

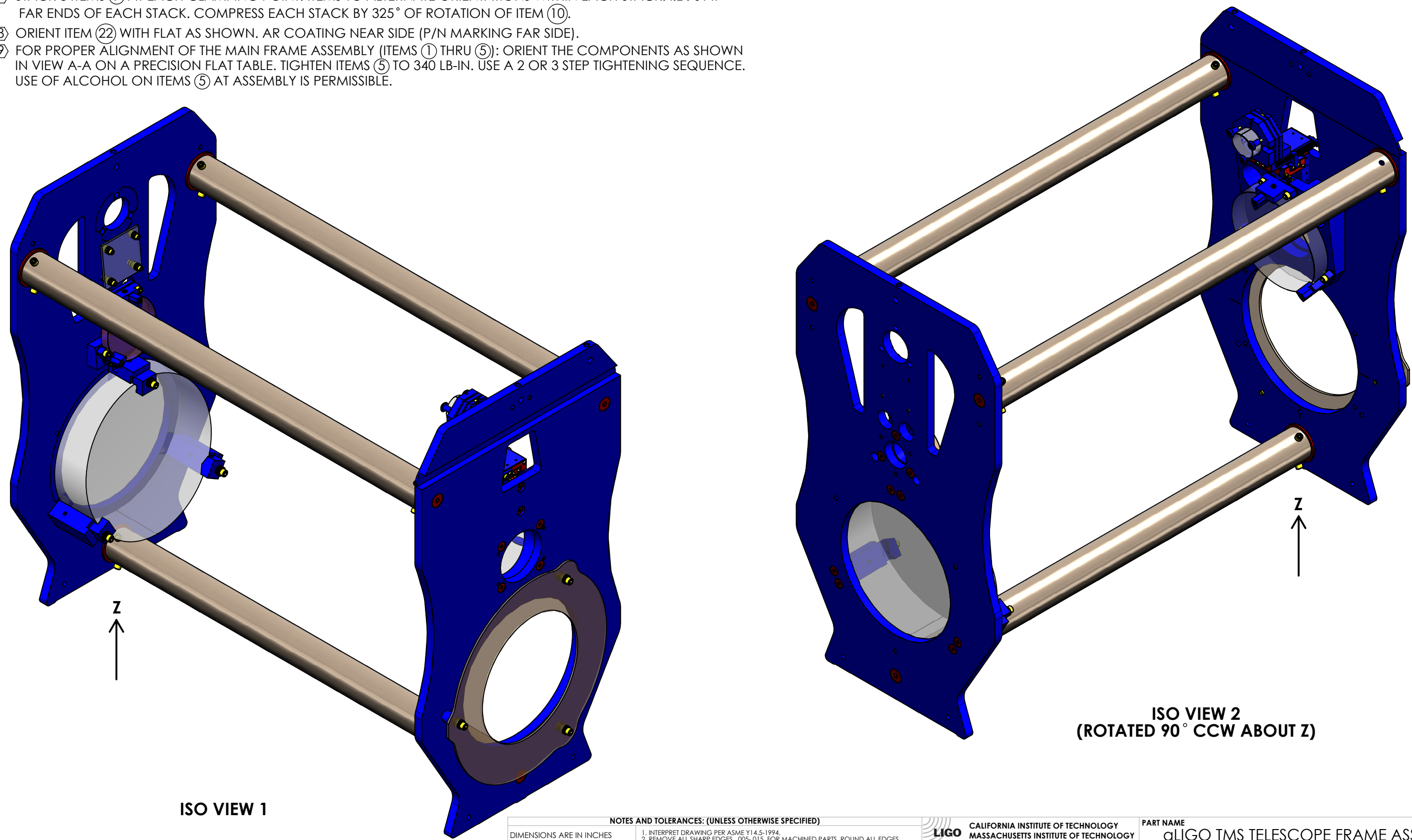
8 7 6 5 4 3 2 1

NOTES CONTINUED:

- 5. BAG OR WRAP AND TAG ASSEMBLY WITH DRAWING NUMBER, REVISION, AND SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY.
EXAMPLE (TAG): DXXXXXXX-VY, S/N 001
- 6. MASS/WEIGHT = 58.866 LB [26.701 KG].
- ⑦ STACK 8 ITEMS ⑩ AT EACH CLAMPING POINT. ITEMS TO ALTERNATE ORIENTATIONS WITHIN EACH STACK. I.D.'s AT FAR ENDS OF EACH STACK. COMPRESS EACH STACK BY 325° OF ROTATION OF ITEM ⑩.
- ⑧ ORIENT ITEM ⑫ WITH FLAT AS SHOWN. AR COATING NEAR SIDE (P/N MARKING FAR SIDE).
- ⑨ FOR PROPER ALIGNMENT OF THE MAIN FRAME ASSEMBLY (ITEMS ① THRU ⑤): ORIENT THE COMPONENTS AS SHOWN IN VIEW A-A ON A PRECISION FLAT TABLE. TIGHTEN ITEMS ⑤ TO 340 LB-IN. USE A 2 OR 3 STEP TIGHTENING SEQUENCE. USE OF ALCOHOL ON ITEMS ⑤ AT ASSEMBLY IS PERMISSIBLE.

REV	DATE	DCN #	BOM #
v1	15 DEC 2011	E1100351	E1100344-v1
-	-	-	-
-	-	-	-

D1003120 aLIGO TMS Telescope, PART PDM REV: X-480, DRAWING PDM REV: X-078



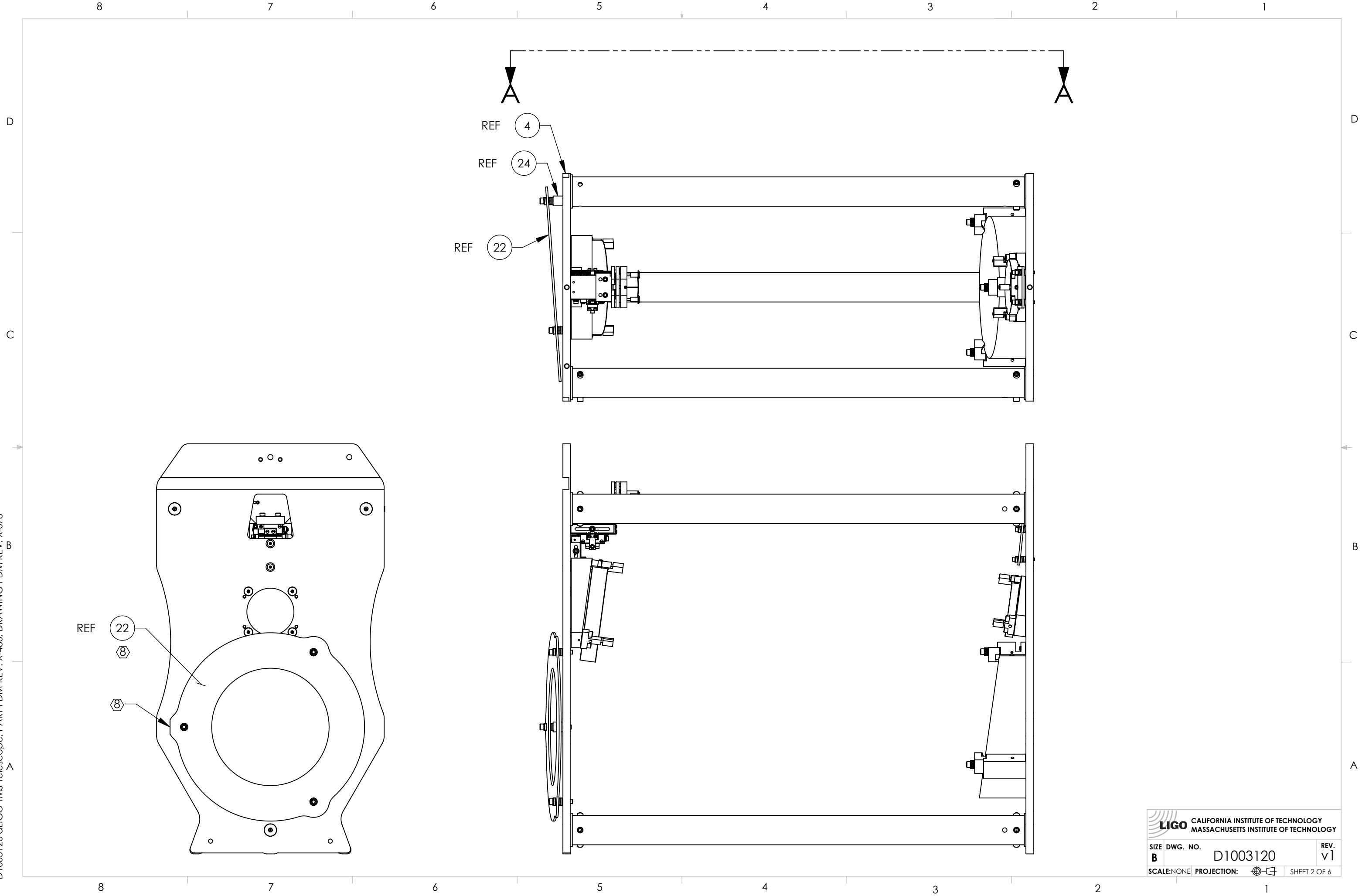
ISO VIEW 1

**ISO VIEW 2
(ROTATED 90° CCW ABOUT Z)**

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1.0°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		aLIGO TMS TELESCOPE FRAME ASSEMBLY	
MATERIAL		FINISH		SYSTEM		SUB-SYSTEM	
N/A		N/A μinch		ADVANCED LIGO		AOS	
NEXT ASSY				DESIGNER		DATE	
D1002460				K. MAILAND		26 AUG 2010	
DESIGNER				DRAFTER		SIZE	
SEE DCN				M. MILLER		DWG. NO.	
CHECKER				SEE DCN		B	
APPROVAL				SEE DCN		D1003120	
SCALE: NONE				PROJECTION:		REV.	
PROJECTION:				SHEET 1 OF 6		v1	

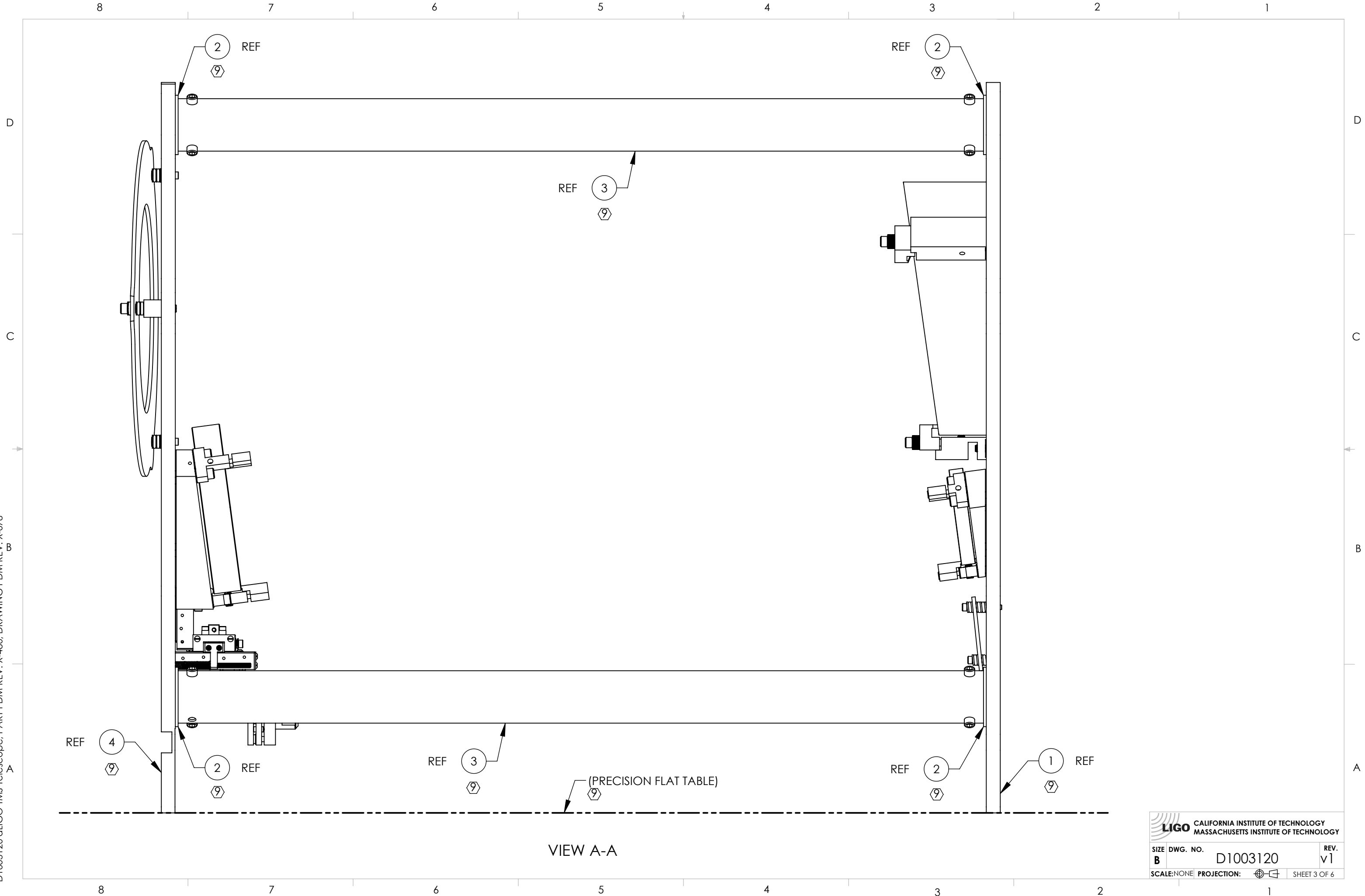
8 7 6 5 4 3 2 1

D1003120 dLIGO TMS Telescope, PART PDM REV: X-480, DRAWING PDM REV: X-078



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SIZE	DWG. NO.	REV.
B	D1003120	v1
SCALE: NONE	PROJECTION:	SHEET 2 OF 6

D1003120 dLIGO TMS Telescope, PART PDM REV: X-480, DRAWING PDM REV: X-078

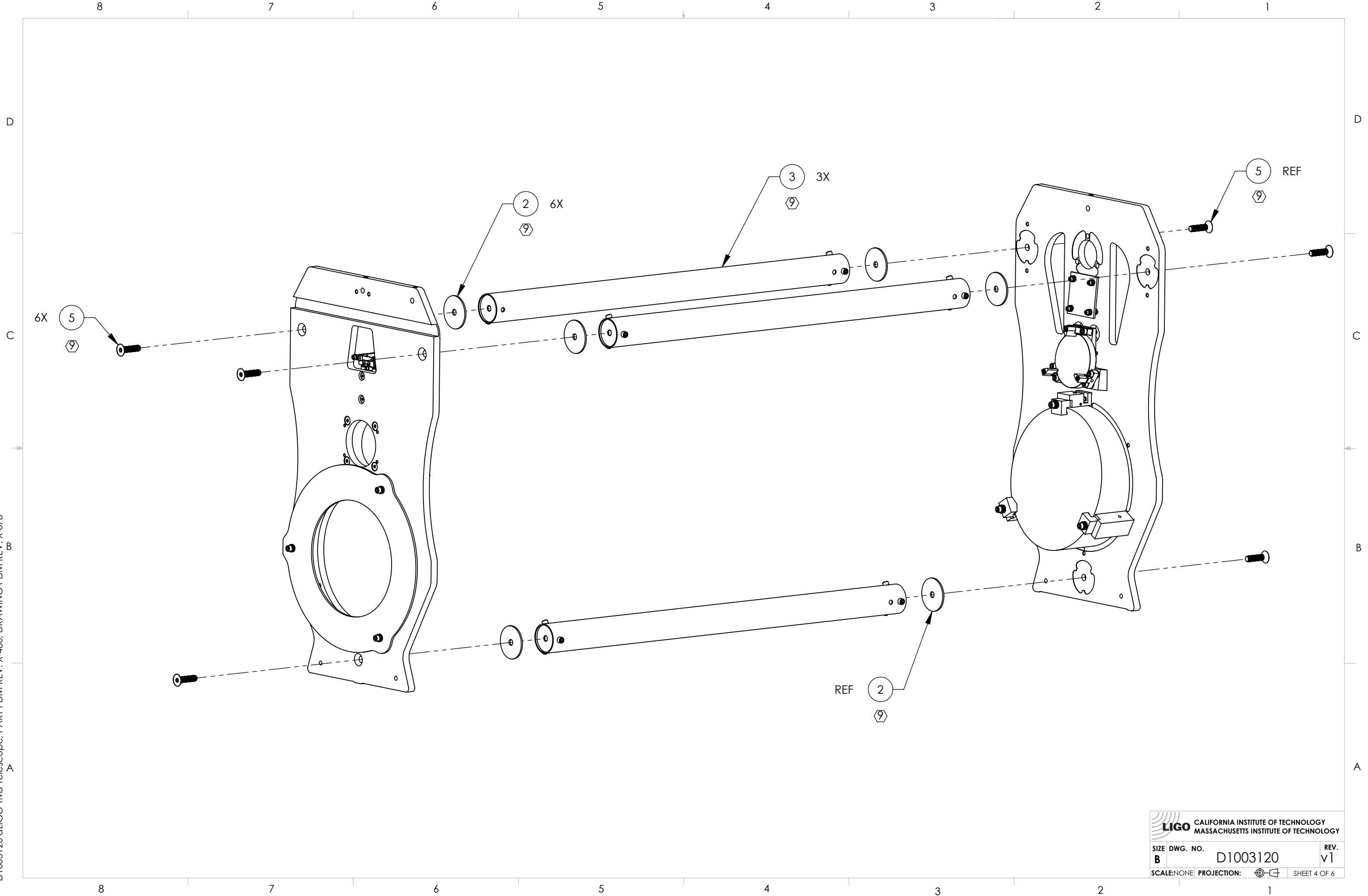


VIEW A-A

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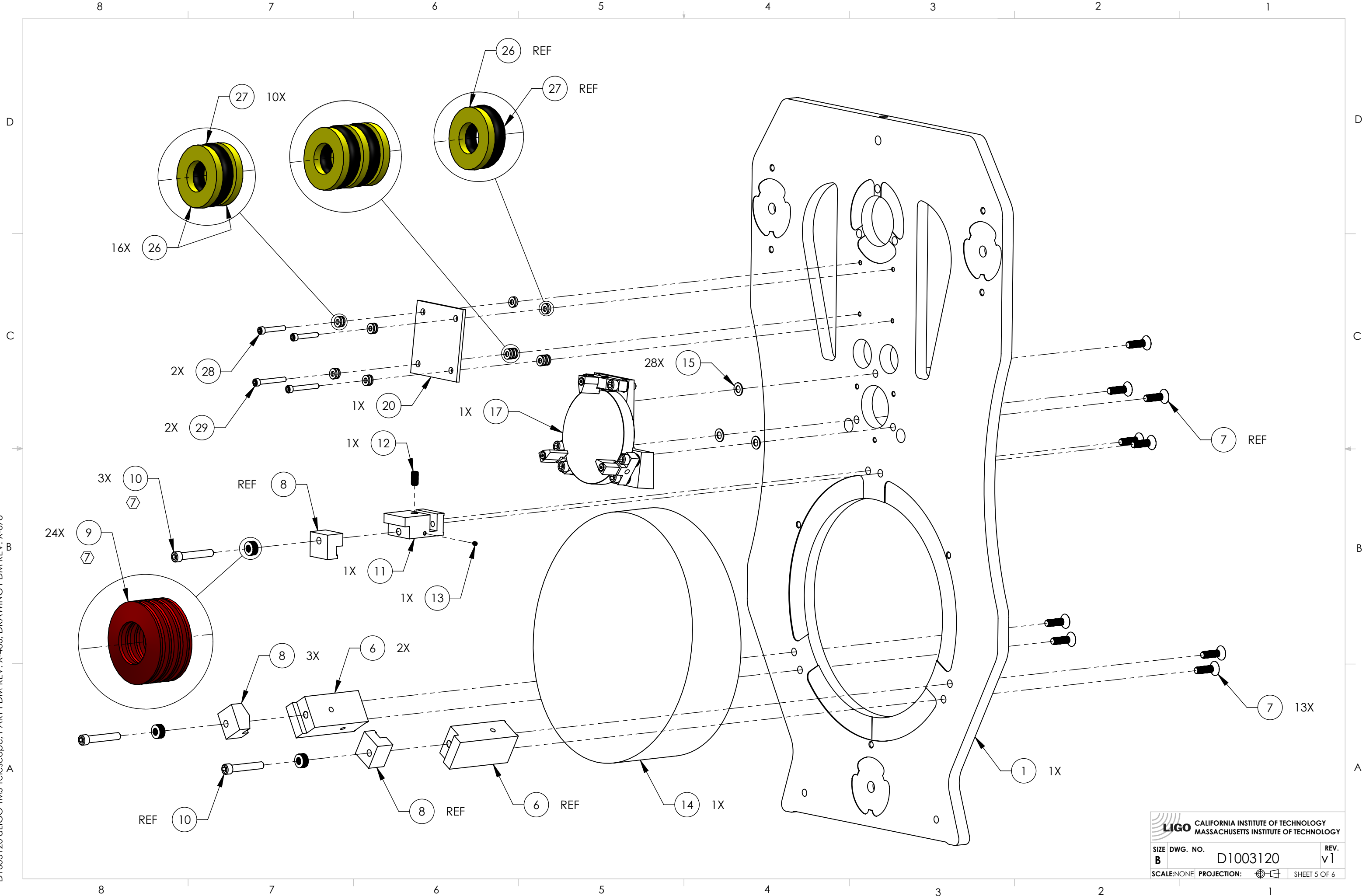
SIZE	DWG. NO.	REV.
B	D1003120	v1
SCALE: NONE		PROJECTION:
		SHEET 3 OF 6

D1003120 dLIGO TMS Telescope, PART PDM REV: X-480, DRAWING PDM REV: X-078

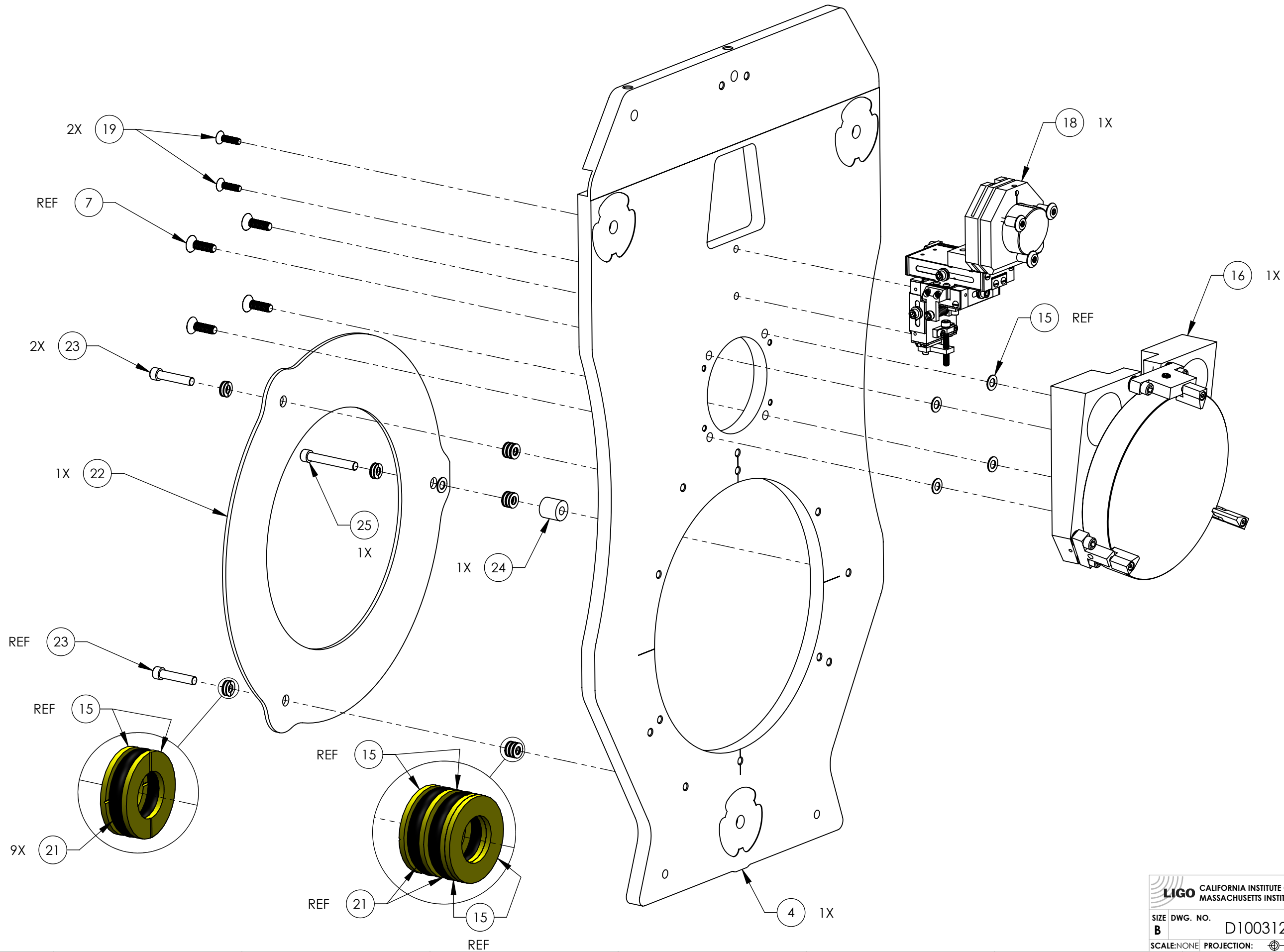



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SIZE	DWG. NO.	REV.
B	D1003120	v1
SCALE: NONE	PROJECTION:	SHEET 4 OF 6

D1003120 dLIGO TMS Telescope, PART PDM REV: X-480, DRAWING PDM REV: X-078



D1003120 dLIGO TMS Telescope, PART PDM REV: X-480, DRAWING PDM REV: X-078



 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE DWG. NO.	REV.
B D1003120	v1
SCALE: NONE PROJECTION: 	SHEET 6 OF 6