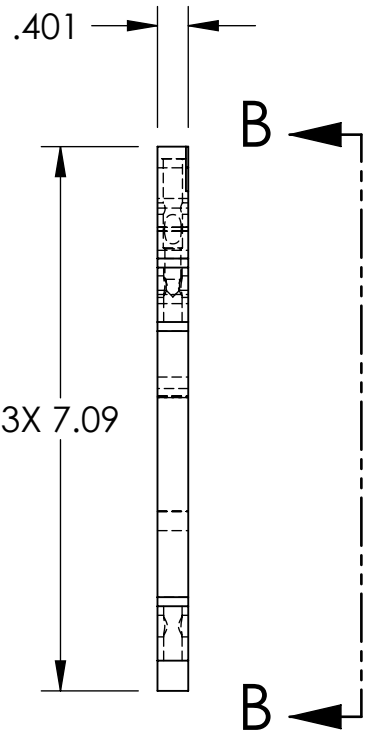
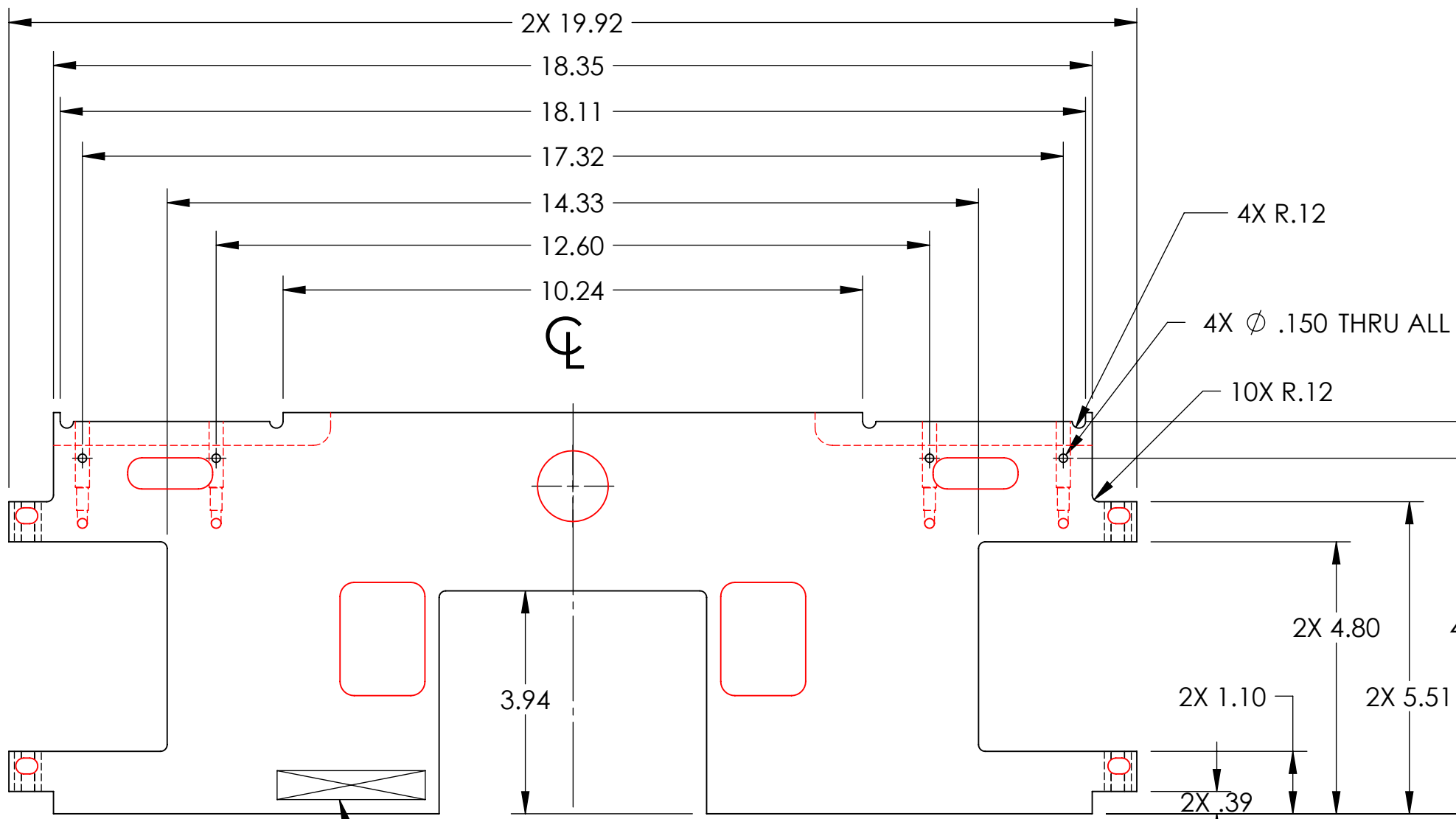
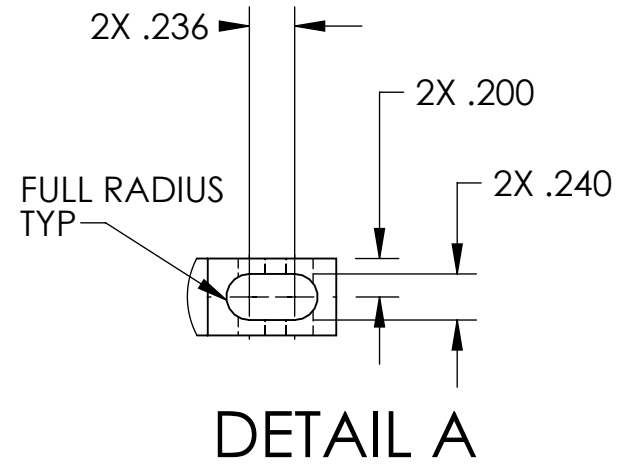
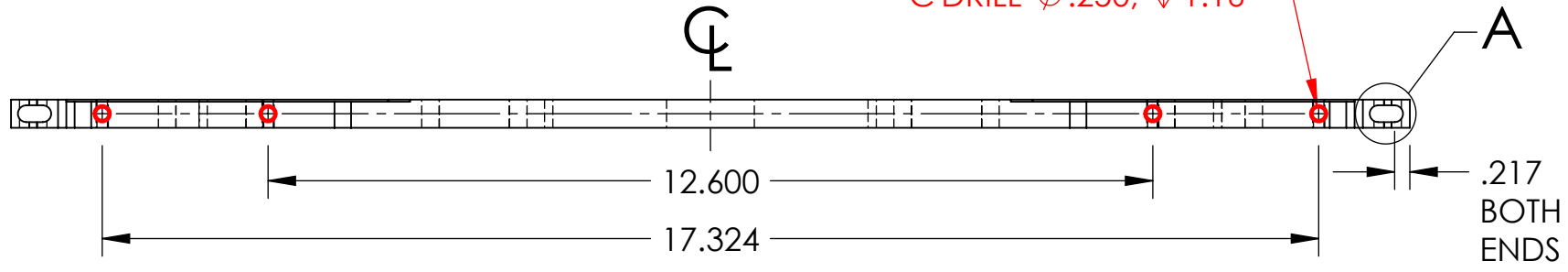


**NOTES CONTINUED:**  
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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

REV.	DATE	DCN #	DRAWING TREE #
v1	JUN-29-2010	E1000234-v1	
v2	31 MAR 2011	E1100277-v1	

4X  $\phi$  .173  $\nabla$  1.80  
 TAP FOR #8-32 (H3) HELICOIL INSERT = 2.0 \* DIA.  
 P/N 1185-2EN-328 (INSTALLED BY LIGO)  
 C'DRILL  $\phi$  .250,  $\nabla$  1.16



- 6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 7. DO NOT USE SANDPAPER, SCOTCH BRITE OR SIMILAR PRODUCTS.
- 8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE TECHNIQUES IS NOT ALLOWED.
- 9. WEIGHT 3.39 LB [1.54 KG].

5 11

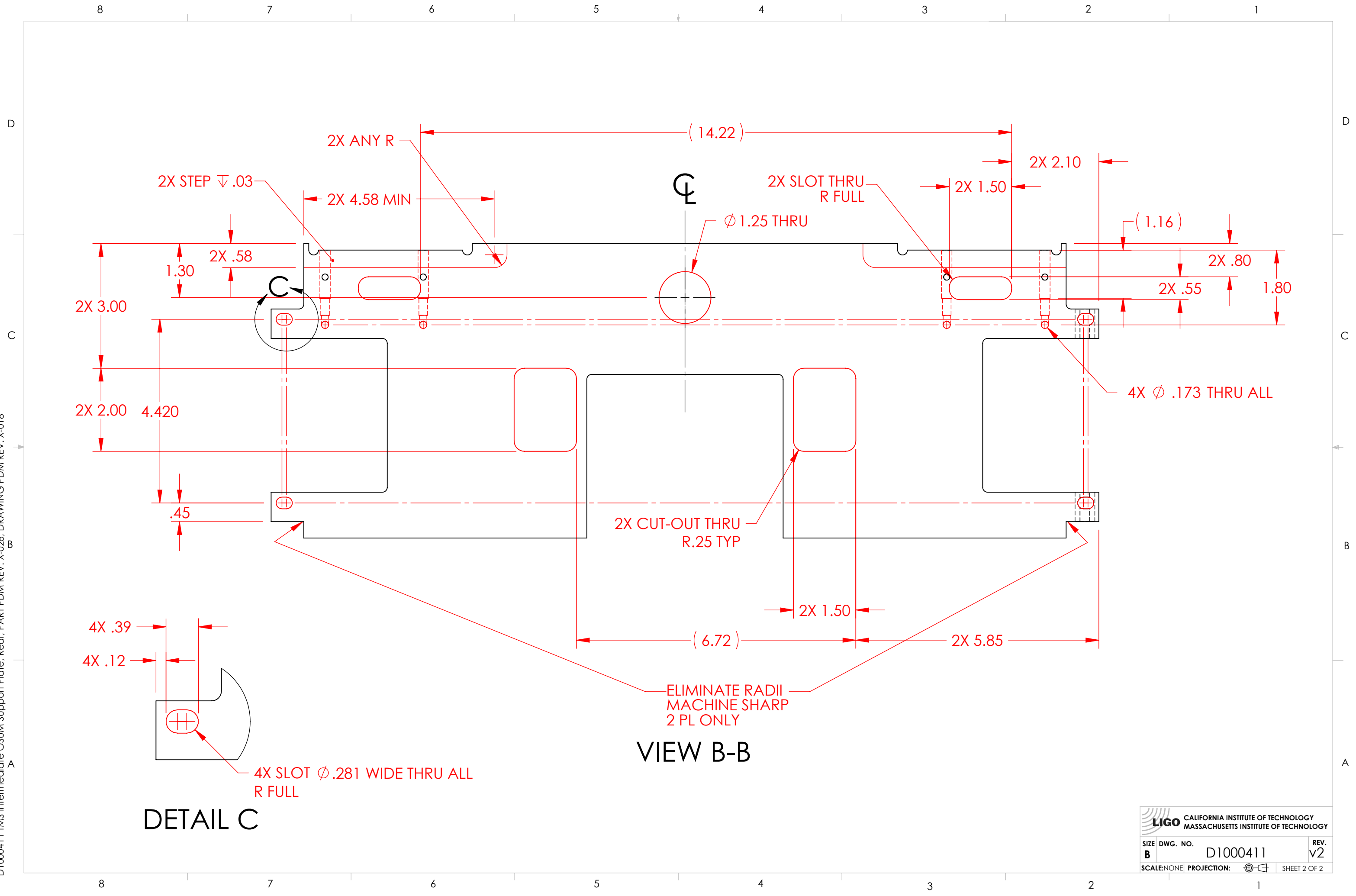
10. THIS DRAWING IS FOR EXISTING PART REWORK. REWORK DETAILS ARE IN RED.  
 11. MARK OUT OLD REVISION LABEL AND REPLACE WITH "v2".

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX $\pm$ .01 .XXX $\pm$ .005 ANGULAR $\pm$ 0.1°	
MATERIAL	6061-T6 AL ALLOY
FINISH	63 $\mu$ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	SYSTEM	aLIGO AOS
	SUB-SYSTEM	AOS
NEXT ASSY	D1000549	

PART NAME		TMS INTERMEDIATE OSUM SUPPORT PLATE, REAR	
DESIGNER	I. ROMERO	DATE	04 FEB 2010
DRAFTER	I. ROMERO	DATE	6/29/10
CHECKER	K. MAILAND	DATE	6/29/10
APPROVAL	K. MAILAND	DATE	6/29/10
SIZE	DWG. NO.	REV.	
B	D1000411	v2	
SCALE	NONE	PROJECTION	
SHEET 1 OF 2			

D1000411 TMS Intermediate OSUM Support Plate, Rear, PART PDM REV: X-028, DRAWING PDM REV: X-018



DETAIL C

VIEW B-B

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MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D1000411	v2
SCALE: NONE	PROJECTION:	SHEET 2 OF 2