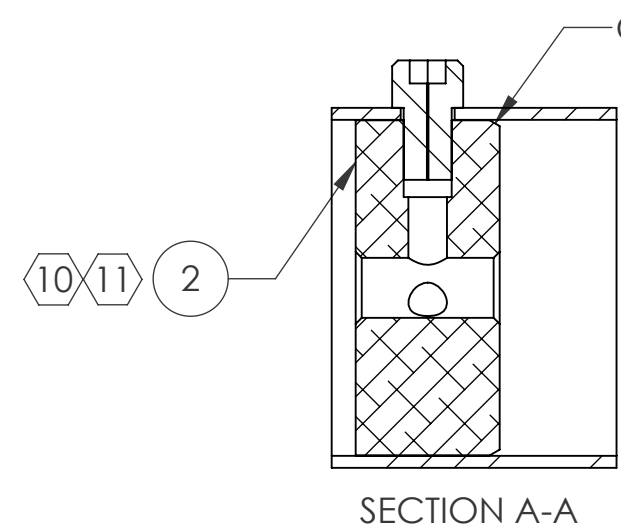
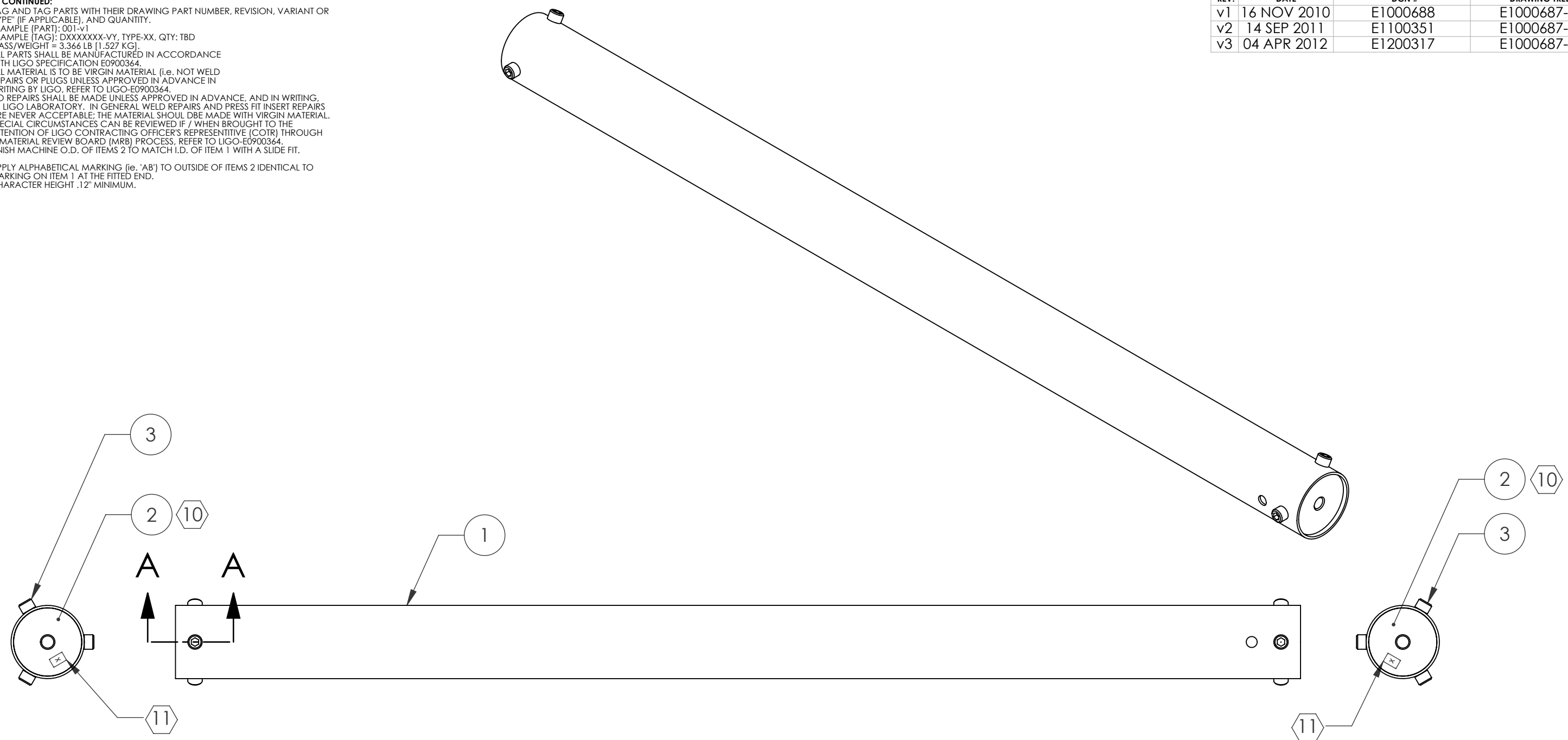


D1000243 aLIGO_ETM_TUBES_AND_INSERTS_ASSEMBLY, PART PDM REV: X-194, DRAWING PDM REV: X-020

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
v3	04 APR 2012	E1200317	E1000687-v3



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 SSSL	6	3	9
2	D1000242	v3	aLIGO ETM TELE TUBE THD INSERT	6061-T6 Al	2	-	2
1	D1000072	v4	ADLIGO ETM TELE TUBE	INVAR 36	1	-	1

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.

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ±
 .XXX ±
 ANGULAR ± °

PARTS LIST

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
DESIGNER	K. MAILAND	10 AUG 2009	SIZE DWG. NO.
DRAFTER	C. CONLEY	14 SEP 2010	B
CHECKER	SEE DCN		
APPROVAL	SEE DCN		

aLIGO ETM TELE TUBE AND INSERTS ASSEMBLY
D1000243
 REV. v3
 SCALE: NONE PROJECTION: SHEET 1 OF 1

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1