

8

7

6

5

4

3

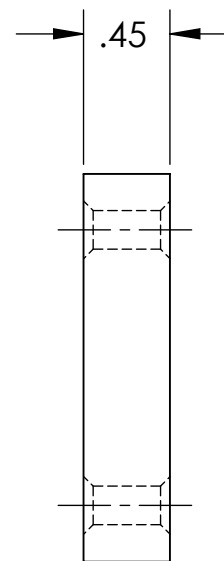
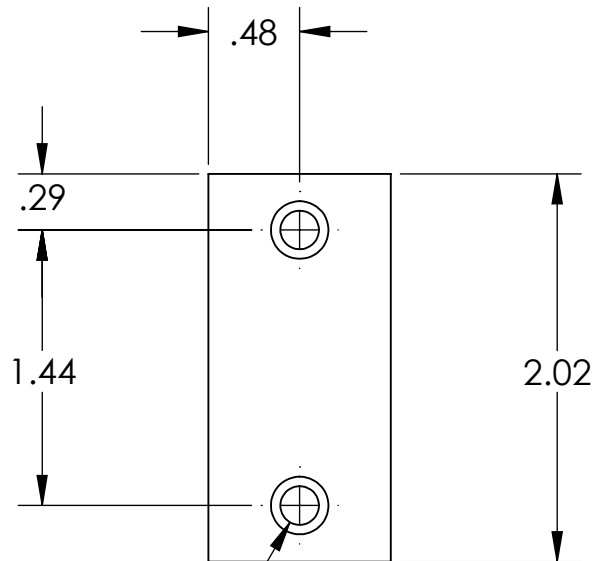
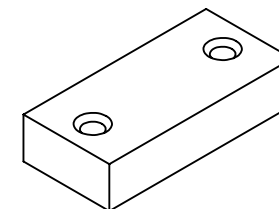
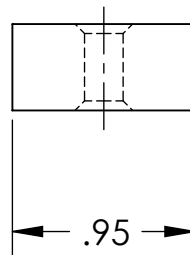
2

1

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 = X.XXX 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.
- 11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.
- 12. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE. THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

| REV. | DATE | DCN # | DRAWING TREE # |
|------|-------------|-----------|----------------|
| v1 | 01 JUN 2011 | E1100352 | - |
| v2 | 07-18-12 | TO FOLLOW | - |
| - | - | - | - |



2X 1/4-20 UNC, .005" OVERSIZE THRU
4X \sphericalangle 90° X ϕ .30

D1100403 TMS TOOLING Telescope Alignment Support Nutplate, PART PDM REV: X-013, DRAWING PDM REV: X-008

| NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) | | | | LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY | | PART NAME | |
|--|--|--|--|---|--|--|--|
| DIMENSIONS ARE IN INCHES | | | | ADVANCED LIGO | | TMS TOOLING TELESCOPE ALIGNMENT SUPPORT NUTPLATE | |
| TOLERANCES: .XX ± .01 .XXX ± .005 | | | | SUB-SYSTEM AOS | | DESIGNER C. CONLEY 01 MAR 2011 | |
| ANGULAR ± 1.0° | | | | NEXT ASSY D1100613 | | DRAFTER M. MILLER 03/03/2011 | |
| MATERIAL 6061-T6 Al | | | | FINISH 63 μinch | | SIZE DWG. NO. B D1100403 | |
| | | | | | | CHECKER | |
| | | | | | | APPROVAL | |
| | | | | | | SCALE: 1:1 PROJECTION: SHEET 1 OF 1 | |
| | | | | | | REV. v2 | |

8

7

6

5

4

3

2

1