

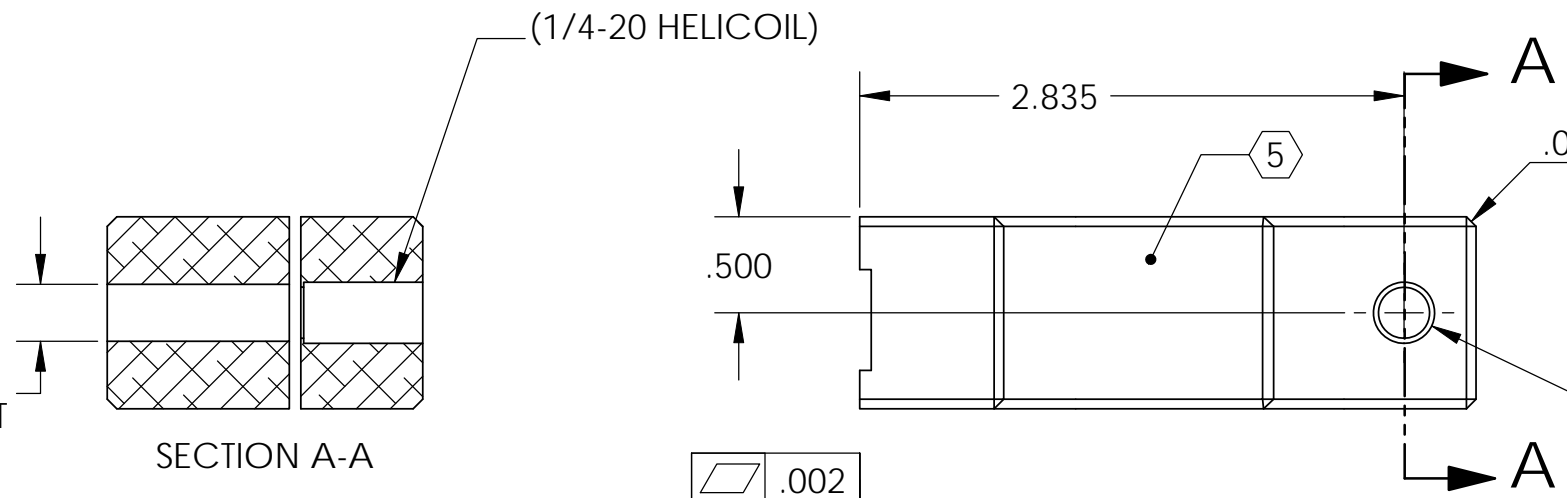
D0902251 Stage1-2 Vertical Sensor Target Mount, PART PDM REV: X-010, DRAWING PDM REV: X-005

REV.	DATE	DCN #	DRAWING TREE #
v1	01 Mar. 2010	E1000049	E1000025
v2	28 July 2010	E1000339	E1000025
v3	24 Aug. 2010	E1000353	E1000025

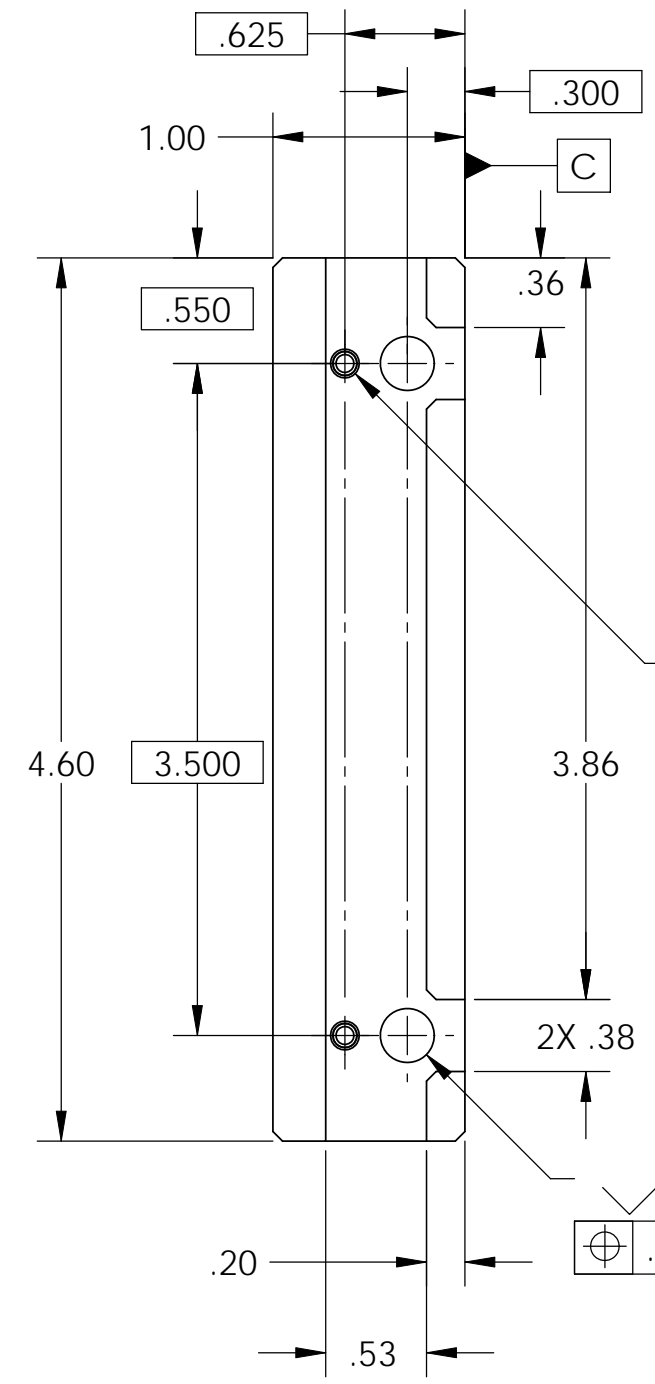
NOTES CONTINUED:
 (5) SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12 HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
 EXAMPLE DXXXXXX-VV, TYPE-XX, S/N XXX.
 6. APPROXIMATE WEIGHT = 0.71 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 THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.
 10. A TRUE POSITION TOLERANCE OF $\phi .010$ IS - THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.

D
C
B
A

D
C
B
A

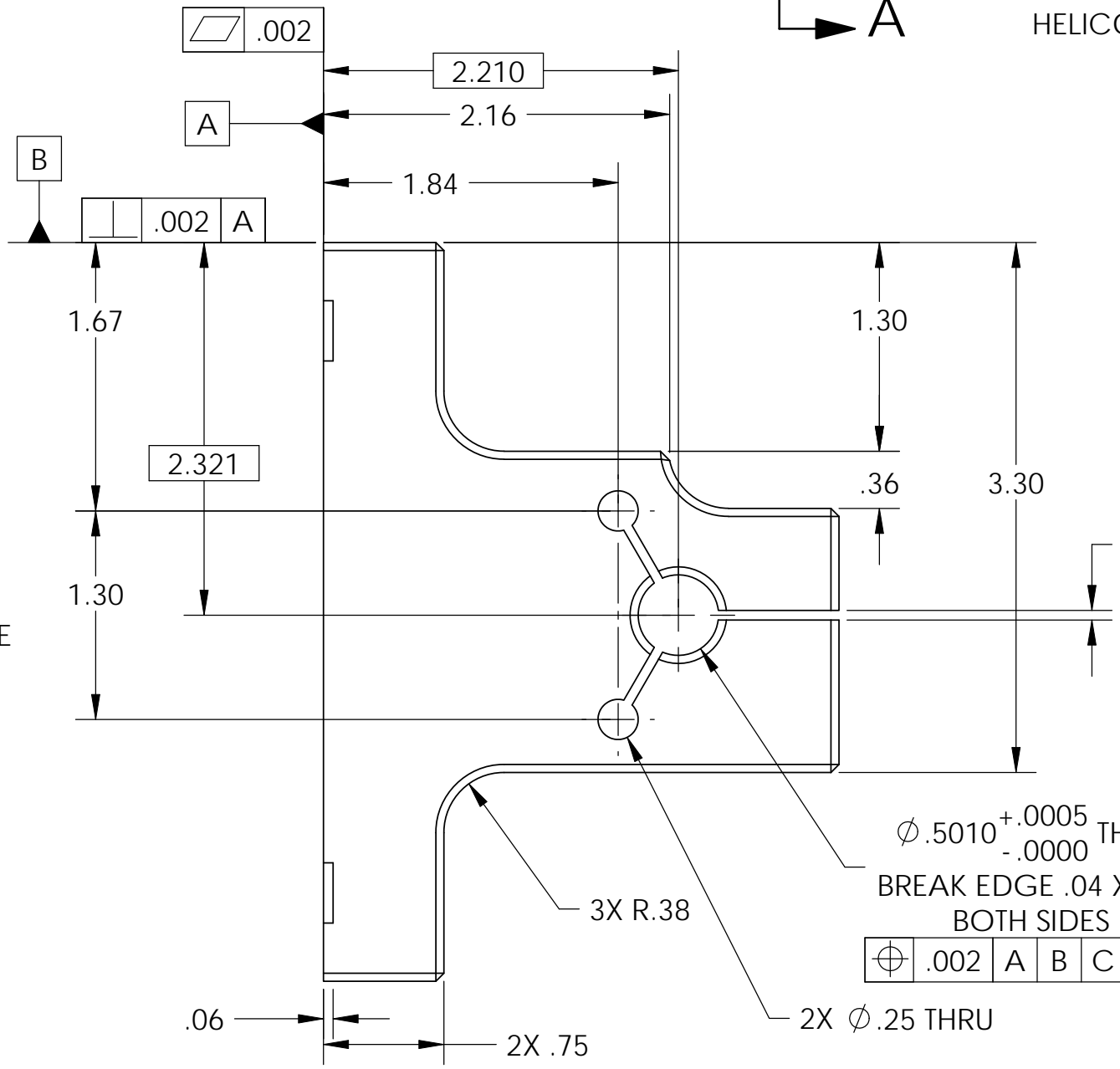


$\phi .27$ THRU ALL TAP FOR 1/4-20 HELICOIL INSERT = 2.0 * DIA.



2X $\phi .093$ THRU
 $\phi .1250^{+.0000}_{-.0003} \nabla .25$
 $\phi .126^{+.001}_{-.000} \nabla .06$
 $\phi .15 \times 90^\circ$, NEAR SIDE
 $\phi .002$ A B C

2X $\phi .28 \nabla .81$
 $\phi .33 \times 90^\circ$, FAR SIDE
 $\phi .010$ A B C



$\phi .5010^{+.0005}_{-.0000}$ THRU
 BREAK EDGE .04 X 45°
 BOTH SIDES
 $\phi .002$ A B C

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		STAGE 1-2, VERTICAL SENSOR TARGET MOUNT					
TOLERANCES: .XX $\pm .015$.XXX $\pm .005$				SEI		DESIGNER	S.BARNUM	01 Mar. 2010	SIZE	DWG. NO.	REV.
ANGULAR $\pm .5^\circ$				MATERIAL		DRAFTER	M.HILLARD	01 Mar. 2010	B	D0902251	v3
				FINISH		CHECKER	F.MATICHARD	01 Mar. 2010	SCALE: 1:1 PROJECTION:		
				NEXT ASSY		APPROVAL	K.MASON	01 Mar. 2010	SHEET 1 OF 1		
				6061-T6 Al		D0902534					
				32 μ inch							

8 7 6 5 4 3 2 1