

NOTES CONTINUED:

5) SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR TYPE (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
 EXAMPLE (PART): 001-v1
 EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD

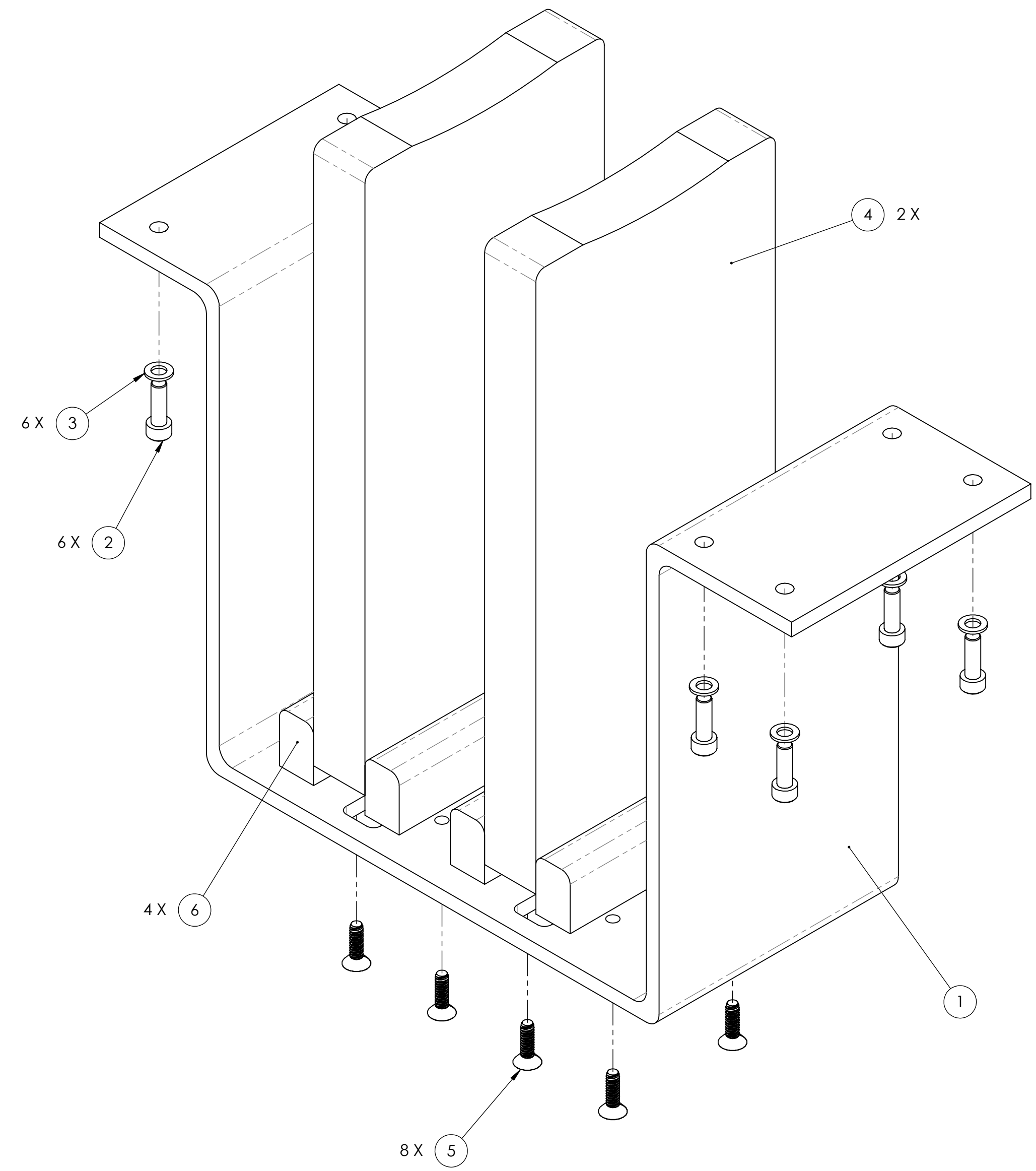
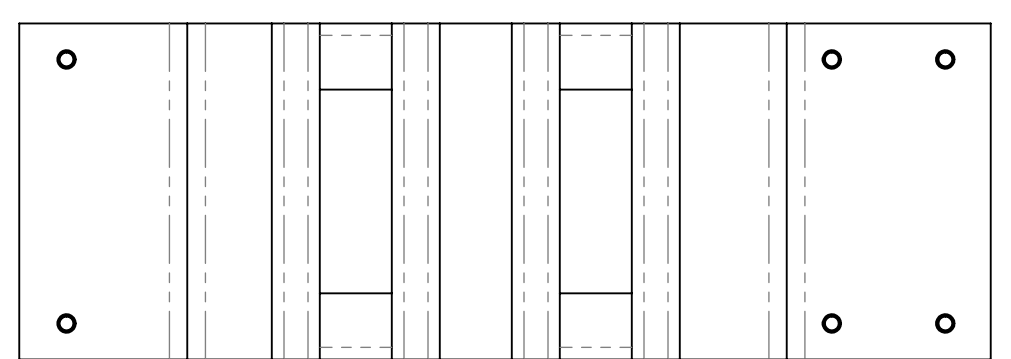
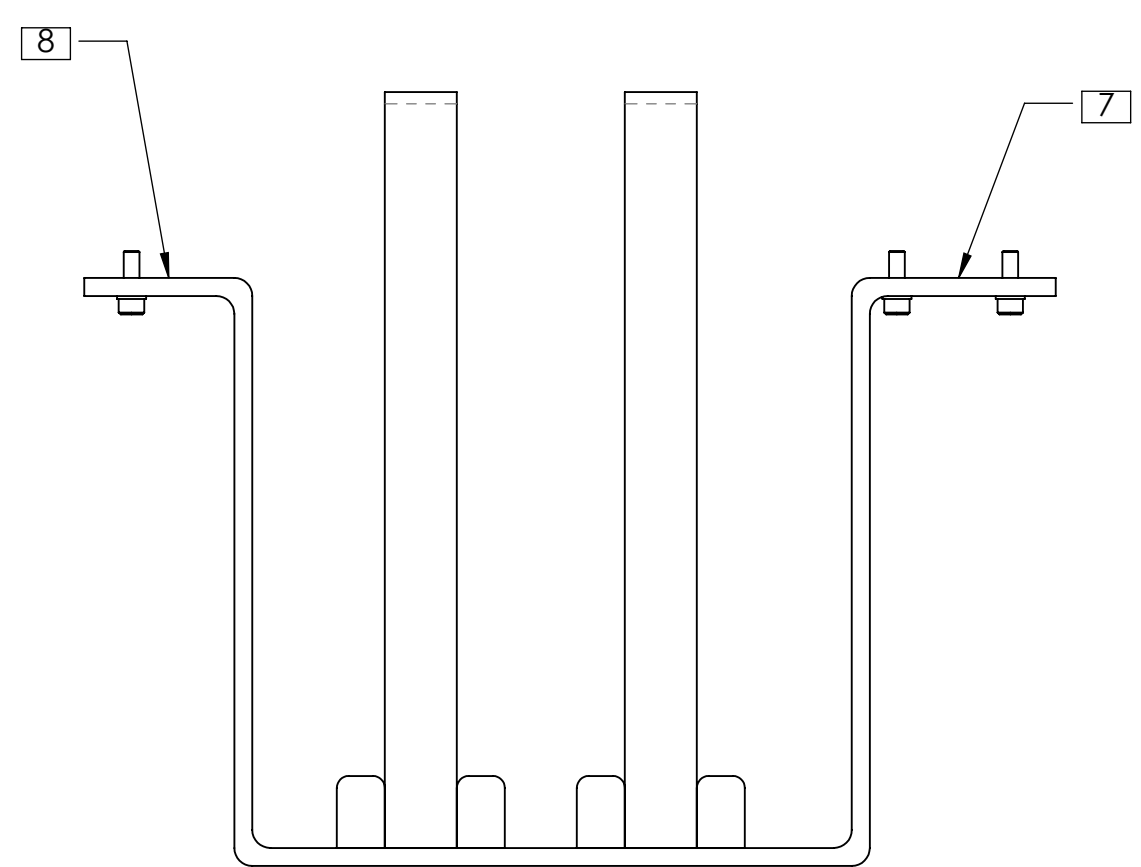
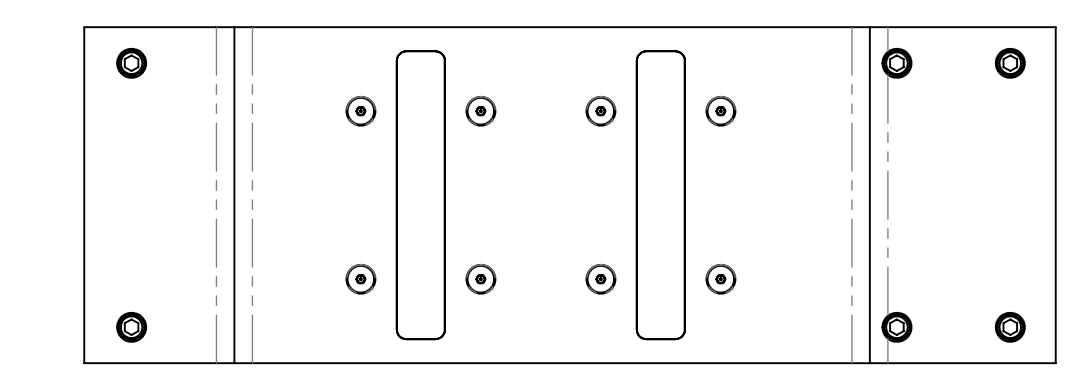
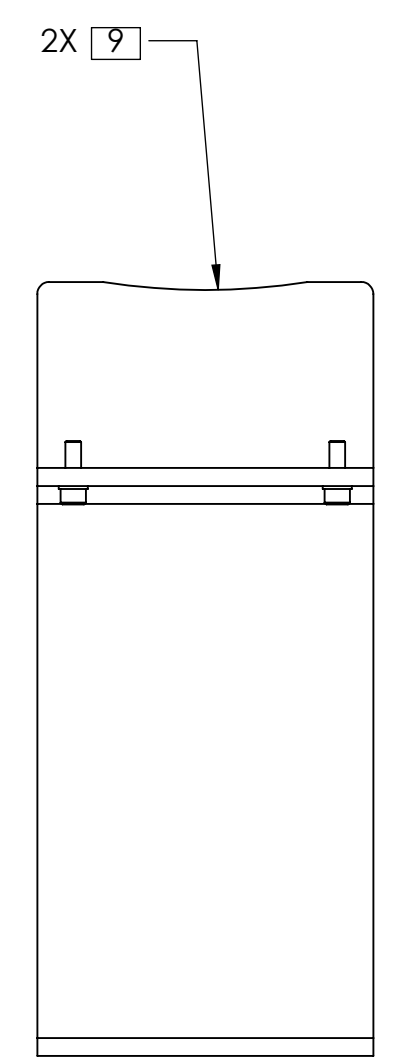
6 APPROXIMATE WEIGHT = 5.12 LB

7 INTERFACES TO BOTTOM-FACING, INTERIOR LOWER QUADRUPLE SUSPENSION STRUCTURE

8 INTERFACES TO BOTTOM-FACING, OUTER LOWER QUADRUPLE SUSPENSION STRUCTURE

9 SURFACES CRADLE BARREL OF PRIMARY OPTICAL TEST MASS

REV.	DATE	DCN #	DRAWING TREE #
v1	12 JUL 2011	E1100659-v1	E1100660-v1



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
6	D1101268	CRUTCH STIFFENER	6061 Alloy	4		4
5	FA-608-N	FHSCS 6-32 X .5 LONG, NON-VENTED	18-8 SSSL	8		8
4	D1101254	TCS RH REPLACEMENT TM CRUTCH	TEFLON PFA 440-HP	2		2
3	WF-08	WASHER, FLAT, #8 (NAS 620-C8 OR EQUIVALENT)	18-8 SSSL	6		6
2	C-808-N	SCREW, SOCKET HEAD CAP, #8-32 UNC X 0.5 LONG	18-8 SSSL	6		6
1	D1101255	TCS RH REPLACEMENT TM CRUTCH SUPPORT	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 [MM]	
TOLERANCES: .XX ± .XXX ±	
ANGULAR ± °	
MATERIAL	N/A
FINISH	N/A μinch

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 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

NEXT ASSY: D0901346

PART NAME									
TCS RH REPLACEMENT FIXTURE ASSY									
DESIGNER	M. JACOBSON	30 JUN 2011	SIZE	DWG. NO.		REV.			
DRAFTER	M. JACOBSON	12 JUL 2011	D	D1101253		v1			
CHECKER	J. O'DELL	12 JUL 2011	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1				
APPROVAL	C. TORRIE	13 JUL 2011							

D1101253_TCS RH REPLACEMENT FIXTURE ASSY, PART PDM REV: X012, DRAWING PDM REV: X001