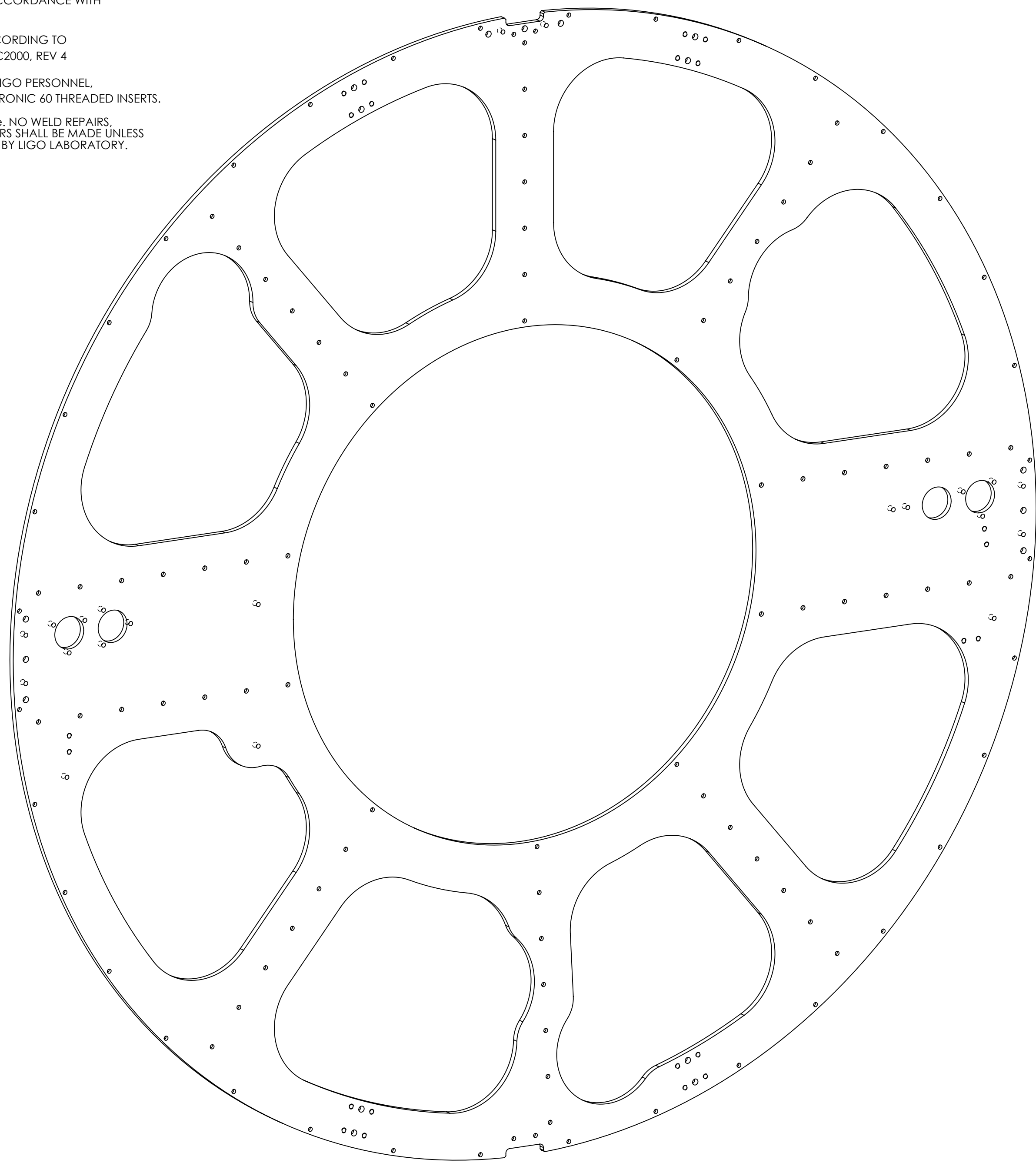
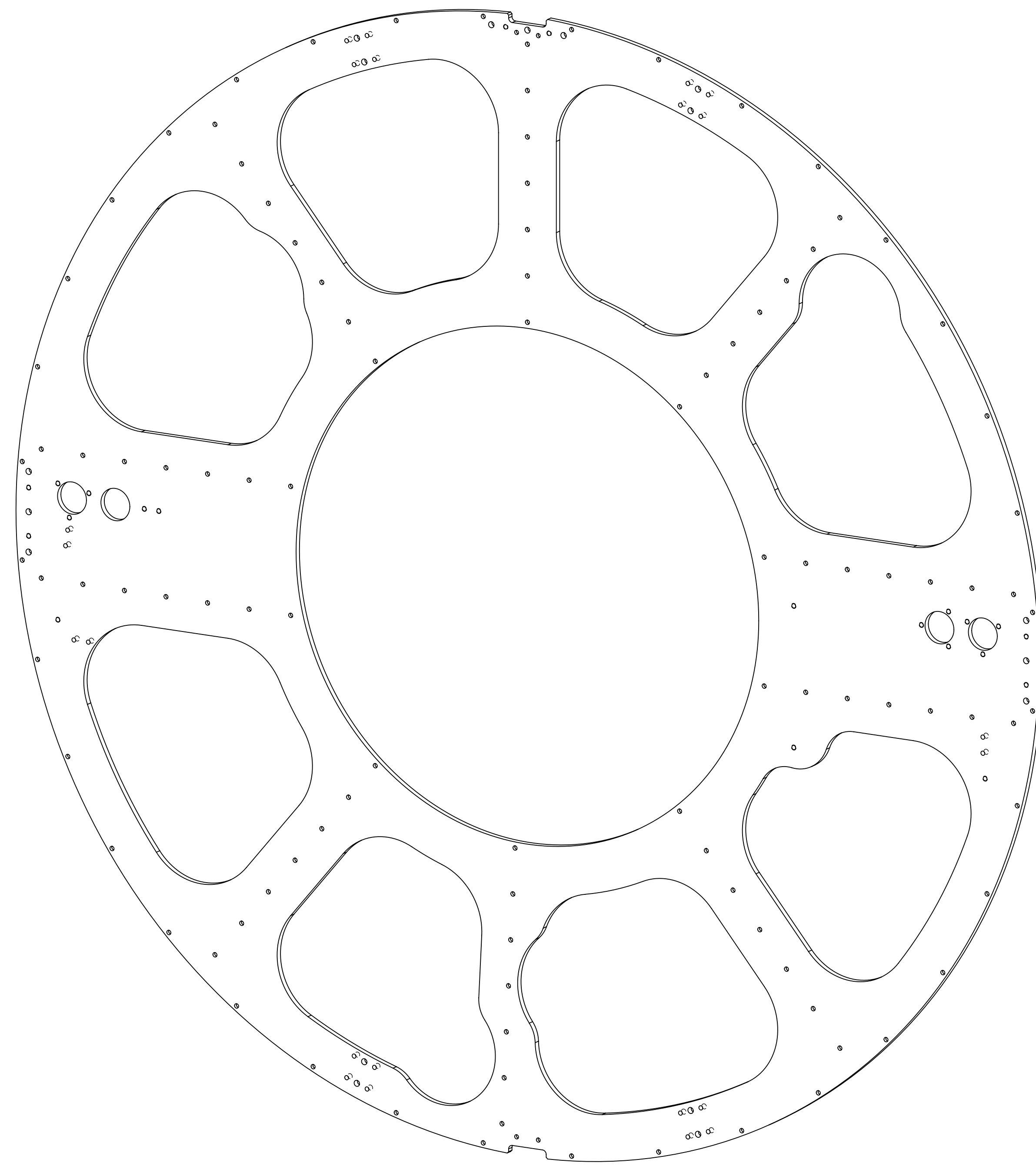


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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	
V5	10 SEPT 2012	E1200700	
V6	23 SEPT 2012	E1200700	
V7	28 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	

DIMENSIONS ARE IN INCHES		TOLERANCES: .XX ± .05 .XXX ± .010		ANGULAR ± 0.5°	
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		MATERIAL		FINISH	
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.		6061 Alloy		63 μinch	

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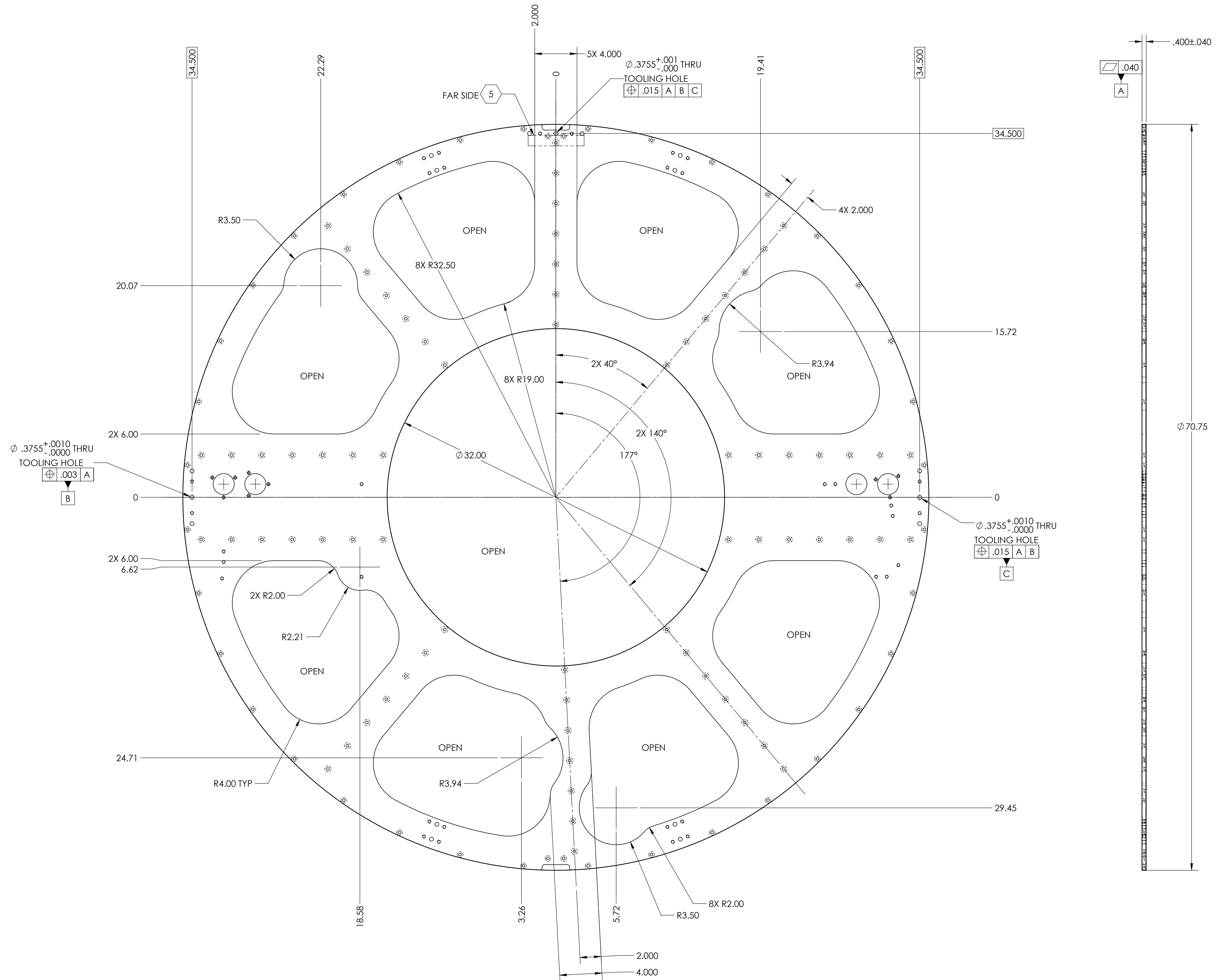
SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **AOS**

NEXT ASSY: **D1200174**

PART NAME		DESIGNER		SIZE		DWG. NO.		REV.	
PCAL PLATE MIRROR MTG		S. SHANKLE		10 JUN 2012		D		D1200727	
DRAFTER		S. SHANKLE		26 JUN 2012				v7	
CHECKER		S. SHANKLE		26 JUN 2012					
APPROVAL		S. SHANKLE		26 JUN 2012		SCALE: 1:8		PROJECTION:	

8 7 6 5 4 3 2 1

H
G
F
E
D
C
B
A



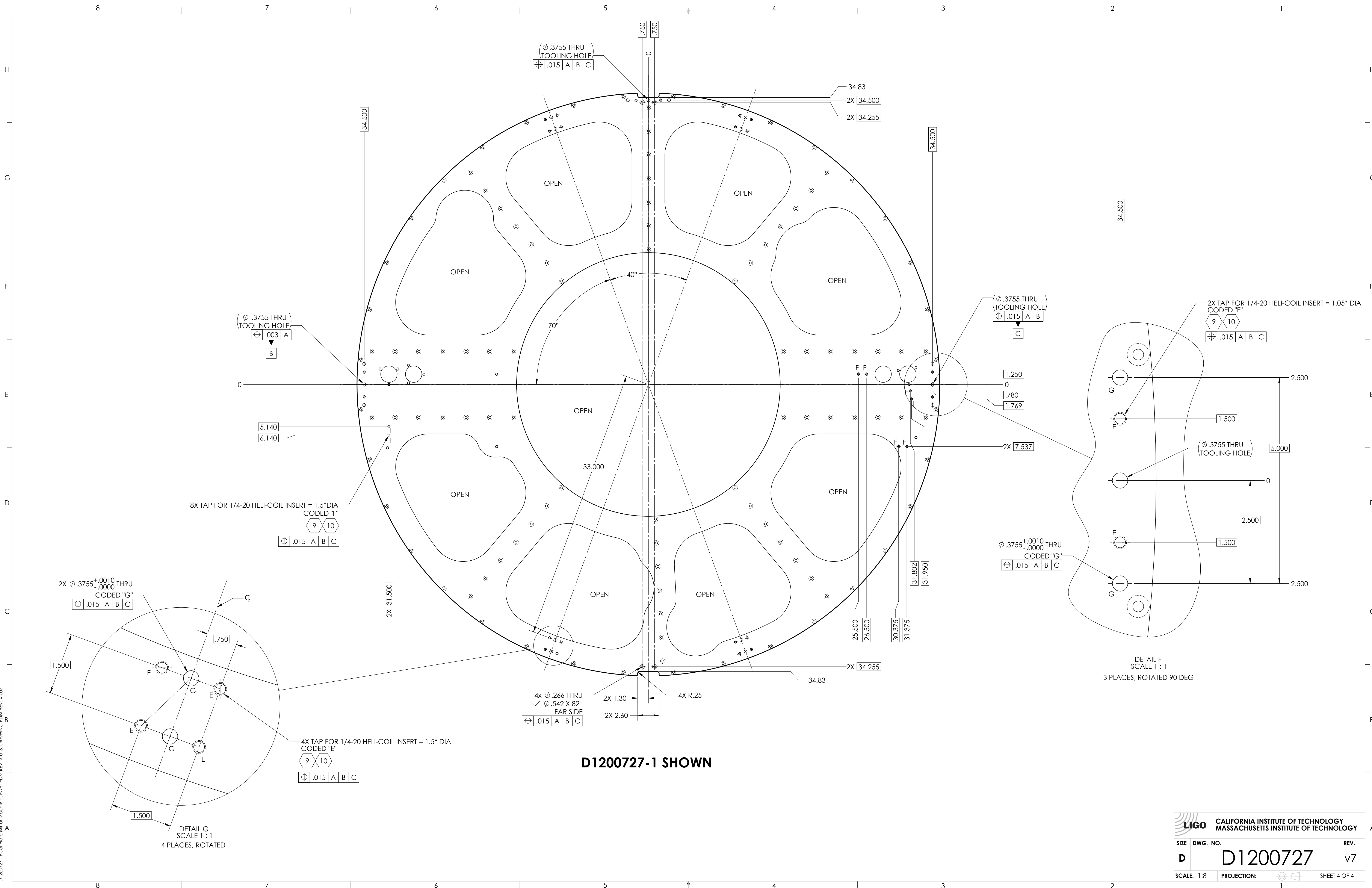
D1200727-1 SHOWN

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SIZE	DWG. NO.	REV.
D	D1200727	v7
SCALE: 1:8	PROJECTION:	SHEET 2 OF 4

8 7 6 5 4 3 2 1

D1200727-1 FCI Plate Mirror Mounting, PART PDM REV: X-013, DRAWING PDM REV: X-007



D1200727-1 SHOWN

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SIZE	DWG. NO.	REV.
D	D1200727	v7
SCALE: 1:8	PROJECTION:	SHEET 4 OF 4

D1200727-1_PCD File Mirror Mounting_1.PART.PDM.REV.X.013.DRAWING.PDM.REV.X.007