

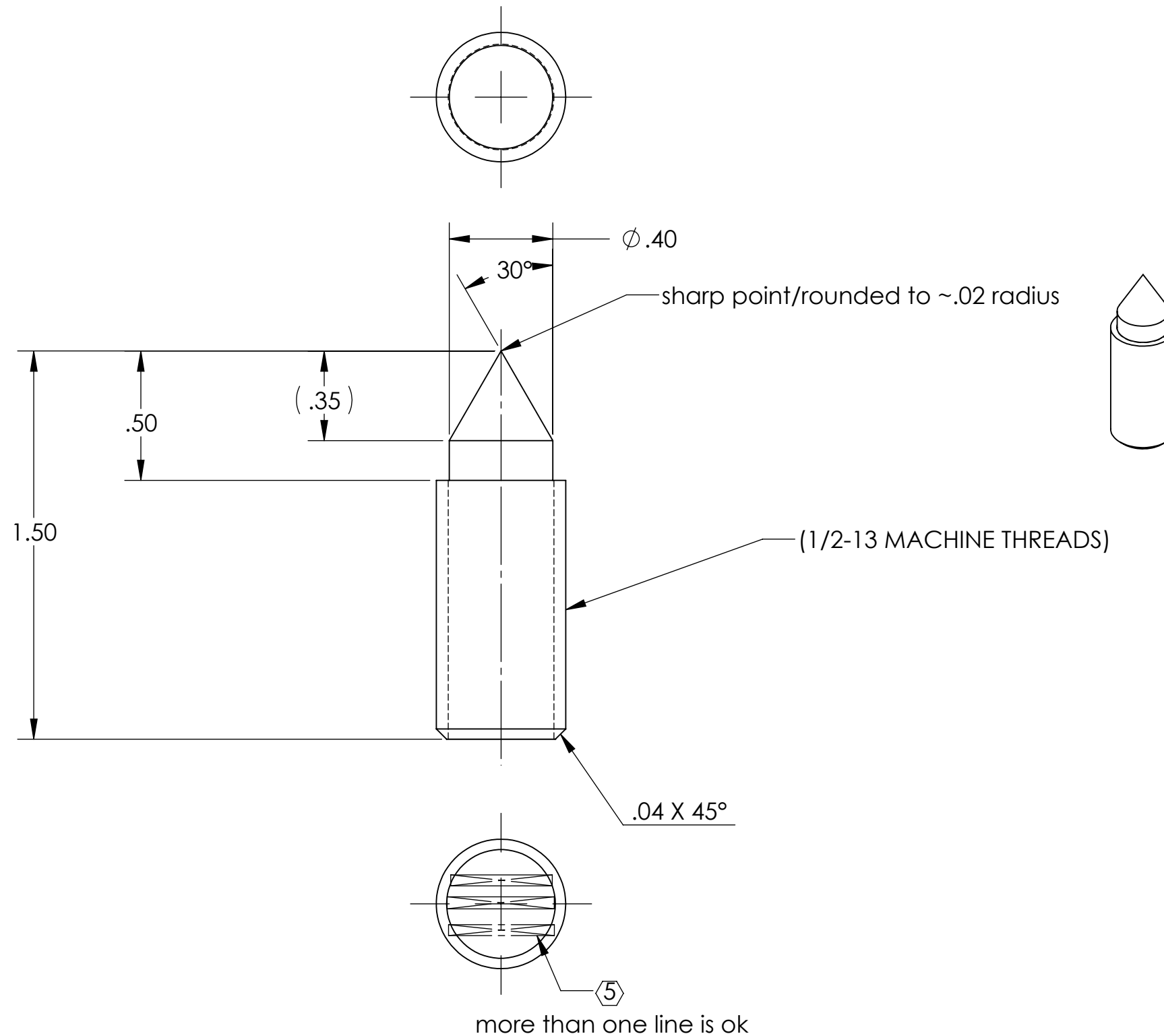
D1100653_dLIGO TMS OPTICAL TABLE SUSPENSION BRIDGE PIN, PART PDM REV: X-034, DRAWING PDM REV: X-010

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 = 0.07 LBS.
- 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 8. 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.
- 9. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

10 MATERIAL: McMASTER CARR PART NO. 95815A393
ROD, THREADED, 1/2-13 UNC CLASS 2A, NICKEL-COPPER ALLOY TYPE 400 MONEL, PER ASTM B-164

REV.	DATE	DCN #	DRAWING TREE #
v1	14 JUN 2011	E1100355-v1	-
v2	8-10-12	to follow	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .02 .XXX ± .005 ANGULAR ± 1.0°	
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.	
MATERIAL	10
FINISH	μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		dLIGO TMS OPTICAL TABLE SUSPENSION BRIDGE PIN	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	AOS	DESIGNER	J. TERRAZAS 11 APR 2011
NEXT ASSY	D1100649	CHECKER	J. TERRAZAS 14 APR 2011	APPROVAL	
SIZE DWG. NO. B D1100653			REV.	v2	
SCALE: 2:1			PROJECTION:	SHEET 1 OF 1	