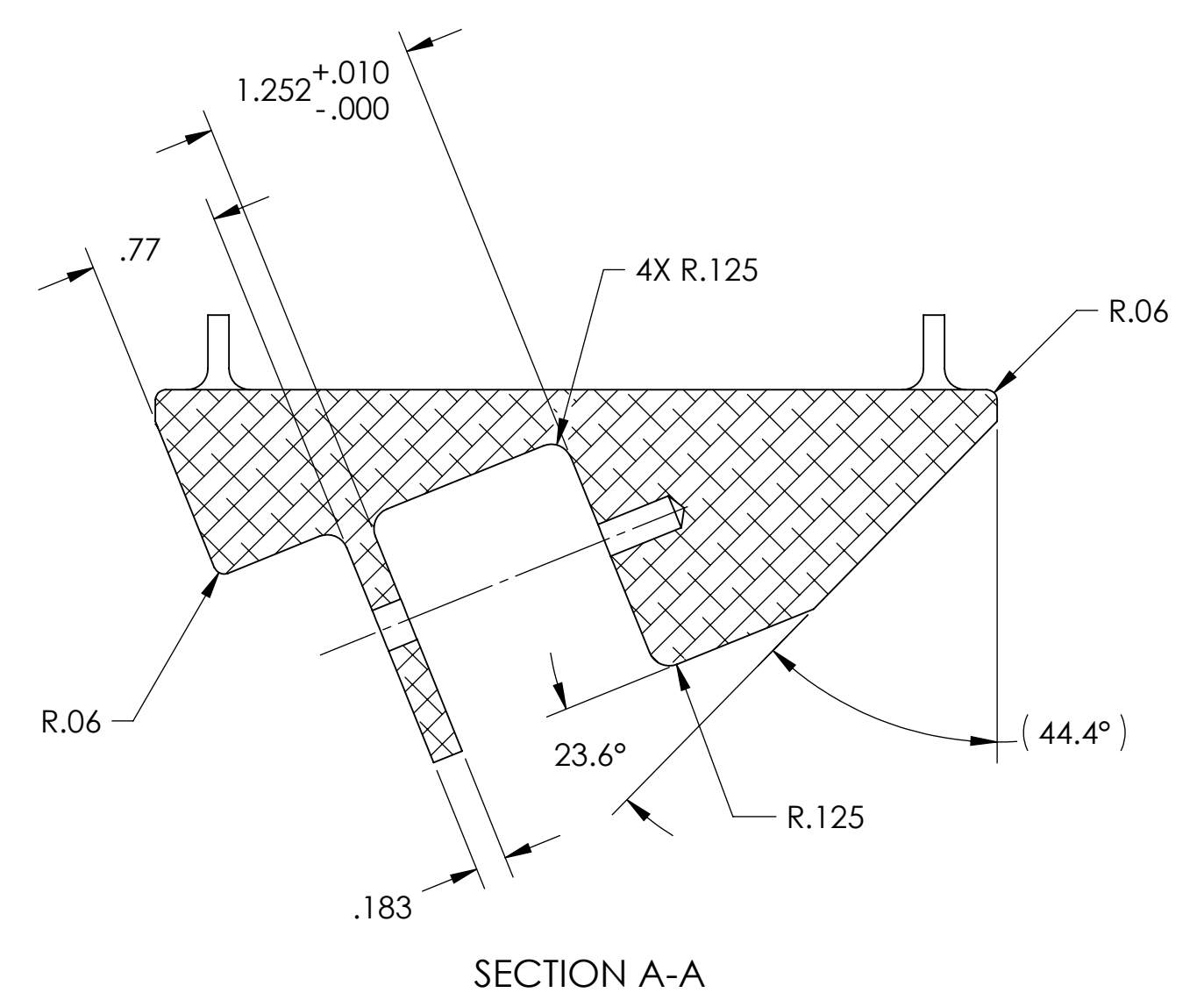
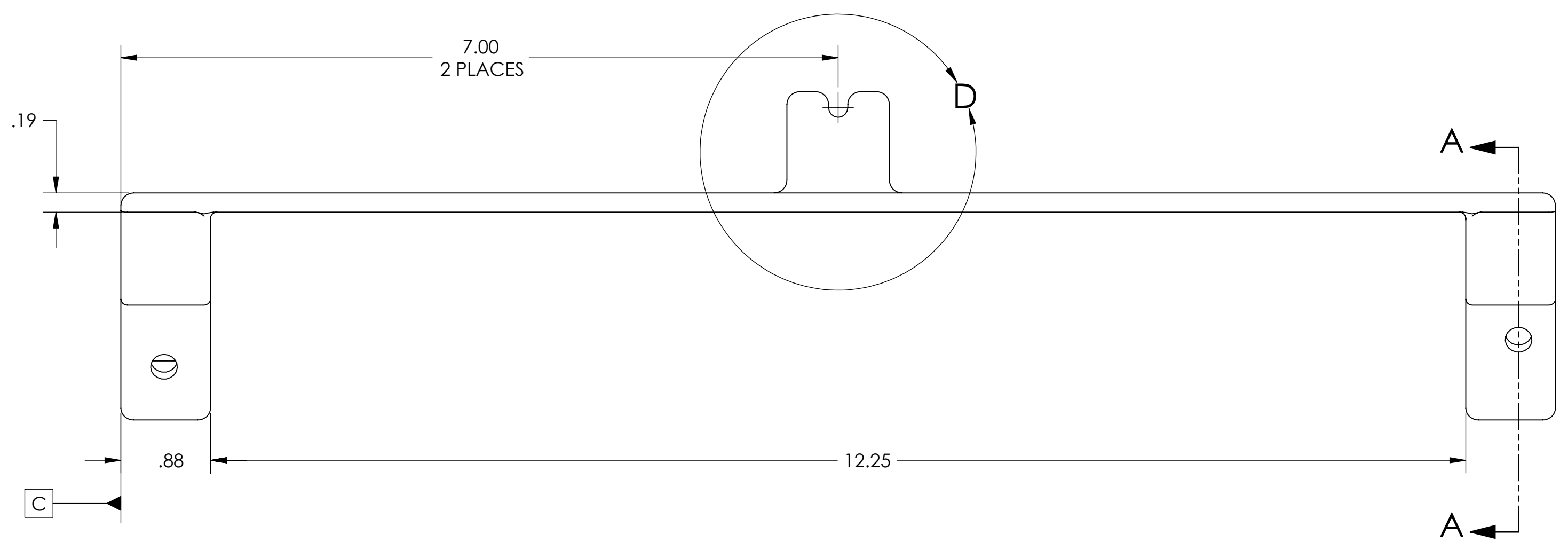
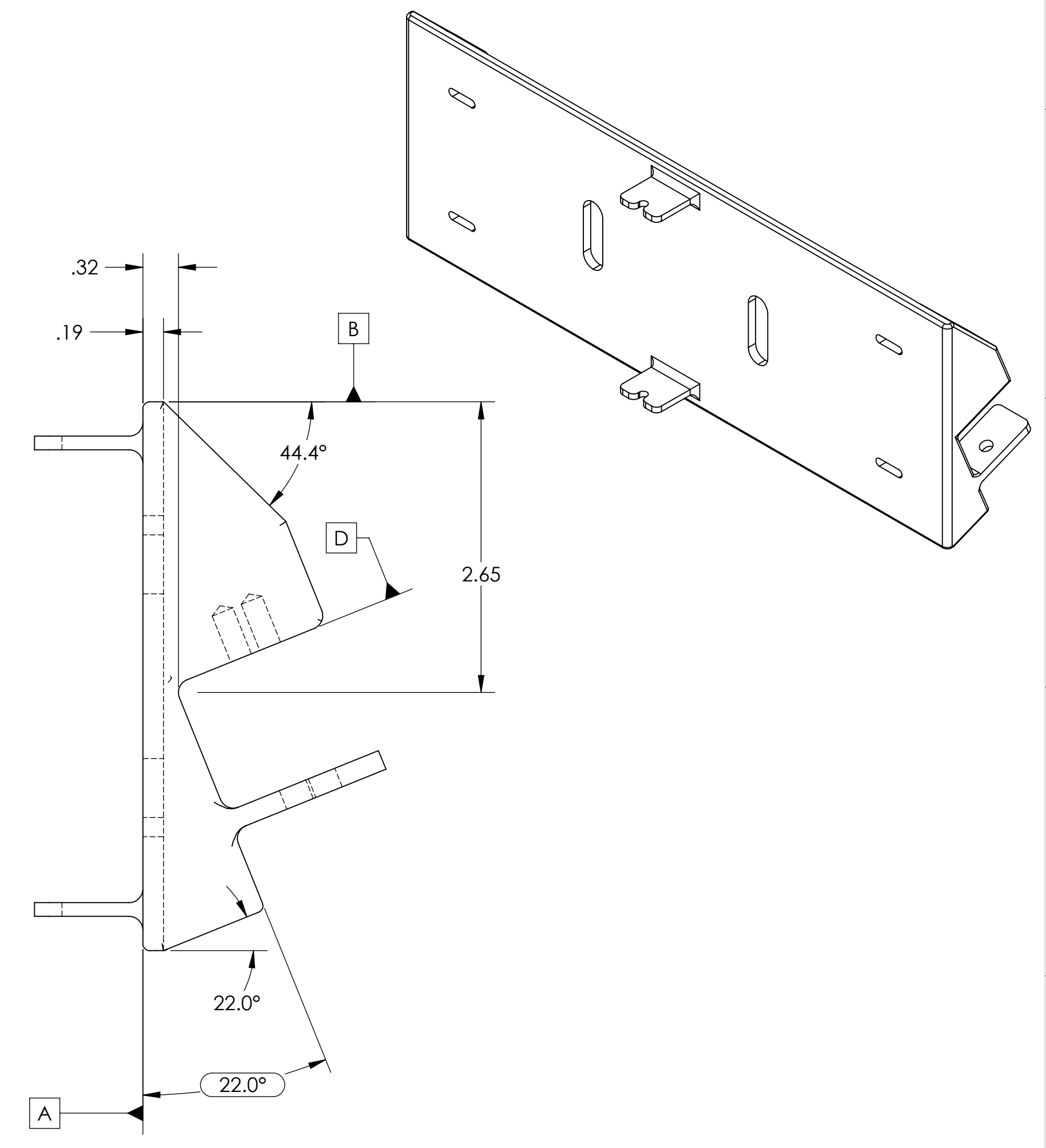
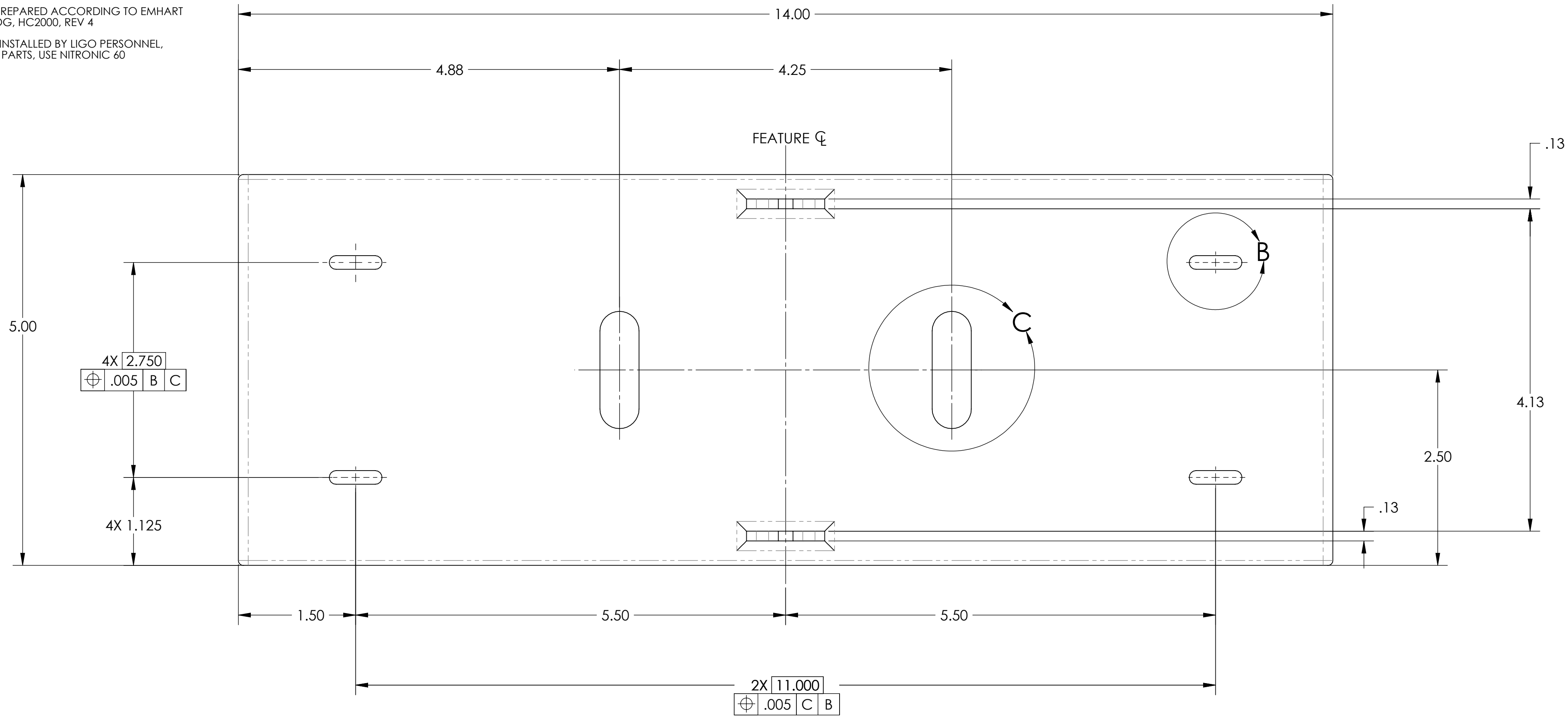


**NOTES CONTINUED:**  
 5) SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: 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   | 14-OCT-2010 | -           | -              |
| v2   | 23-DEC-2010 | E1000883-v1 | E1000884-v1    |
| v3   | 28-MAR-2011 | E1000883-v3 | E1000884-v3    |



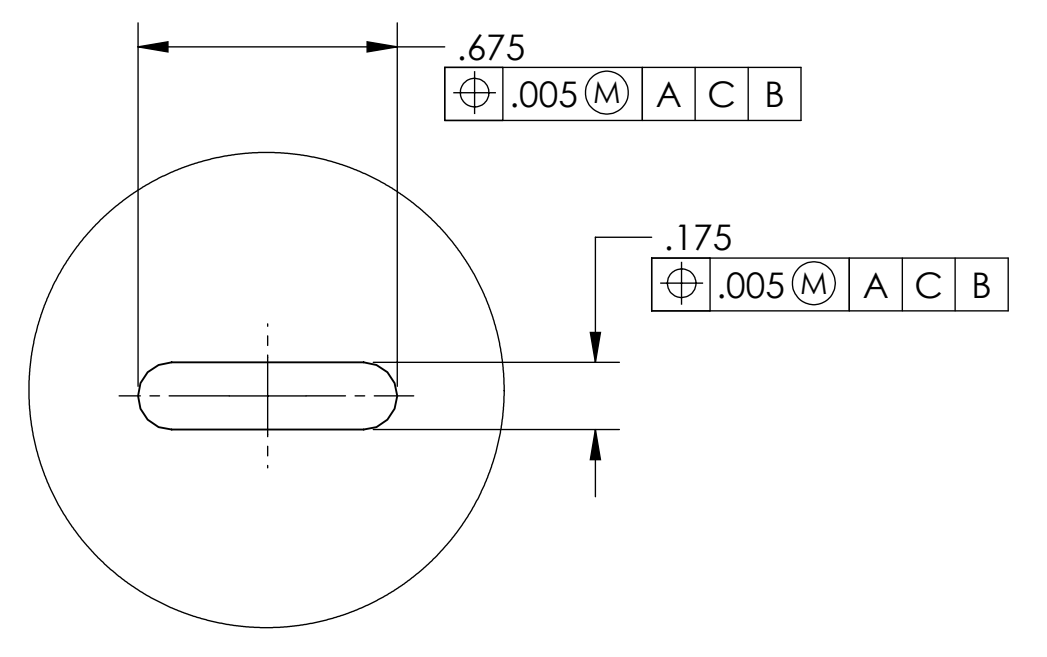
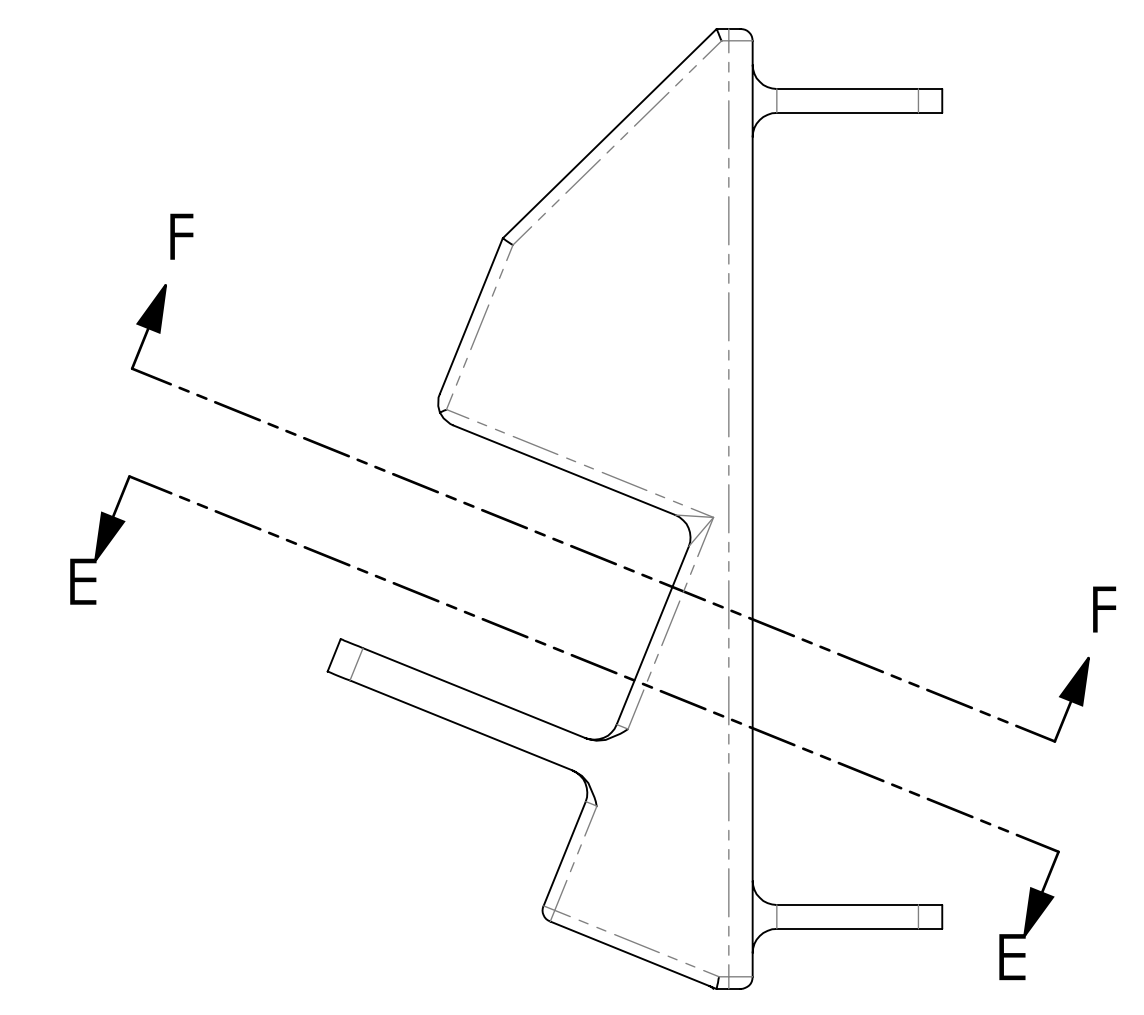
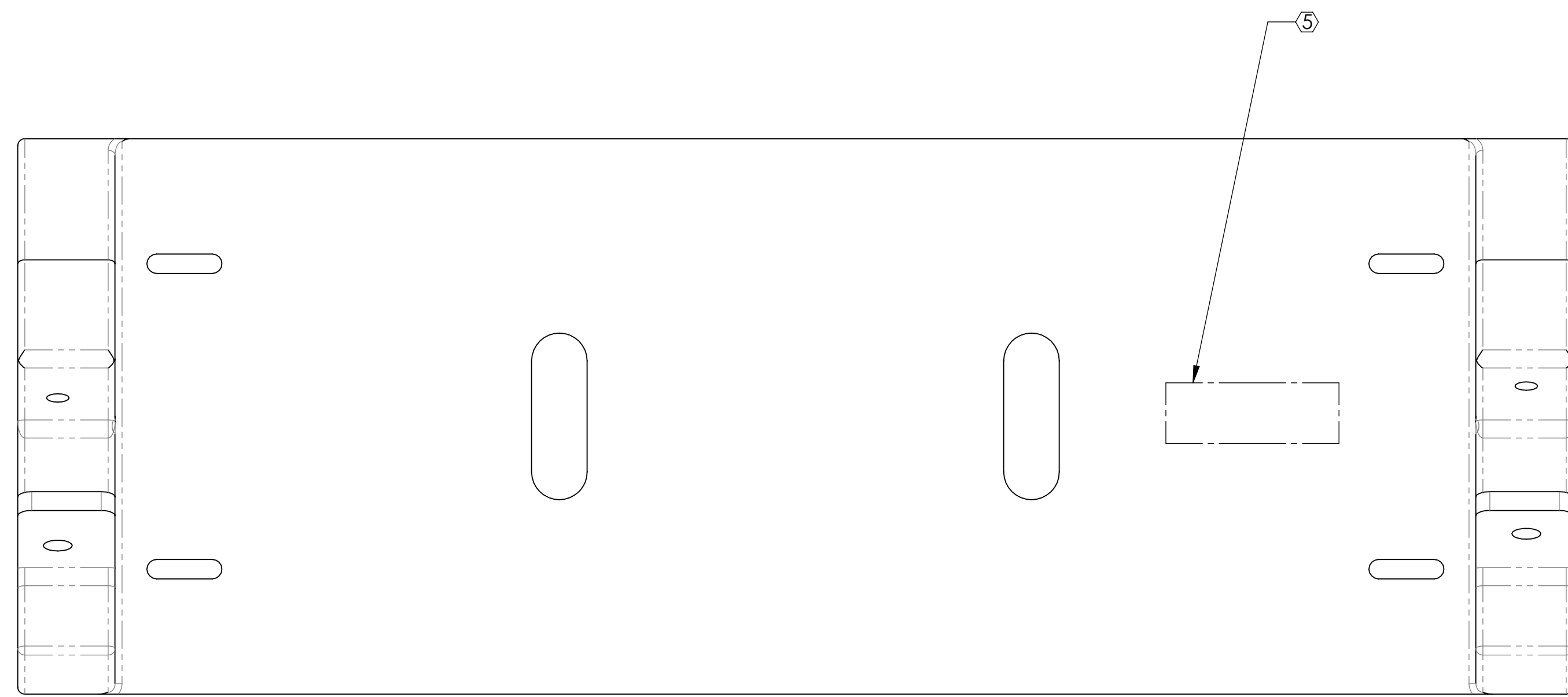
| NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)   |              |
|--|--------------|
| 1. INTERPRET DRAWING PER ASME Y14.5-1994.  |              |
| 2. REMOVE ALL SHARP EDGES, .02 MIN.  |              |
| 3. DO NOT SCALE FROM DRAWING.  |              |
| 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. |              |
| DIMENSIONS ARE IN INCHES   |              |
| TOLERANCES:  |              |
| .XX ± .01  |              |
| .XXX ± .005  |              |
| ANGULAR ± 0.5°   |              |
| MATERIAL   | 6061-T6 (SS) |
| FINISH   | 63 μinch     |

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

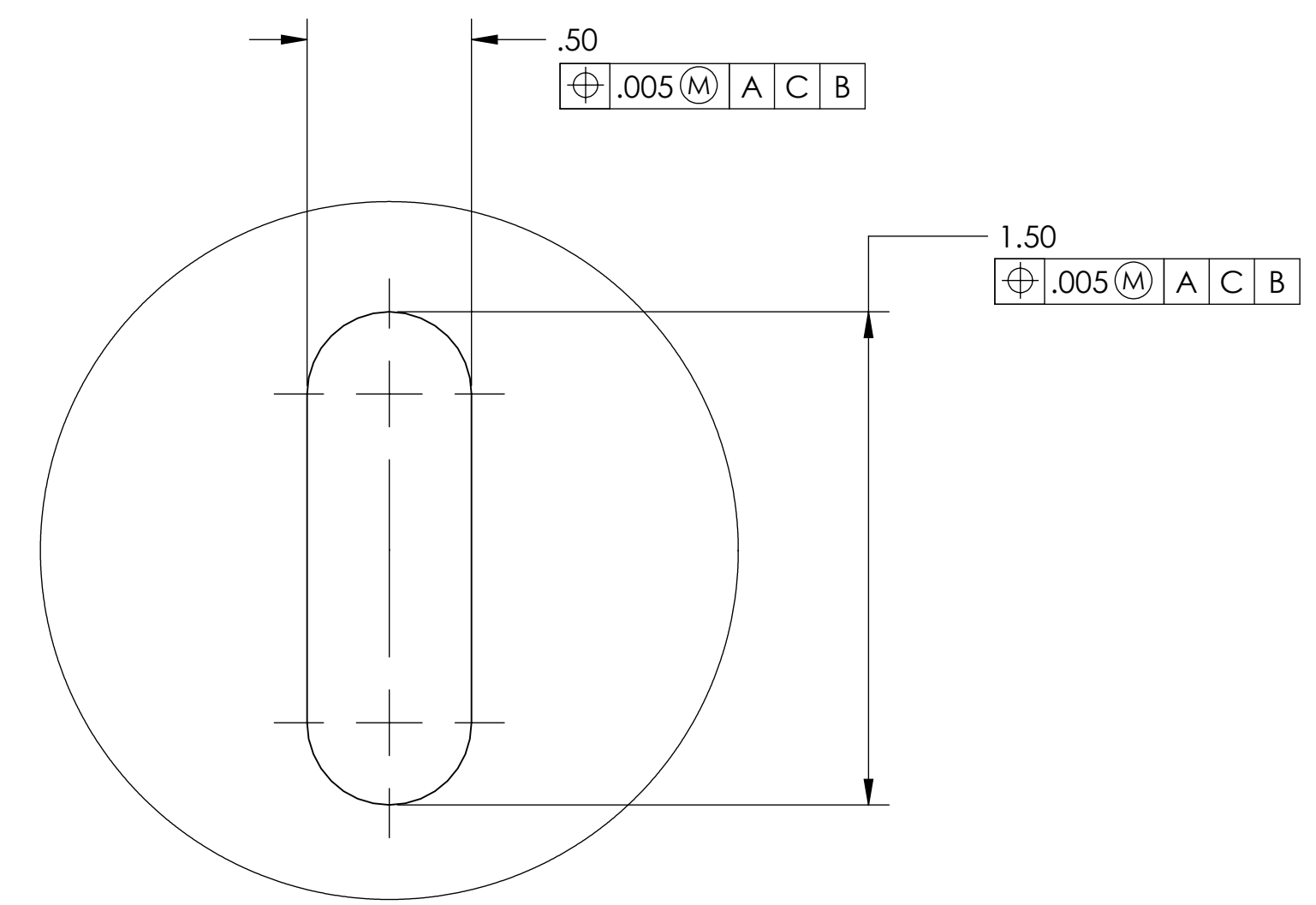
SYSTEM: ADVANCED LIGO  
 SUB-SYSTEM: AOS  
 NEXT ASSY: D1002431

| PART NAME                                     |             |              |               |
|---|-------------|--------------|---------------|
| LIGO TCS UHV AZ FINE ADJUST PIVOT PLATE, BSC8 |             |              |               |
| DESIGNER                                      | M. JACOBSON | 16-SEP-2010  | SIZE DWG. NO. |
| DRAFTER                                       | A. COLE     | 14-OCT-2010  | D D1002455    |
| CHECKER                                       | B. ANDERSON | 05 JAN 2011  |               |
| APPROVAL                                      | C. TORRIE   | 06 JAN 2011  | SCALE: 1:1    |
| PROJECTION:                                   |             | SHEET 1 OF 3 |               |

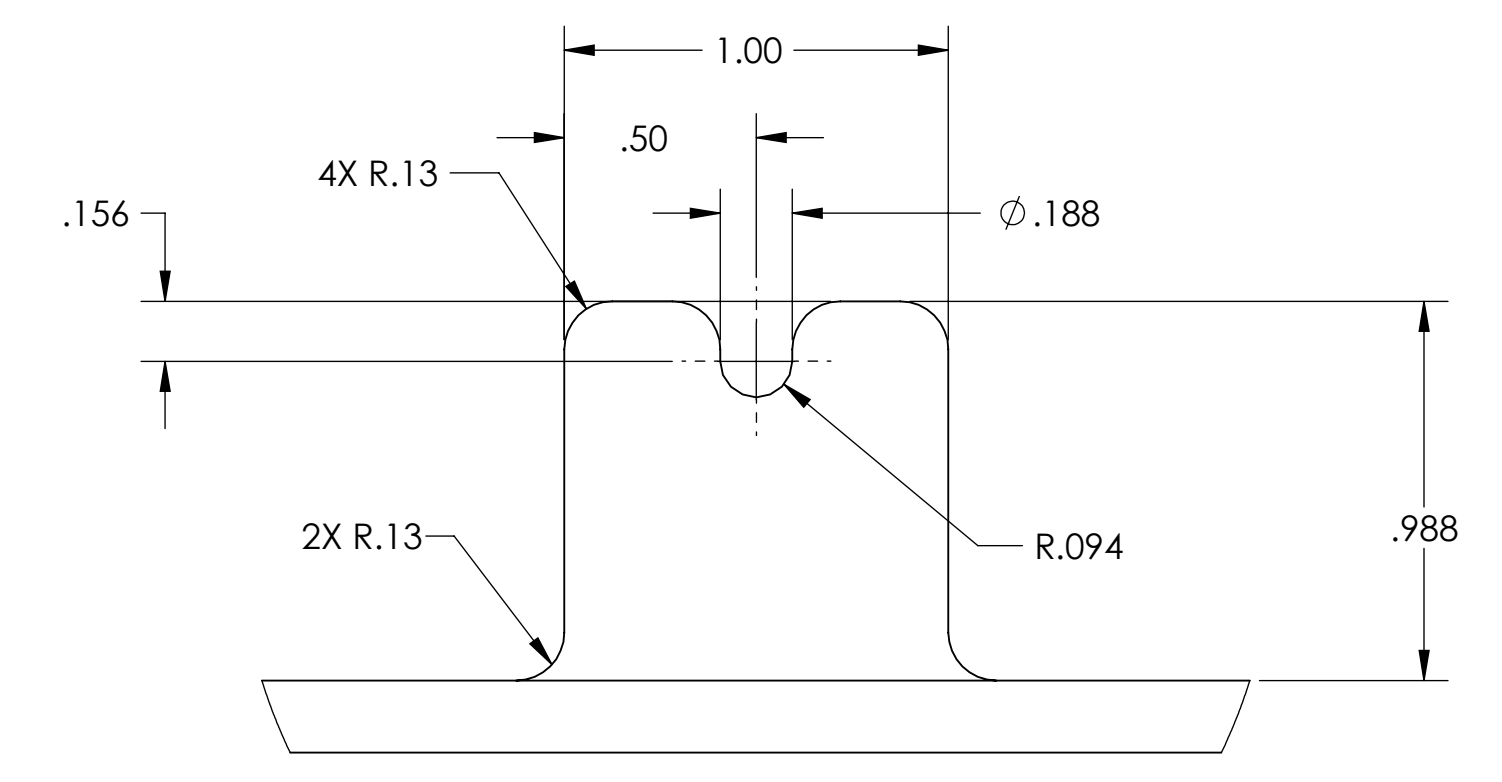
D:\000455\_01\G0 TCS UHV FINE ADJUST PIVOT PLATE PART PDM REV-X-009 DRAWING PDM REV-X-007



DETAIL B  
SCALE 2 : 1



DETAIL C  
SCALE 2 : 1



DETAIL D  
SCALE 2 : 1

|   |             |              |
|---|-------------|--------------|
| CALIFORNIA INSTITUTE OF TECHNOLOGY<br>MASSACHUSETTS INSTITUTE OF TECHNOLOGY |             |              |
| SIZE  | DWG. NO.    | REV.         |
| D   | D1002455    | v3           |
| SCALE: 1:1  | PROJECTION: | SHEET 2 OF 3 |

D:\002455\_01\GOTOCS\JURY FINE ADJUST PIVOT PLATE.PART PDM REV:X:009 DRAWING PDM REV: X:007

8

7

6

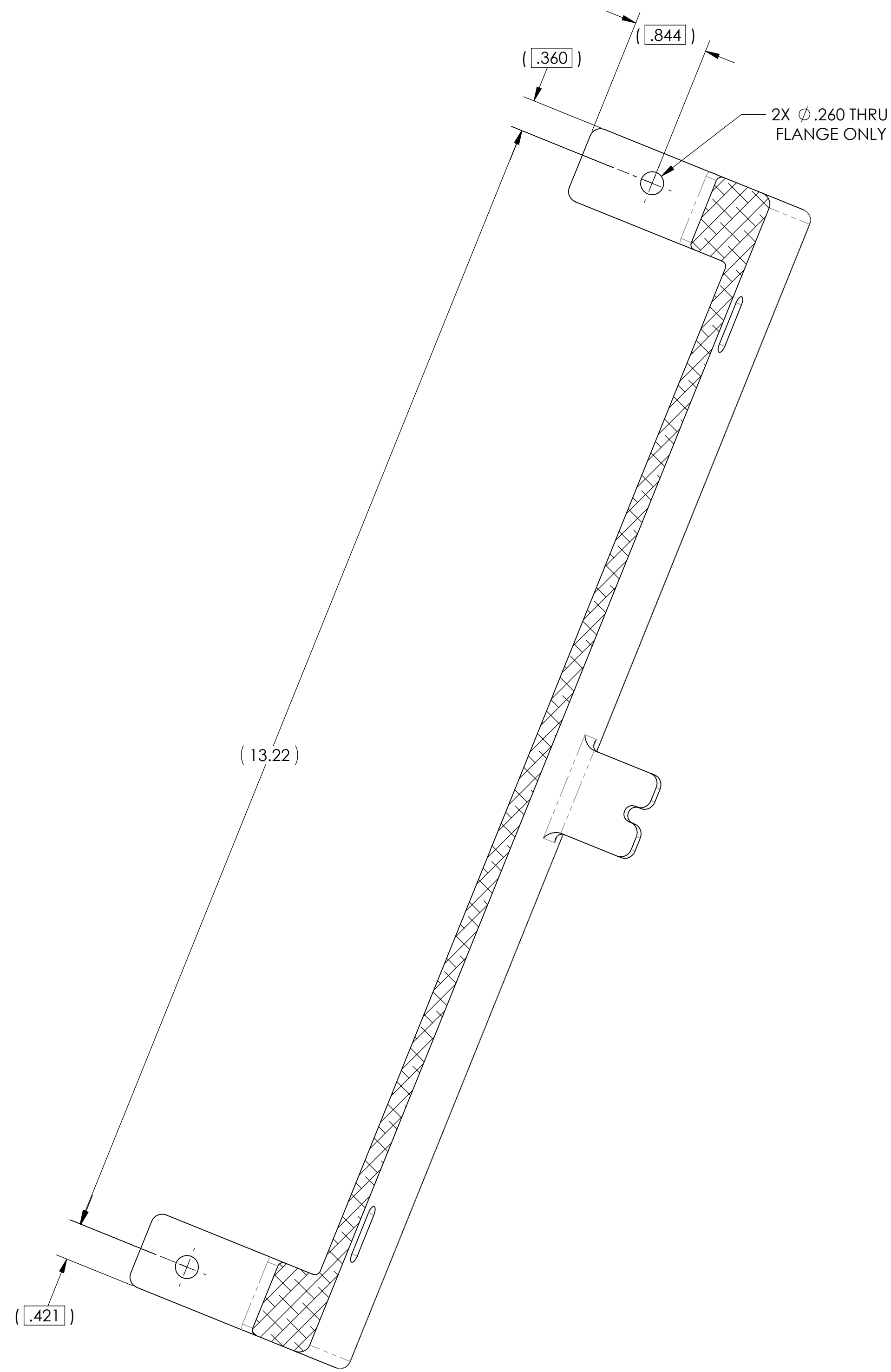
5

4

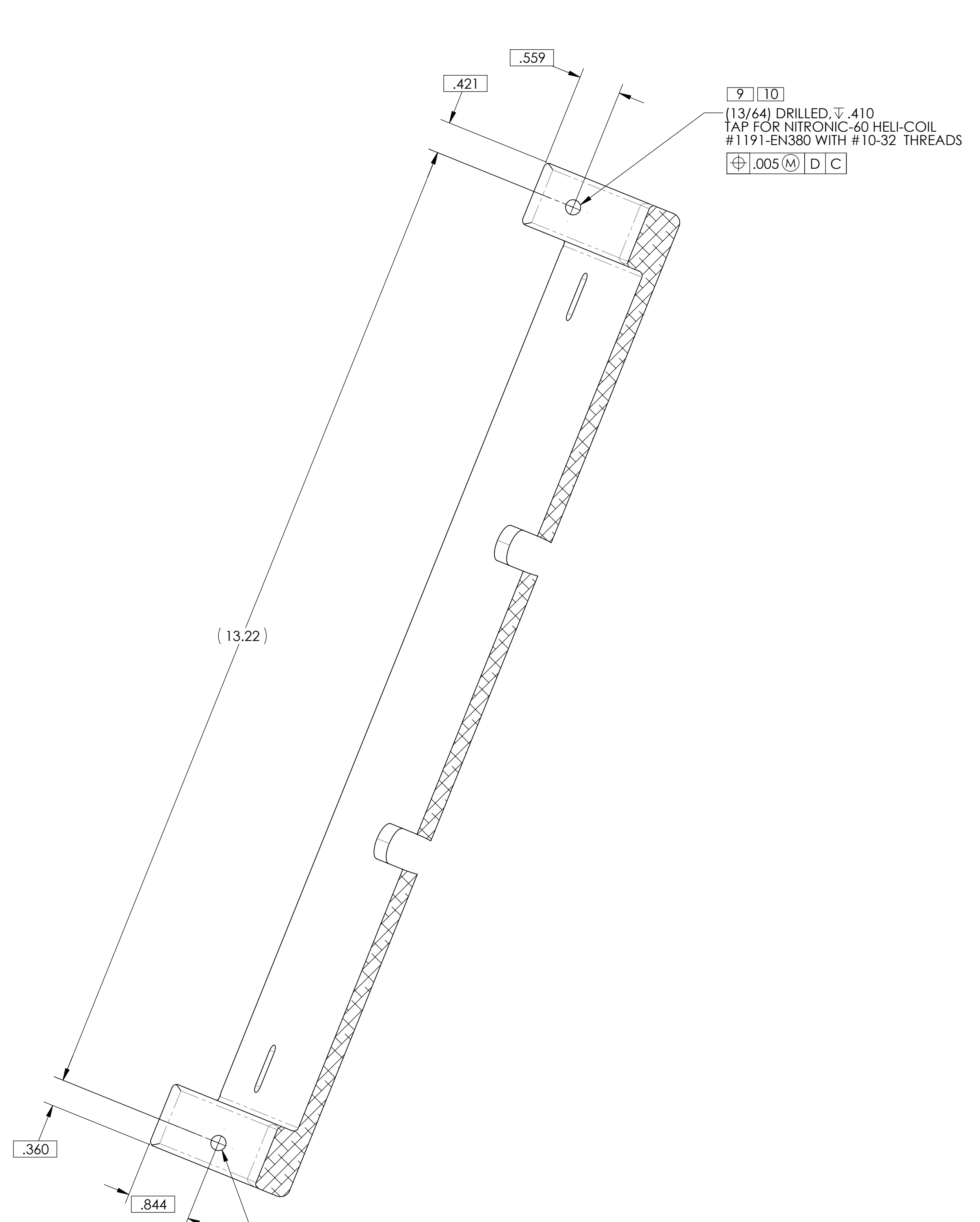
3

2

1



SECTION E-E



SECTION F-F

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

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

|   |             |              |
|---|-------------|--------------|
| <b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY<br>MASSACHUSETTS INSTITUTE OF TECHNOLOGY |             |              |
| SIZE  | DWG. NO.    | REV.         |
| D   | D1002455    | v3           |
| SCALE: 1:1  | PROJECTION: | SHEET 3 OF 3 |

D:\002455\_d1002455.dwg TCS (MAY) FINE ADJUST PIVOT PLATE PART PDM REV: X-009 DRAWING PDM REV: X-007