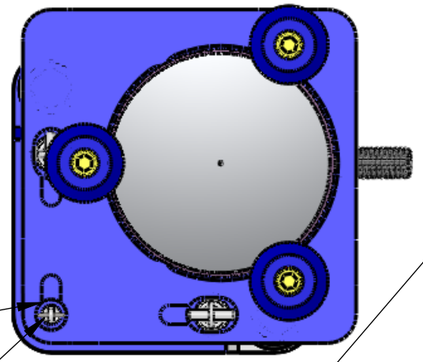
NOTES CONTINUED:

⟨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: DXXXXXXX-VY, TYPE-XX, S/N XXX

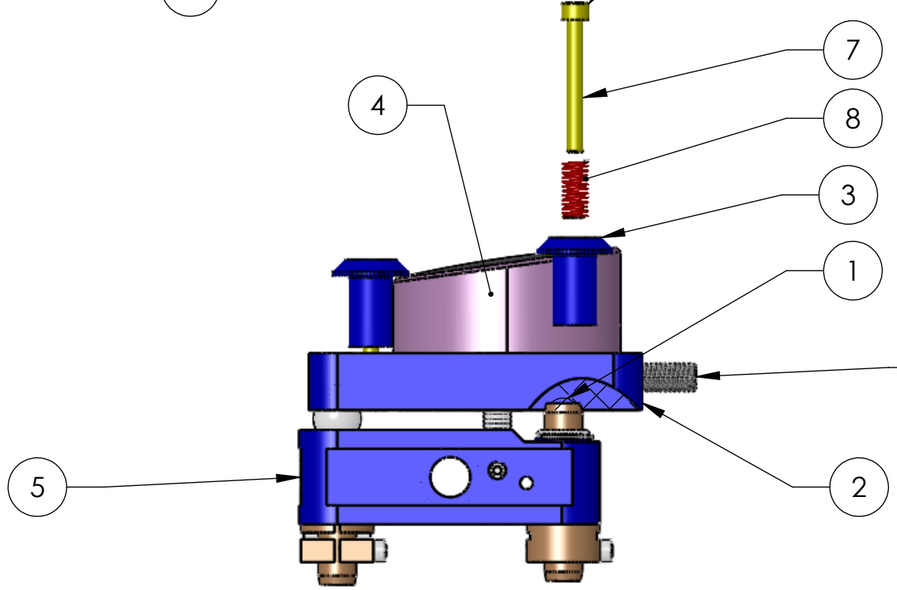
6. APPROXIMATE WEIGHT = X.XXX LB.

REV.	DATE	DCN #	DRAWING TREE #
v1	8-28-12	to follow	-
v2	3-6-13	to follow	E1200793
-	-	-	-

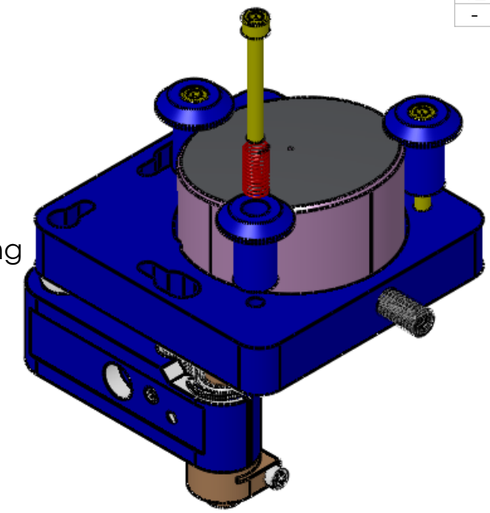
Note: to replace Part #2, use Tool D1201557 to pull spring to clear dowel plane and install dowel with pliar tool (3 PL.)

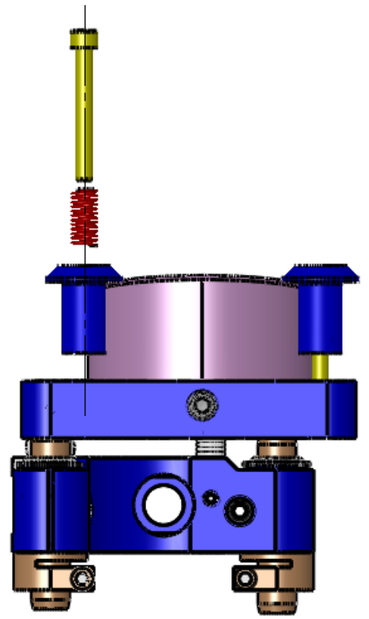


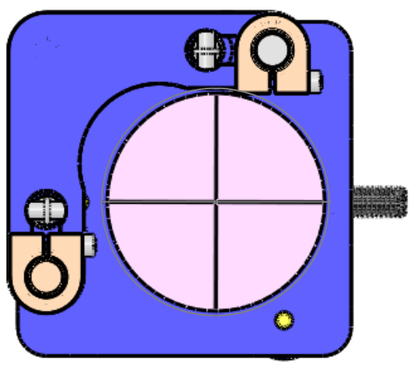
Note: In assembly the screw head will be flush with the part #3 at the proper spring tension (3places)



Note: Only use fingers to tighten this screw do not use a tool







ITEM NO.	PART NUMBER	QTY
9	D1300212 Mc Master 90145A310 CORNER SPRING DOWEL .03 Dia. x.18 lg s stl	1
8	9435K24 .500" Length, .18" OD, .018" Wire Spring	3
7	92196A114 SST SHCS #4-40 UNC-2A X 0.875 LONG	3
6	Mc Master 92778A121 SS Oval Point Socket Set Scr 10-32, 1/2" lg.	1
5	D1201076 aLigo secondary mirror mount tip-tilt sub assem ISC Group	1
4	D0901565 ETM TELESCOPE SECONDARY MIRROR	1
3	D1100114 SECONDARY MIRROR CLAMP	3
2	D1200826-v1 aLIGO Secondary Mount Plate	1
1	D1201078 Ball for Secondary Adjusting Screw Provided by ISC Group	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .02
.XXX ± .010
ANGULAR ± 1.0°

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.

MATERIAL: N/A
FINISH: N/A µinch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: AOS
NEXT ASSY: D12002365

PART NAME: aLigo sec. mirror mt. tip-tilt sub assem with Ligo mt pL.SLDASM

DESIGNER	k mailand	8-28-12
DRAFTER	k mailand	8-28-12
CHECKER	k mailand	3-6-13
APPROVAL		

SIZE: B — DWG. NO.: D1201077 — REV.: v3
SCALE: 1:1 — PROJECTION: — SHEET 1 OF 1

D1201077-aLigo sec. mirror mt. tip-tilt sub assem with Ligo mt pL. PART PDM REV: X-007, DRAWING PDM REV: X-020