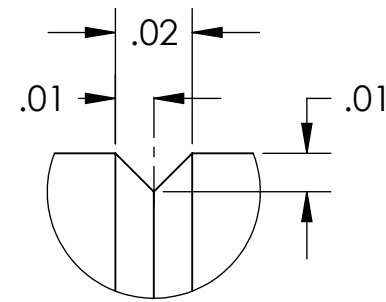
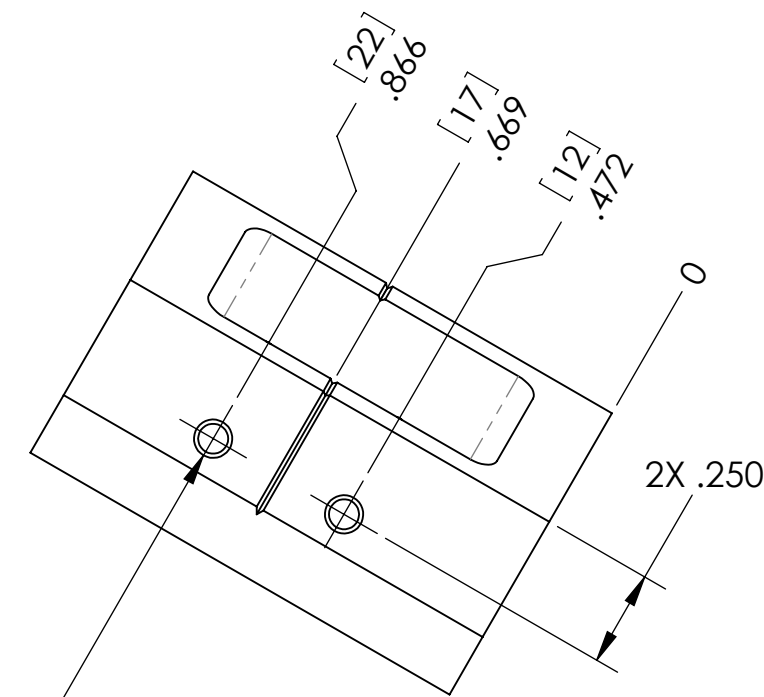
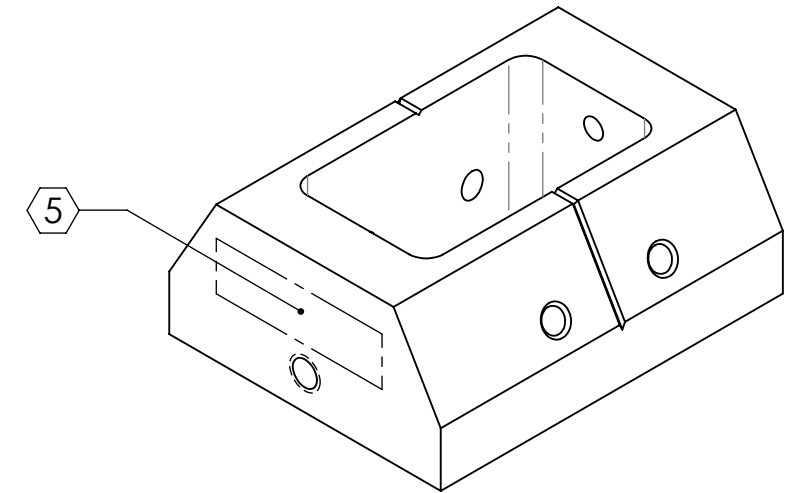


NOTES CONTINUED:  
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.  
 EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX  
 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.  
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 OCT 2009	E0900369	E080191
v2	02 SEP 2011	E1100826	E080191
-	-	-	-

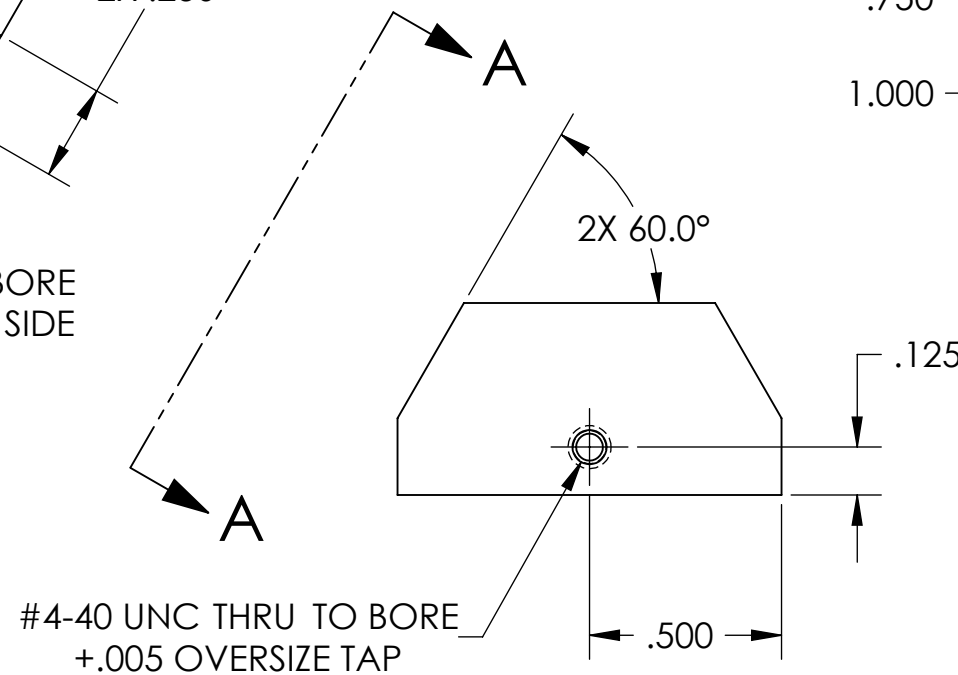


DETAIL B  
 SCALE 20 : 1  
 TYPICAL

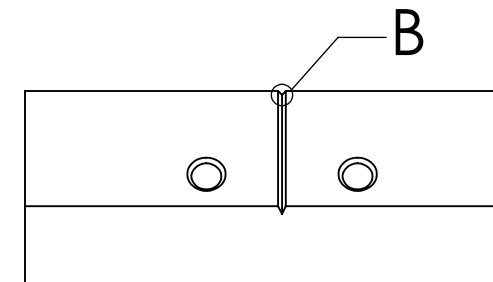
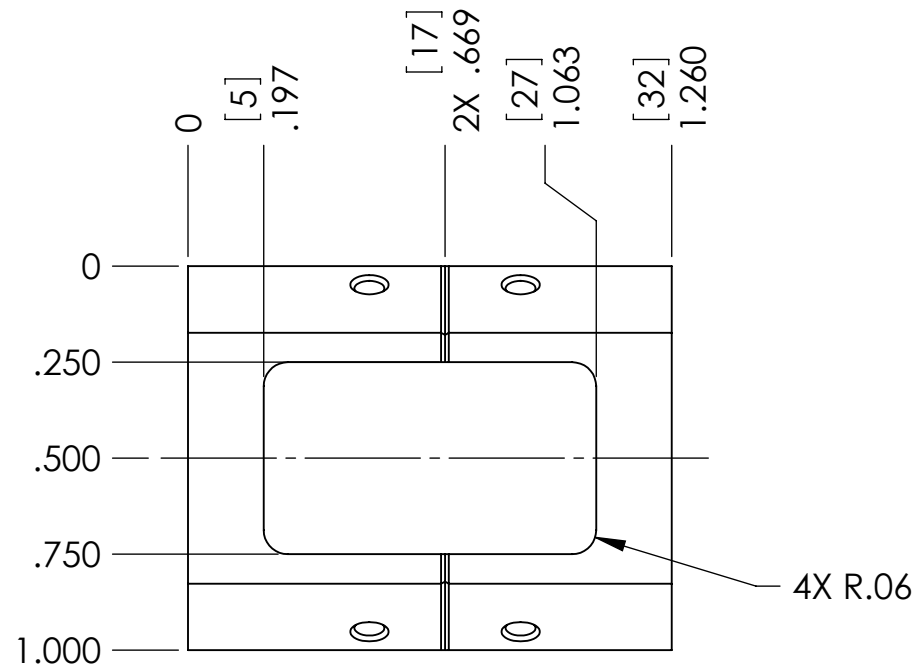


2X Ø .0781±.0005 THRU TO BORE  
 ✓ Ø .100 MAX X 90°, NEAR SIDE

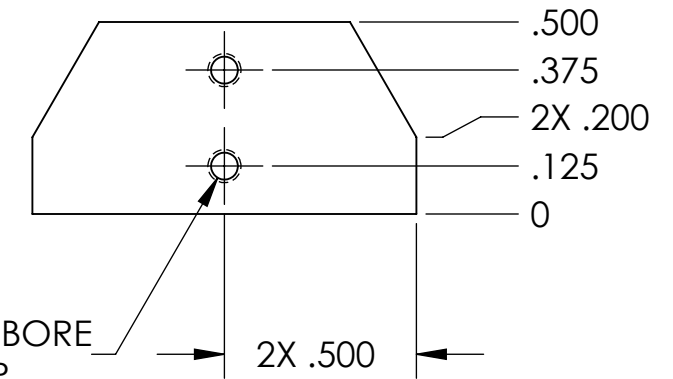
VIEW A-A



#4-40 UNC THRU TO BORE  
 +.005 OVERSIZE TAP



2X #2-56 UNC THRU TO BORE  
 +.003 OVERSIZE TAP



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)  
 DIMENSIONS ARE IN INCHES [MM]  
 TOLERANCES:  
 .XX ± .01  
 .XXX ± .005  
 ANGULAR ± 0.5°

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 6061-T6 Al  
 FINISH 63 μinch

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY  
 SYSTEM ADVANCED LIGO SUB-SYSTEM SUS  
 NEXT ASSY SAPPHIRE PRISM HOLDER

PART NAME  
**SAPPHIRE PRISM HOLDER**  
 DESIGNER D. BRIDGES 06 SEP 2011  
 DRAFTER D. BRIDGES 06 SEP 2011  
 CHECKER B. MOORE 07 SEP 2011  
 APPROVAL  
 SIZE DWG. NO. B D0902664  
 REV. v2  
 SCALE: 2:1 PROJECTION: SHEET 1 OF 1

D0902664\_Advanced\_LIGO\_SUS\_HLTS\_Sapphire\_Prism\_Holder\_PART PDM REV: V1-002, DRAWING PDM REV: V1-002