

**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. APPROXIMATE WEIGHT = 15.356 LB.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

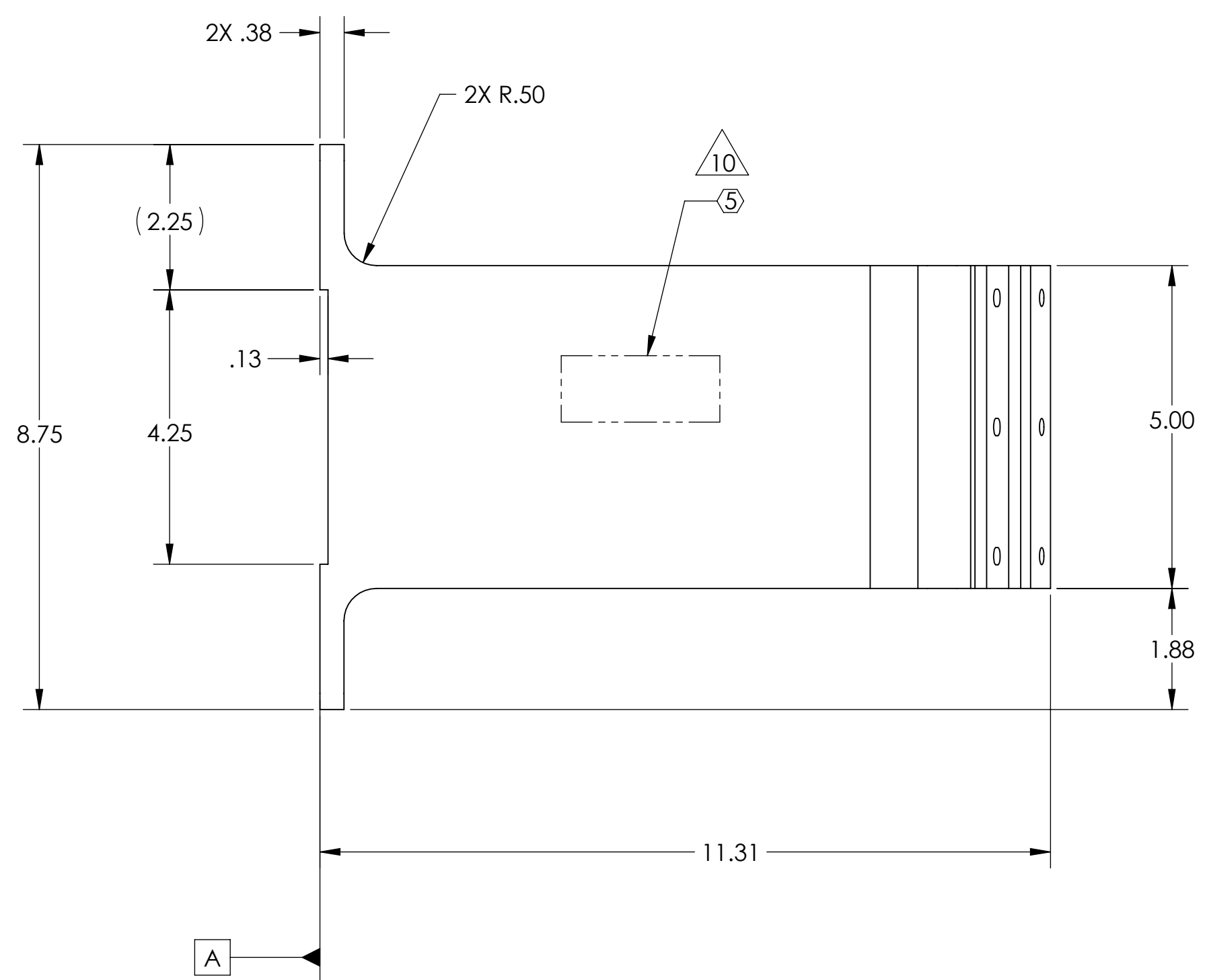
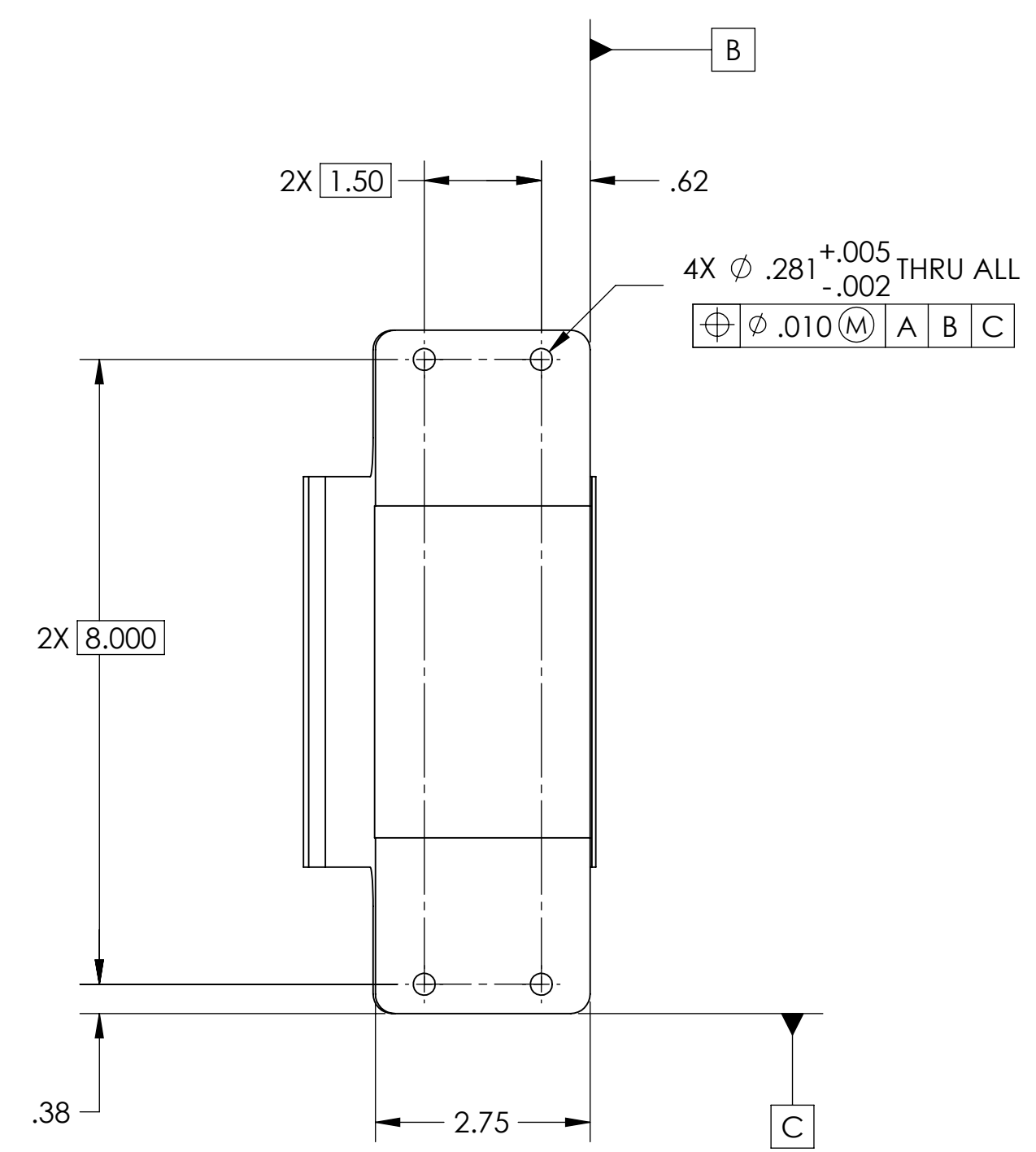
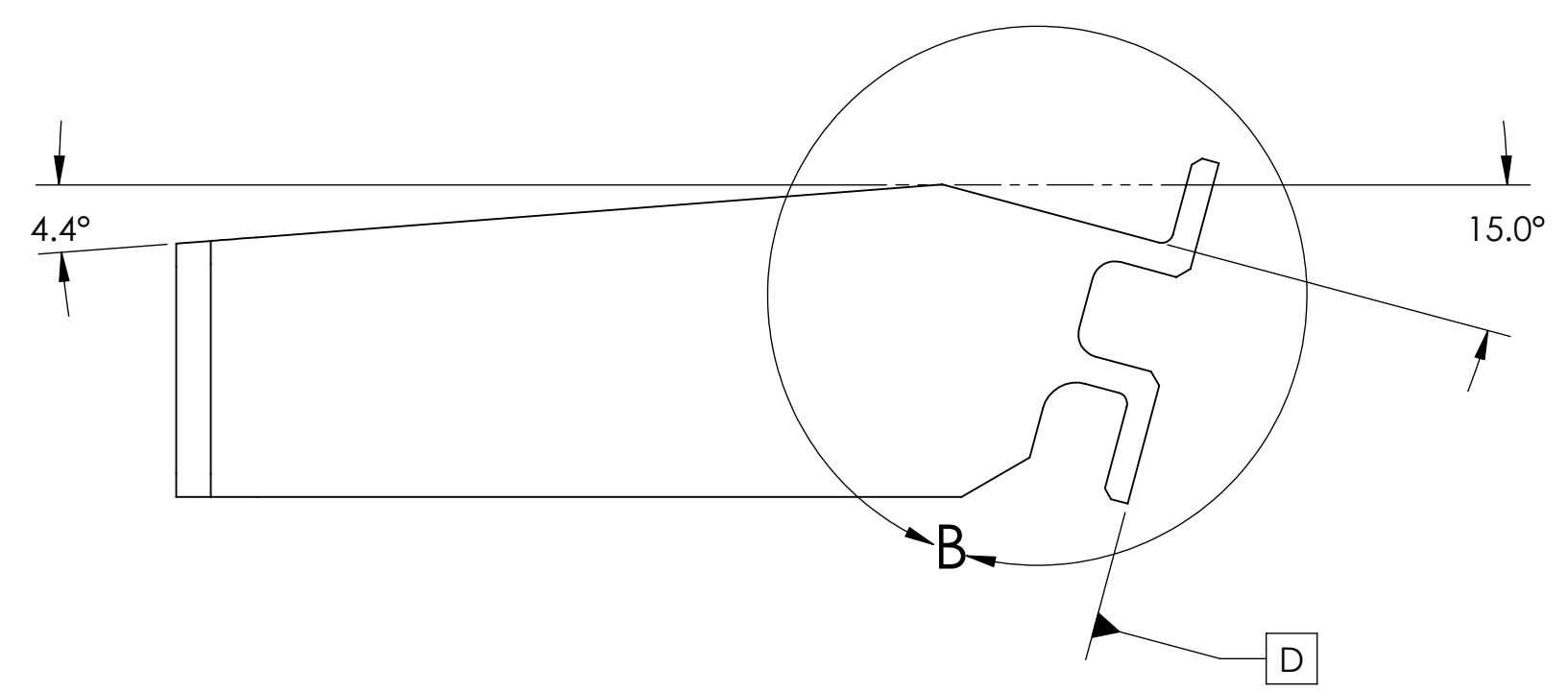
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL 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.

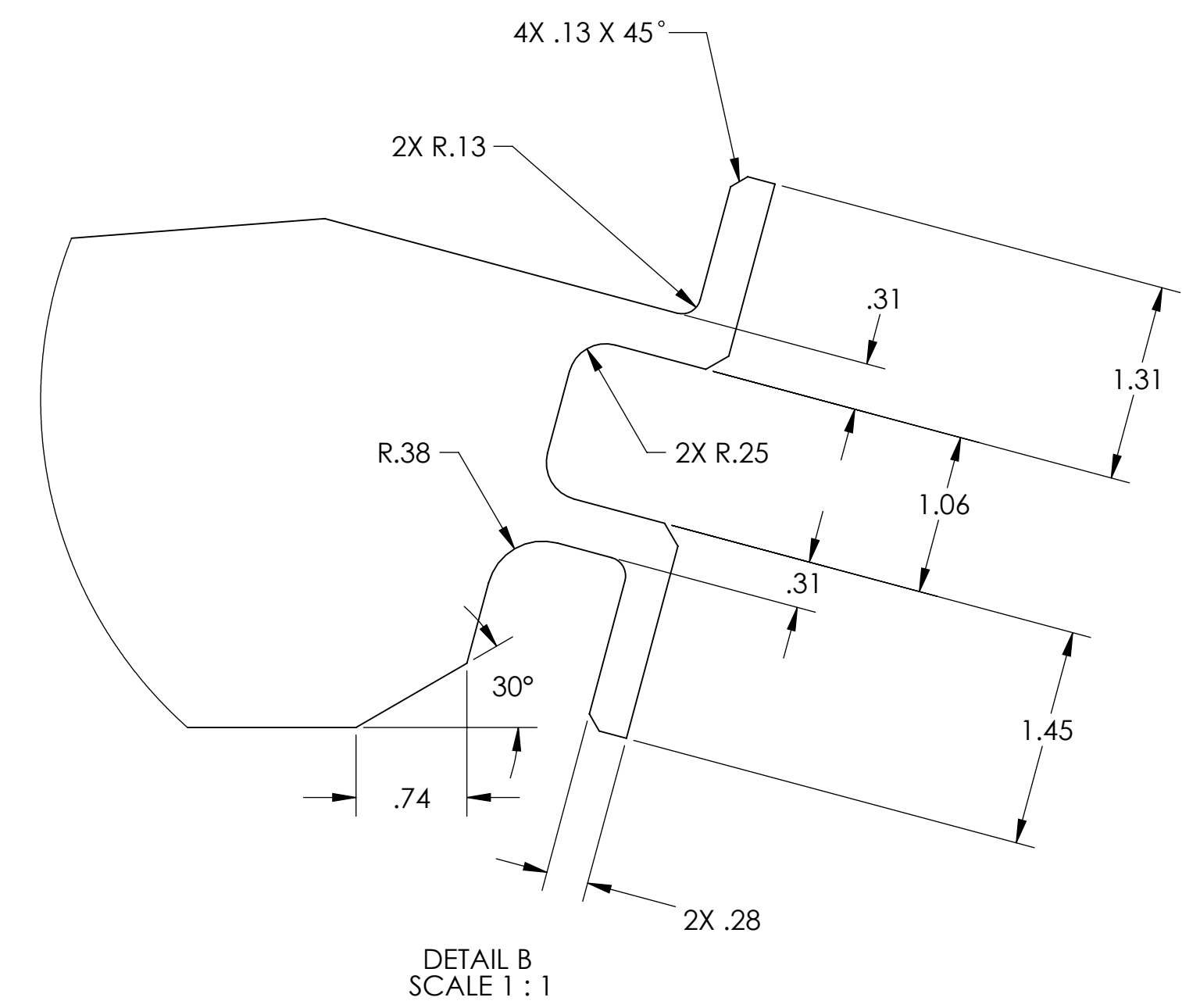
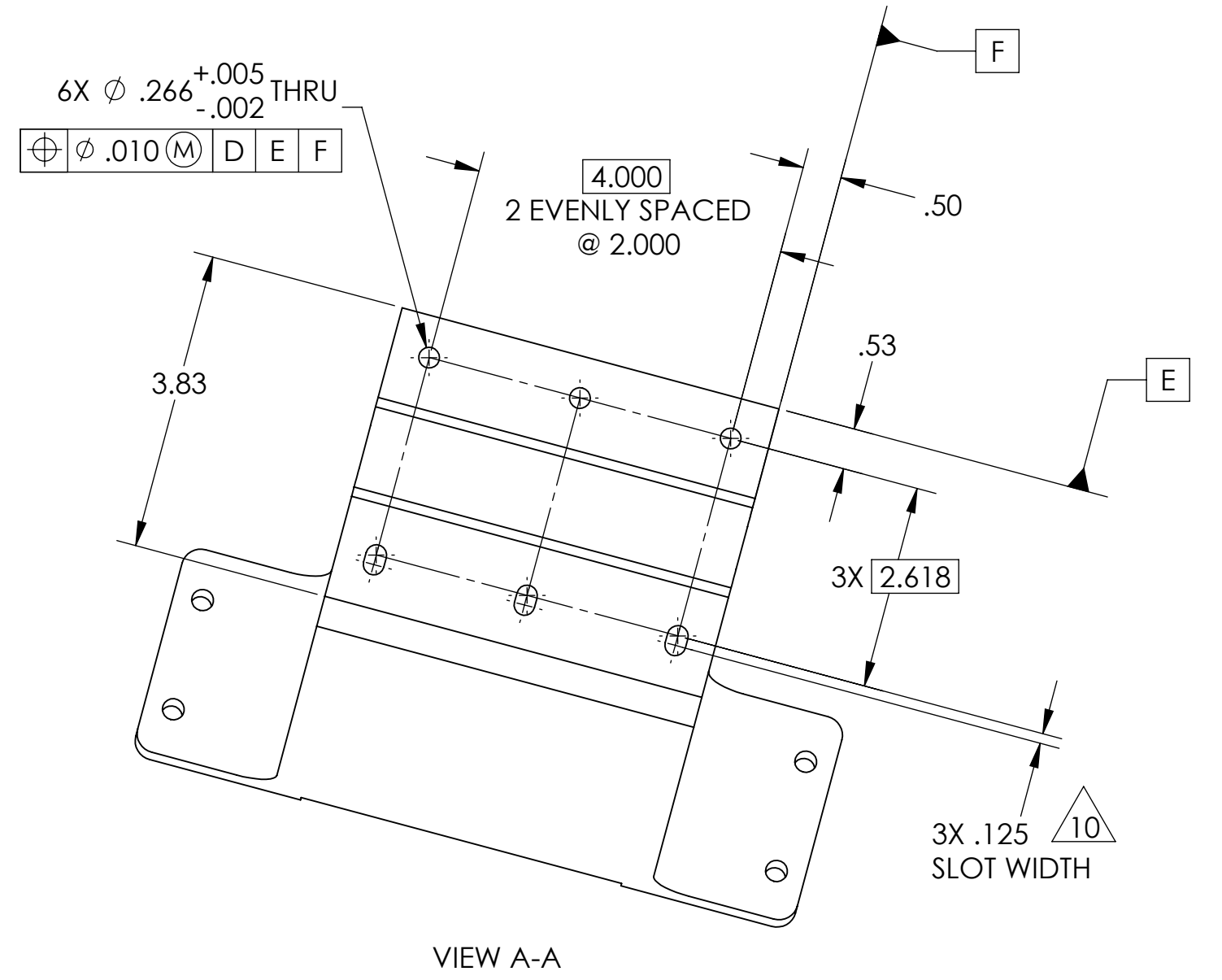
10. SLOT EXISTING THRU HOLES AS SPECIFIED

CONFIG.	DESCRIPTION
-01	X-ARM, BSC3
-02	Y-ARM, BSC1

REV.	DATE	DCN #	DRAWING TREE #
v1	05-MAR-12	E1101043-v1	E1101044-v1
v2	20-FEB-13	E1300141-x0	E1200917-v2
-	-	-	-



**-01**



DIMENSIONS ARE IN INCHES		TOLERANCES: .XX ± .01 .XXX ± .005		ANGULAR ± 1.0°	
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		MATERIAL		FINISH	
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.		6061-T6 ALLOY		63 μinch	

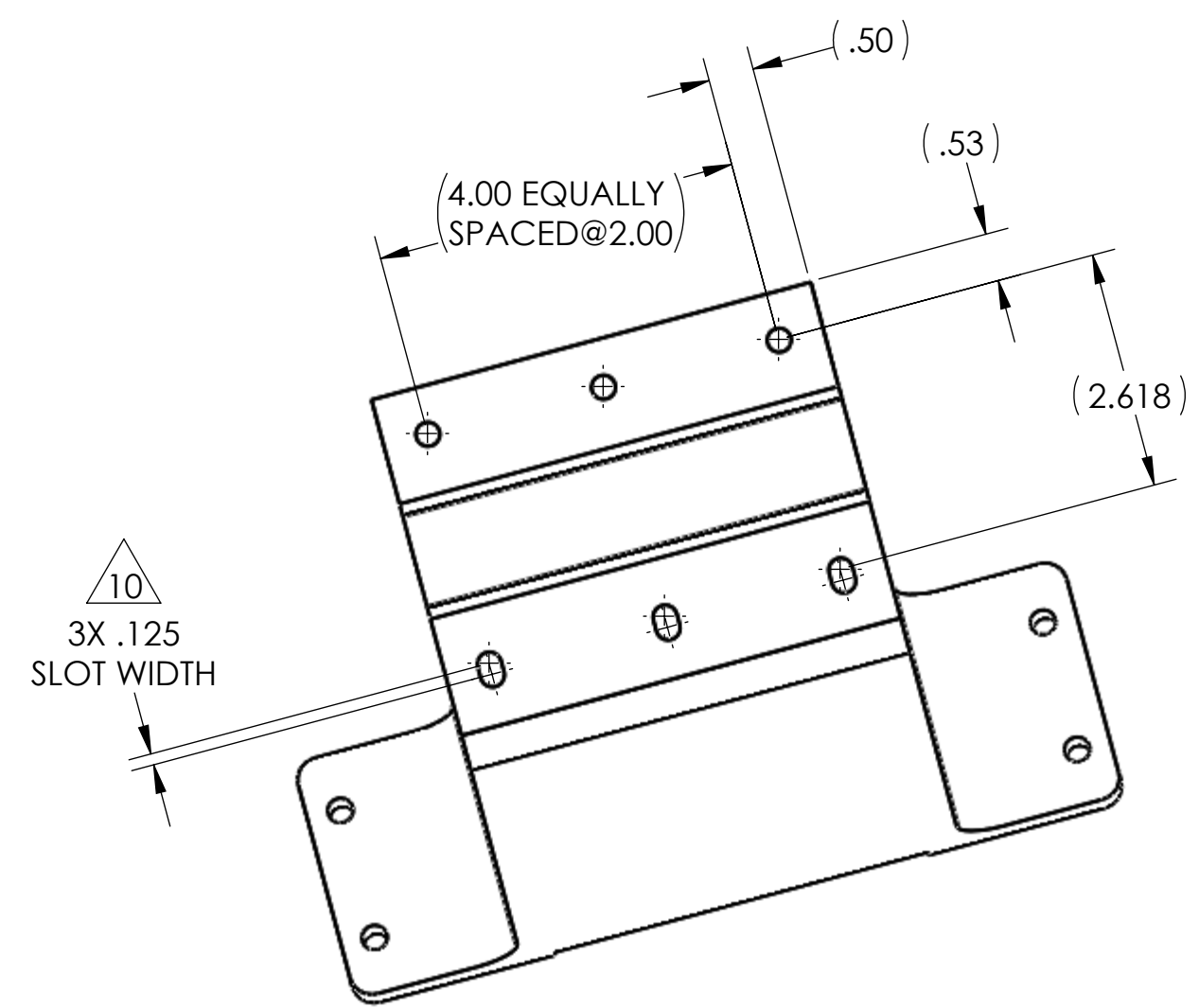
**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO      SUB-SYSTEM: AOS

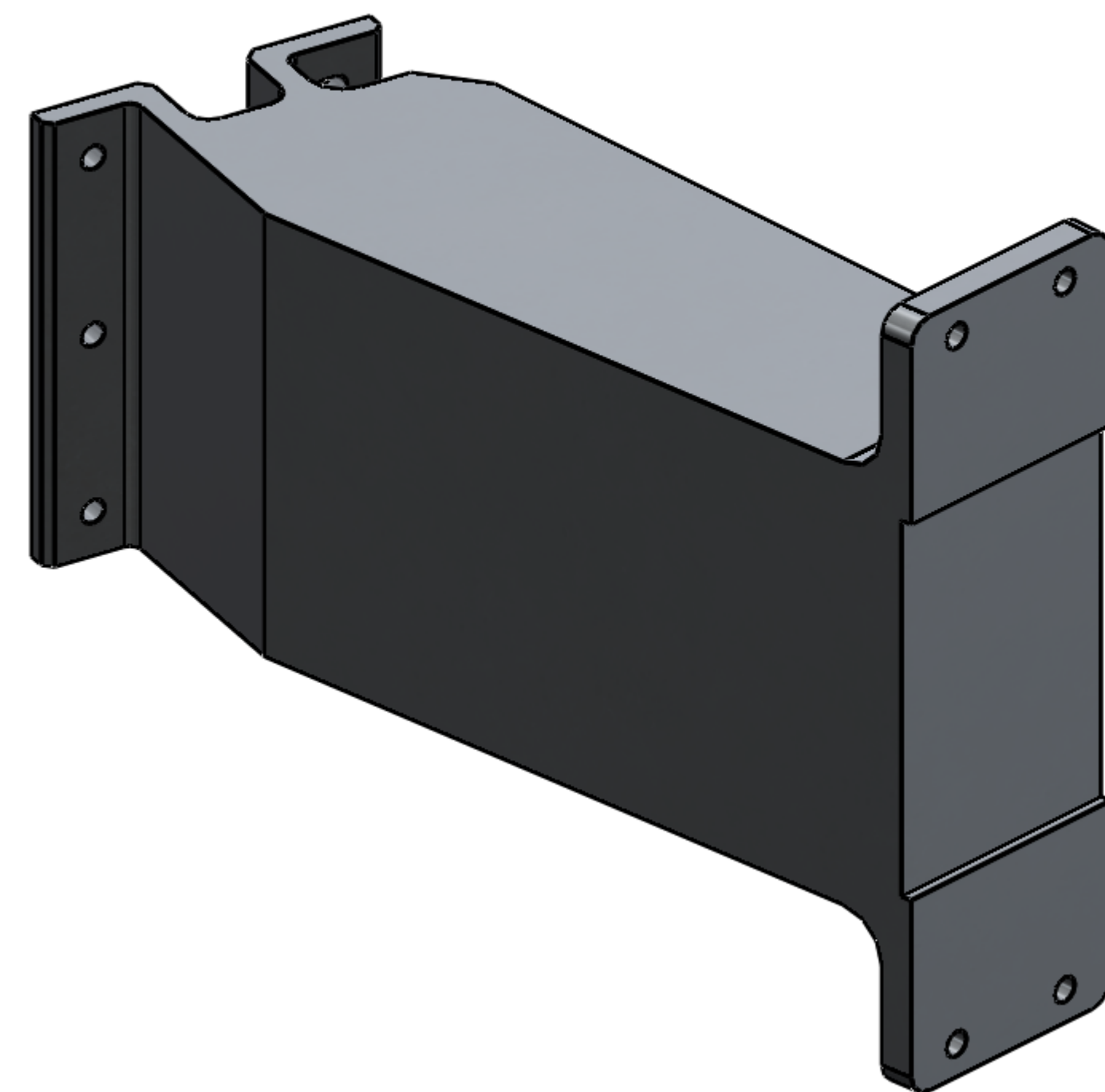
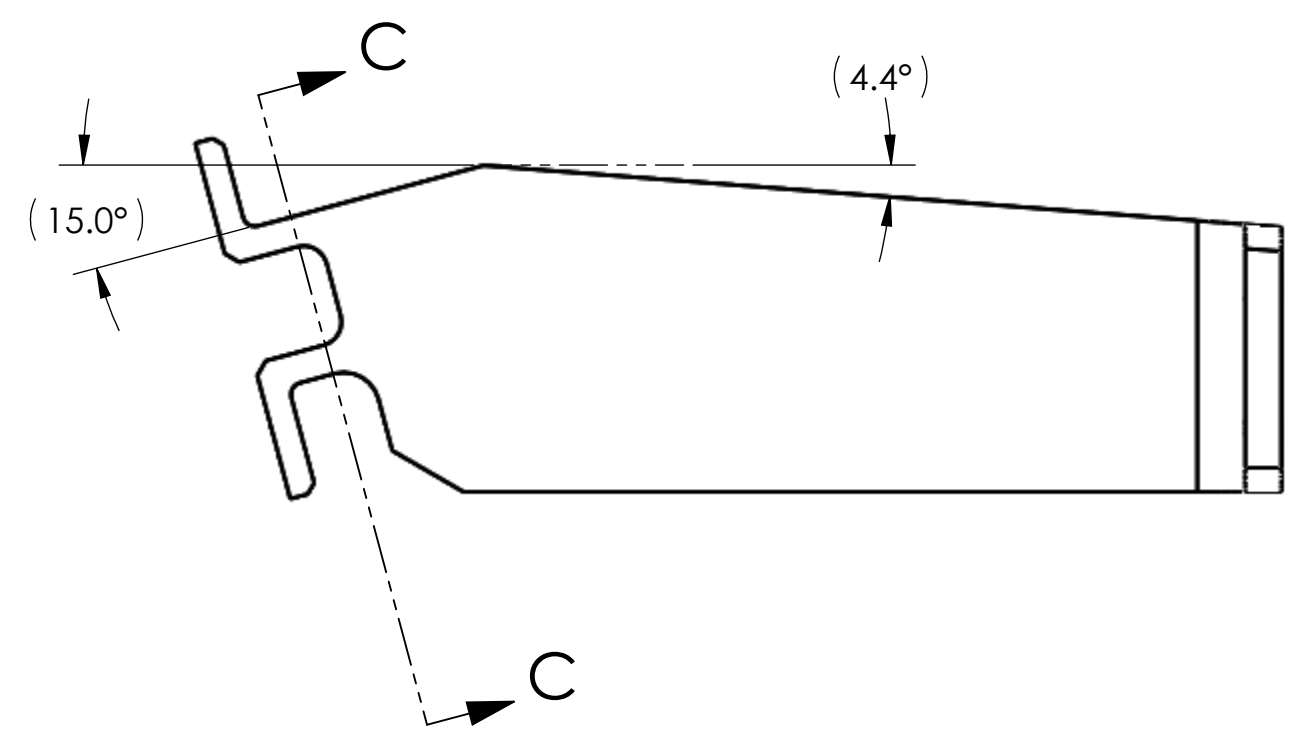
NEXT ASSY: D1102088

PART NAME <b>WEDGE SUPPORT, H1-L1, αLIGO TCS CO2P SM1</b>			
DESIGNER	M. JACOBSON	04-SEPT-11	SIZE DWG. NO.
DRAFTER	A. COLE	12-OCT-2011	<b>D</b> <b>D1101771</b>
CHECKER	C. GUIDO	20-FEB-2013	
APPROVAL	M. JACOBSON	20-FEB-2013	SCALE: 1:2      PROJECTION:
			SHEET 1 OF 2

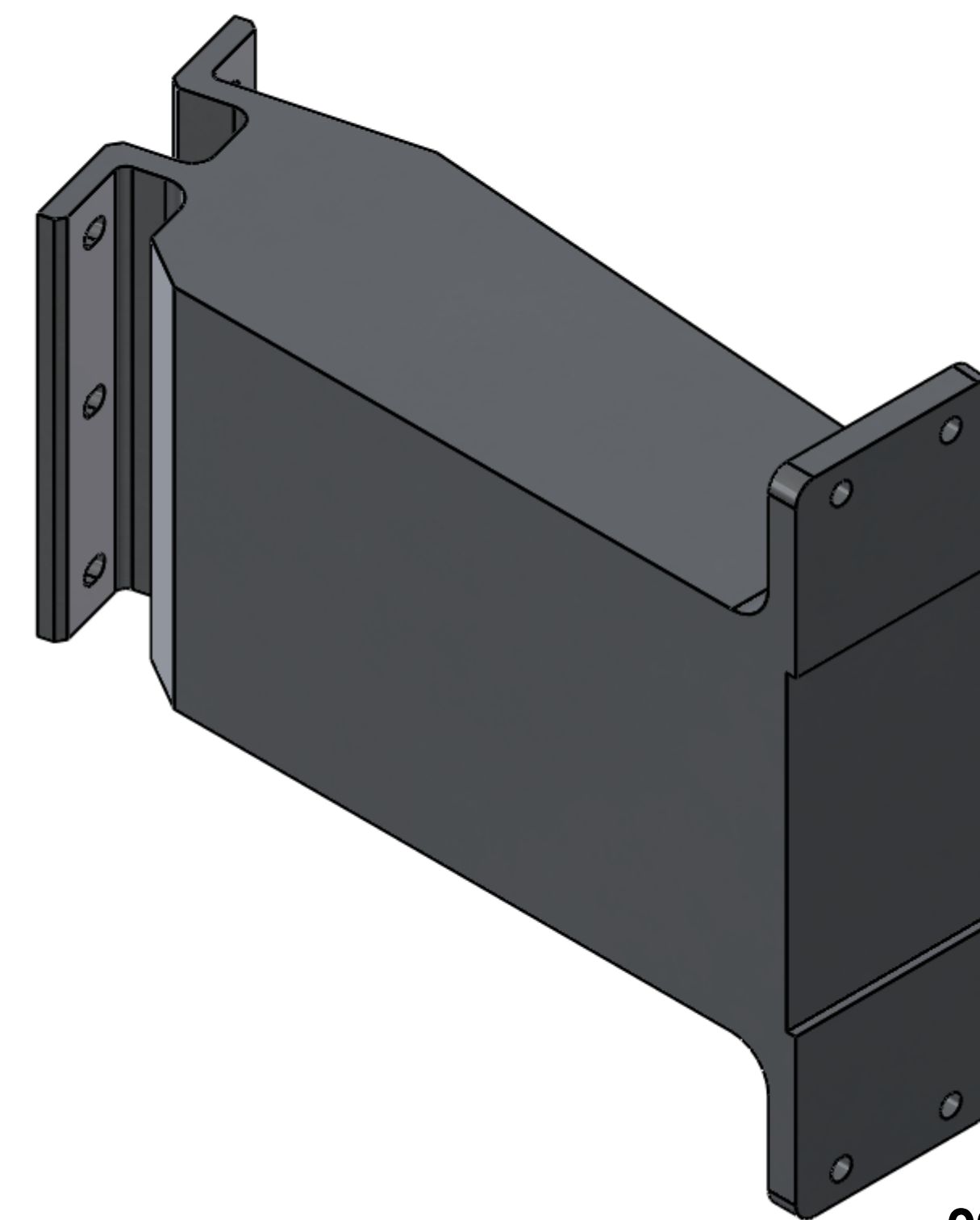
D1101771\_WEDGE\_SUPPORT\_H1-L1\_αLIGO\_TCS\_CO2P\_SM1\_PARR\_FDM\_REV.3-017\_DRAWING\_PDM\_REV.X-012



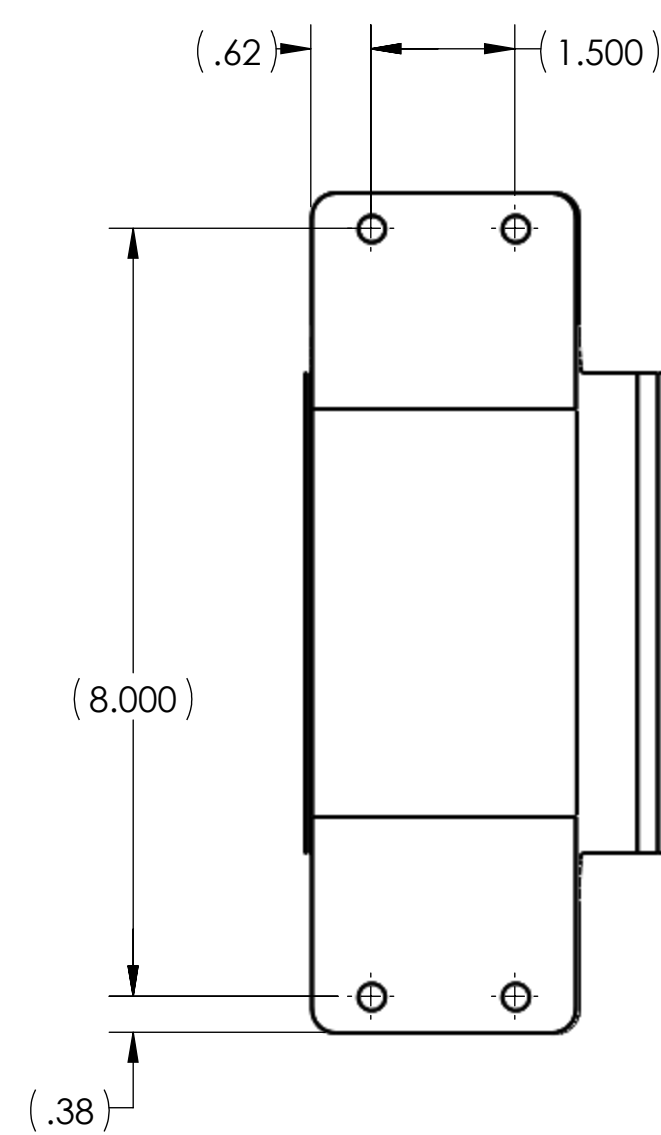
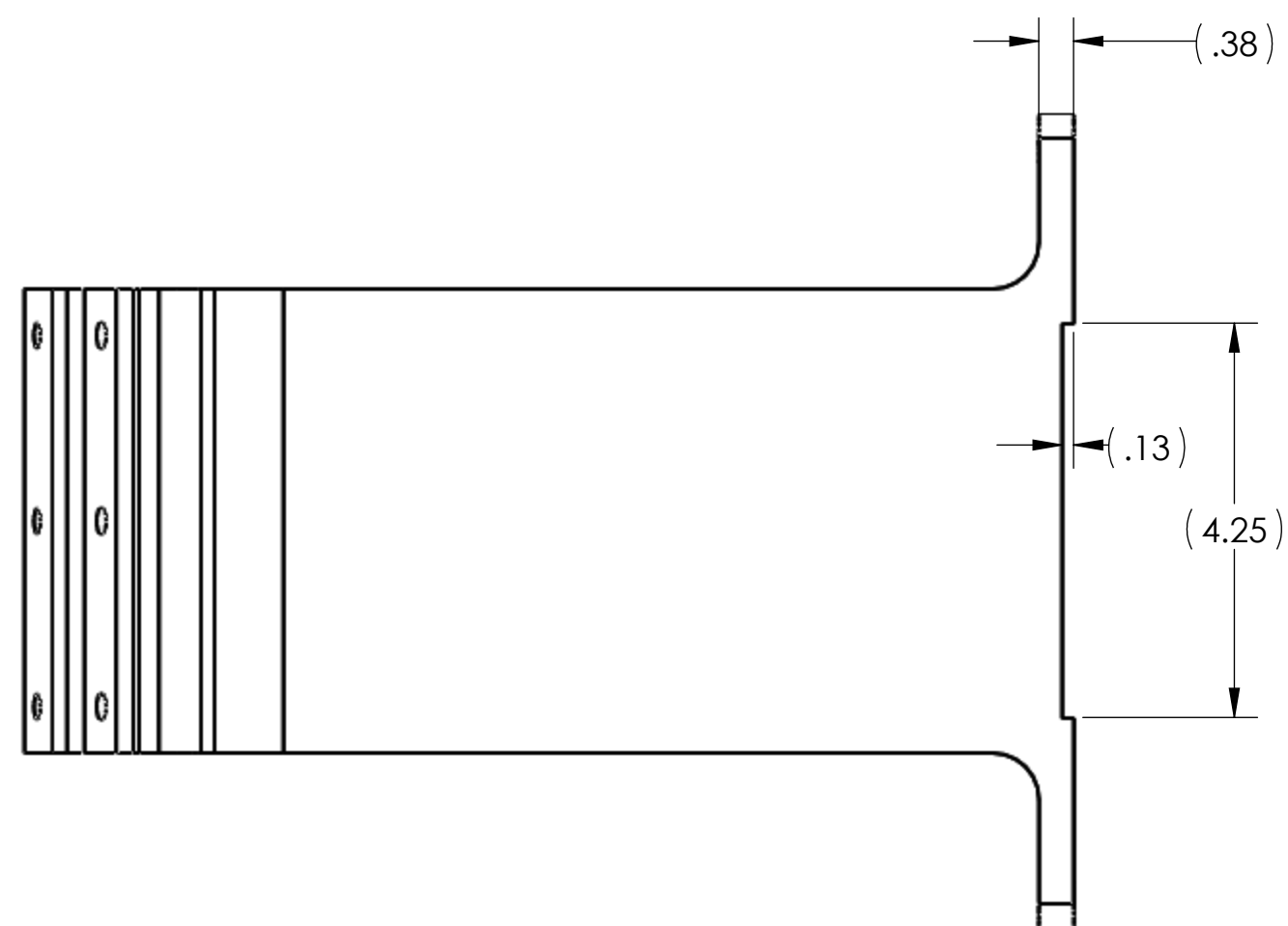
VIEW C-C



-01



-02



**-02**  
**MIRRORED PART**  
 SEE SHT1 FOR DETAILS ALL DIMENSIONS  
 ARE FOR REFERENCE ONLY

D:\10771\WEDGE\SUB\PORT\_H1.L1.dwg LIGO TCS CO2P SMI\_PARR FDM REV:4-03 DRAWING PDM REV: X-012