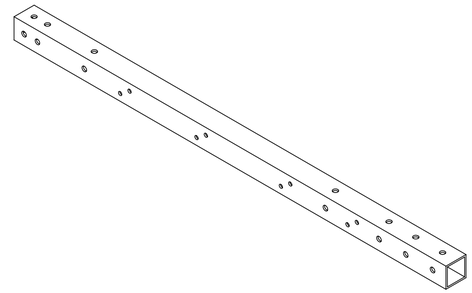
NOTES CONTINUED:

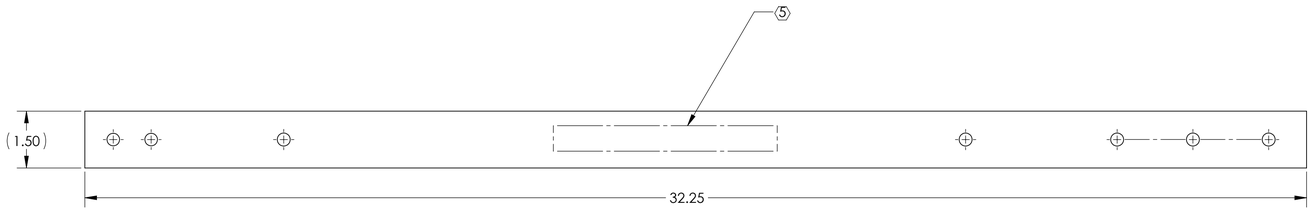
Ⓢ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

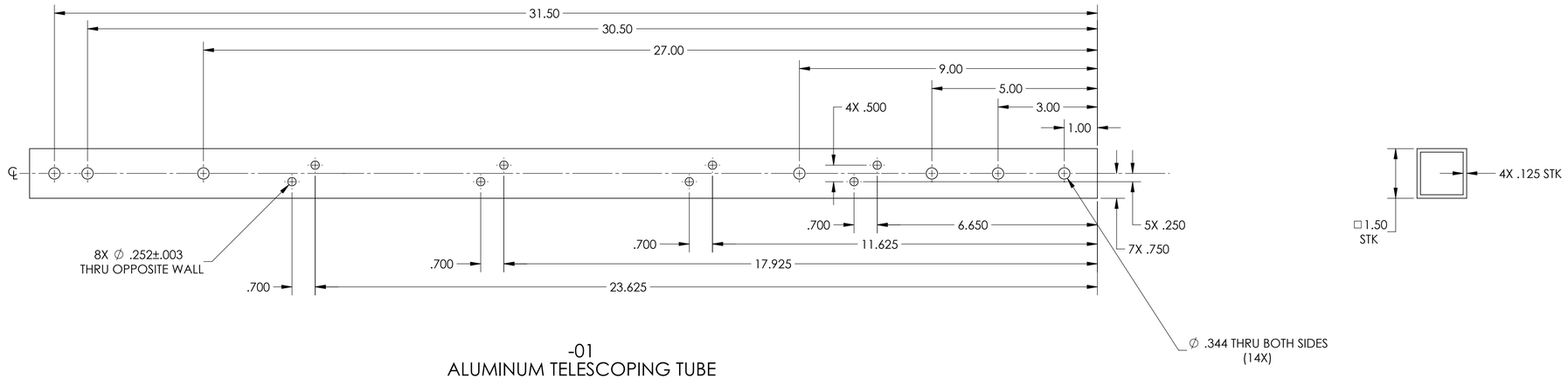
6. APPROXIMATE WEIGHT = 1.853 LB.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
9. MATERIAL AS RECEIVED MACHINE FINSIH.

REV.	DATE	DCN #	DRAWING TREE #
v1	20 OCT 2011	E1100335-v4	-
v2	2 DEC 2011	E1100335-v4	-
v3	27 JUN 2012	E1100335-v5	-



GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE





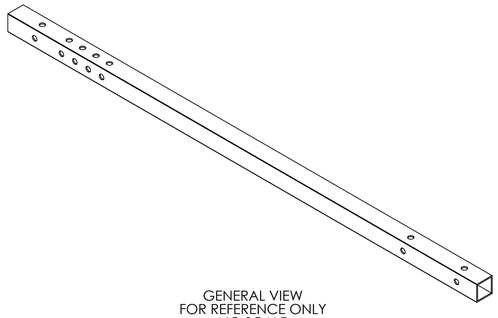
-01
ALUMINUM TELESCOPING TUBE

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)							
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .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 APPROXIMATLEY 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.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: TELESCOPE TUBE FRAMING		
	MATERIAL: 6061-T6 Al	FINISH: N/A µinch	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	DESIGNER: TQ. NGUYEN 15 OCT 2011	SIZE: D	DWG. NO.: D1102144 REV.: v3
			NEXT ASSY: D1101957		DRAFTER: TQ. NGUYEN 17 OCT 2011		
					CHECKER: L. AUSTIN 23 JAN 2012		
					APPROVAL: C. TORRIE 23 JAN 2012	SCALE: 1:2	PROJECTION: SHEET 1 OF 2

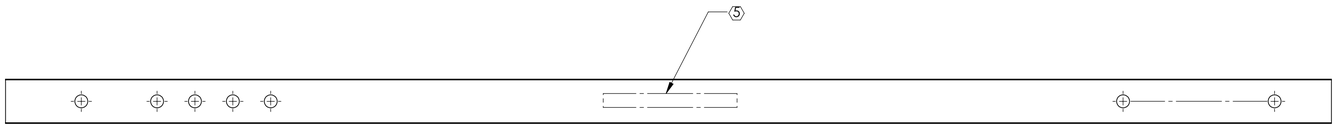
D1102144_ACB Installation Stand_Telescope Tube Framing, PART PDM REV: X-073, DRAWING PDM REV: X-040

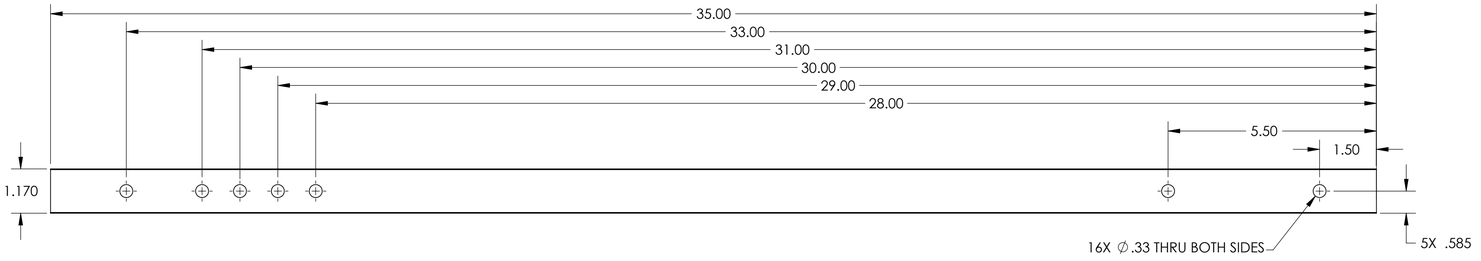
NOTES:

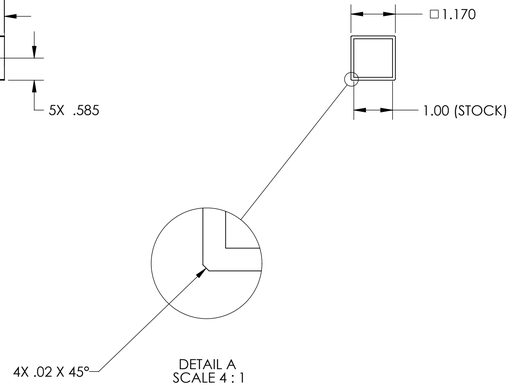
1. MACHINE FOUR SIDE OF ALUMINUM RAIL TUBE
   TO MAKE ALUMINUM TELESCOPING TUBE SLIDE FREELY.



GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE







DETAIL A
SCALE 4 : 1

-02
ALUMINUM RAIL TUBE

LIGO	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE: D	DWG. NO.: D1102144	REV.: V3
SCALE: 1:2	PROJECTION:	SHEET 2 OF 2