

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

6. APPROXIMATE WEIGHT = 35.96 LB (16.31 KG).

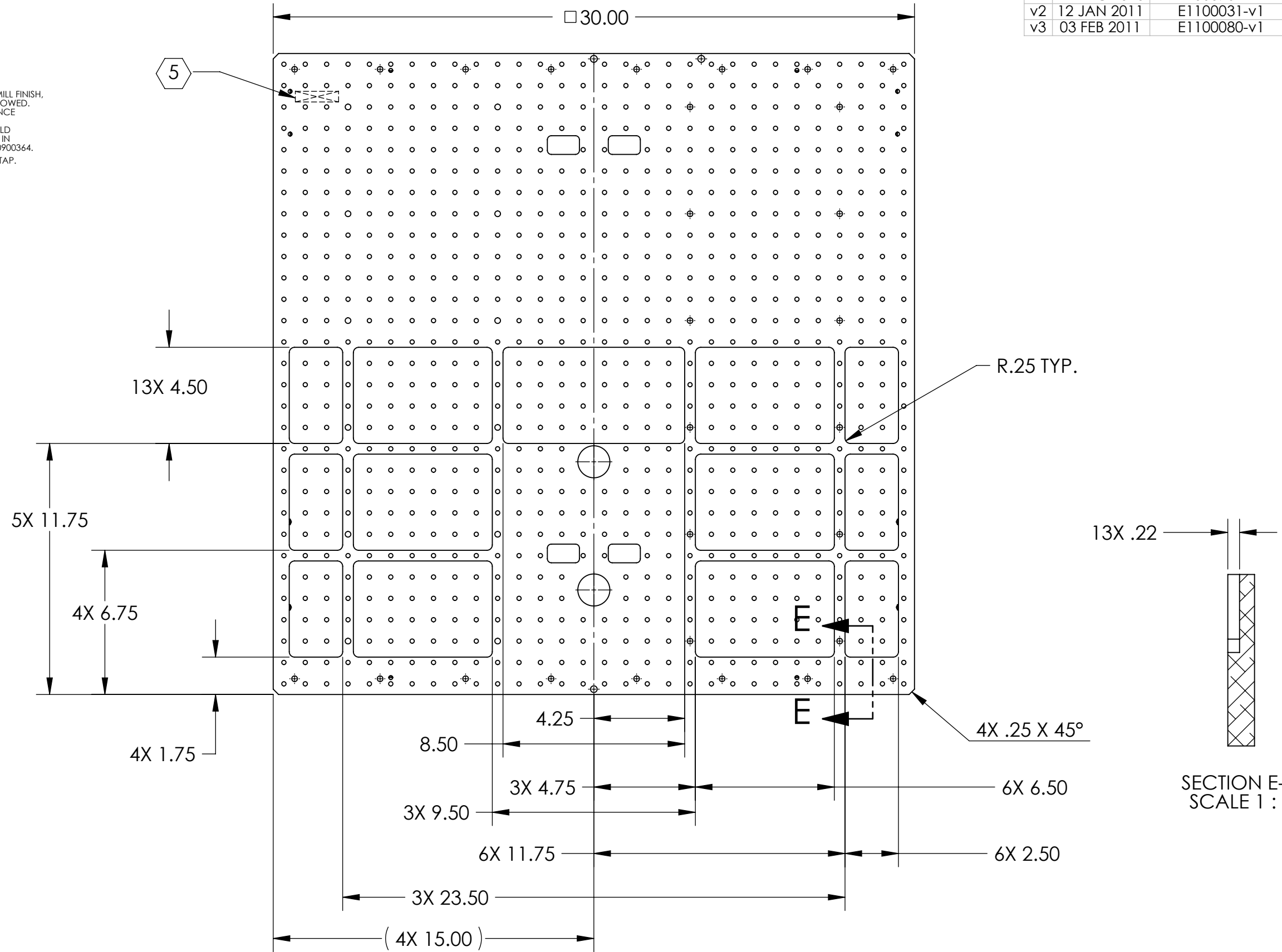
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO). REFER TO LIGO SPECIFICATION E0900364.

10. ALL TAPPED HOLES: .005" OVERSIZE BOTH DRILL AND TAP. SEE SHEET 2.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 DEC 2010	E1000762-v1	-
v2	12 JAN 2011	E1100031-v1	-
v3	03 FEB 2011	E1100080-v1	-

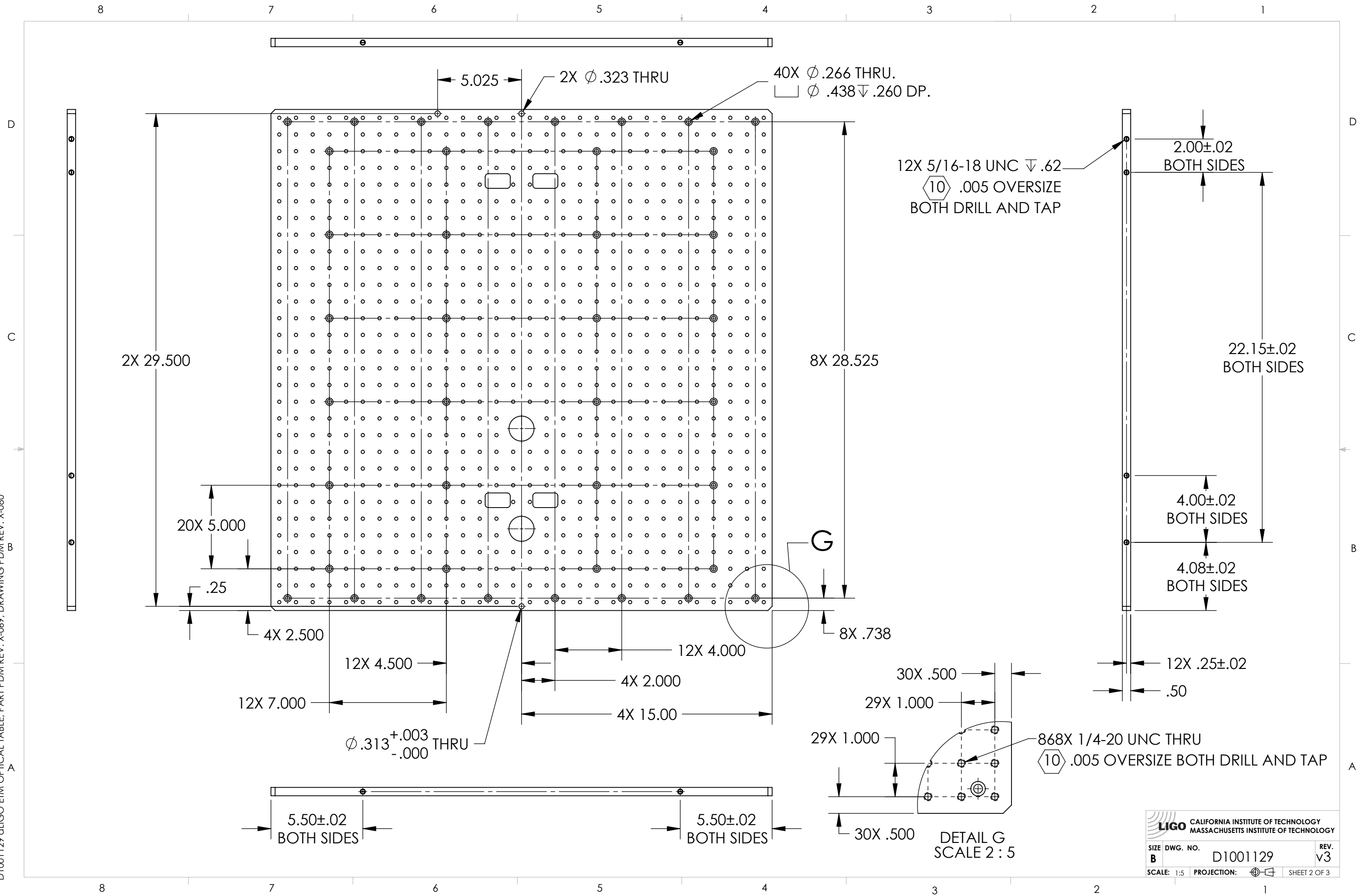


D1001129 aLIGO ETM OPTICAL TABLE, PART PDM REV: X-069, DRAWING PDM REV: X-080

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± 1.0°	
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.	
MATERIAL	6061-T6 Al
FINISH	63 μinch Ra

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		aLIGO ETM OPTICAL TABLE	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	AOS	DESIGNER	K. MAILAND 10/09/2010
NEXT ASSY	D1001160	CHECKER	M. MILLER 11/09/2010	SIZE	DWG. NO.
		APPROVAL		B	D1001129
				SCALE: 1:5	PROJECTION: SHEET 1 OF 3
				REV.	v3

D1001129 dLIGO EIM OPTICAL TABLE, PART PDM REV: X-069, DRAWING PDM REV: X-080

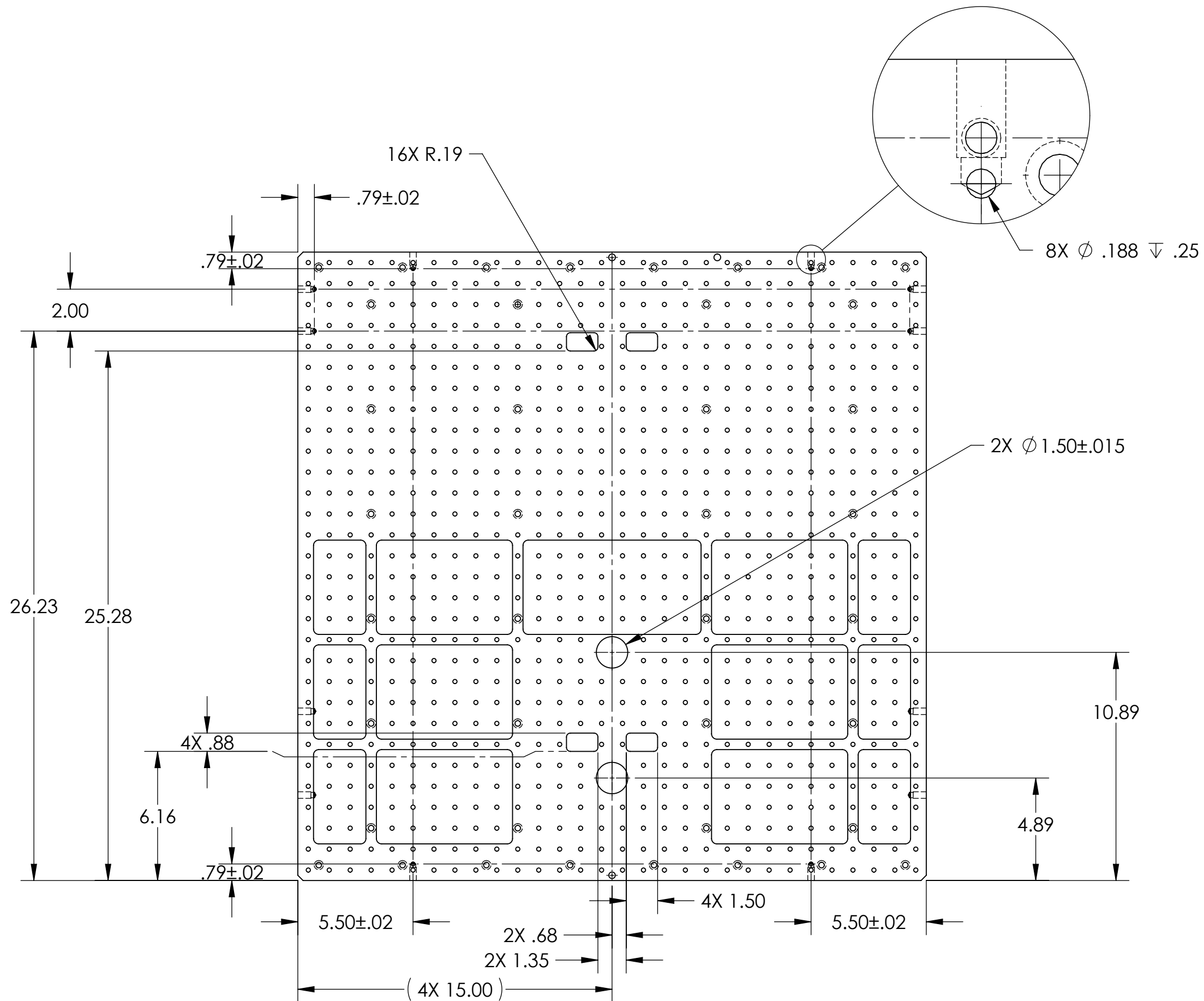


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SIZE	DWG. NO.	REV.
B	D1001129	v3
SCALE: 1:5	PROJECTION:	SHEET 2 OF 3

DETAIL G
SCALE 2:5

D1001129 dLIGO EIM OPTICAL TABLE, PART PDM REV: X-069, DRAWING PDM REV: X-080



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SIZE	DWG. NO.	REV.
B	D1001129	v3
SCALE: 1:5	PROJECTION:	SHEET 3 OF 3