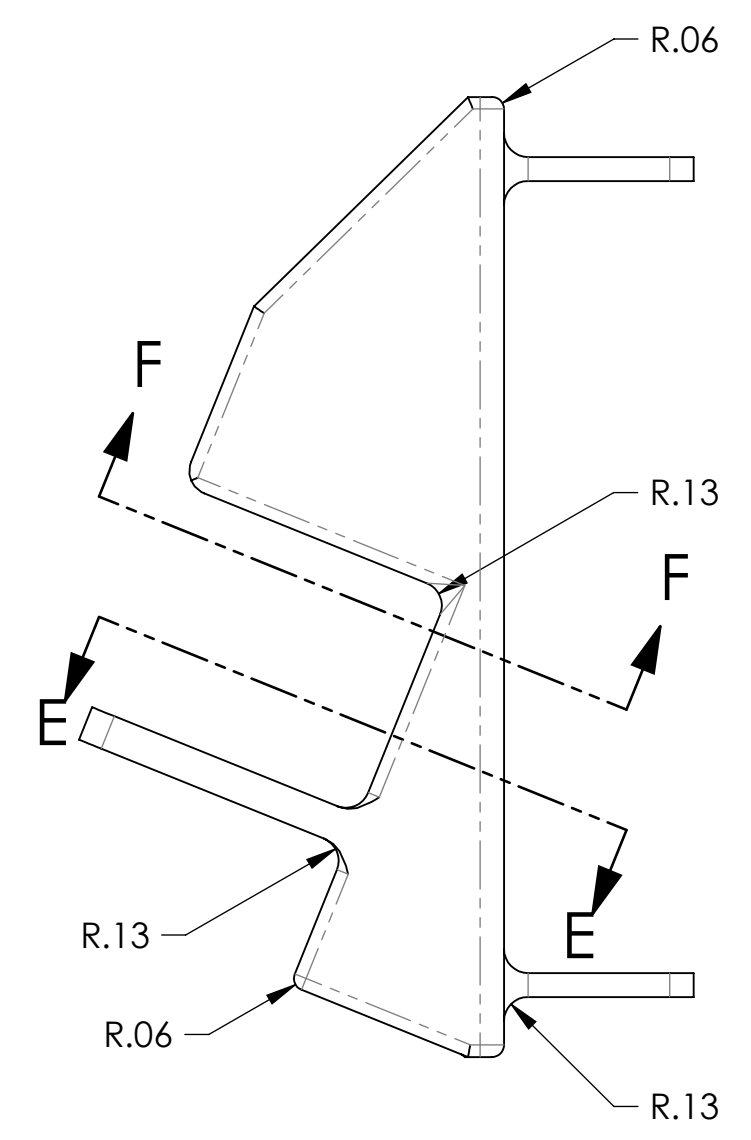
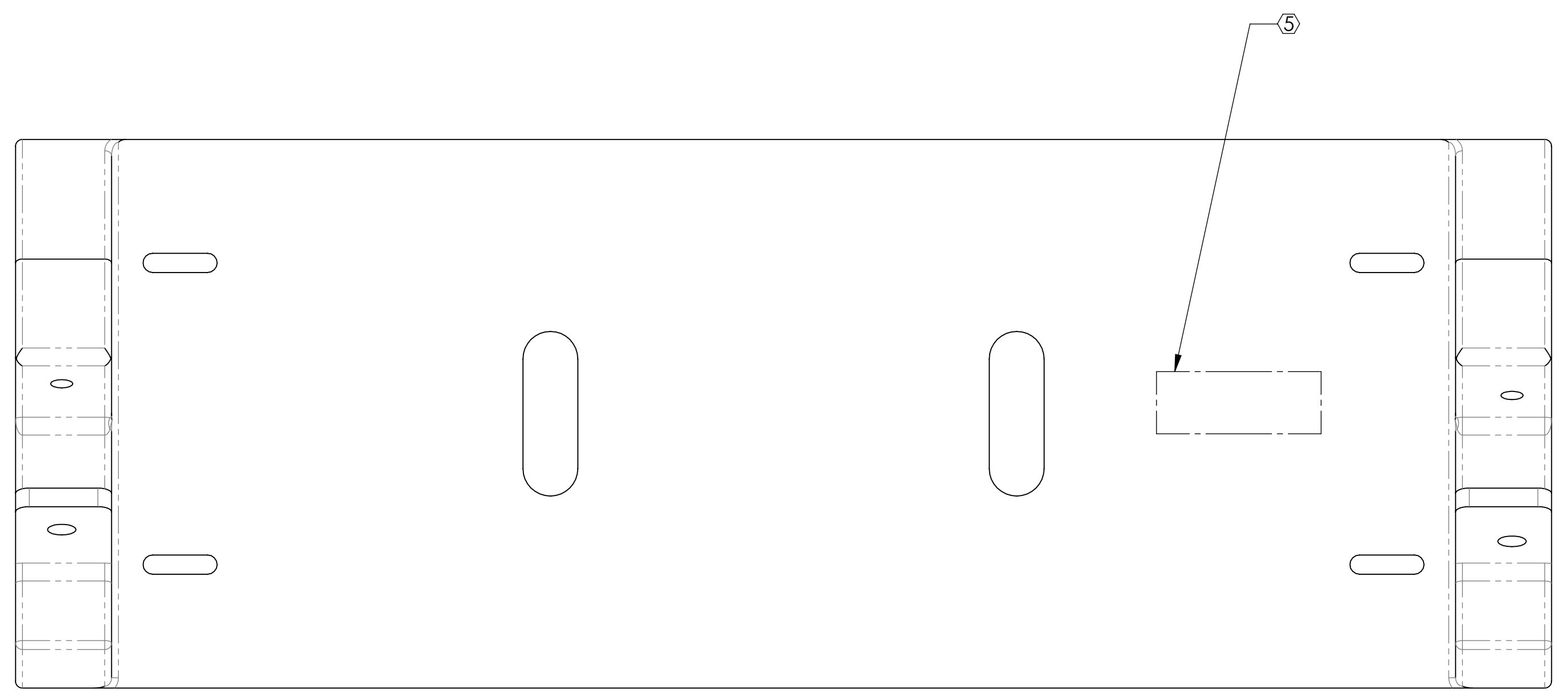
- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-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	-	-
v2	23-DEC-2010	E1000833-v1	E1000834-v1
-	-	-	-



DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± .01 .XXX ± .005		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .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.		SYSTEM <b>ADVANCED LIGO</b>		SUB-SYSTEM <b>AOS</b>	
ANGULAR ± 0.5°		MATERIAL <b>6061-T6 (SS)</b>		FINISH <b>63 μinch</b>		NEXT ASSY <b>D1001742</b>	
						DESIGNER M. JACOBSON 08 JUL 2010	
						DRAFTER A. COLE 22-AUG-2010	
						CHECKER B. ANDERSON 05 JAN 2011	
						APPROVAL C. TORRIE 06 JAN 2011	
						SIZE DWG. NO. <b>D D1002312</b>	
						REV. <b>v2</b>	
						SCALE: 1:1 PROJECTION:	
						SHEET 1 OF 3	

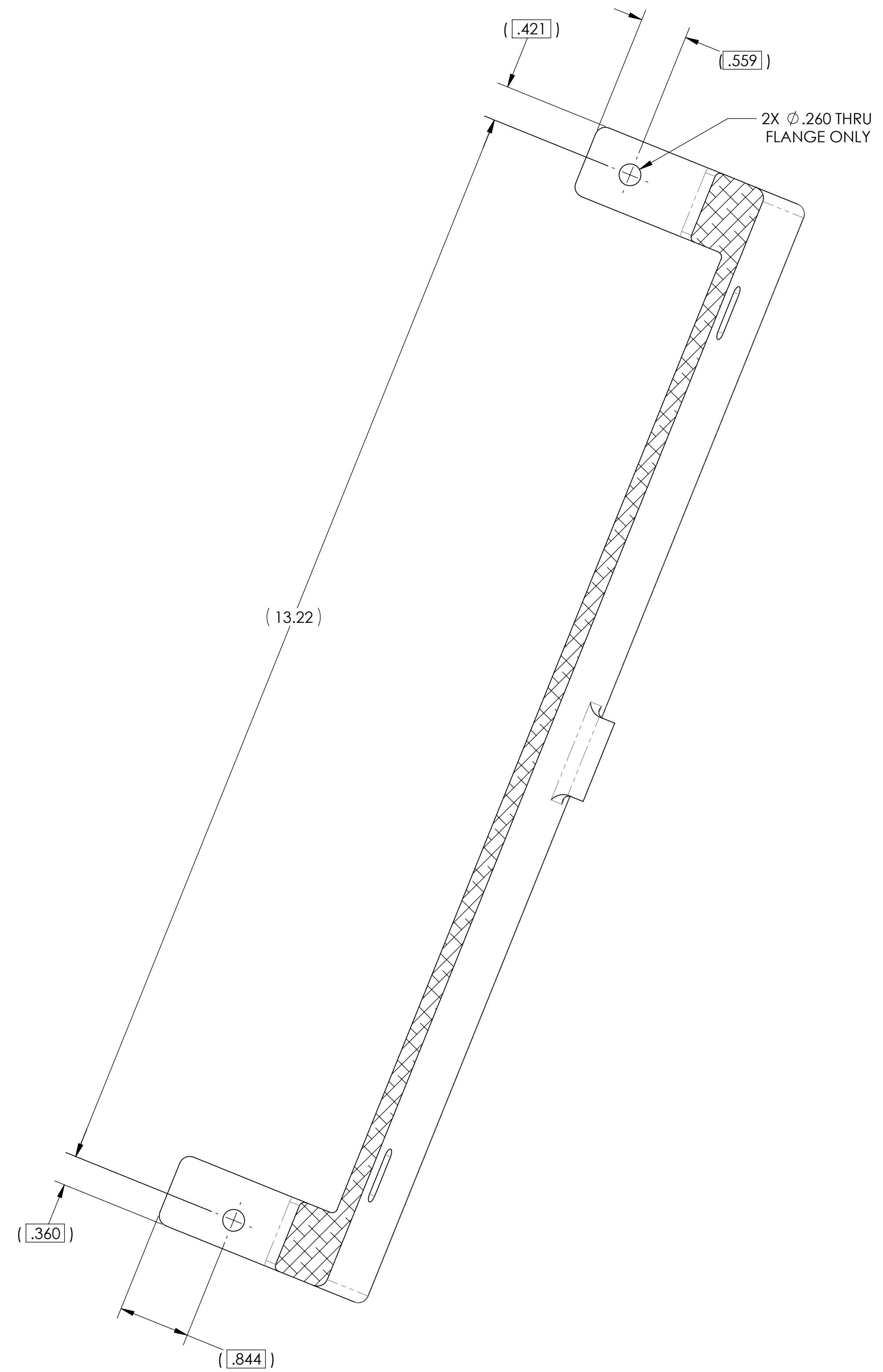
D1002312, ICS UNV AZ FINE ADJUST PIVOT PLATE, PART PDM, REV. X.023, DRAWING PDM, REV. X.018



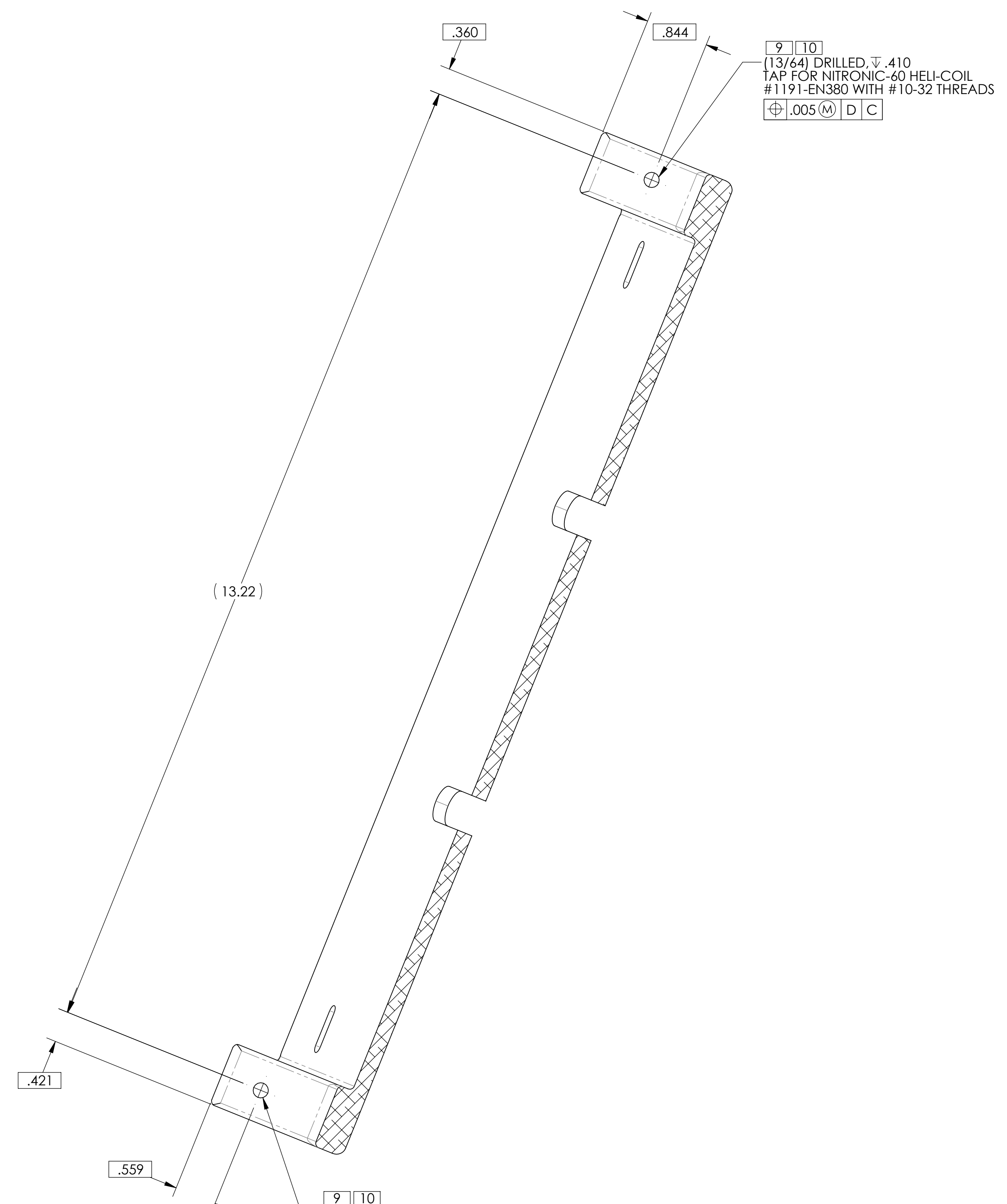
D1002312\_ICS\_UHV\_AZ\_FINE\_ADJUST\_PIVOT\_PLATE\_PARR\_FDM\_REV-X.023\_DRAWING\_PDM\_REV-X.018

8 7 6 5 4 3 2 1

H  
G  
F  
E  
D  
C  
B  
A



SECTION E-E



SECTION F-F

9 10  
 (13/64) DRILLED,  $\nabla$ .410  
 TAP FOR NITRONIC-60 HELI-COIL  
 #1191-EN380 WITH #10-32 THREADS  
⊕ .005 M D C

9 10  
 (13/64) DRILLED,  $\nabla$ .410  
 TAP FOR NITRONIC-60 HELI-COIL  
 #1191-EN380 WITH #10-32 THREADS  
⊕ .005 M D C

<b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
D	D1002312	v2
SCALE: 1:1	PROJECTION:	SHEET 3 OF 3

D1002312, ICS UHV AZ FINE ADJUST PIVOT PLATE, PART PDM, REV. X.023, DRAWING PDM, REV. X.018

8 7 6 5 4 3 2 1