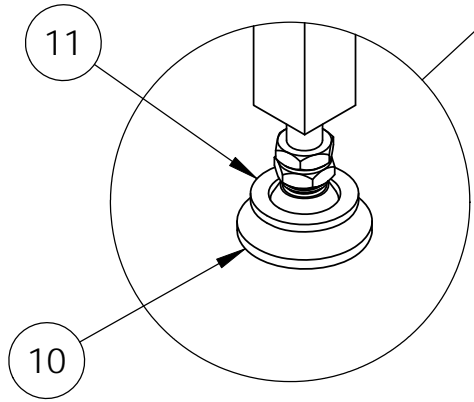
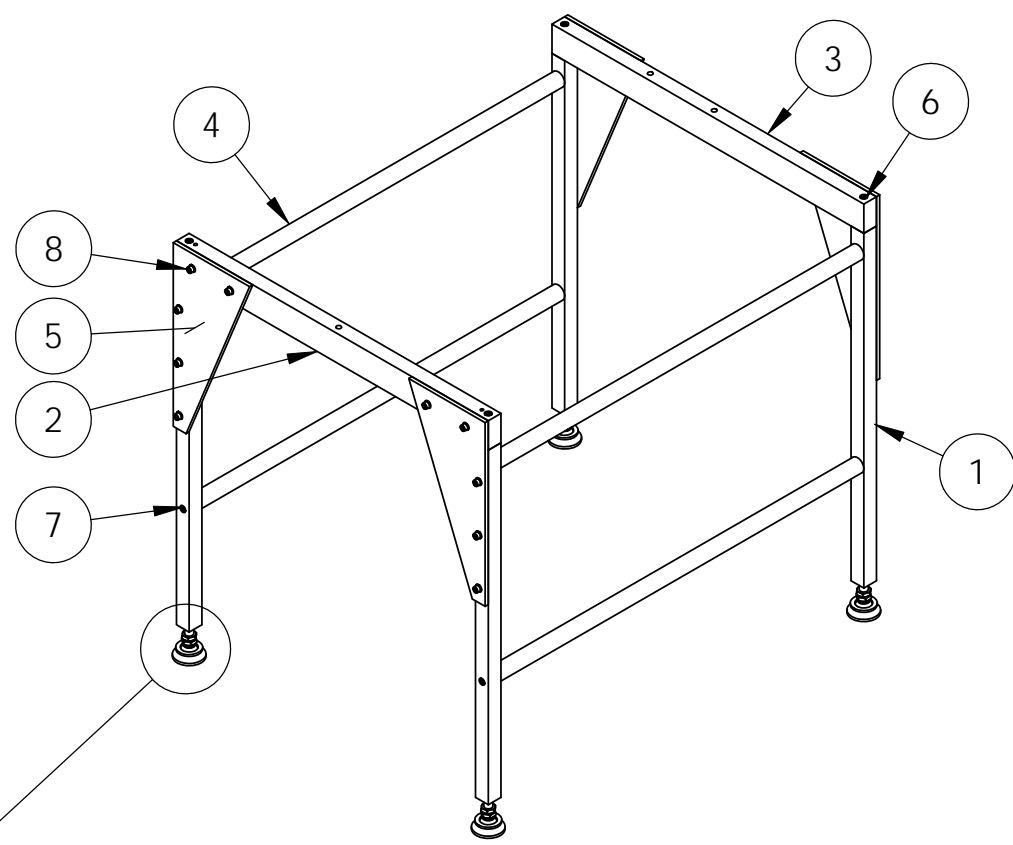


D1100460\_aLIGO TMS TELE ALIGNMENT SUPPORT BRIDGE ASSY, PART PDM REV: X-033, DRAWING PDM REV: X-025

- 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.
  - 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 #
V-1	04/13/2011	E1100352-v1	



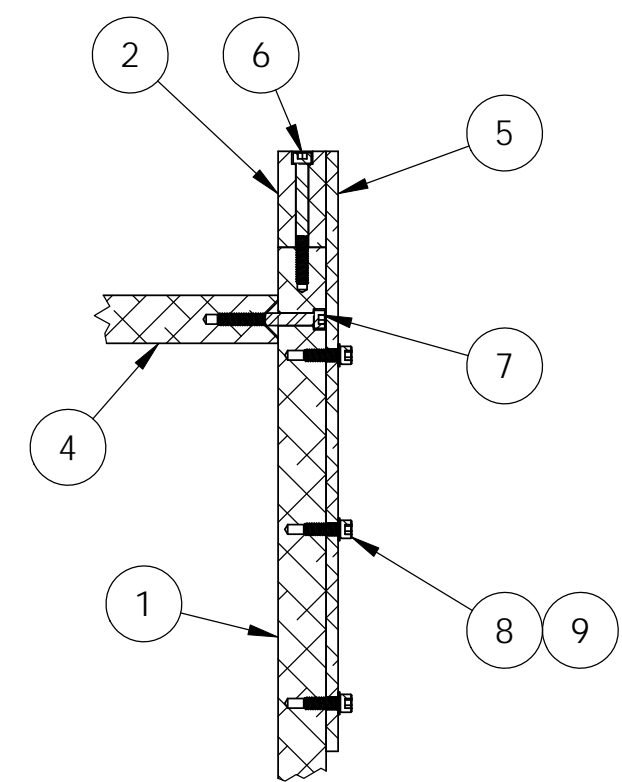
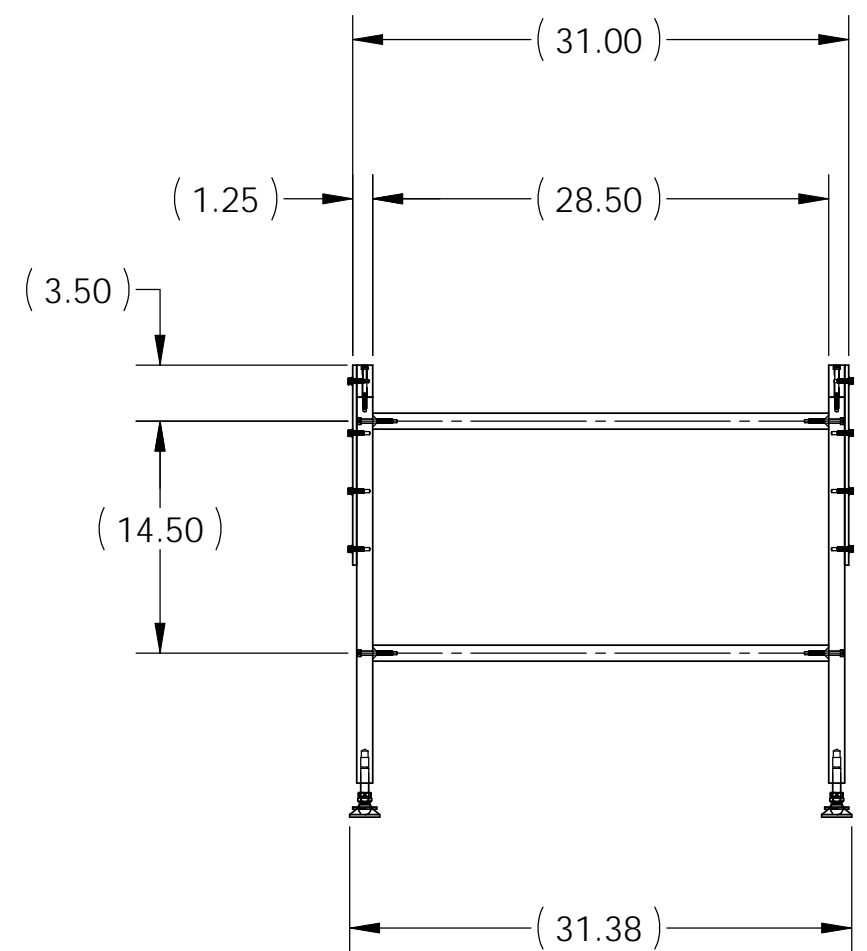
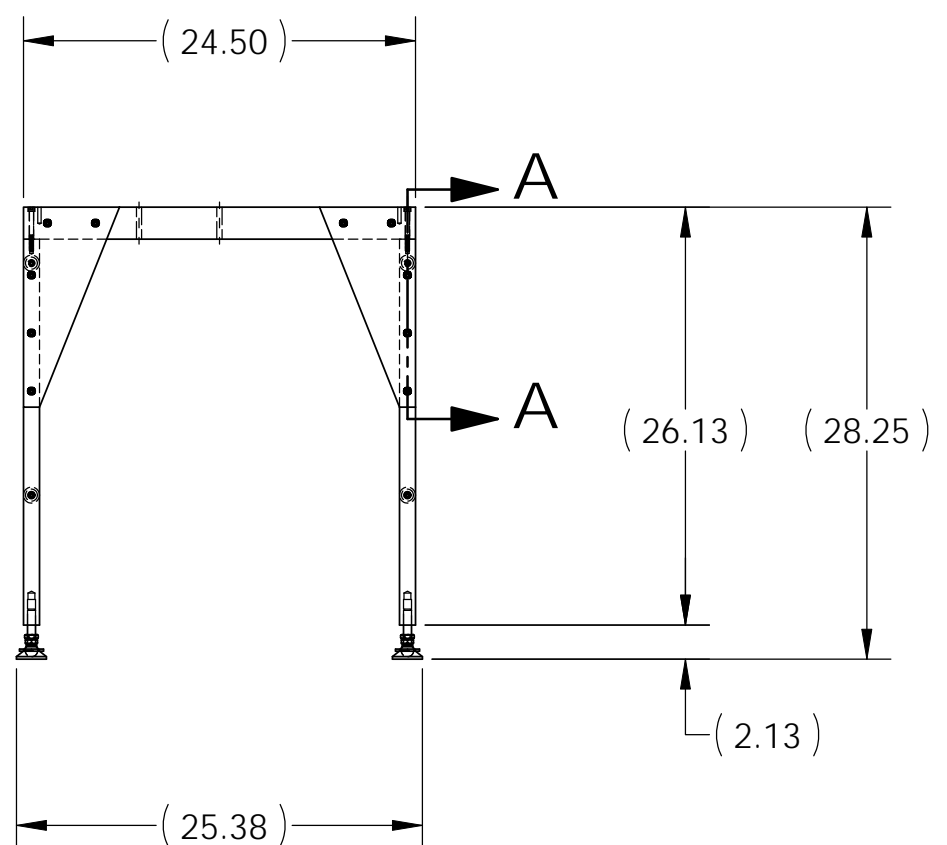
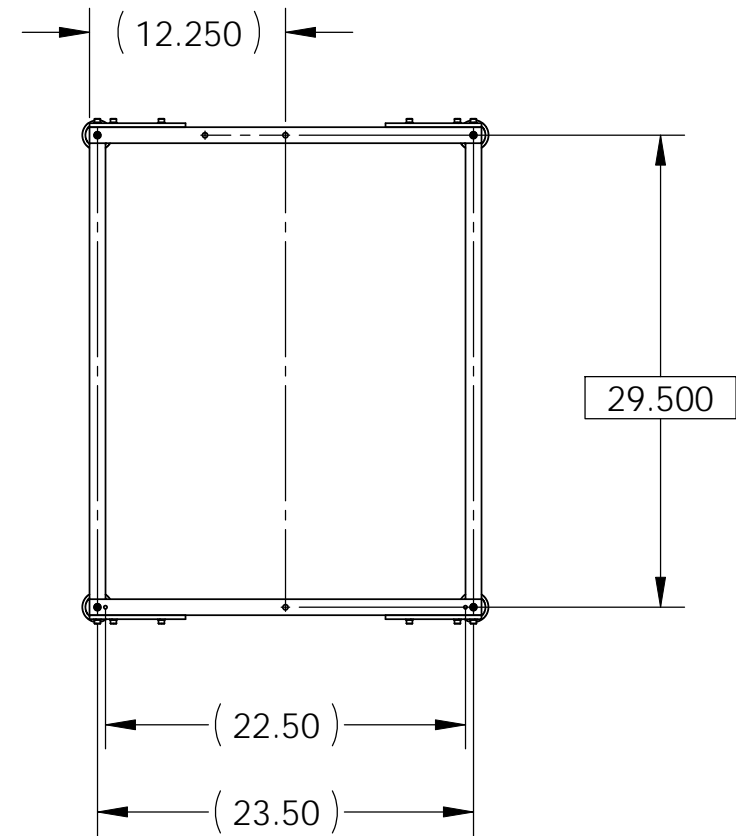
DETAIL B  
SCALE 3 : 8

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
11	98126A849	(McMASTER-CARR), WASHER, 1" ID X 1.5 OD x .12 T	18-8 SSTL	4		4
10	6111K55	McMASTER, SWIVEL LEVELING MOUNT, .50-13 X 3.125 LG, 1.875 DIA BASE, 2.00 STUD	NICKEL PLATED STEEL	4		4
9	96861A600	(McMASTER-CARR).25 VENTED WASHER,) .255 ID X .468 OD X .031 THK	18-8 SSTL	20		20
8	92196A540	(McMASTER-CARR) .25-20-.75 L. S.H.C.S.	18-8 SSTL	20		20
7	92196A550	(McM-Carr) .25-20-2.0L. S.H.C.S.	18-8 SSTL	8		8
6	92196A552	(McM-Carr) .25-20-2.50L. S.H.C.S.	18-8 SSTL	4		4
5	D1100465	aLIGO TMS TELE ALIGNMENT SUPPORT BRIDGE GUSSET	6061-T6 Al	4		4
4	D1100464	aLIGO TMS TELE ALIGNMENT SUPPORT BRIDGE SIDE BRACE	6061-T6 Al	4		4
3	D1100552	aLIGO TMS TELE ALIGNMENT SUPPORT BRIDGE TOP BAR, ENTRY	6061-T6 Al	1		1
2	D1100463	aLIGO TMS TELE ALIGNMENT SUPPORT BRIDGE TOP BAR, PRIMARY	6061-T6 Al	1		1
1	D1100462	aLIGO TMS TELE ALIGNMENT SUPPORT BRIDGE LEGS	6061-T6 Al	4		4

PARTS LIST

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± .02 .XXX ± .005		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
ANGULAR ± 1.0°		MATERIAL N/A		FINISH N/A μinch		NEXT ASSY	
				DESIGNER J. TERRAZAS 16 FEB 2011		SIZE DWG. NO.	
				DRAFTER J. TERRAZAS 5/19 2011		B D1100460	
				CHECKER		REV. v1	
				APPROVAL		SCALE: 1:12 PROJECTION: SHEET 1 OF 2	

D1100460\_aLIGO TMS TELE ALIGNMENT SUPPORT BRIDGE ASSY, PART PDM REV: X-033, DRAWING PDM REV: X-025



SECTION A-A  
TYPICAL CORNER DETAIL  
SCALE 1 : 4

<b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE <b>B</b>	DWG. NO. D1100460
SCALE: 1:12	REV. v1
PROJECTION:	SHEET 2 OF 2