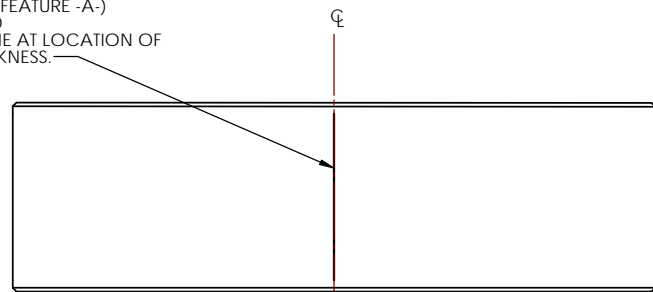
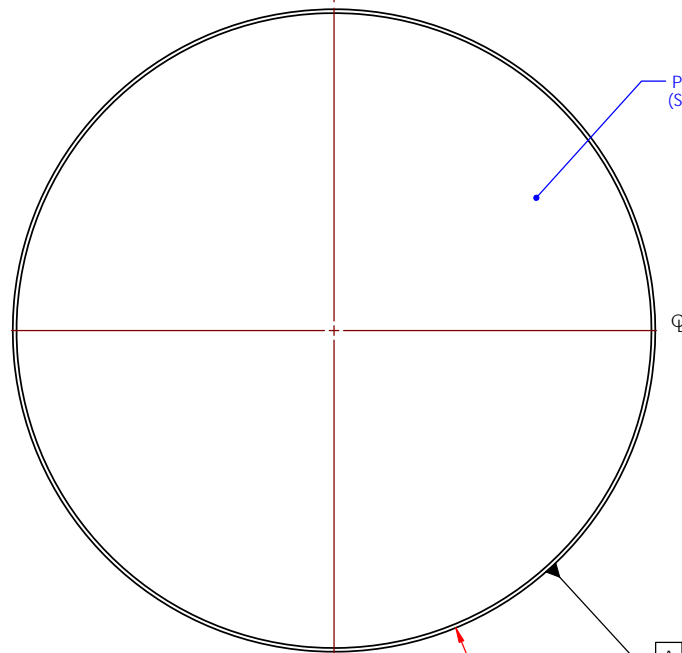


REV.	DATE	DCN #	DRAWING TREE #
v1	4/23/10	E1000139	
v2	28 MAY 2010	E1000188	

ETCH OR GRIND REGISTRATION MARKS  
 0.25mm ± 0.05mm WIDE x  
 88mm ± 3mm LONG MINIMUM LEGIBLE  
 DEPTH LINE ALONG  $\phi$ , CENTERED  
 BETWEEN SURFACES 'S1' AND 'S2', PARALLEL  
 TO THE CYLINDRICAL AXIS  
 (DEFINED BY DATUM FEATURE -A-)  
 WITHIN ±0.1mm AND  
 90° FROM SCRIBE LINE AT LOCATION OF  
 MINIMUM PART THICKNESS.



TOP VIEW



$\phi 340.00 \pm 0.25$   
 0.1  
 0.18 B

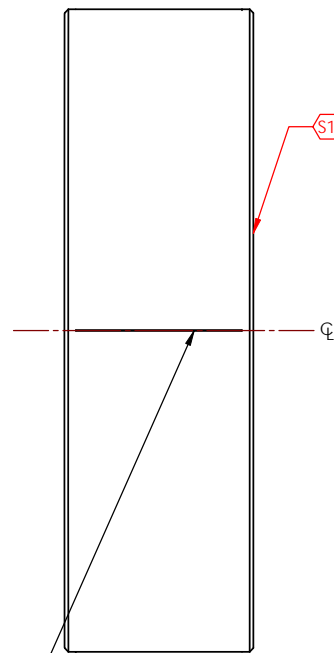
2X, ± 0.2 x 45° ± 5° CHAMFER,  
 ALL AROUND

S3 BARREL SIDE AND BEVEL POLISH  
 (SEE NOTE 3)

.04<sup>+</sup>.04<sup>-</sup>  
 -.03°  
 WEDGE ANGLE

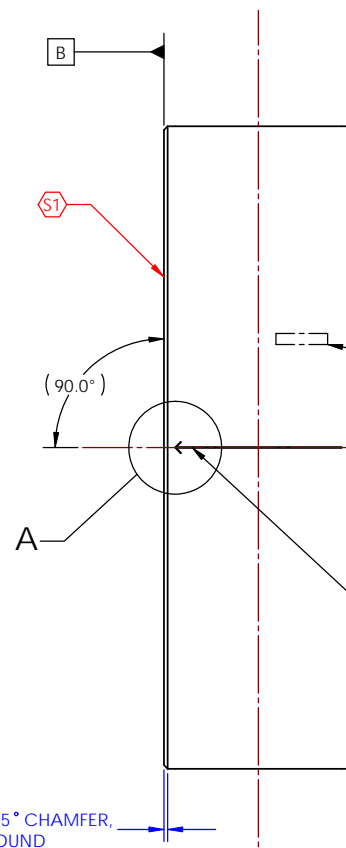
ETCH OR GRIND REGISTRATION MARKS  
 0.25mm ± 0.05mm WIDE x  
 88mm ± 3mm LONG MINIMUM LEGIBLE  
 DEPTH LINE ALONG  $\phi$ , CENTERED  
 BETWEEN SURFACES 'S1' AND 'S2', PARALLEL  
 TO THE CYLINDRICAL AXIS  
 (DEFINED BY DATUM FEATURE -A-)  
 WITHIN ±0.1mm AND  
 90° FROM SCRIBE LINE AT LOCATION OF  
 MINIMUM PART THICKNESS.

BOTTOM VIEW



ETCH OR GRIND REGISTRATION MARKS  
 0.25mm ± 0.05mm WIDE x  
 88mm ± 3mm LONG MINIMUM LEGIBLE  
 DEPTH LINE ALONG  $\phi$ , CENTERED  
 BETWEEN SURFACES 'S1' AND 'S2', PARALLEL  
 TO THE CYLINDRICAL AXIS  
 (DEFINED BY DATUM FEATURE -A-)  
 WITHIN ±0.1mm AND  
 180° FROM SCRIBE LINE AT LOCATION OF  
 MINIMUM PART THICKNESS.

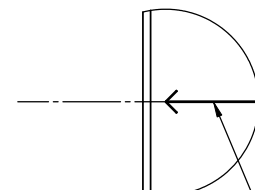
100.0 ± 0.5



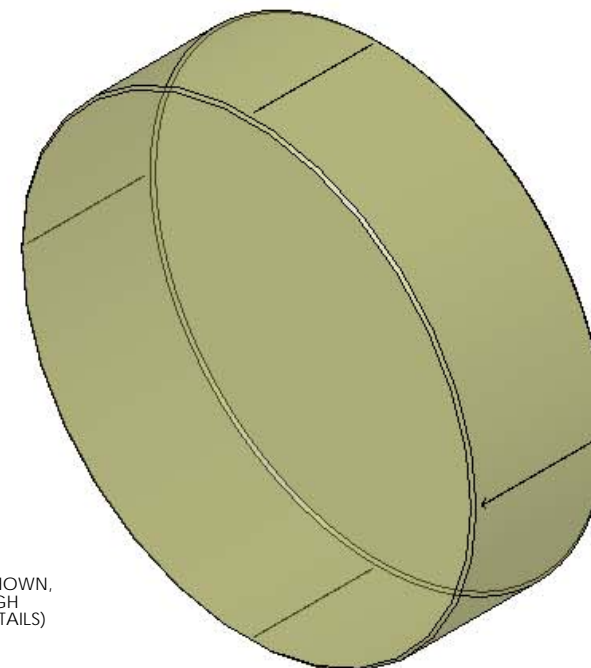
ETCH OR GRIND SERIAL  
 NUMBER, APPROX. WHERE SHOWN,  
 LETTERING APPROX. 4mm HIGH  
 (SEE NOTE 5 FOR FURTHER DETAILS)

S2 POLISH SURFACE 'S2'  
 (SEE NOTE 4)

ETCH OR GRIND REGISTRATION MARKS  
 0.25mm ± 0.05mm WIDE x  
 88mm ± 3mm LONG MINIMUM LEGIBLE  
 DEPTH LINE ALONG  $\phi$ , CENTERED  
 BETWEEN SURFACES 'S1' AND 'S2' AT  
 LOCATION OF MINIMUM PART THICKNESS  
 WITHIN ± 5° CLOCKING ANGLE  
 (WITH RESPECT TO DATUM FEATURE -A-),  
 AND PARALLEL TO THE CYLINDRICAL AXIS  
 (DEFINED BY DATUM FEATURE -A-)  
 WITHIN ±0.1mm, WITH ARROW POINTING  
 TO SURFACE 'S1'.



DETAIL A  
 SCALE 1 : 1



"THIN COMPENSATION PLATE"  
 TCP

MANUFACTURING NOTES:

- DO NOT SCALE FROM DRAWING.
- INTERPRET DRAWING AS PER ANSI Y14.5M 1994.
- BARREL SIDE AND BEVEL POLISH PER E1000158.
- FINISH SURFACES 'S1' AND 'S2' AS PER E1000158.
- REFER TO E1000158 OR MORE INFORMATION ON SERIAL NUMBER.
- APPLY COATING PER E0900074.
- APPLY BARREL GOLD COATING PER E0900112.
- APPLY ESD GOLD COATING PER E0900113.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN MILLIMETERS

TOLERANCES:  
 X ± .10  
 XX ± .25

ANGULAR ± 0.1°

SEE MANUFACTURING NOTES

MATERIAL REFER TO E080037

FINISH SEE NOTES

CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM COC

NEXT ASSY D1000980

PART NAME THIN COMPENSATION PLATE (TCP) SUBSTRATE

DESIGNER	K. BUCKLAND	4/23/10	SIZE	DWG. NO.	REV.
DRAFTER	K. BUCKLAND	22 APR 2010		D1000979	v2
CHECKER	C. TORRE	5/4/10			
APPROVAL	G. BULLINGSLEY	5/4/10	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1

D1000979 ALIGO COC TCP SUBSTRATE, PART PDM REV. X.003, DRAWING FROM REV. X.002