

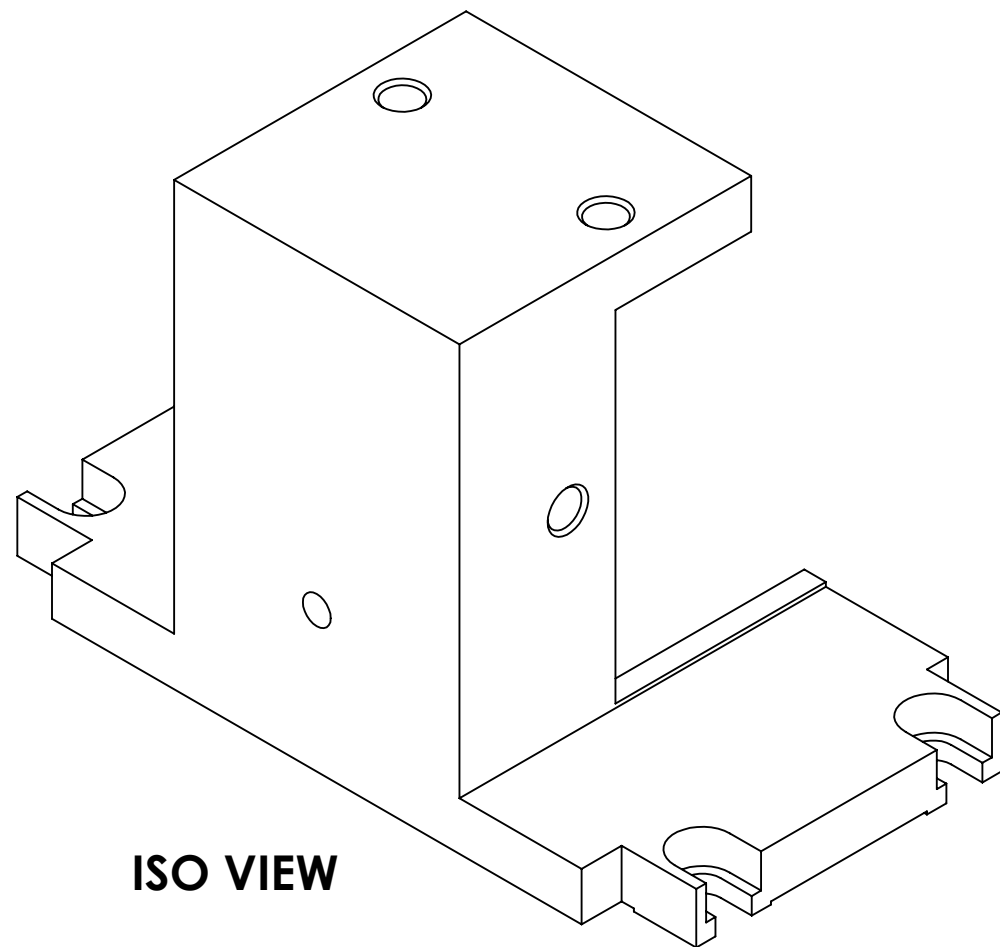
NOTES (CONTINUED):

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. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

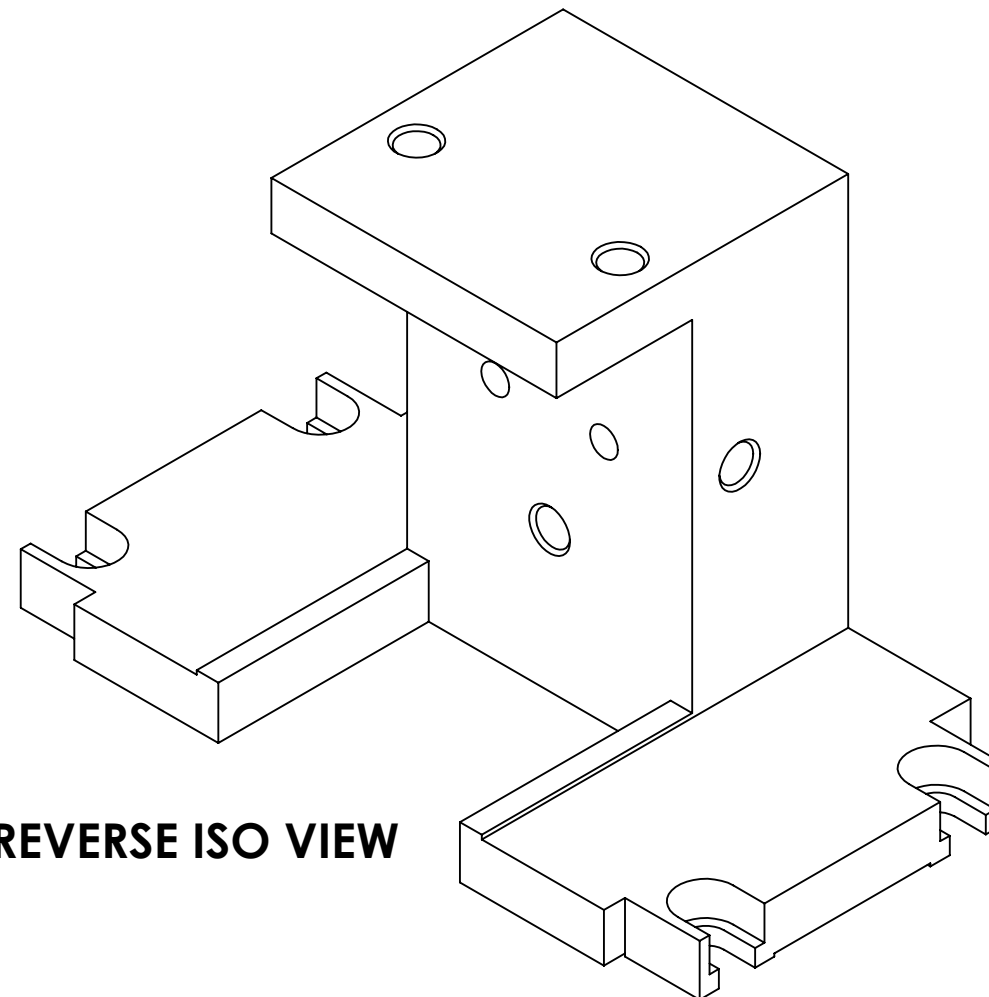
- 6. MASS: 1.448 KG [3.192 LB].
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL, WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE PART 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.

⑩ ALL TAPPED HOLES: 0.005 OVERSIZE BOTH DRILL AND TAP.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 MAR 2012	E1101214	
v2	11 APR 2012	E1101214	



ISO VIEW



REVERSE ISO VIEW

D1101519 aLIGO TMS Top Add Mass Tower, PART PDM REV: X-020, DRAWING PDM REV: X-001

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.1°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.		aLIGO TMS TOP ADD MASS TOWER	
MATERIAL		FINISH		SYSTEM		SUB-SYSTEM	
304 SSSL		63 μinch Ra		ADVANCED LIGO		AOS	
NEXT ASSY				DESIGNER		SIZE DWG. NO.	
D1101526				K. MAILAND		B	
D1101526				C. CONLEY		D1101519	
D1101526				SEE DCN		REV.	
D1101526				SEE DCN		v2	
D1101526				SCALE: NONE		PROJECTION:	
D1101526				SHEET 1 OF 3			

D1101519 dLIGO TMS Top Add Mass Tower, PART PDM REV: X-020, DRAWING PDM REV: X-001

8 7 6 5 4 3 2 1

D

D

C

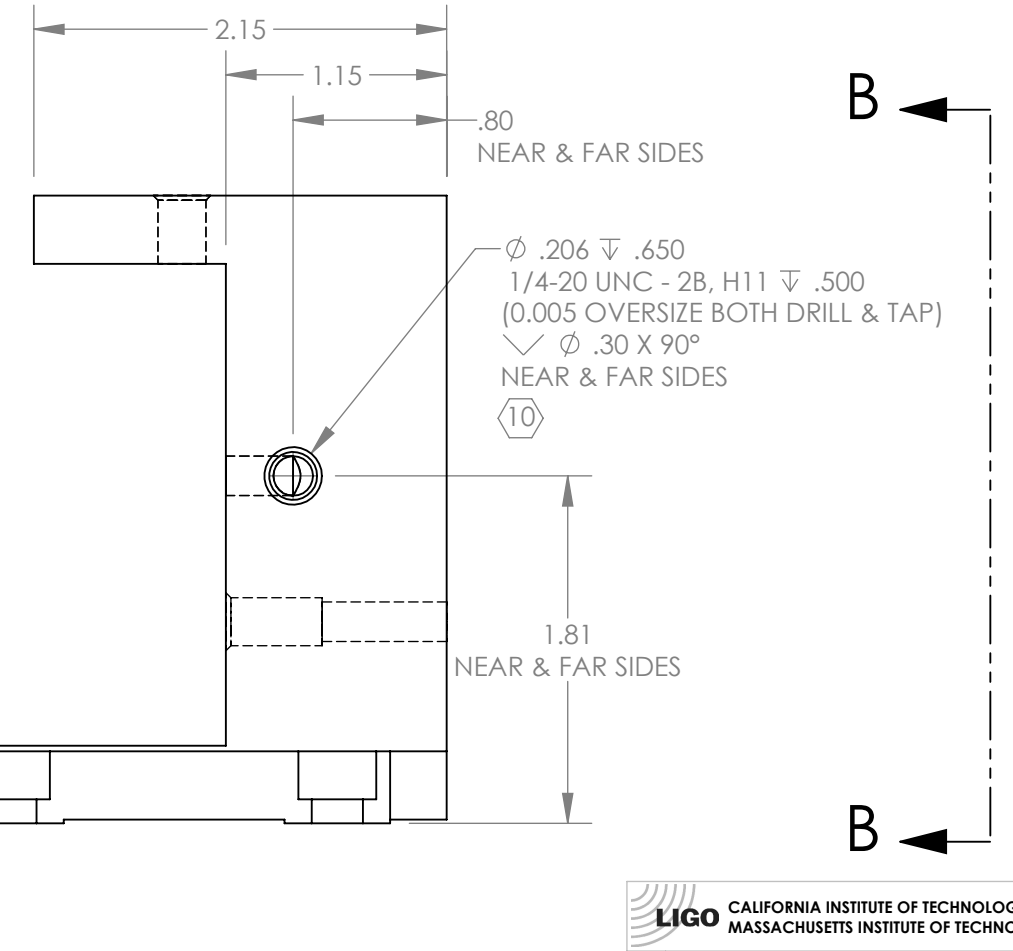
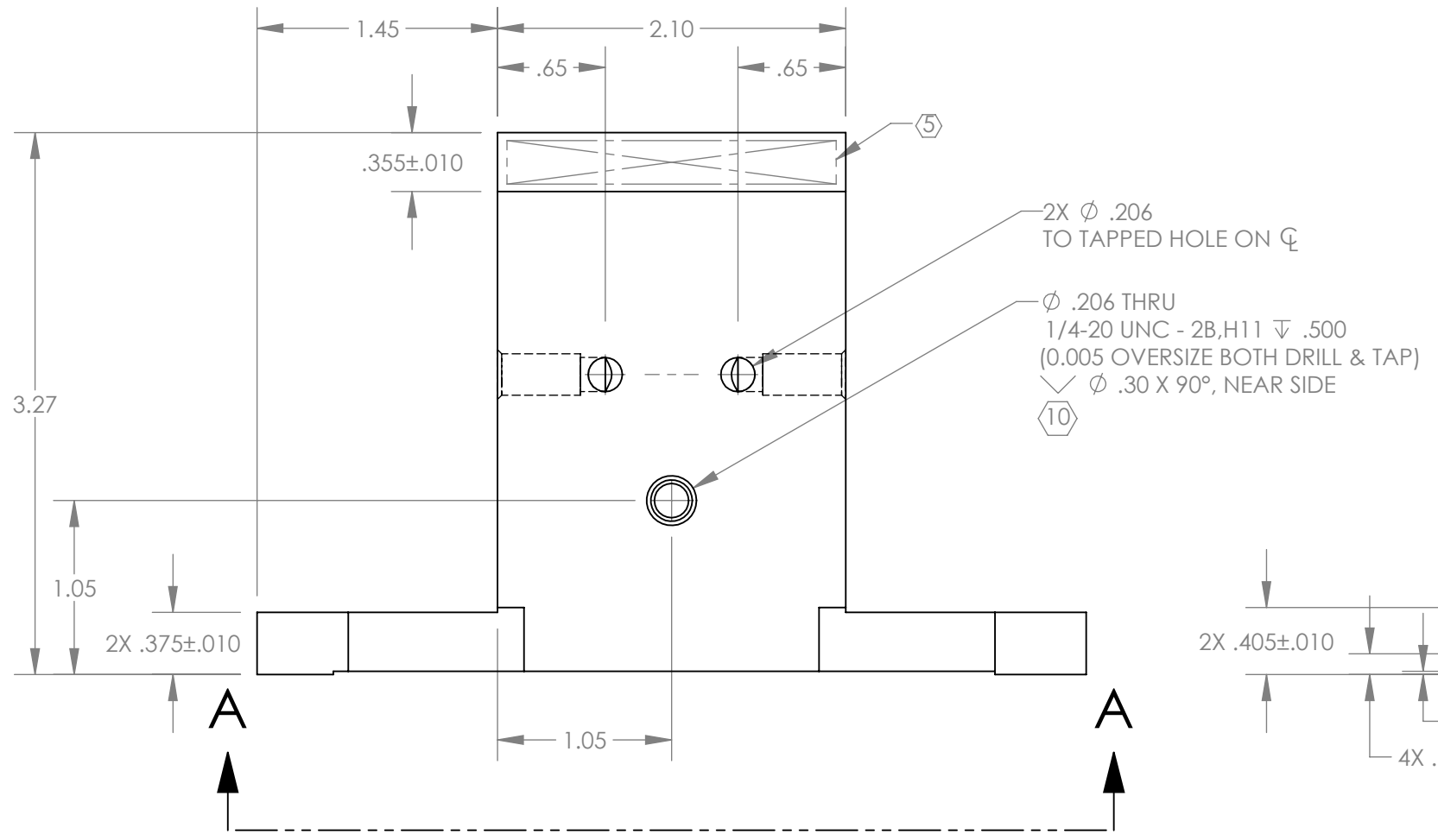
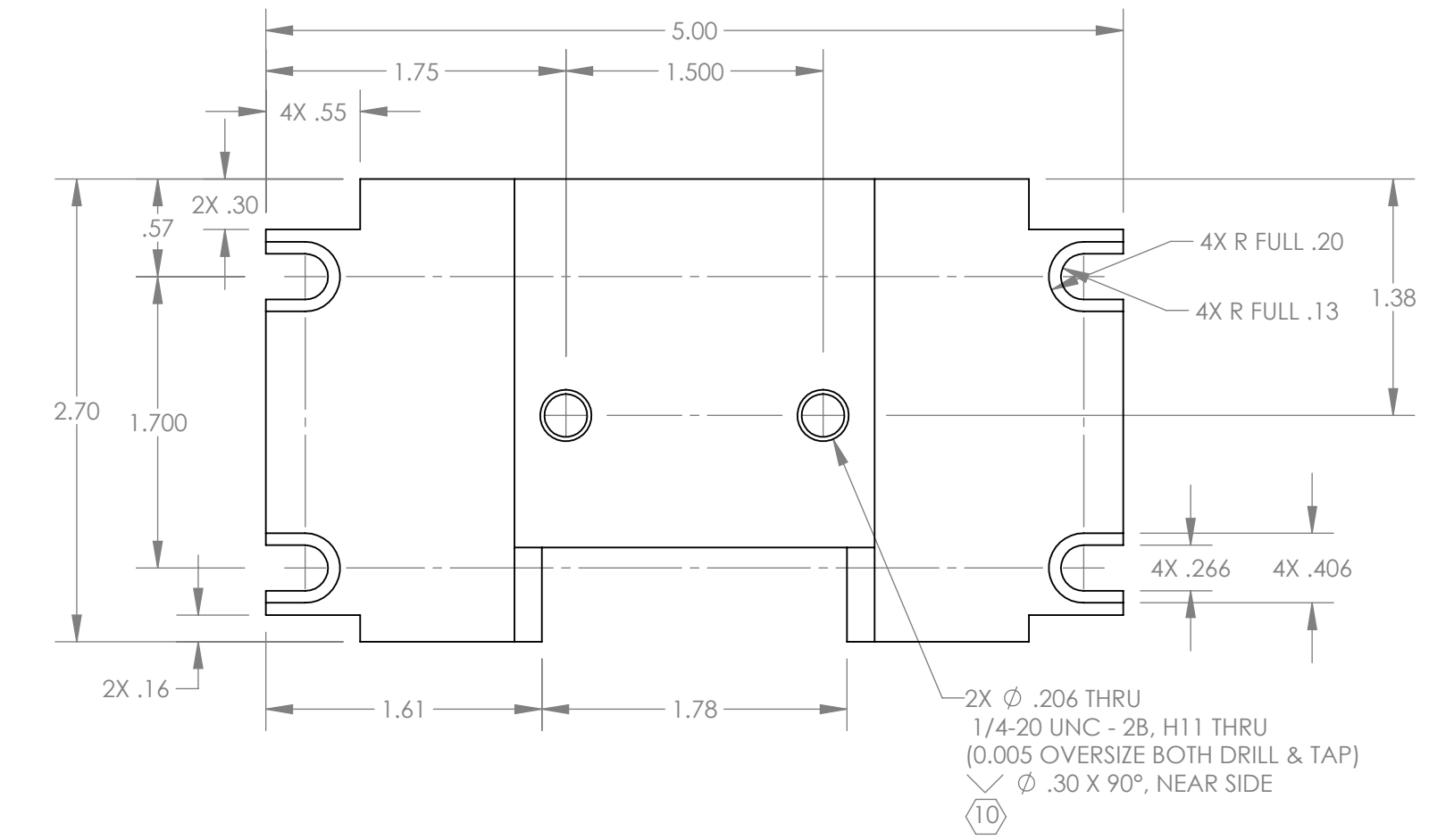
C

B

B

A

A



B

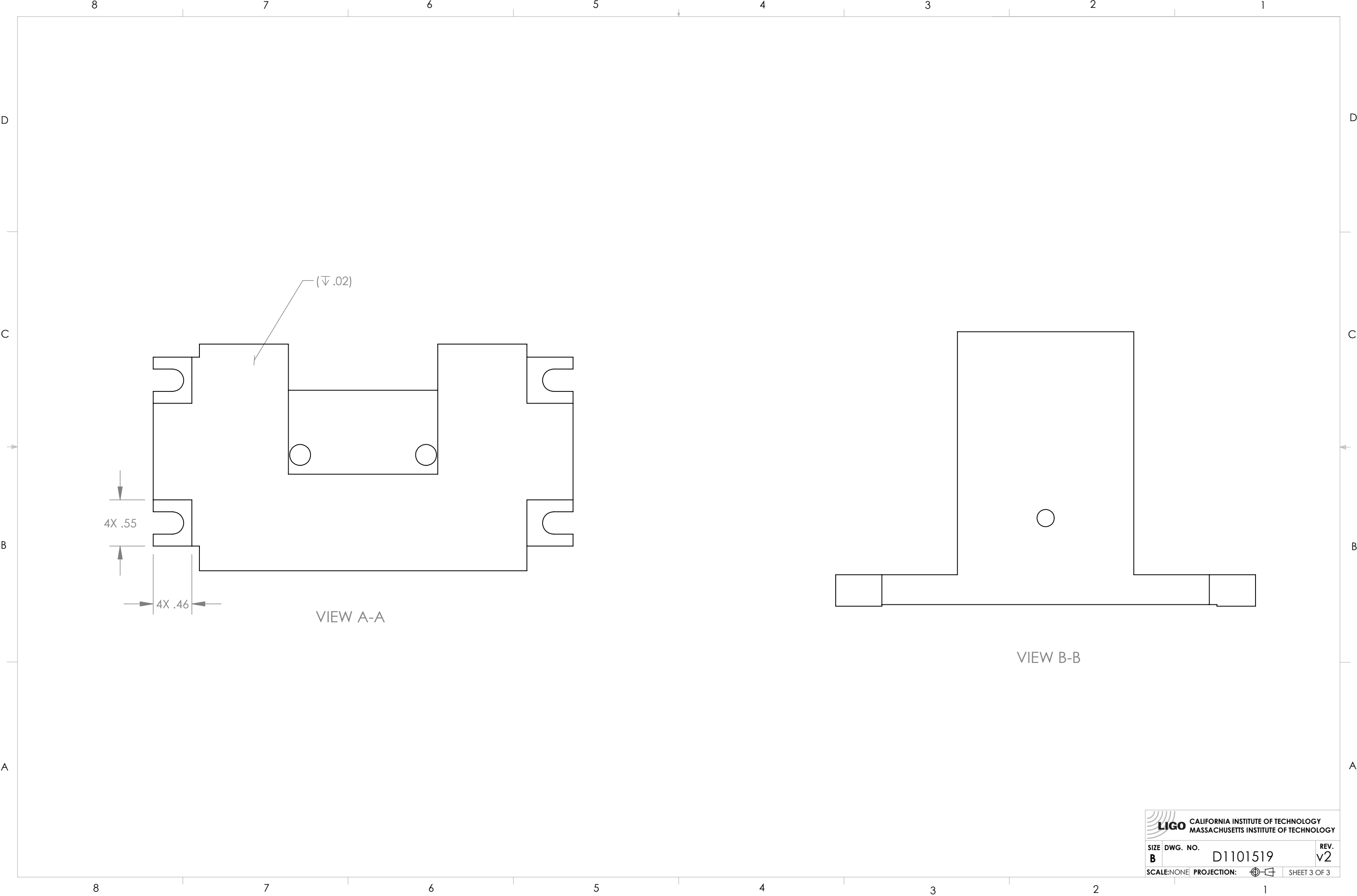
B

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MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D1101519	v2
SCALE: NONE	PROJECTION:	SHEET 2 OF 3


8 7 6 5 4 3 2 1

D1101519 dLIGO TMS Top Add Mass Tower, PART PDM REV: X-020, DRAWING PDM REV: X-001



VIEW A-A

VIEW B-B

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
B	D1101519	v2
SCALE: NONE	PROJECTION:	SHEET 3 OF 3