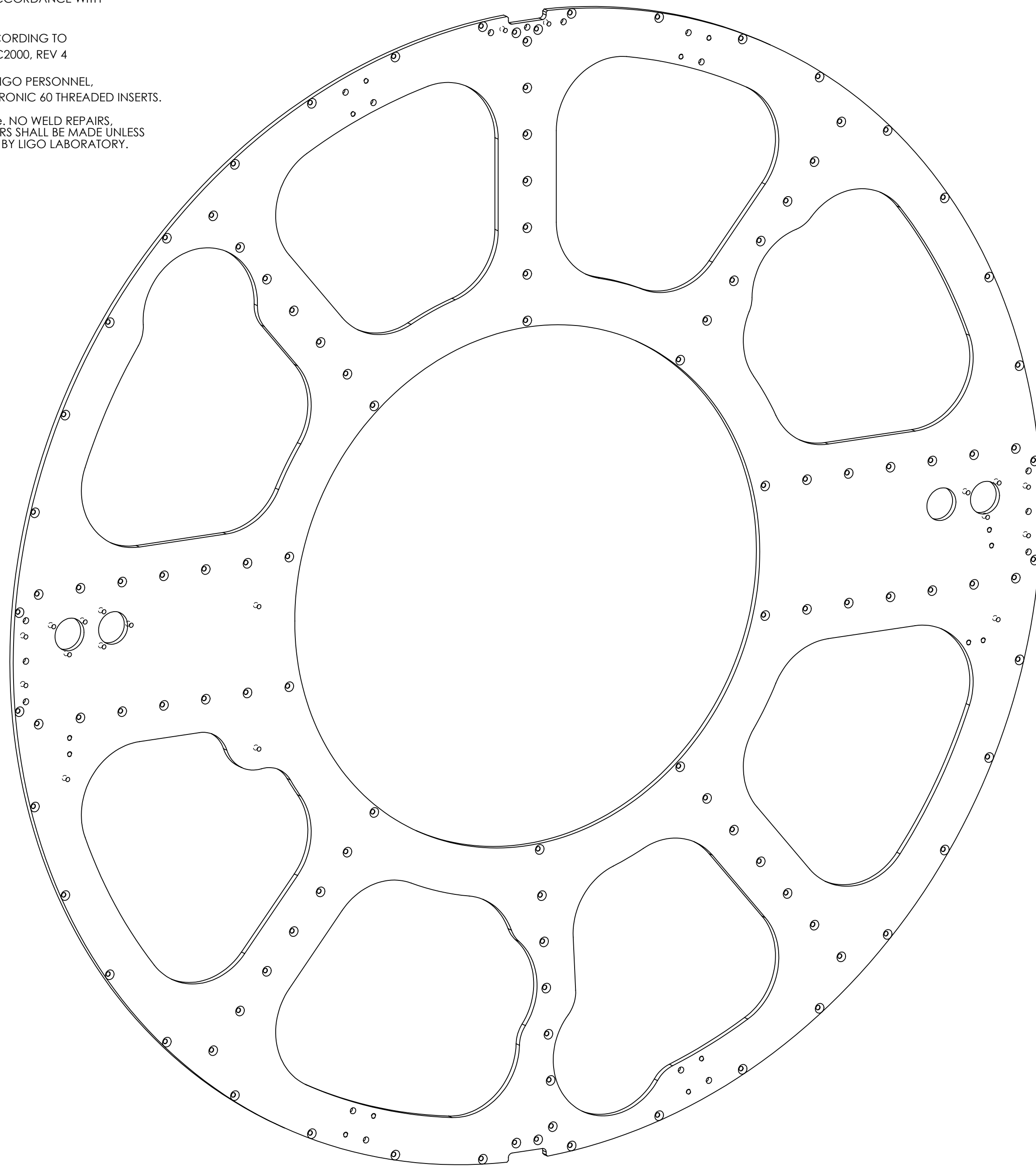
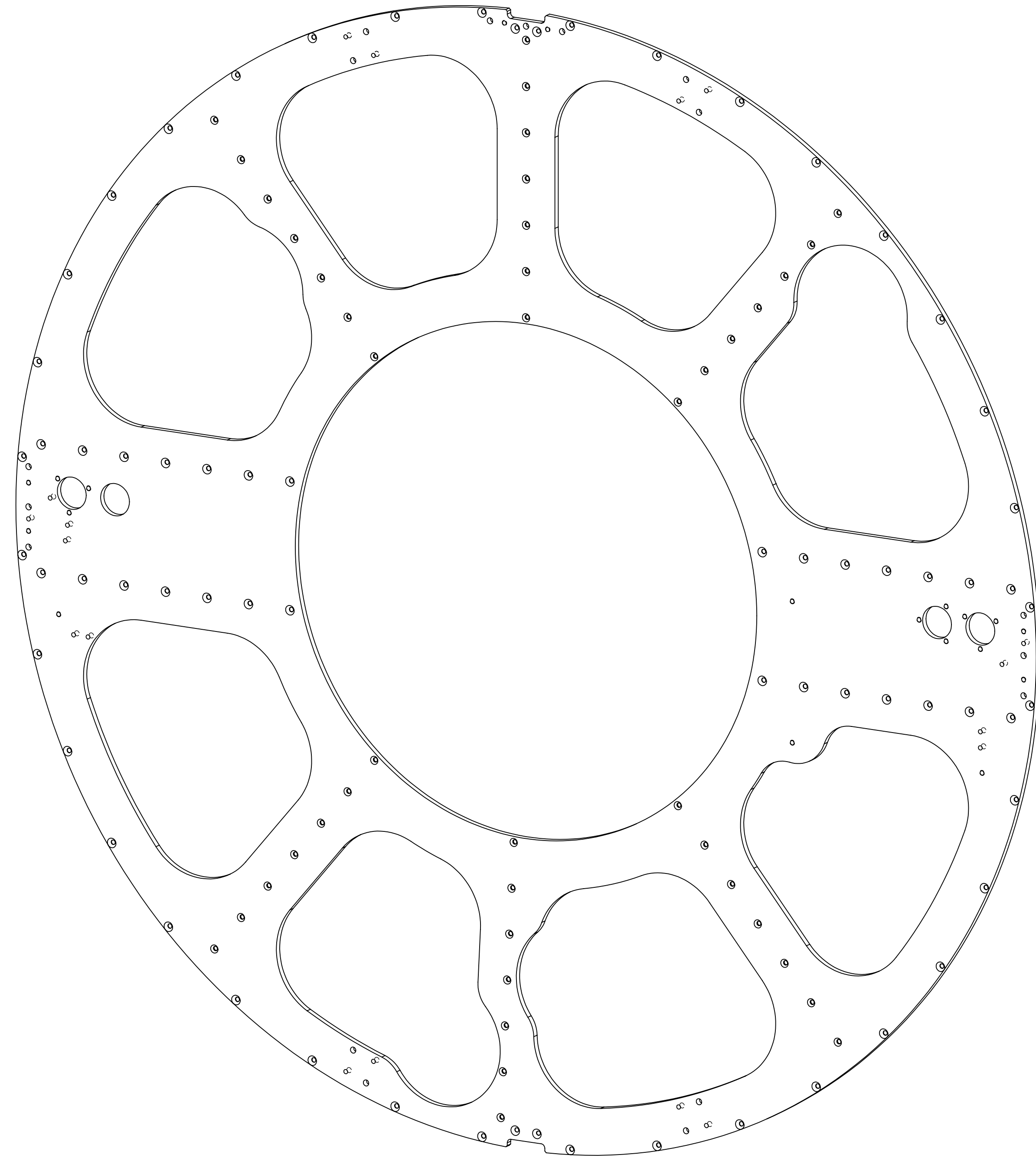


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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 = 59.5 LBS.
 - 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 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. 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.

REV.	DATE	DCN #	DRAWING TREE #
V1	26 JUN 2012	E1200700	
V2	13 JUL 2012	E1200700	
V3	20 AUG 2012	E1200700	
V4	03 SEPT 2012	E1200700	



**D1200727-1
(COUNTERSINK ON DATUM "A" SURFACE)**



**D1200727-2
(COUNTERSINK OPPOSITE DATUM "A" SURFACE)**

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	SUPPLIER
2	4	1185-4EN375	INSERT, HELI-COIL, 1/4-20 X .375LG, NITRONIC 60	HELI-COIL
1	1	D1200727-1	PCAL PLATE MIRROR MTG	

PARTS LIST

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 ± .05 .XXX ± .010	
ANGULAR ± 0.5°	
MATERIAL	6061 Alloy
FINISH	63 μinch

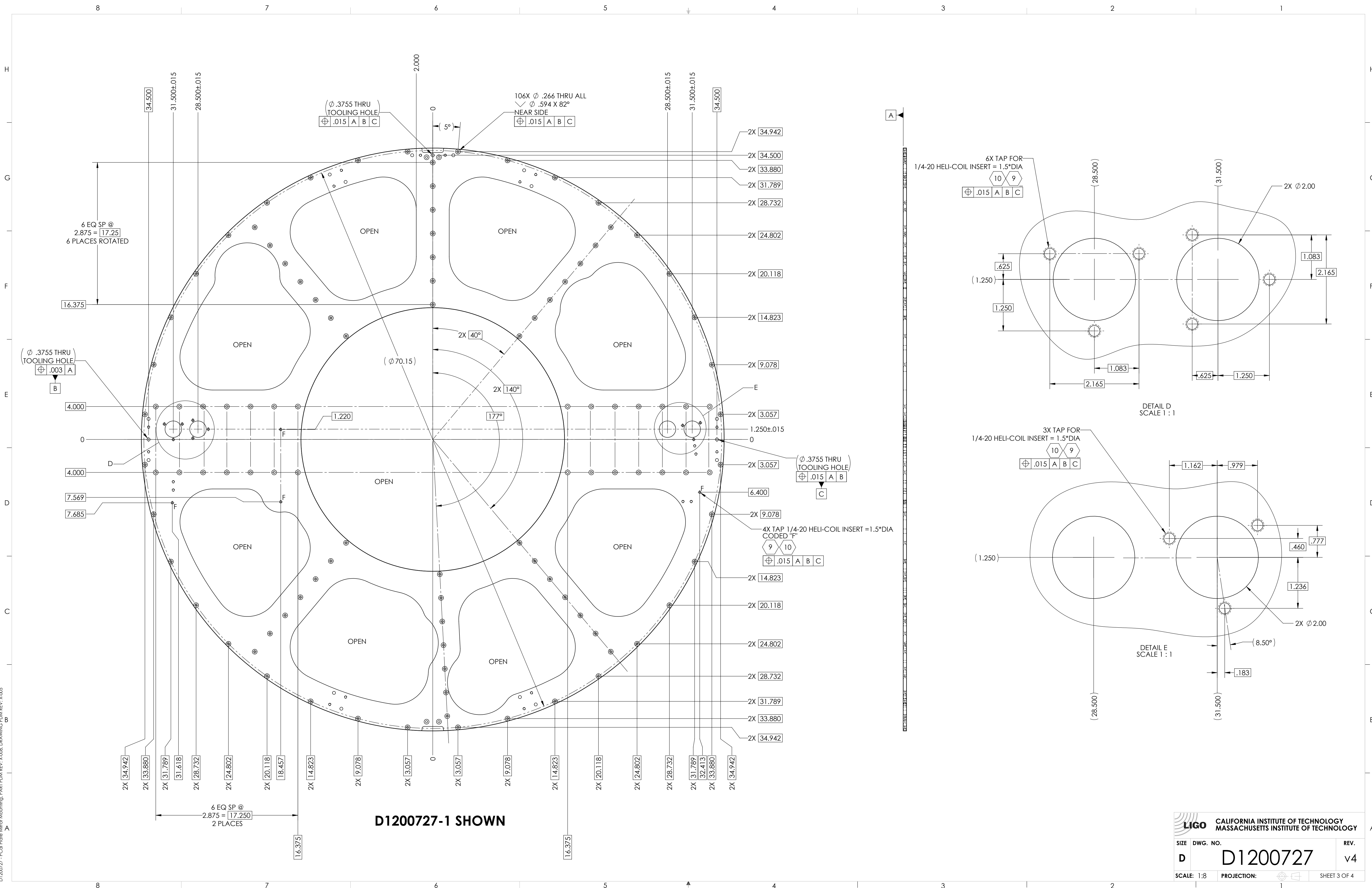
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

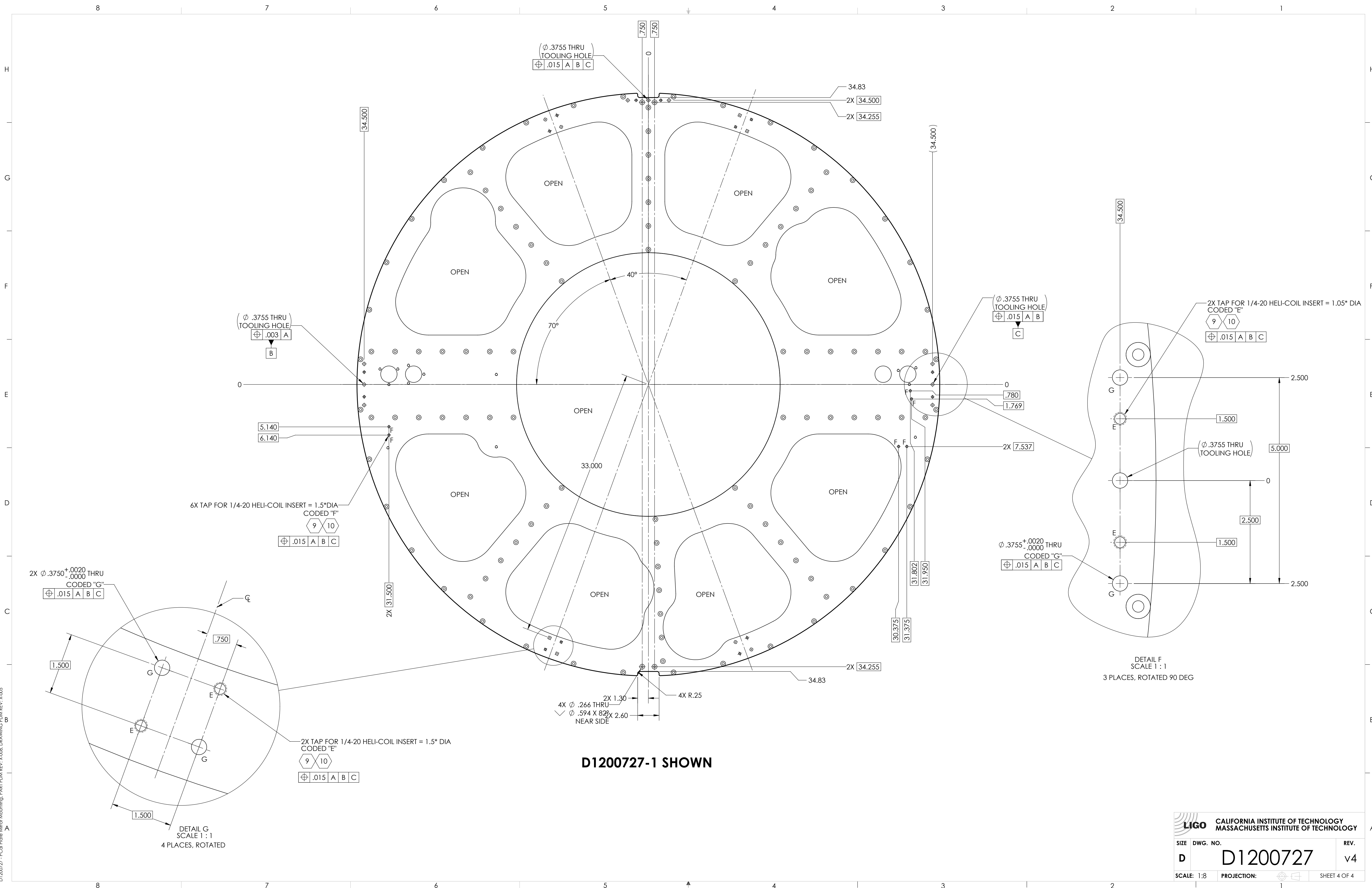
SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

NEXT ASSY: D1200174

PART NAME		DESIGNER		SIZE		DWG. NO.		REV.	
PCAL PLATE MIRROR MTG		S. SHANKLE	10 JUN 2012	D	D	D1200727		v4	
CHECKER		S. SHANKLE	26 JUN 2012	SCALE: 1:8		PROJECTION:		SHEET 1 OF 4	
APPROVAL		S. SHANKLE	26 JUN 2012						

D1200727- PCAL Plate Mirror Mounting, PART PDM, REV-X-008, DRAWING PDM, REV-X-005





(ϕ .3755 THRU)
TOOLING HOLE
 \oplus .015 A B C

34.83
2X $\boxed{34.500}$
2X $\boxed{34.255}$

(ϕ .3755 THRU)
TOOLING HOLE
 \oplus .003 A
B

(ϕ .3755 THRU)
TOOLING HOLE
 \oplus .015 A B
C

2X TAP FOR 1/4-20 HELI-COIL INSERT = 1.05" DIA
CODED "E"
9 10
 \oplus .015 A B C

6X TAP FOR 1/4-20 HELI-COIL INSERT = 1.5" DIA
CODED "F"
9 10
 \oplus .015 A B C

2X ϕ .3750^{+0.0020}_{-.0000} THRU
CODED "G"
 \oplus .015 A B C

ϕ .3755^{+0.0020}_{-.0000} THRU
CODED "G"
 \oplus .015 A B C

4X ϕ .266 THRU
 \checkmark ϕ .594 X 8.25 X 2.60
NEAR SIDE

D1200727-1 SHOWN

2X TAP FOR 1/4-20 HELI-COIL INSERT = 1.5" DIA
CODED "E"
9 10
 \oplus .015 A B C

DETAIL F
SCALE 1 : 1
3 PLACES, ROTATED 90 DEG

DETAIL G
SCALE 1 : 1
4 PLACES, ROTATED

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE DWG. NO.	REV.
D D1200727	v4
SCALE: 1:8	PROJECTION:
SHEET 4 OF 4	

D1200727-1 FCD File Mirror Mounting, PART PDM, REV: X-008, DRAWING PDM, REV: X-005