

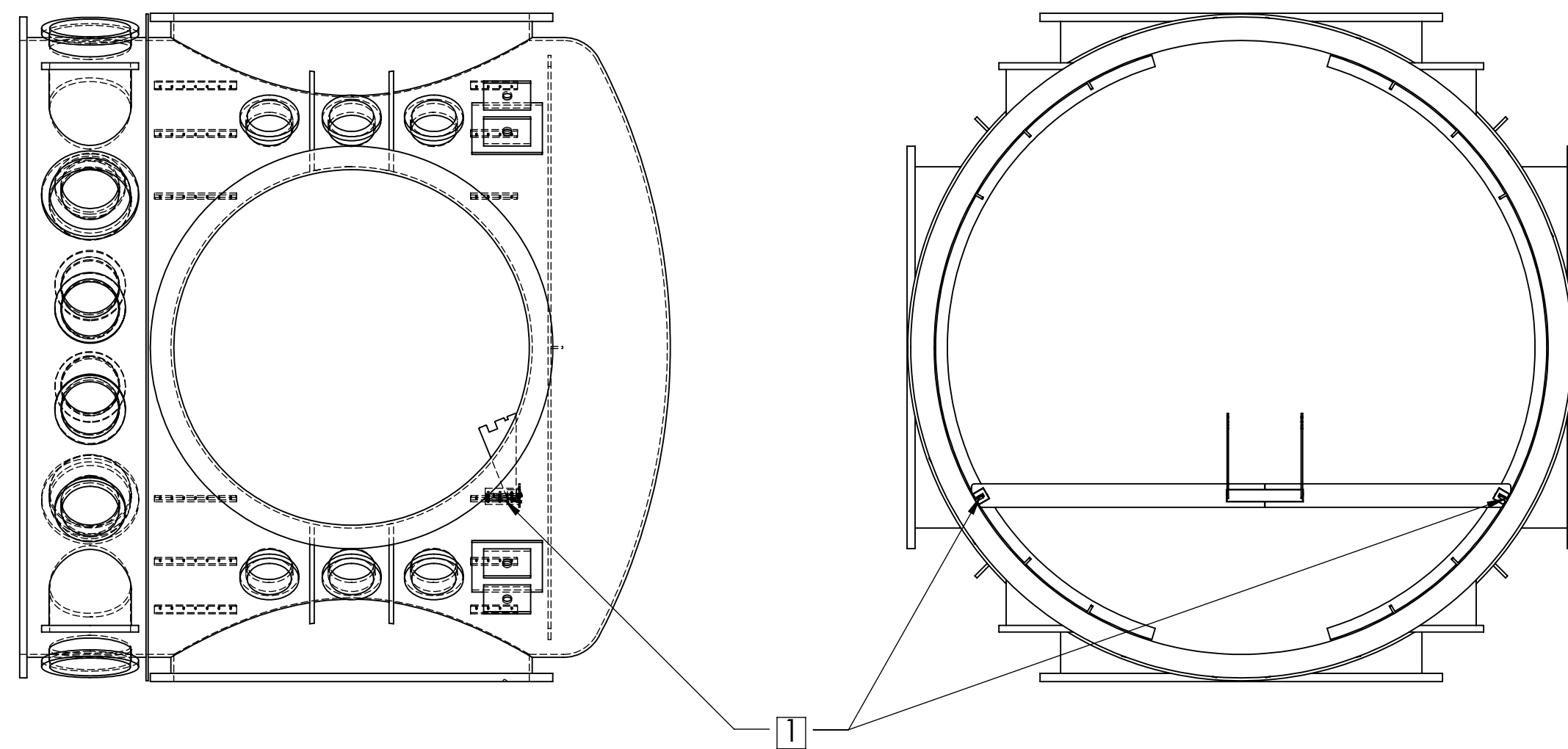
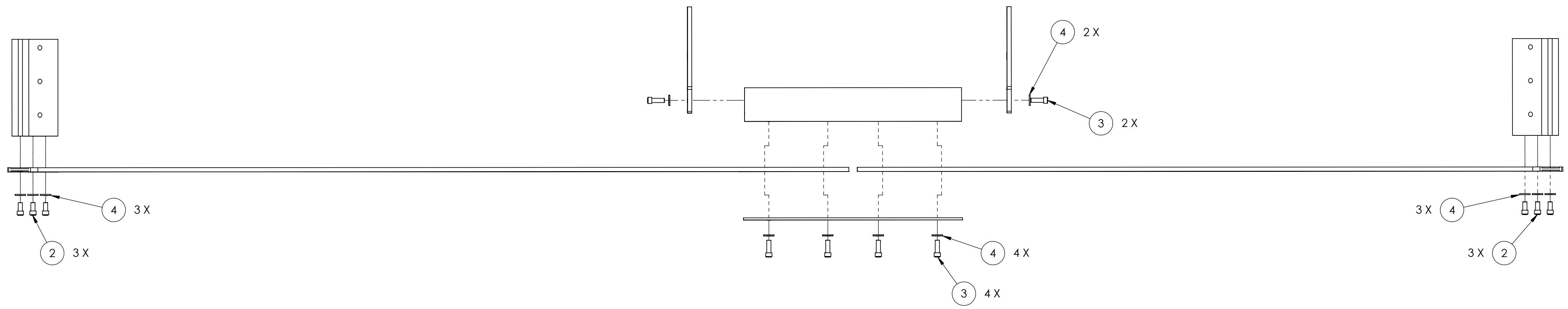
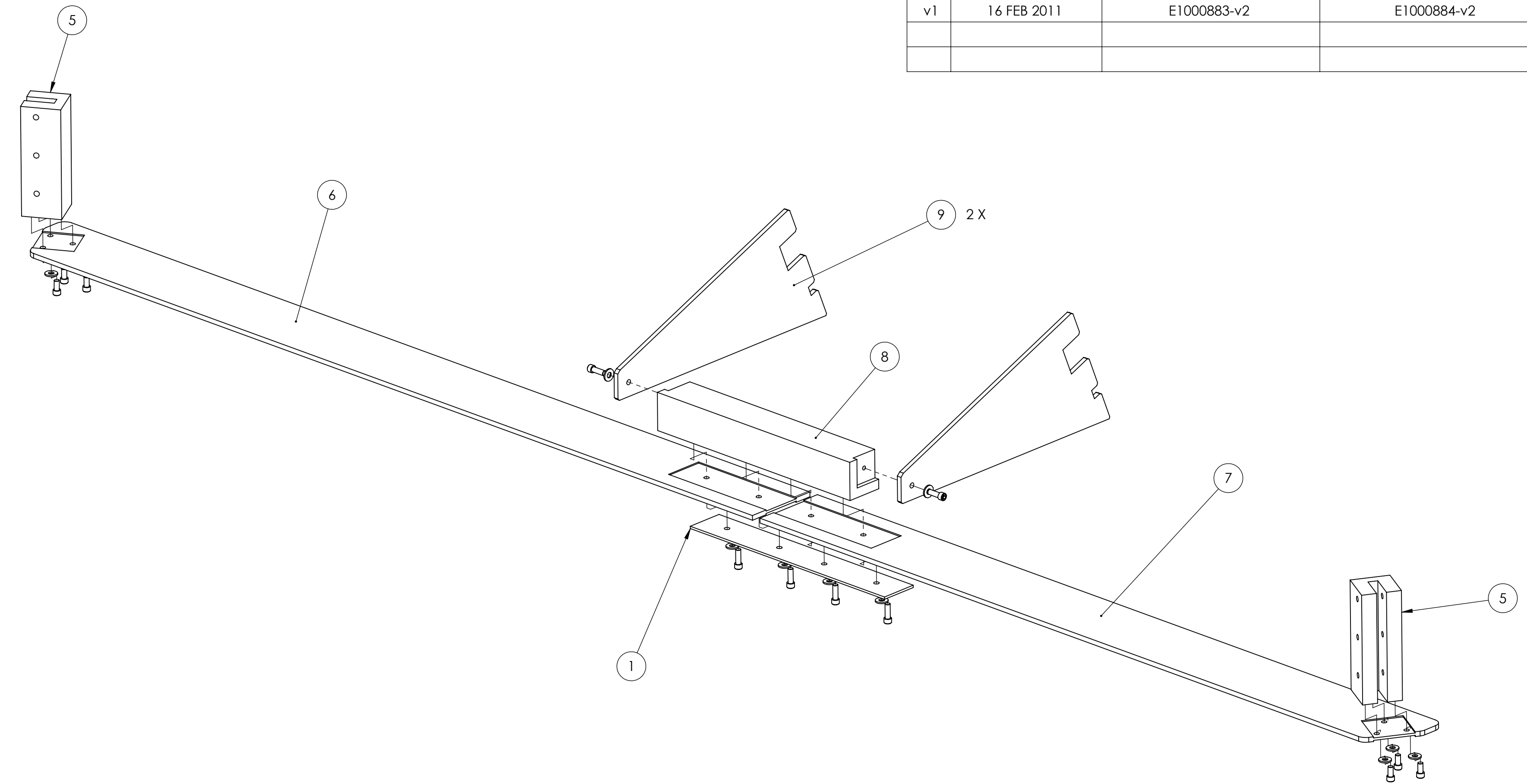
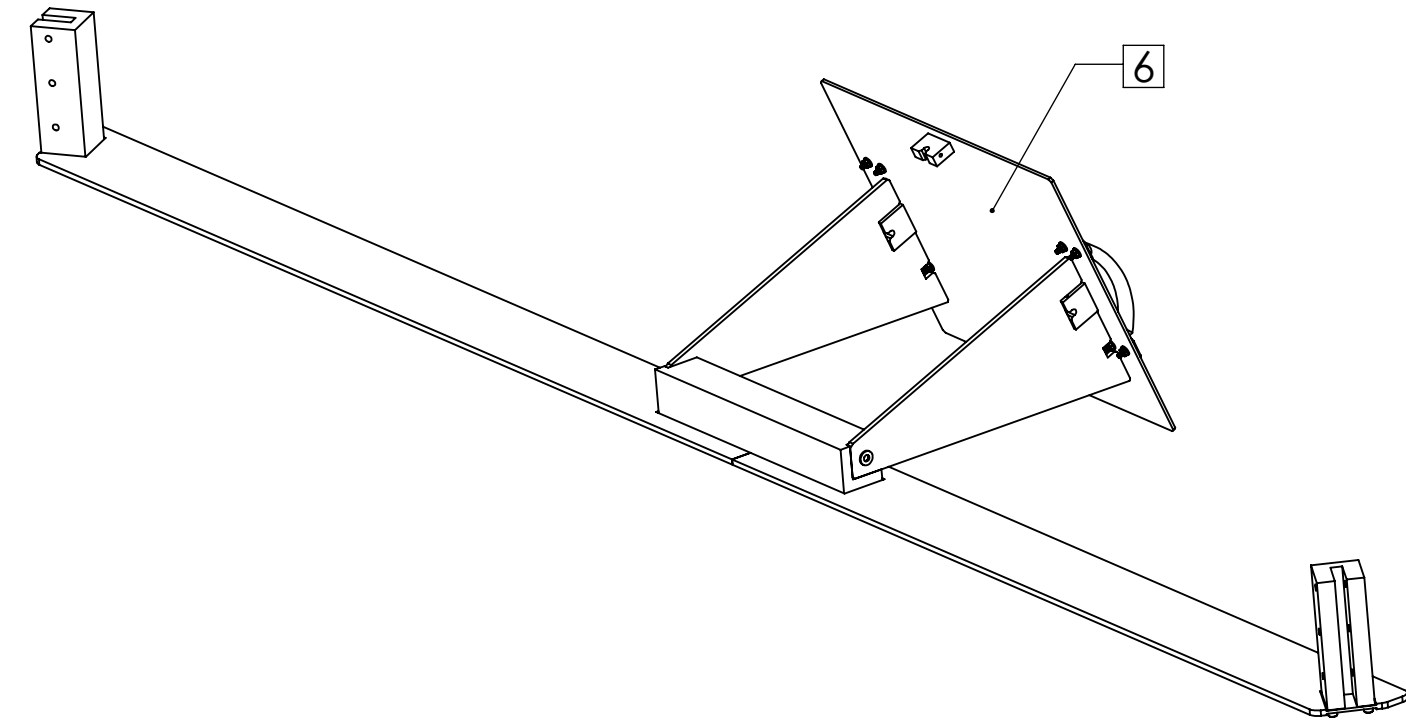
REV.	DATE	DCN #	DRAWING TREE #
v1	16 FEB 2011	E1000883-v2	E1000884-v2

BSC FIT-CHECK ASSEMBLY STEP SEQUENCE:

- 1 USING ITEMS 10, SECURE ITEMS 5 TO INTERIOR FLANGES OF BSC7 OR BSC8
- 2 USING ITEMS 2 AND 4, SECURE ITEM 6 AND 7 TO ITEMS 5
- 3 USING ITEM 1, CONFIRM BUTTED END-TO-END FIT OF ITEMS 6 AND 7 WITH RESPECT TO EACH OTHER
- 4 SECURE ITEMS 1 AND 8 TO ITEMS 6 AND 7 USING ITEMS 3 AND 4

MIRROR ASSEMBLY FIT CHECK SEQUENCE:

- 5 AFTER COMPLETING STEPS 1 - 4, SECURE ITEMS 9 TO ITEM 8 USING ITEMS 2 AND 4
- 6 CENTER MIRROR ASSEMBLY FIXTURE D1100263 ON ITEMS 9



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	BSC FIT-CHECK TEMPLATE/REQ	SPARE	TOTAL
10	97365A170	PULL-OUT DOWEL PIN, 1/4 IN. FLAT VENT, 2.5 IN LONG [NOT SHOWN]	18-8 SSTL. MCMMASTER	4	2	6
9	D1100294	αLIGO TCS FIXTURE TEMPLATE	6061 Alloy	2		2
8	D1100295	αLIGO TCS FIXTURE TEMPLATE BRACE	6061 Alloy	1		1
7	D1100296	αLIGO TCS SHORT BASE TEMPLATE	6061 Alloy	1		1
6	D1100297	αLIGO TCS LONG BASE TEMPLATE	6061 Alloy	1		1
5	D1100300	αLIGO TCS INTERFACE TEMPLATE	6061 Alloy	2		2
4	96659A106	FLAT WASHER 1/4 IN. 5/8 OD (MS 15795 OR EQUIVALENT)	18-8 SSTL. MCMMASTER	12		12
3	C-2012-N	SHCS 1/4-20 UNC-2A X 0.75 LONG, UC COMPONENTS	18-8 SSTL	6		6
2	C-2008-N	SHCS 1/4-20 UNC-2A X 0.5 LONG, UC COMPONENTS	18-8 SSTL	6		6
1	D1100298	αLIGO TCS TEMPLATE BRACE	6061 Alloy	1		1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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.

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .01
 .XXX ± .005

ANGULAR ± 0.5°

MATERIAL	N/A	FINISH	N/A μinch
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LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

NEXT ASSY: D1001742, D1002431

PART NAME: αLIGO TCS TEMPLATE, H2 UHV CO2P MIRR ASSY

DESIGNER	M. JACOBSON	14 FEB 2011	SIZE	DWG. NO.	REV.
DRAFTER	M. JACOBSON	15 FEB 2011	D	D1100293	v1
CHECKER	J. LEWIS	16 FEB 2011	SCALE: 1:12	PROJECTION:	SHEET 1 OF 1
APPROVAL	C. TORRIE	16 FEB 2011			

D1100293 αLIGO TCS TEMPLATE, H2 UHV CO2P MIRROR ASSY, PART PDM, REV: X-008, DRAWING PDM, REV: X-002