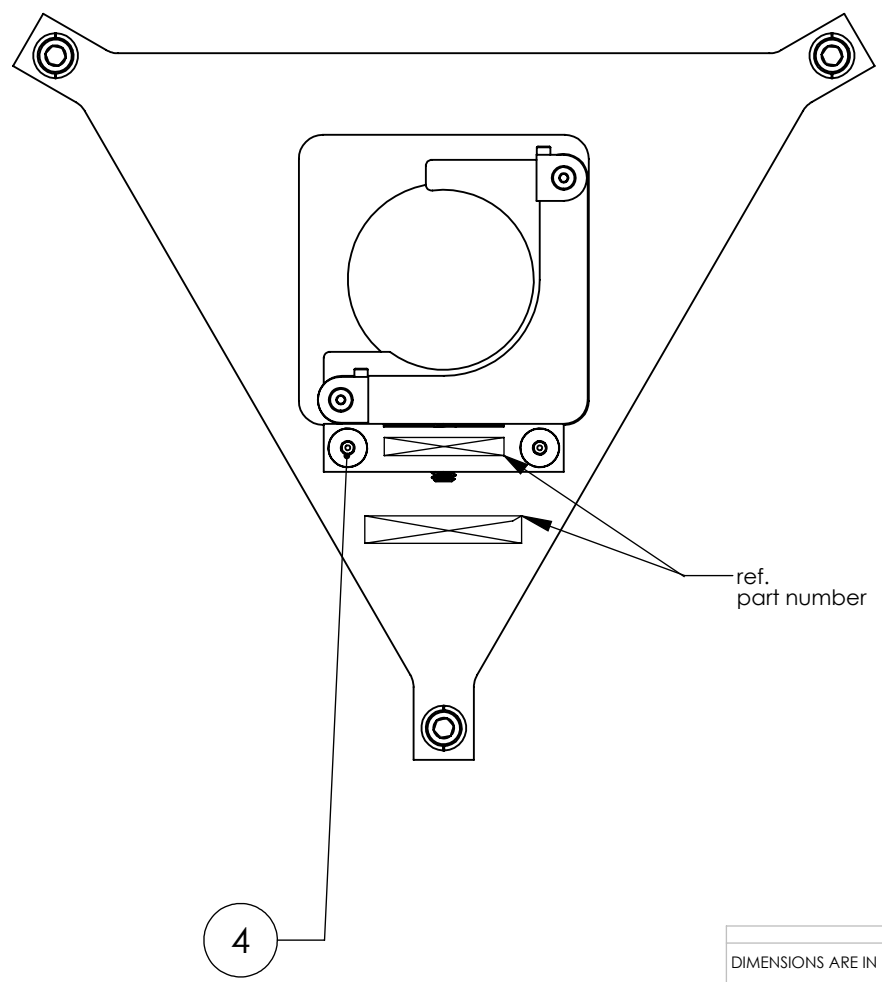
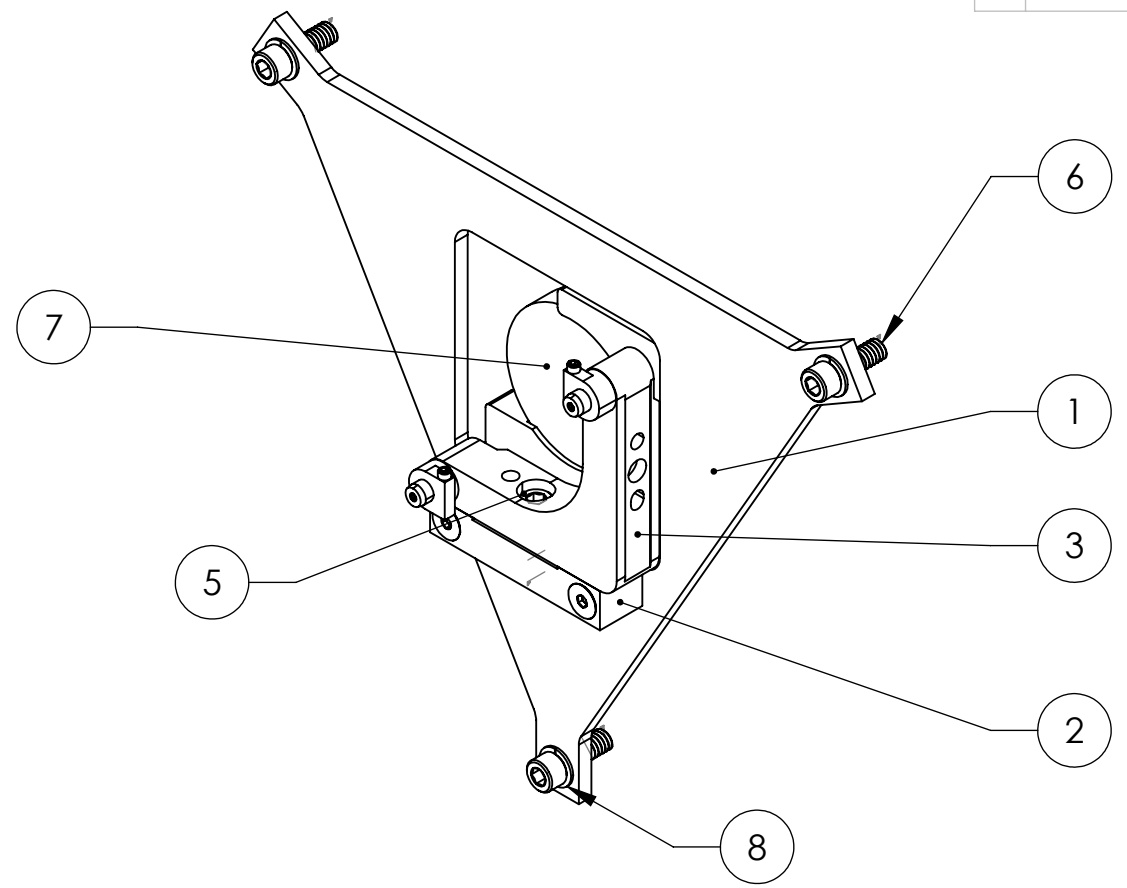


NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED.
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. APPROXIMATE WEIGHT = X.XXX 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. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
- 10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
- 11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO. REFER TO LIGO-E0900364.
- 12. 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 MATERIAL 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.

REV.	DATE	DCN #	DRAWING TREE #
-	-	-	-
-	-	-	-
-	-	-	-



8	96861A600	(McMASTER-CARR).25 VENTED WASHER,) .255 ID X .468 OD X .031 THK	18-8 SSTL	3	3
7		2" dia mirror	Glass	1	1
6		1/4-20 SHCS x 1 inch long	s stl.	3	3
5		1/4-20 SHCS x 1 inch long	s stl.	1	1
4		10-24 stainless flathead .87 long	s stl.	2	2
3	Siskiyou 2" ixm200-c2 -H	2" MIRROR MOUNT	6061-T6 Al	1	1
2	D1200563	aLIGO mirror mount bracket input end tool	6061-T6 (SS)	1	1
1	D1200554	TMS tooling mirror mt plate input end tele	6061-T6 (SS)	1	1
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	TOTAL

PARTS LIST

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES, R.02 MIN.
 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 ± .02
 .XXX ± .005
 ANGULAR ± 1.0°

MATERIAL N/A **FINISH** N/A μinch

SYSTEM ADVANCED LIGO **SUB-SYSTEM** AOS **NEXT ASSY** D1002460

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME aLIGO TMS tele input end mirror tool

DESIGNER K Malland **DATE** 04/04/2012 **SIZE** DWG. NO. **B** **D1200565** **REV.** v2

DRAFTER k malland **DATE** 4-6-2012

CHECKER **APPROVAL**

SCALE: 1:2 **PROJECTION:** **SHEET 1 OF 1**

D1200565-v2 aLIGO Assem. TMS tele input end mirror tool, PART PDM REV: X-003, DRAWING PDM REV: X-000