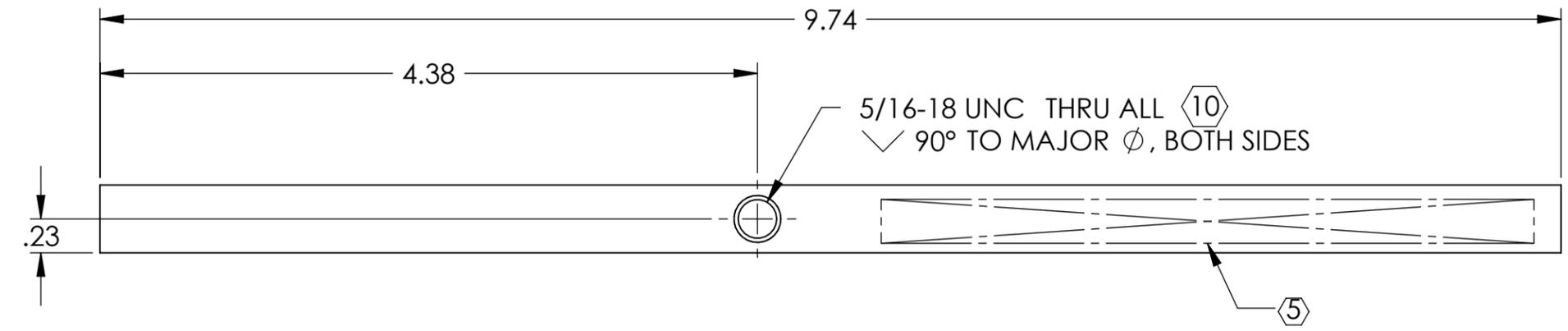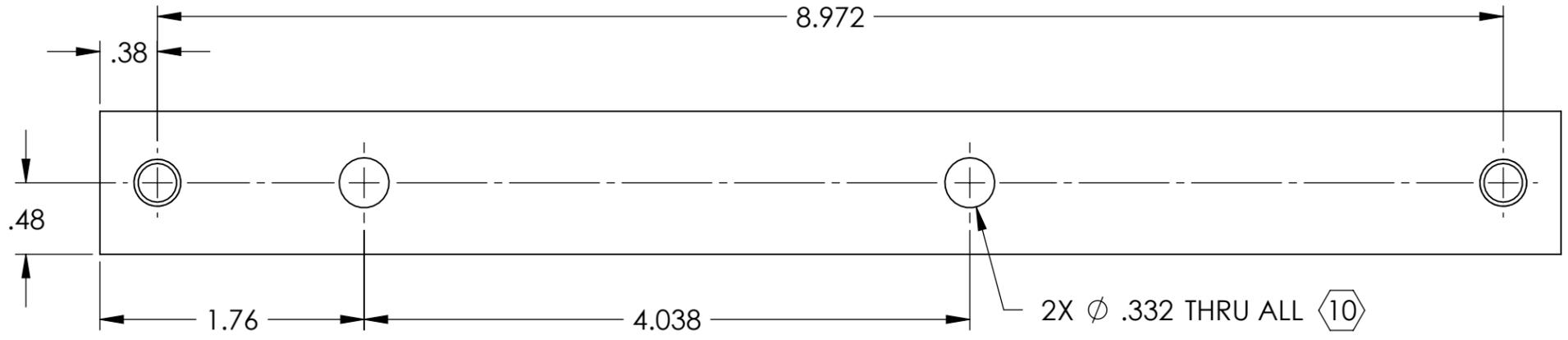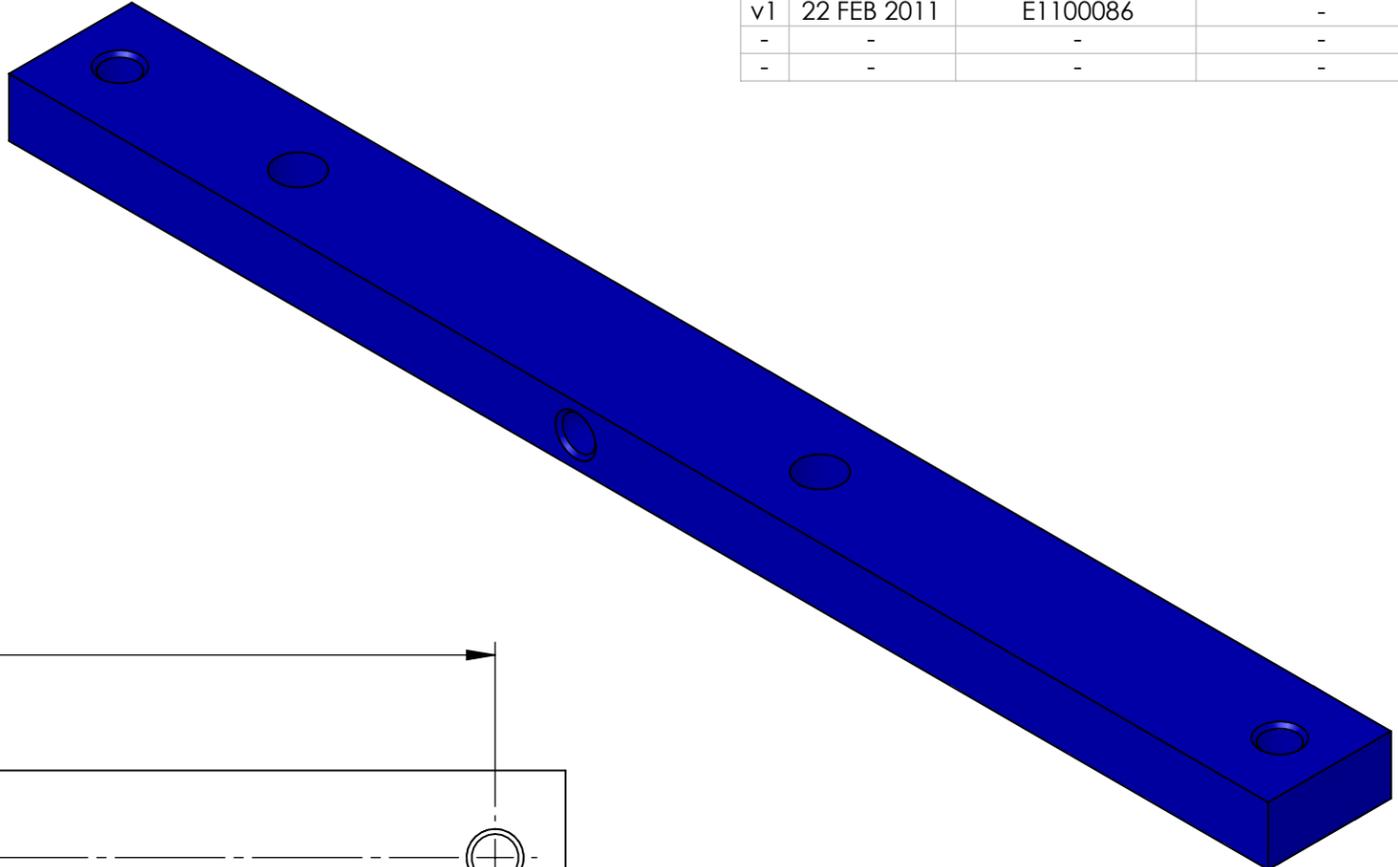**NOTES CONTINUED:**

⟨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 = .39 LB [.18 KG].

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364.

8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

⟨10⟩ ALL TAPPED HOLES: OVERSIZE .005", BOTH DRILL & TAP.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 FEB 2011	E1100086	–
–	–	–	–
–	–	–	–

8.972

.38

.48

1.76

4.038

2X ⌀ .332 THRU ALL ⟨10⟩

9.74

4.38

5/16-18 UNC THRU ALL ⟨10⟩
⌵ 90° TO MAJOR ⌀, BOTH SIDES

.23

⟨5⟩

.45

.95

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, .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.

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS

NEXT ASSY: D1101130

MATERIAL: 6061-T6 Al

FINISH: 63 μinch Ra

PART NAME	TMS SAFETY CHAIN MOUNT, REAR		
DESIGNER	C. CONLEY	04 FEB 2011	SIZE: B
DRAFTER	C. CONLEY	22 FEB 2011	DWG. NO. D1100281
CHECKER	SEE DCN		REV. v1
APPROVAL	SEE DCN		

SCALE: NONE   PROJECTION: SHEET 1 OF 1