

D0902252 STAGE 1-2 HORIZONTAL SENSOR TARGET MOUNT, PART PDM REV: X-009, DRAWING PDM REV: X-005

REV.	DATE	DCN #	DRAWING TREE #
v1	01 Mar. 2010	E1000049	E1000025
v2	03 Aug. 2010	E1000288	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 DXXXXXXX-VY, TYPE-XX, S/N XXX.

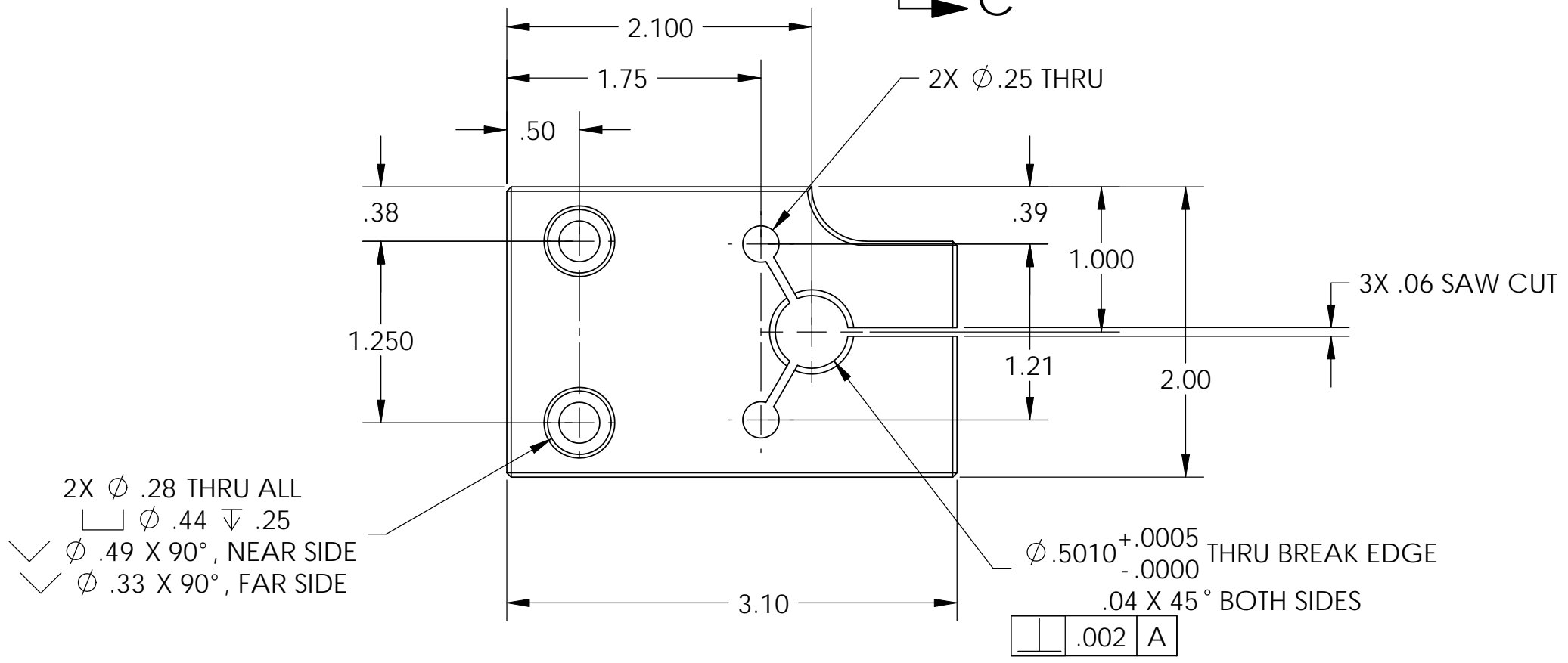
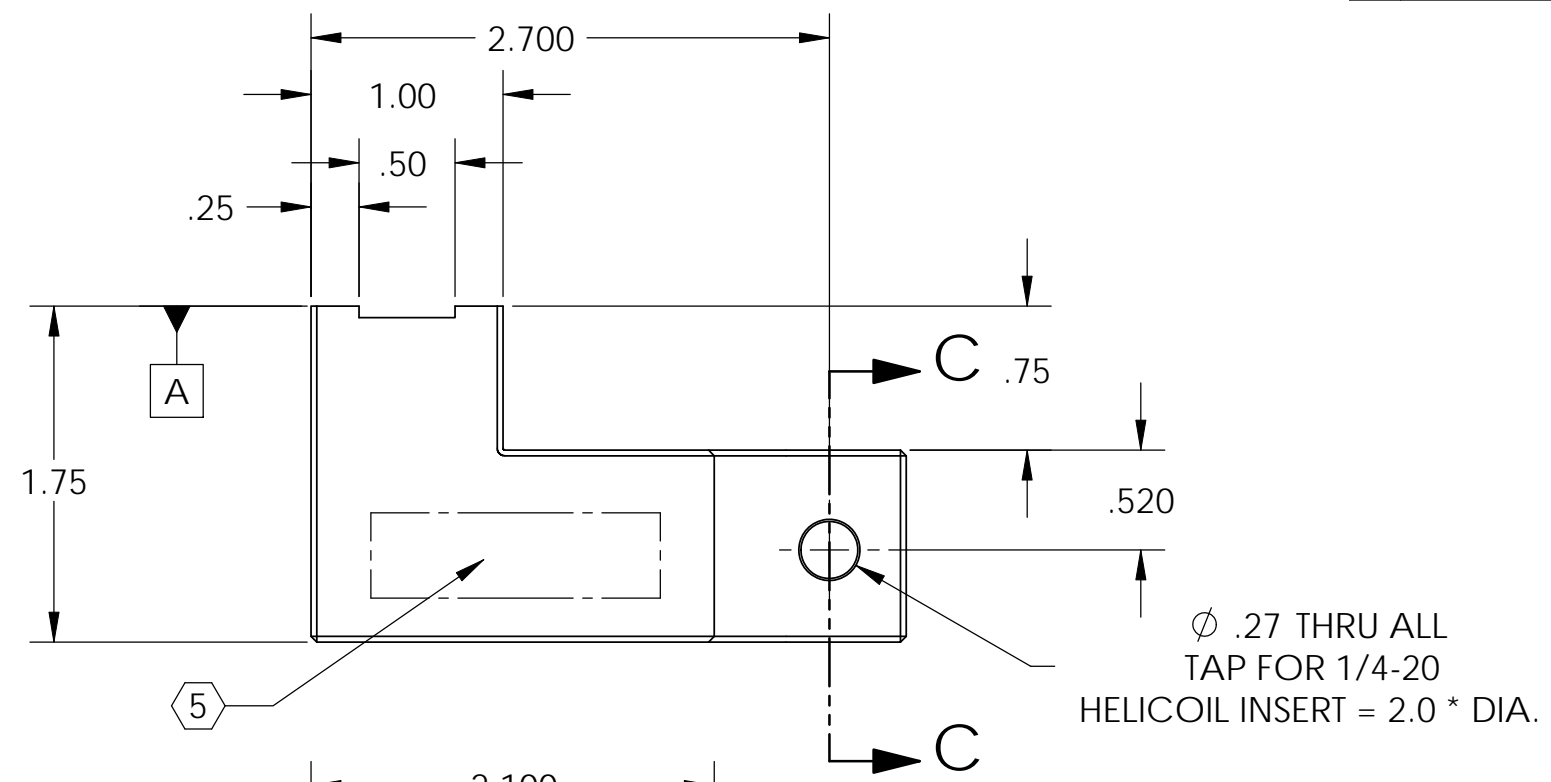
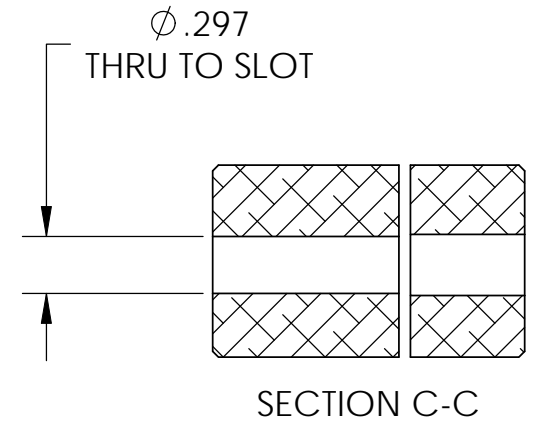
6. APPROXIMATE WEIGHT = 0.64 LB.

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  $\pm .005$ .



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME						
DIMENSIONS ARE IN INCHES TOLERANCES: .XX $\pm .015$ .XXX $\pm .005$ ANGULAR $\pm .5^\circ$				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. BREAK ALL CORNERS AND EDGES .03 X 45°. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		STAGE 1-2 HORIZONTAL SENSOR TARGET MOUNT						
MATERIAL		FINISH		SYSTEM		SUB-SYSTEM		DESIGNER	DATE	SIZE	DWG. NO.	REV.
6061-T6 Al		32 $\mu$ inch		ADVANCED LIGO		SEI		S.BARNUM	01 Mar. 2010	B	D0902252	v2
NEXT ASSY				D0902529		CHECKER		APPROVAL		SCALE: 1:1 PROJECTION:  SHEET 1 OF 1		
						K.MASON		01 Mar. 2010				