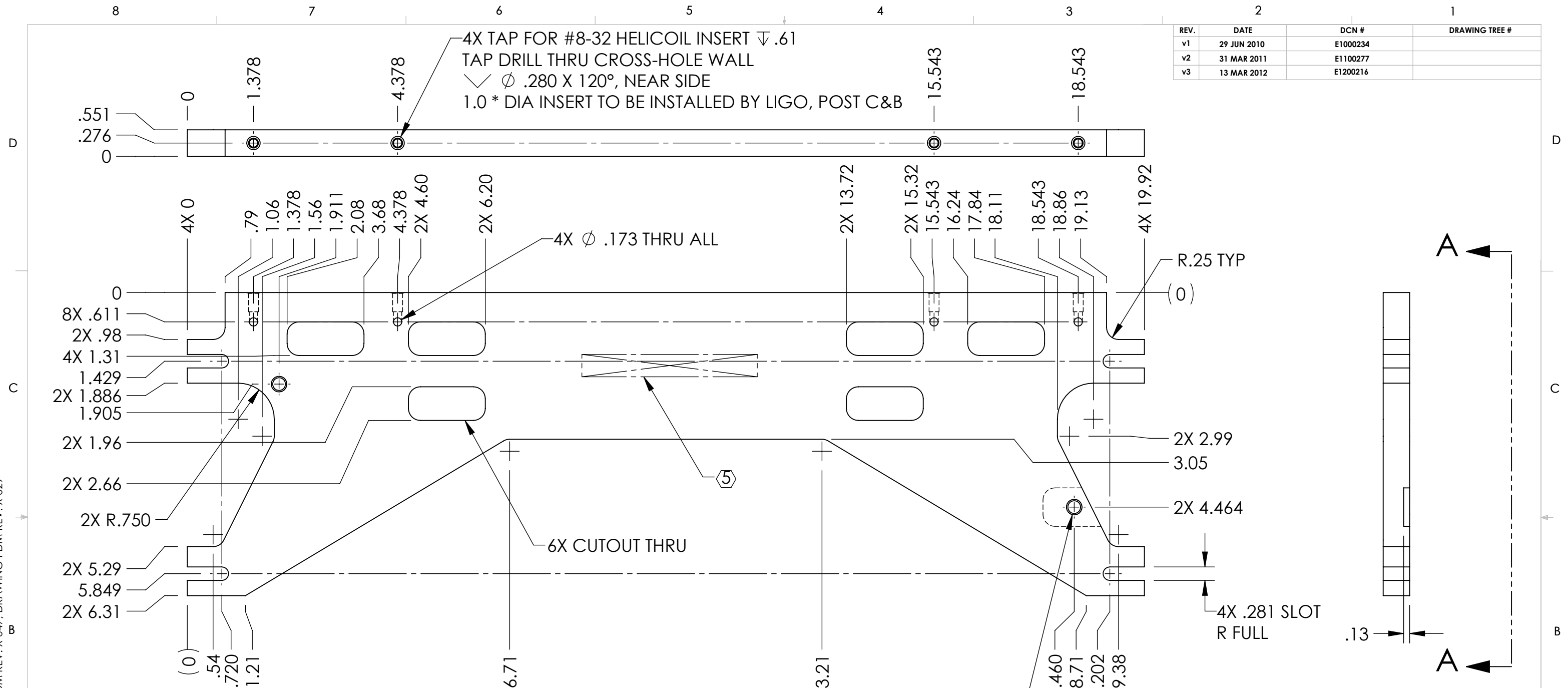


D1000411 TMS Intermediate OSUM Support Plate, Rear, PART PDM REV: X-047, DRAWING PDM REV: X-029

REV.	DATE	DCN #	DRAWING TREE #
v1	29 JUN 2010	E1000234	
v2	31 MAR 2011	E1100277	
v3	13 MAR 2012	E1200216	



NOTES (CONTINUED):

4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE, PER LIGO SPECIFICATION E0900237.
- 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. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXXX-VY, TYPE-XX, S/N XXX.
6. MASS: 1.640 KG [3.616 LB].
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. ALL HELI-COIL TAPPED HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG HC2000.
10. ALL HELICOIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NOT WELD REPAIRS OR PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING BY LIGO LABORATORY. REFER TO LIGO-E0900364.

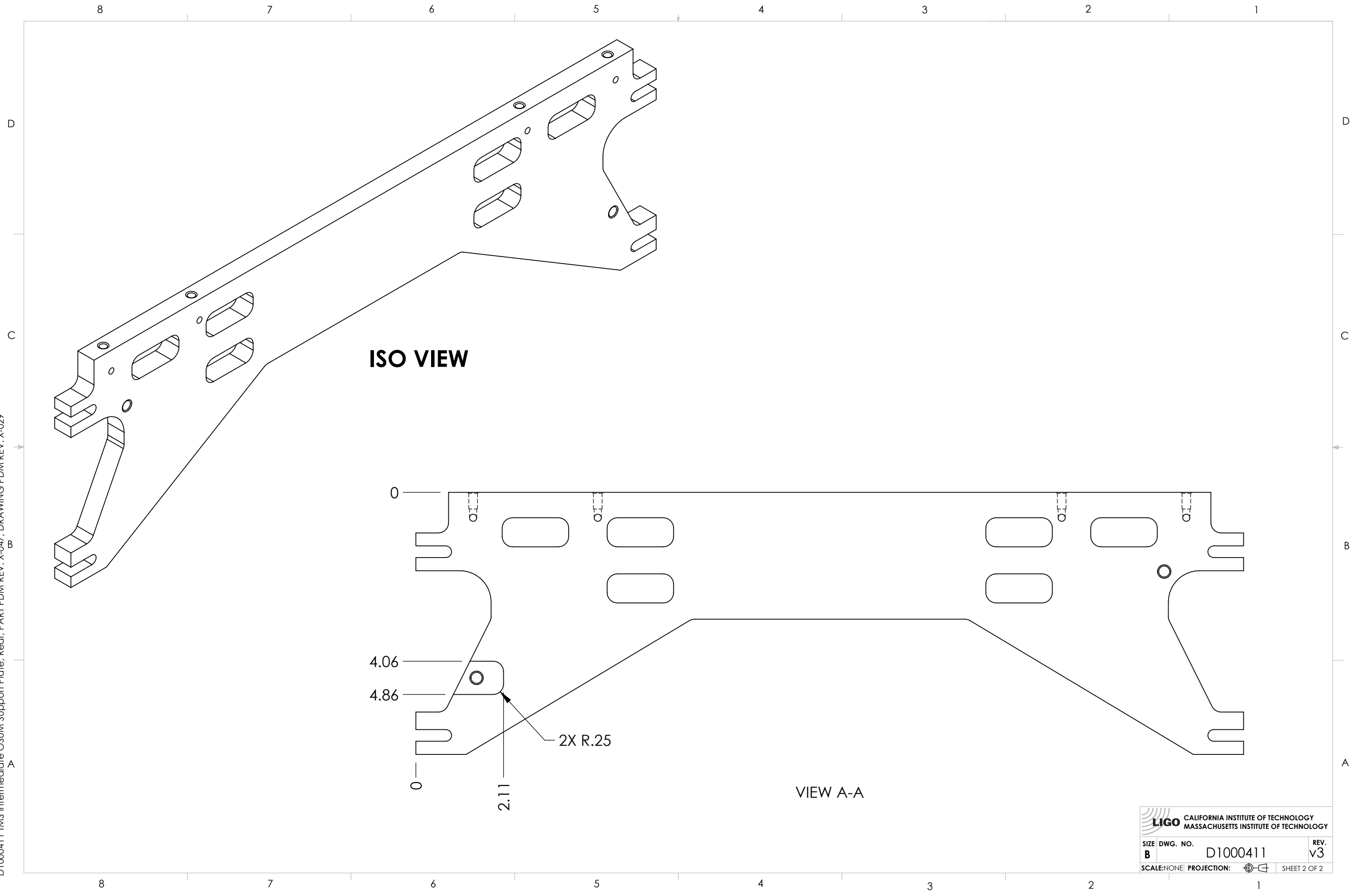
2X TAP FOR 1/4-20 HELICOIL INSERT THRU
 ✓ Ø .325 X 120°, NEAR SIDE
 ✓ Ø .325 X 120°, FAR SIDE
 1.5 * DIA INSERT TO BE INSTALLED BY LIGO, POST C&B

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.1°	
MATERIAL	6061-T6 Al
FINISH	63µinch Ra

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


PART NAME		TMS INTERMEDIATE OSUM SUPPORT PLATE, REAR	
DESIGNER	K. MAILAND	04 FEB 2010	SIZE DWG. NO.
DRAFTER	I ROMERO	29 JUN 2010	B
CHECKER	SEE DCN		D1000411
APPROVAL	SEE DCN		REV. v3
SCALE: NONE		PROJECTION:	
SHEET 1 OF 2			

D1000411 TMS Intermediate OSUM Support Plate, Rear, PART PDM REV: X-047, DRAWING PDM REV: X-029



ISO VIEW

VIEW A-A

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
B	D1000411	v3
SCALE: NONE	PROJECTION:	SHEET 2 OF 2