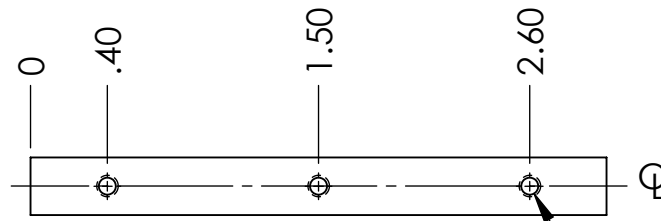


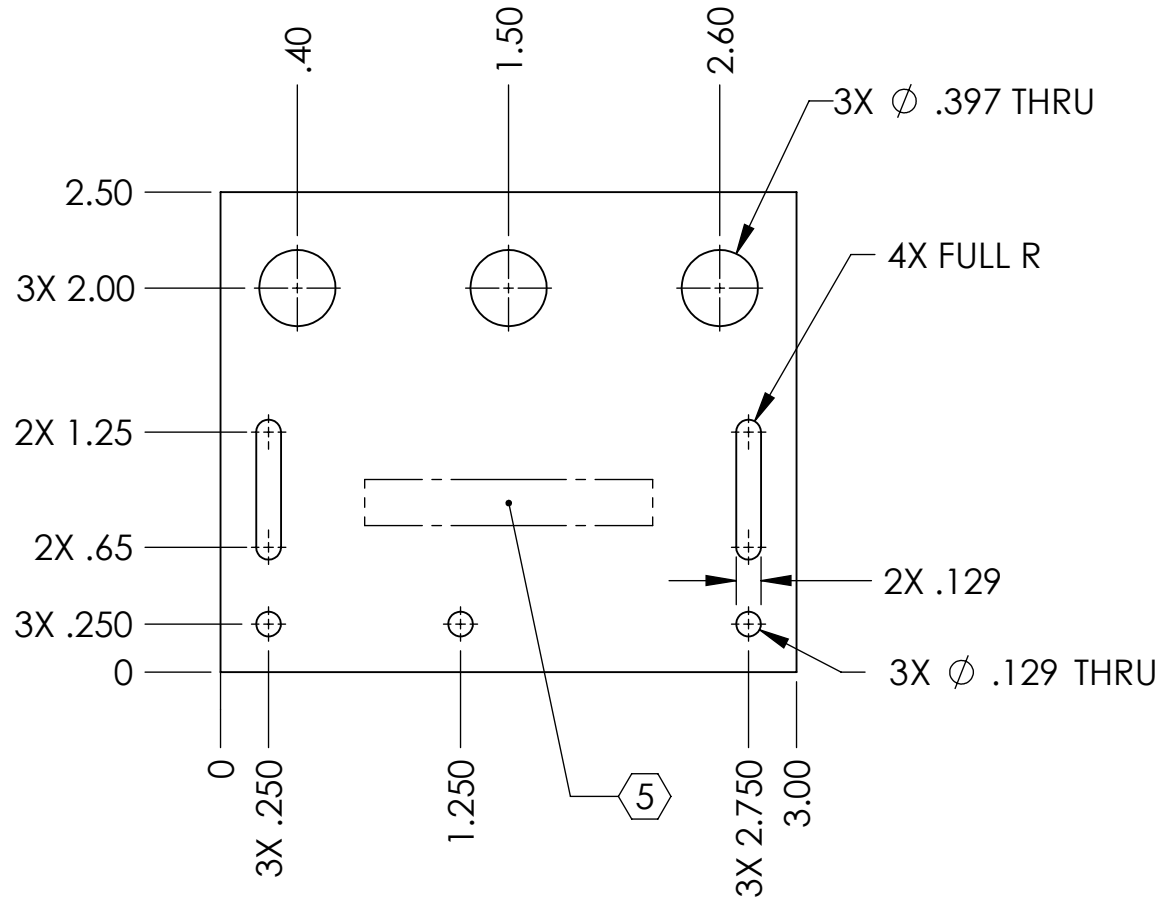
NOTES CONTINUED:

- 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. 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.
- 8. ALL HELICOIL HOLES TO BE PREPARED IN ACCORDANCE WITH EMHART HELICOIL PRODUCT CATALOG, HC2000, REV. 4.
- 9. ALL HELICOILS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY, CLEANING AND BAKING OF FINISHED PARTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 OCT 2009	E0900369	-
v2	02 SEP 2011	E1100826	E080191
v3	27 APR 2012	E1200426	E080191



3X #4-40 UNC THRU TO BORE  
+.005 OVERSIZE TAP



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

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



SYSTEM  
ADVANCED LIGO

SUB-SYSTEM  
SUS

NEXT ASSY  
SAPPHIRE PRISM BONDING FIXTURE

PART NAME

BONDING TEMPLATE SIDE

DESIGNER D. BRIDGES 12 NOV 2009  
DRAFTER B. MOORE 27 APR 2012  
CHECKER D. BRIDGES 27 APR 2012

SIZE  
A

DWG. NO.

D0902666

REV.  
v3

APPROVAL

SCALE: 1:1

PROJECTION:



SHEET 1 OF 1