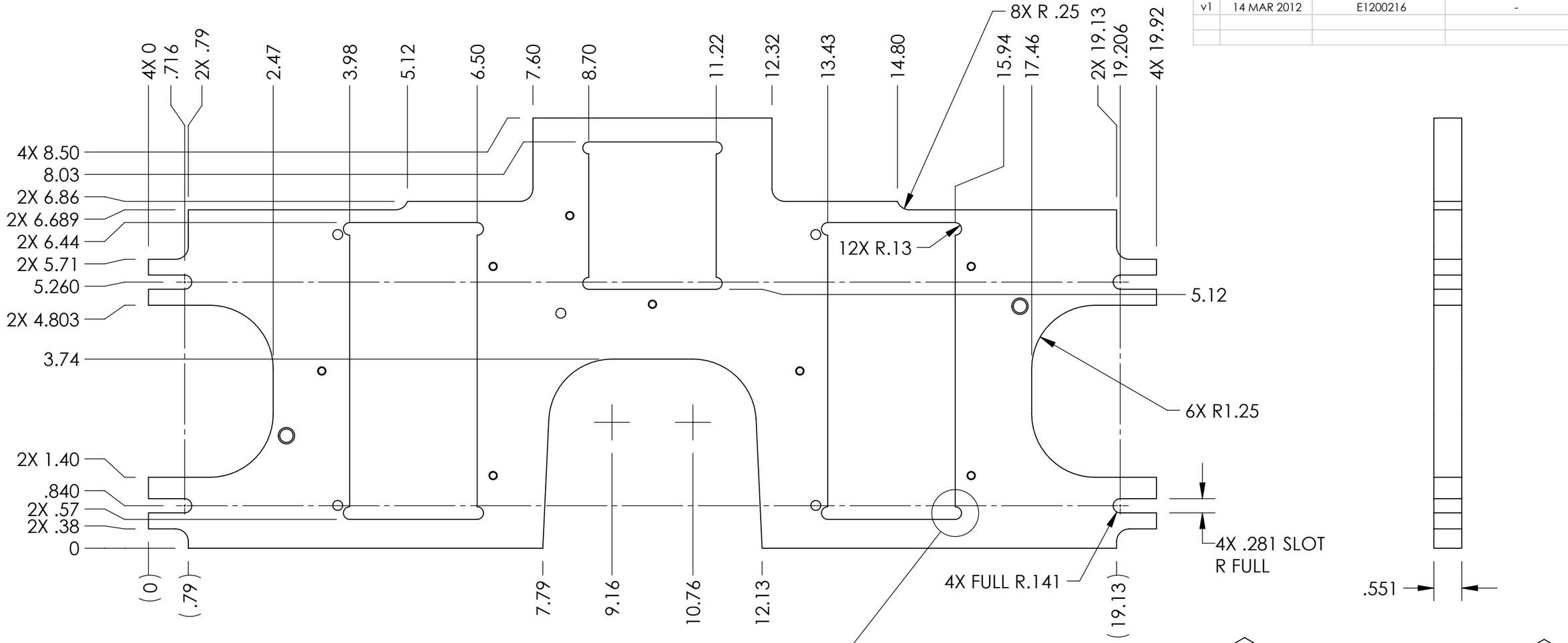
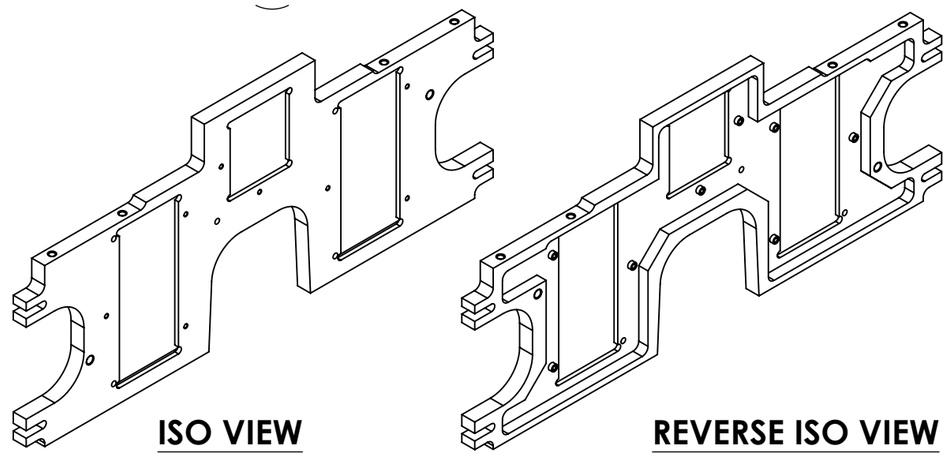
REV.	DATE	DCN #	DRAWING TREE #
v1	14 MAR 2012	E1200216	-





ISO VIEW

REVERSE ISO VIEW

NOTES (CONTINUED):

4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE, PER LIGO SPECIFICATION E0900237.

(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. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXXX-VY, TYPE-XX, S/N XXX.

6. MASS: 0.960 KG [2.117 LB].

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 HELI-COIL TAPPED HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG HC2000.

10. ALL HELICOIL 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 OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING BY LIGO LABBORATORY. REFER TO LIGO-E0900364.

(12) ALL TAPPED HOLES (HELI-COIL EXCLUDED): USE 0.005 OVERSIZE BOTH DRILL & TAP.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .015
.XXX ± .005

ANGULAR ± .5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015.
3. DO NOT SCALE FROM DRAWING.

MATERIAL: 6061-T6 Al

FINISH: 63 µinch Ra

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO

SUB-SYSTEM: AOS

NEXT ASSY: D1000549

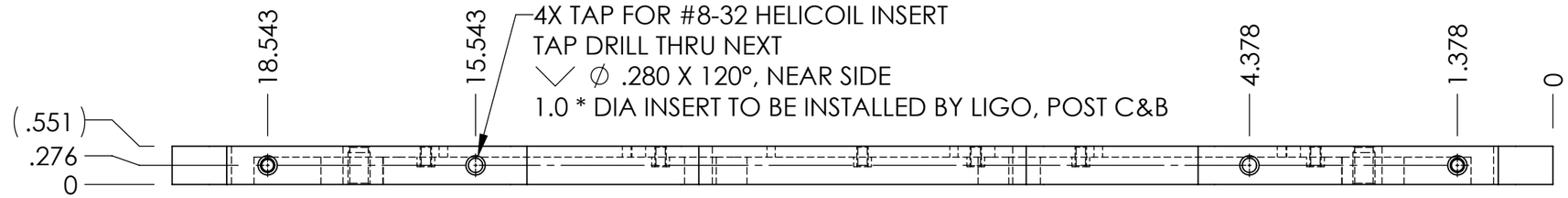
PART NAME: TMS SUSPENSION TABLECLOTH PLATE, FRONT

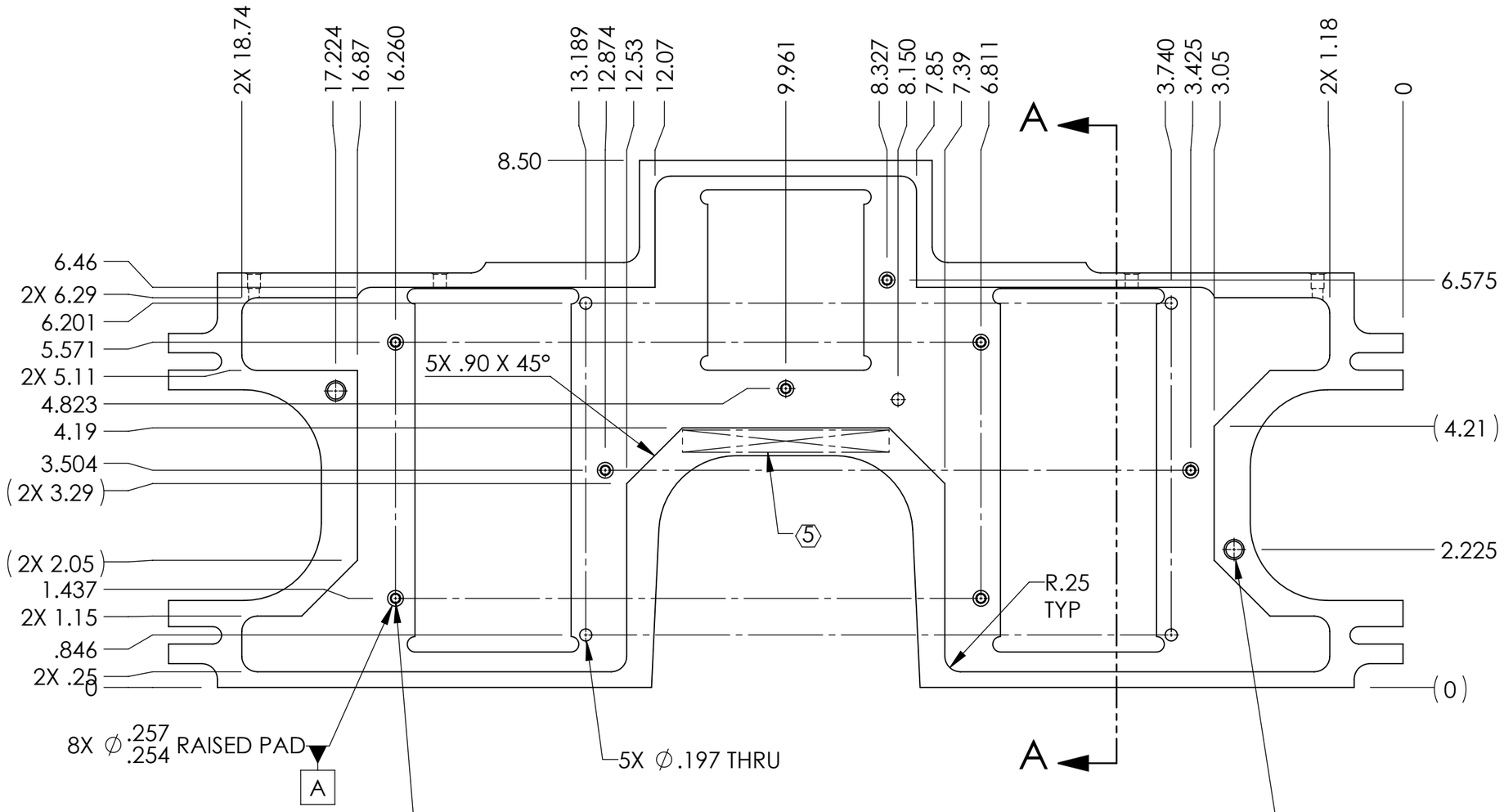
DESIGNER	C. CONLEY	04 MAR 2011
DRAFTER	M. HILLARD	14 MAR 2012
CHECKER	SEE DCN	
APPROVAL	SEE DCN	

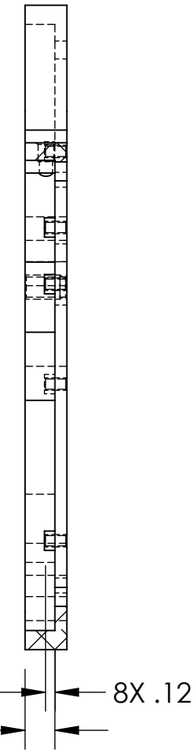
SIZE: B — DWG. NO.: D1100421 — REV.: v1

SCALE: NONE — PROJECTION: — SHEET 1 OF 2

D1100421 aLIGO AOS, TMS Suspension Tablecloth Plate, Front, PART PDM REV: X-039, DRAWING PDM REV: X-018







SECTION A-A

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D1100421	v1

SCALE:NONE PROJECTION: SHEET 2 OF 2

D1100421 aLIGO AOS, TMS Suspension Tablecloth Plate, Front, PART PDM REV: X-039, DRAWING PDM REV: X-018