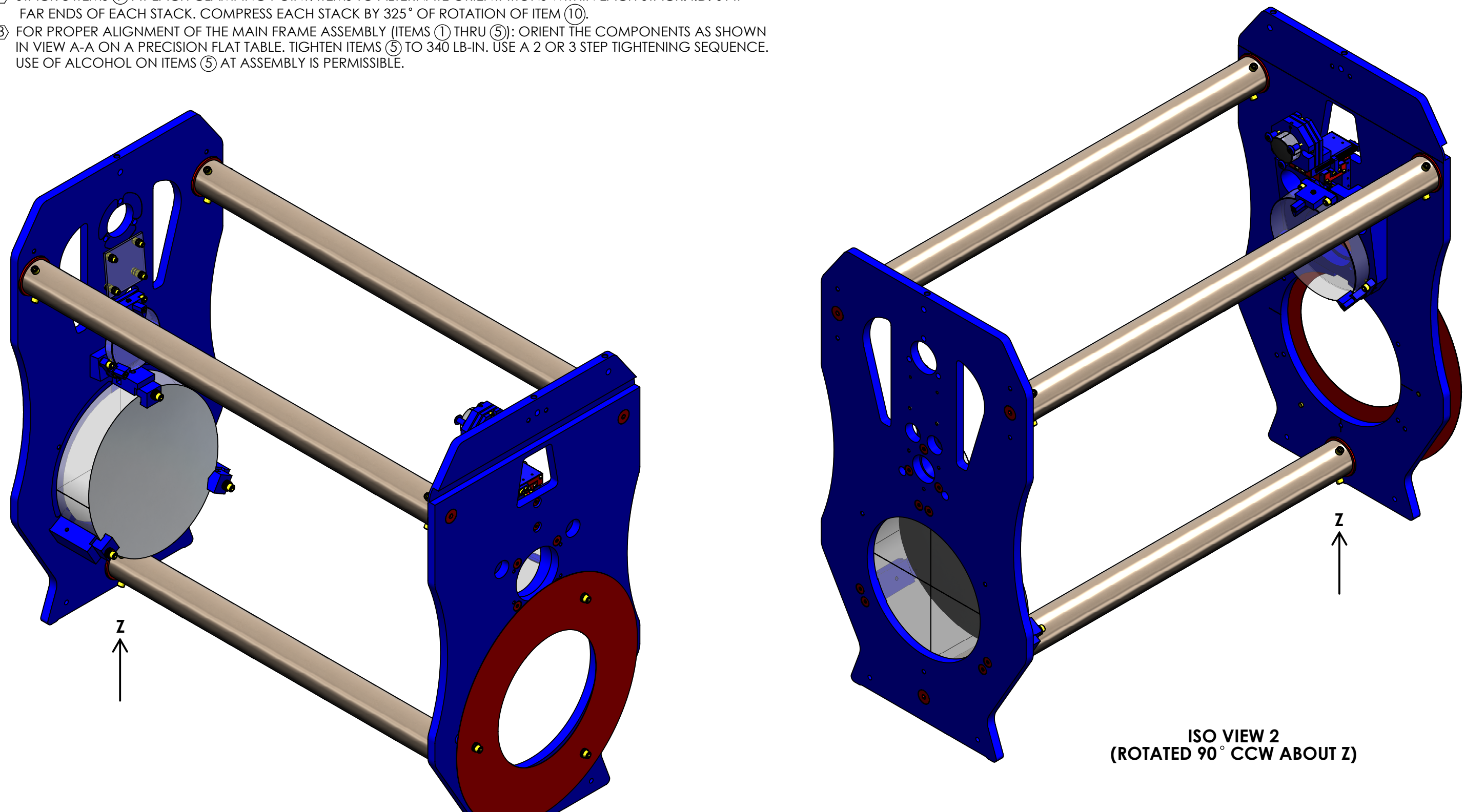


8 7 6 5 4 3 2 1

NOTES CONTINUED:

- 5. BAG OR WRAP AND TAG ASSEMBLY WITH DRAWING NUMBER, REVISION, AND SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. EXAMPLE (TAG): DXXXXXXX-VY, S/N 001
- 6. MASS/WEIGHT = TBD LB [TBD KG].
- ⑦ STACK 8 ITEMS ⑩ AT EACH CLAMPING POINT. ITEMS TO ALTERNATE ORIENTATIONS WITHIN EACH STACK. I.D.'s AT FAR ENDS OF EACH STACK. COMPRESS EACH STACK BY 325° OF ROTATION OF ITEM ⑩.
- ⑧ FOR PROPER ALIGNMENT OF THE MAIN FRAME ASSEMBLY (ITEMS ① THRU ⑤): ORIENT THE COMPONENTS AS SHOWN IN VIEW A-A ON A PRECISION FLAT TABLE. TIGHTEN ITEMS ⑤ TO 340 LB-IN. USE A 2 OR 3 STEP TIGHTENING SEQUENCE. USE OF ALCOHOL ON ITEMS ⑤ AT ASSEMBLY IS PERMISSIBLE.

REV	DATE	DCN #	BOM #
v1	01 MAR 2012	E1101204	E1101208-v1
-	-	-	-
-	-	-	-



ISO VIEW 1

**ISO VIEW 2
(ROTATED 90° CCW ABOUT Z)**

D1102361 aLIGO TMS Telescope Frame Assembly, PART PDM REV: X-011, DRAWING PDM REV: X-000

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

TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 1.0°

MATERIAL	N/A	FINISH	N/A μinch
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
DESIGNER	K. MAILAND	15 DEC 2011	SIZE DWG. NO.
DRAFTER	C. CONLEY	01 MAR 2012	B
CHECKER	SEE DCN		D1102361
APPROVAL	SEE DCN		REV. v1
NEXT ASSY		D1002460	
SCALE: NONE		PROJECTION:	
		SHEET 1 OF 6	

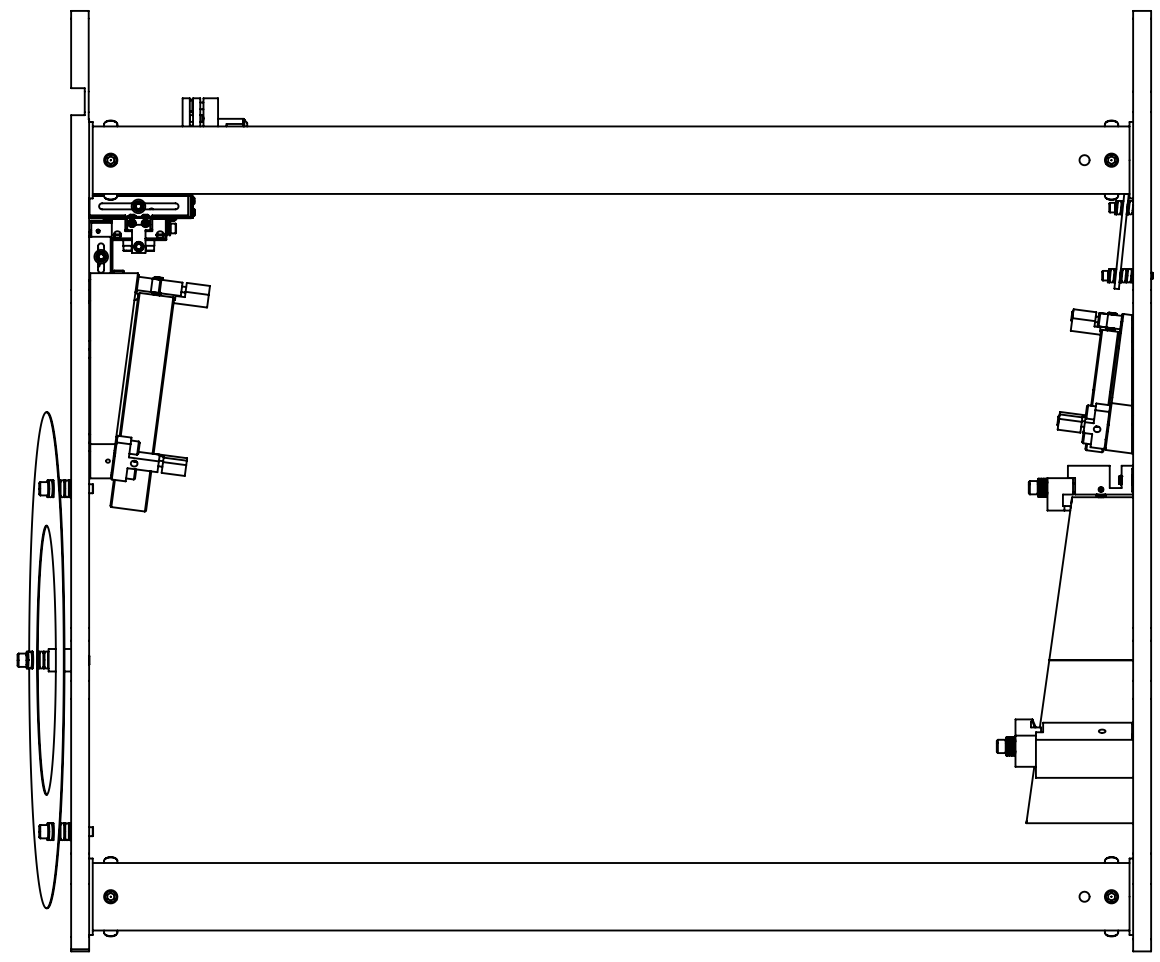
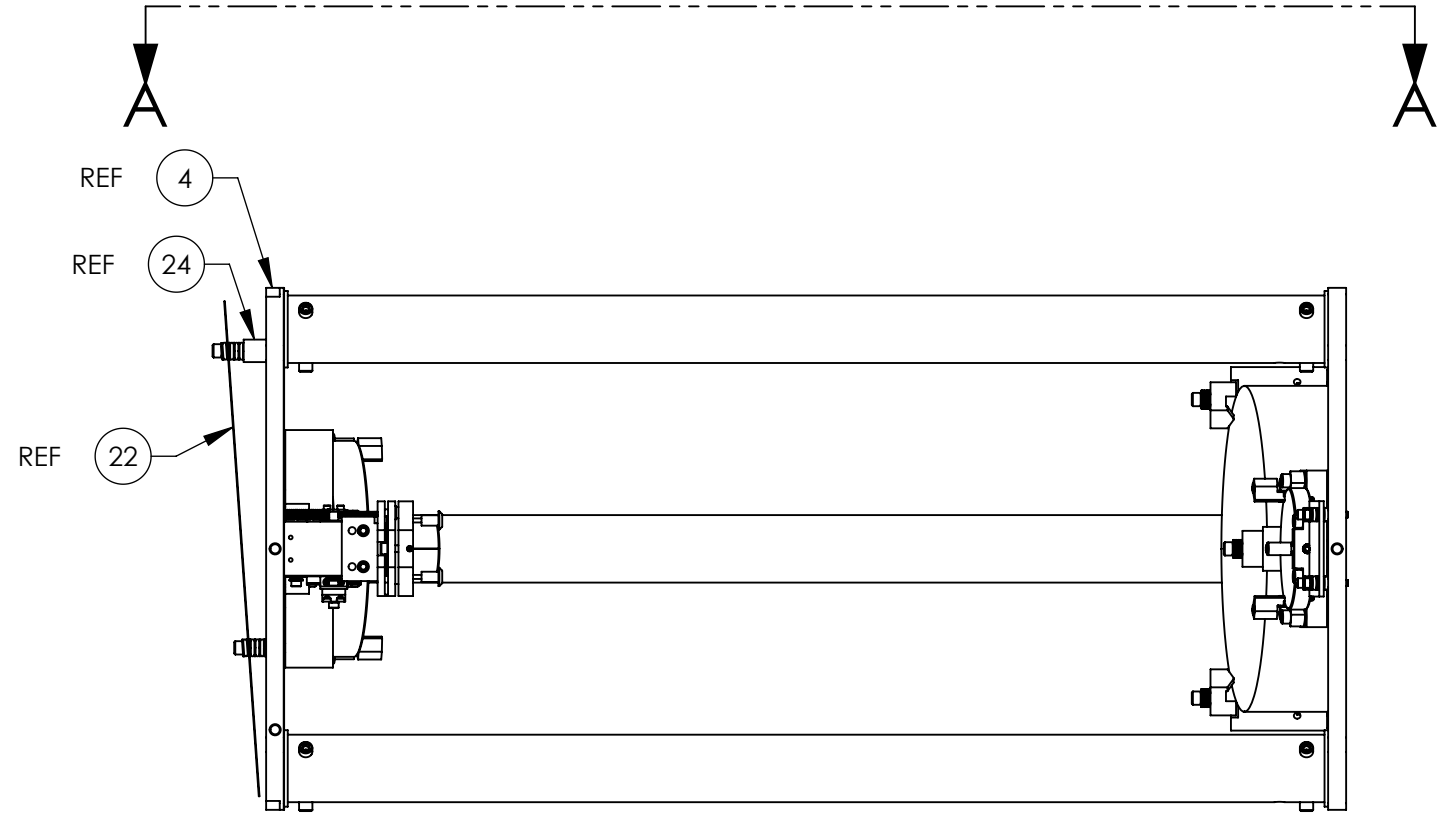
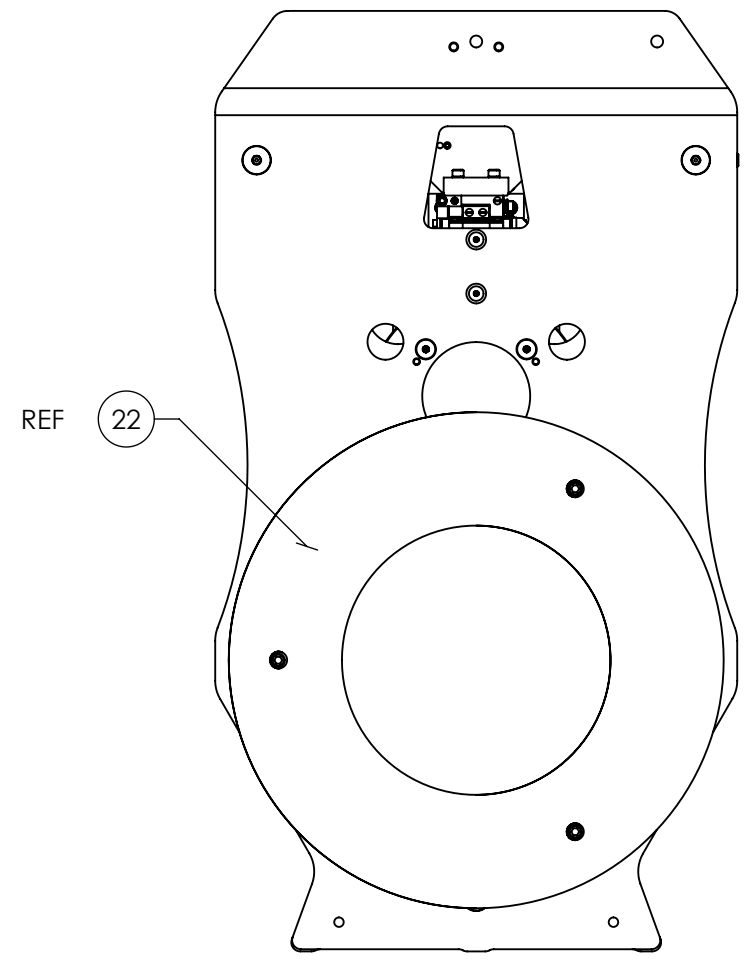
8 7 6 5 4 3 2 1

D1102361 aLIGO TMS Telescope Frame Assembly, PART PDM REV: X-011, DRAWING PDM REV: X-000

8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A

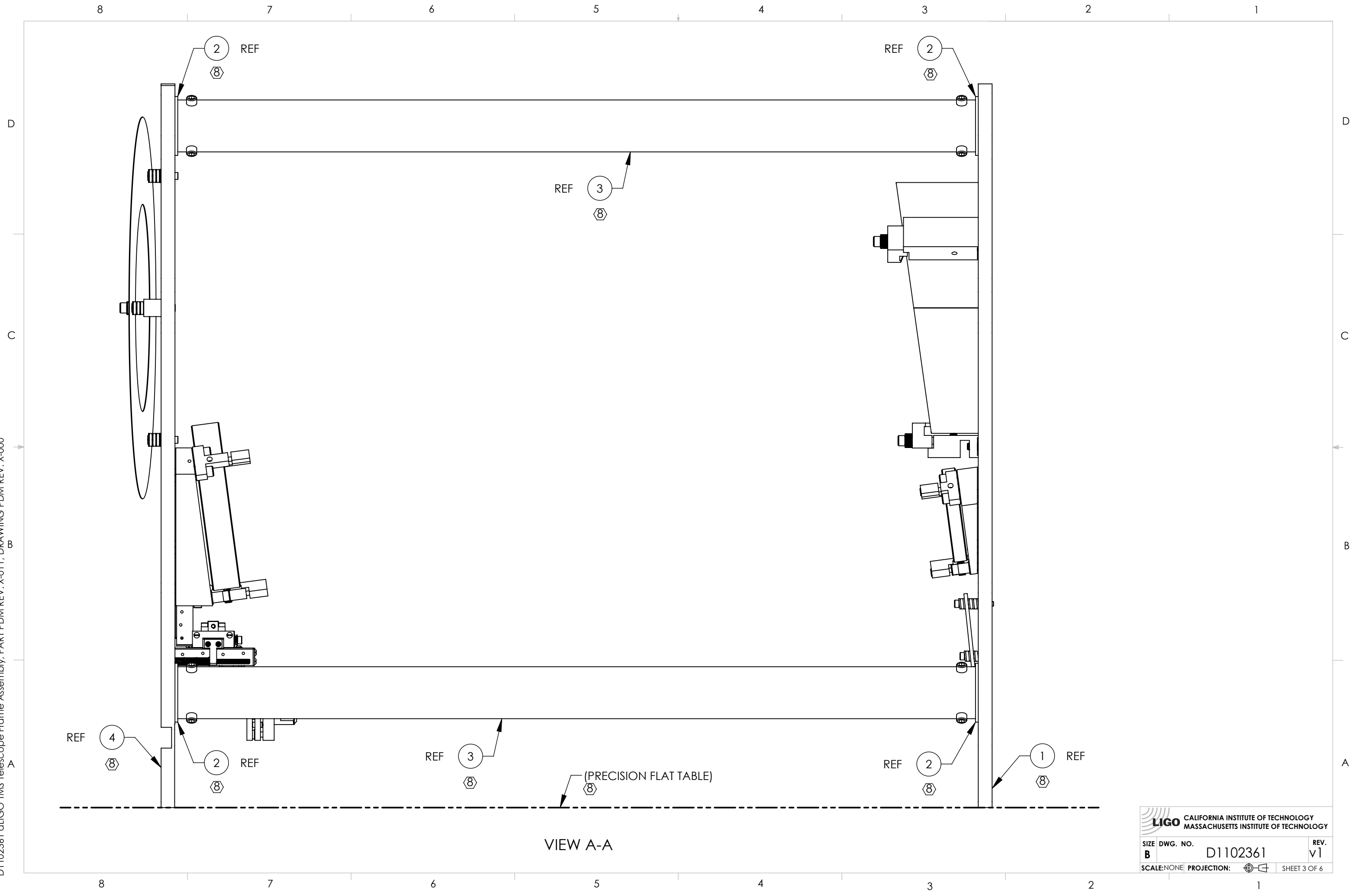


8 7 6 5 4 3 2 1

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MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D1102361	v1
SCALE: NONE		PROJECTION:
		SHEET 2 OF 6

D1102361 aLIGO TMS Telescope Frame Assembly, PART PDM REV: X-011, DRAWING PDM REV: X-000

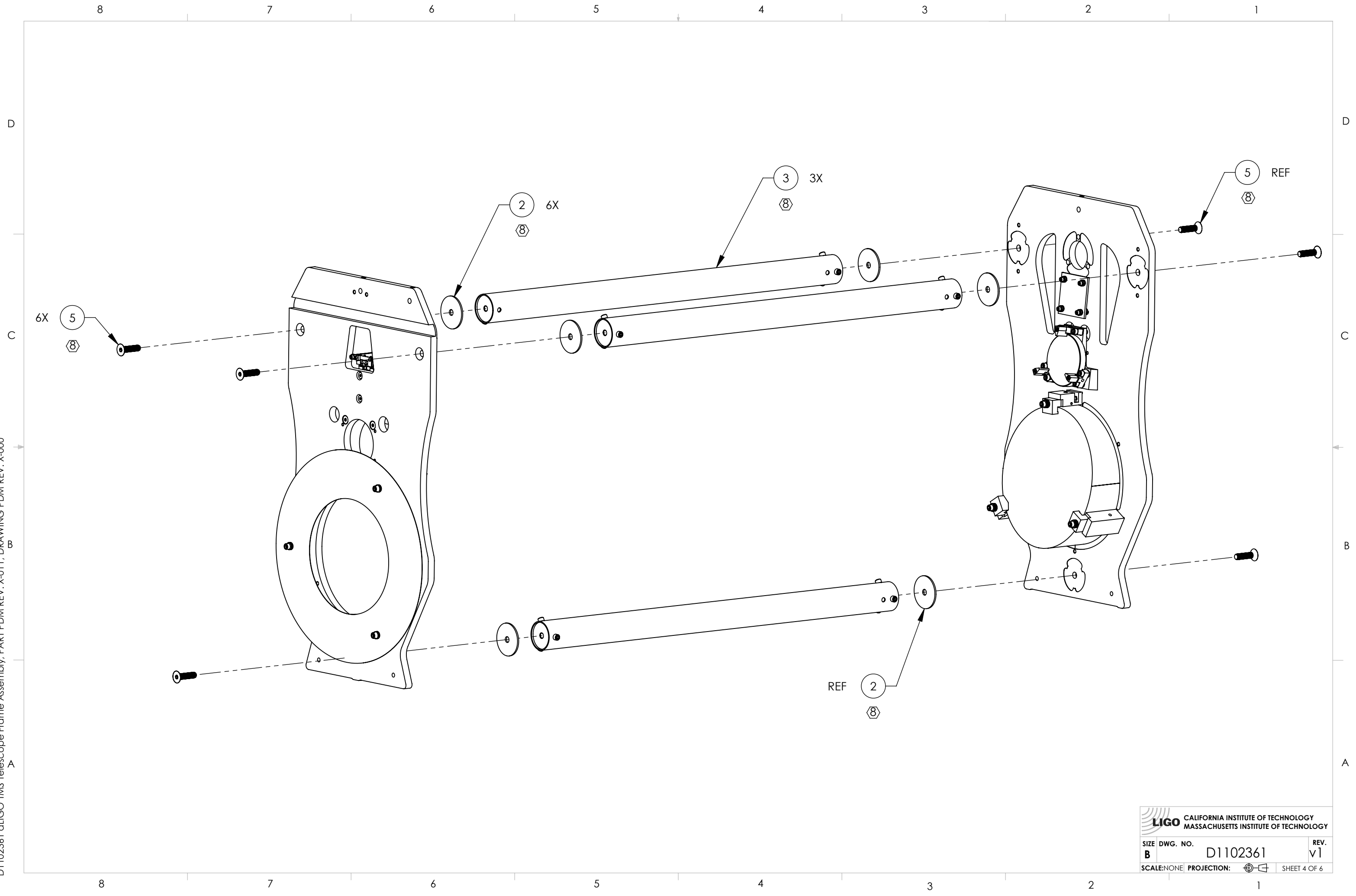



VIEW A-A

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 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

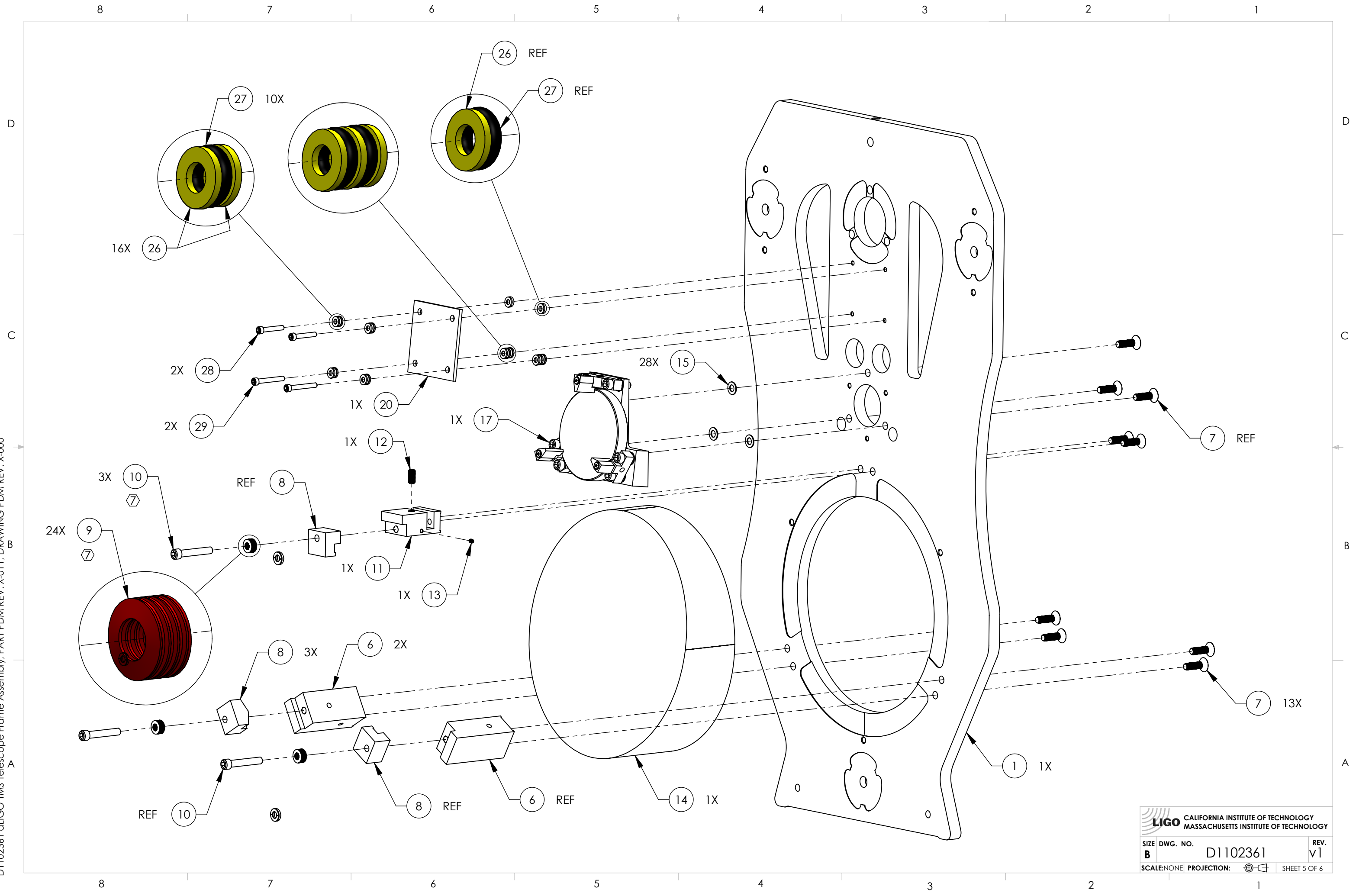
SIZE	DWG. NO.	REV.
B	D1102361	v1
SCALE: NONE	PROJECTION:	SHEET 3 OF 6


D1102361 aLIGO TMS Telescope Frame Assembly, PART PDM REV: X-011, DRAWING PDM REV: X-000



 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
B	D1102361	v1
SCALE: NONE	PROJECTION:	SHEET 4 OF 6

D1102361 dLIGO TMS Telescope Frame Assembly, PART PDM REV: X-011, DRAWING PDM REV: X-000



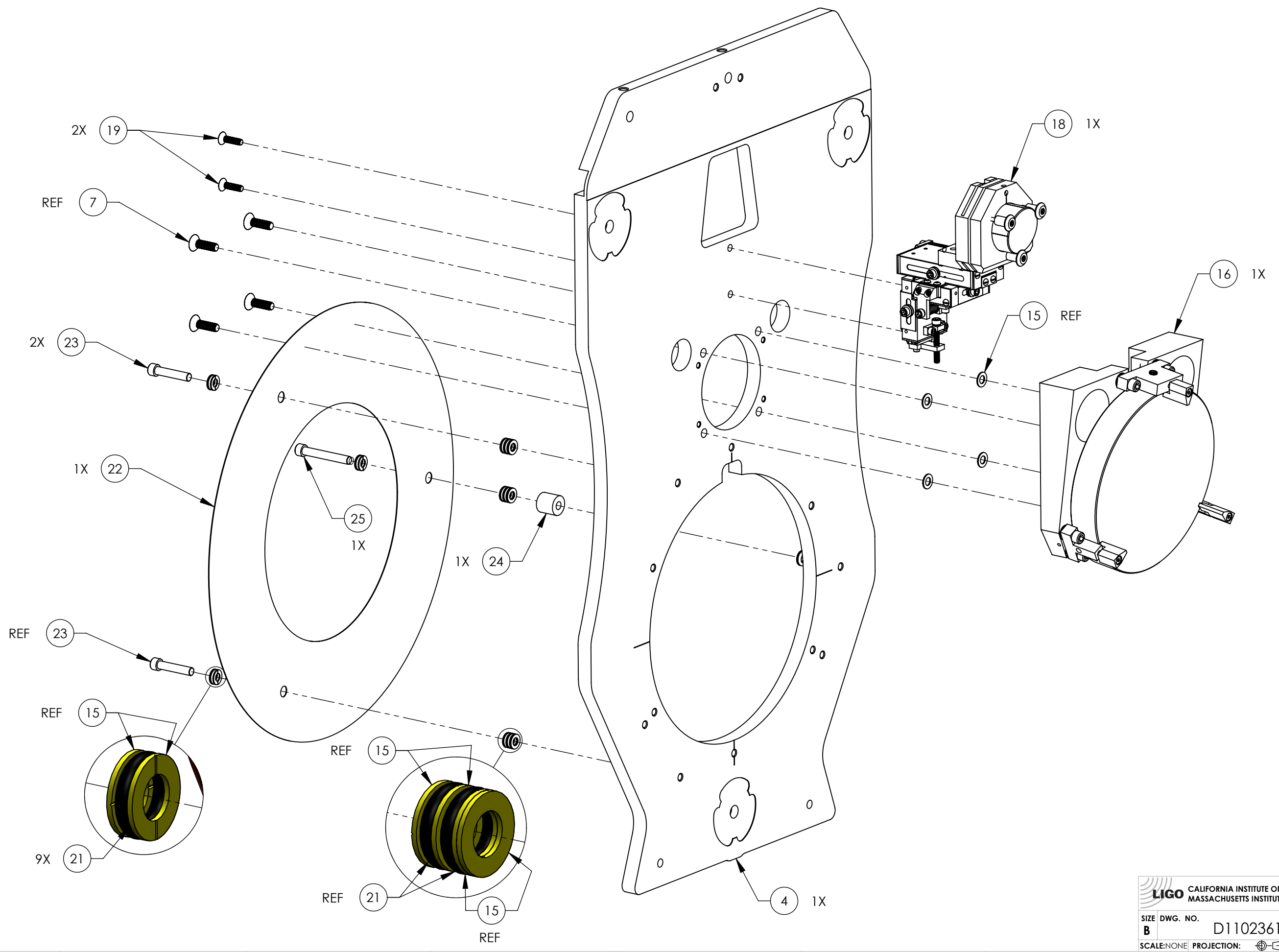
 CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D1102361	v1
SCALE: NONE	PROJECTION:	SHEET 5 OF 6

D1102361 aLIGO TMS Telescope Frame Assembly, PART PDM REV: X-011, DRAWING PDM REV: X-000

8 7 6 5 4 3 2 1

D
C
B
A



8 7 6 5 4 3 2 1

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SIZE	DWG. NO.	REV.
B	D1102361	v1
SCALE: NONE	PROJECTION:	SHEET 6 OF 6