REV.	DATE	DCN #	DRAWING TREE #
v1	29 MAR 2012	E1200317-x0	-
-	-	-	-
-	-	-	-

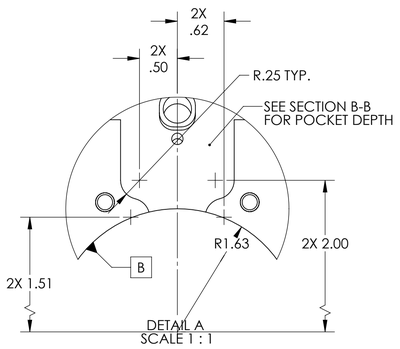
NOTES CONTINUED:

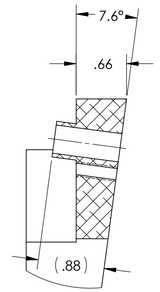
Ⓢ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE 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

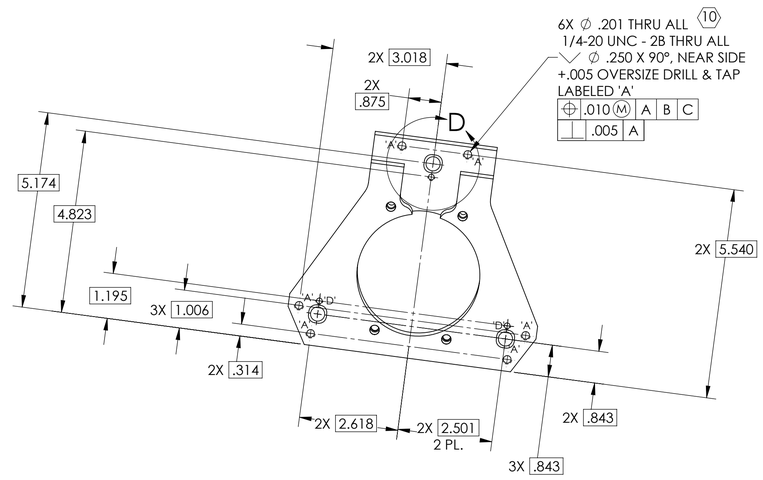
6. APPROXIMATE WEIGHT = 1.38 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

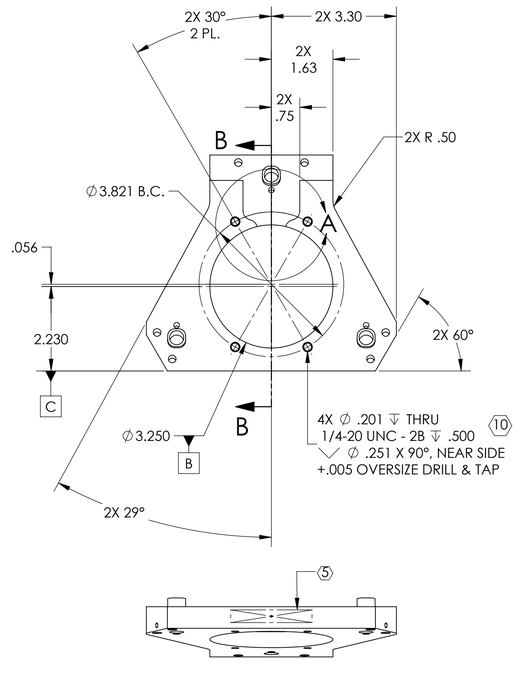
⑩ INDICATED TAPPED HOLES, +.005 OVERSIZE BOTH DRILL & TAP.

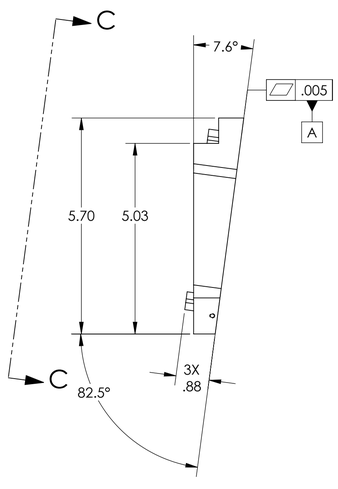
11. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .015 MAX.

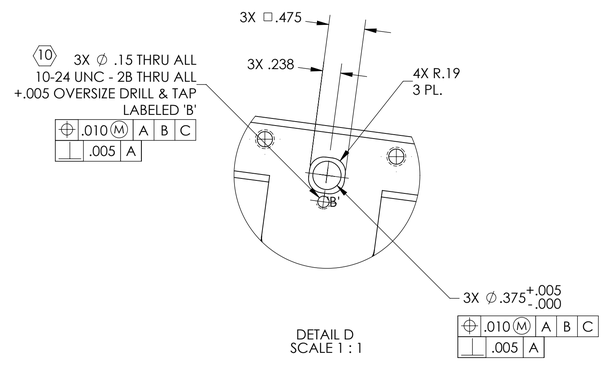






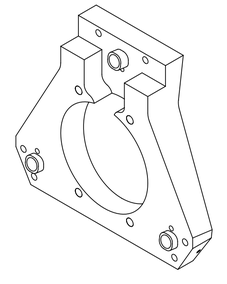






VIEW C-C

DETAIL D
SCALE 1 : 1



ISO VIEW

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°	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.				
MATERIAL: 6061-T6 Al		FINISH: 63 µinch	NEXT ASSY: D11200244		

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO | SUB-SYSTEM: AOS

PART NAME: aLIGO TMS F1 MIRROR BASE

DESIGNER	K. MAILAND	08 FEB 2012	SIZE	DWG. NO.	REV.
DRAFTER	E.SANCHEZ	29 MAR 2012	D	D1200245	v1
CHECKER	SEE DCC	SEE DCC			
APPROVAL	SEE DCC	SEE DCC	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1

D1200245 aLIGO TMS F1 Mirror Base, PART FDM REV: X-008, DRAWING FDM REV: X-008