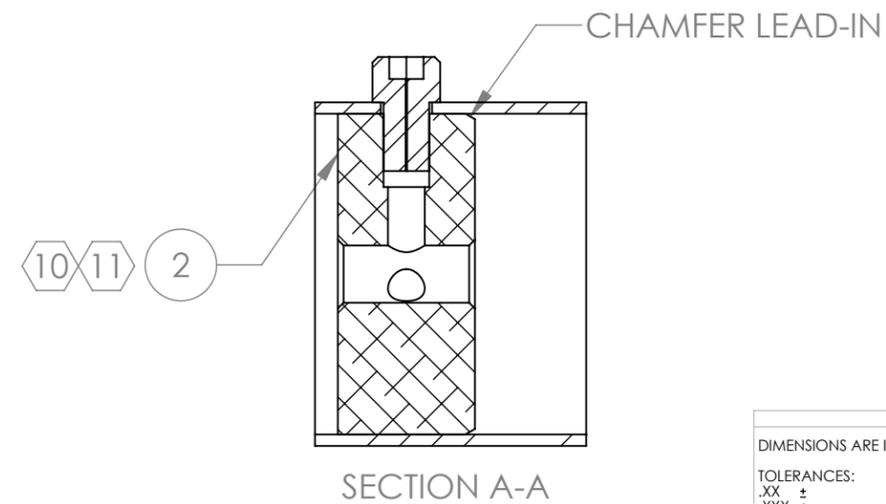
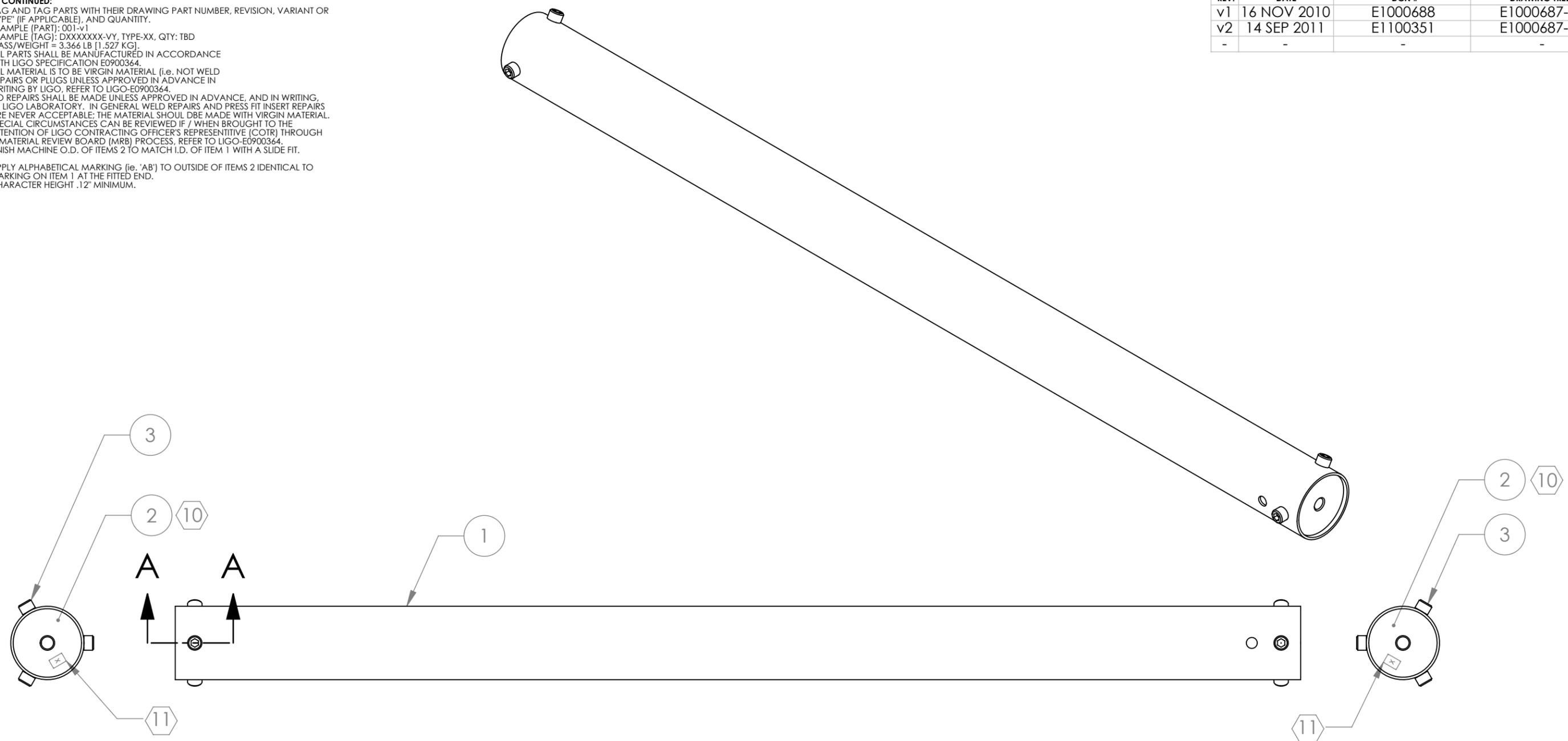


D1000243 aLIGO_ETM_TUBES_AND_INSERTS_ASSEMBLY, PART PDM REV: X-164, DRAWING PDM REV: X-015

NOTES CONTINUED:
 5. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY.
 EXAMPLE (PART): 001-v1
 6. MASS/WEIGHT = 3.366 LB (1.527 KG).
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO. REFER TO LIGO-E0900364.
 9. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS. REFER TO LIGO-E0900364.
 10. FINISH MACHINE O.D. OF ITEMS 2 TO MATCH I.D. OF ITEM 1 WITH A SLIDE FIT.
 11. APPLY ALPHABETICAL MARKING (i.e. 'A') TO OUTSIDE OF ITEMS 2 IDENTICAL TO MARKING ON ITEM 1 AT THE FITTED END. CHARACTER HEIGHT .12" MINIMUM.

REV.	DATE	DCN #	DRAWING TREE #
v1	16 NOV 2010	E1000688	E1000687-v1
v2	14 SEP 2011	E1100351	E1000687-v2
-	-	-	-



ITEM NO.	PART NUMBER	REV	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
3	C-2006 (U-C COMPONENTS) OR EQUIV		SCREW, SOCKET HEAD CAP, 1/4-20 UNC-2A X 0.375 LONG, VENTED	300 SSTL	6	2	8
2	D1000242	v2	aLIGO ETM TELE TUBE THD INSERT	6061-T6 Al	2	-	2
1	D1000072	v3	ADLIGO ETM TELE TUBE	INVAR 36	1	-	1

PARTS LIST

DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .XXX ± ANGULAR ± °		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) 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.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS NEXT ASSY: D1003120		PART NAME: aLIGO ETM TELE TUBE AND INSERTS ASSEMBLY DESIGNER: K. MAILAND 10 AUG 2009 DRAFTER: C. CONLEY 14 SEP 2010 CHECKER: SEE DCN APPROVAL: SEE DCN		SIZE: B DWG. NO.: D1000243 REV.: v2 SCALE: NONE PROJECTION:		SHEET 1 OF 1	
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8 7 6 5 4 3 2 1