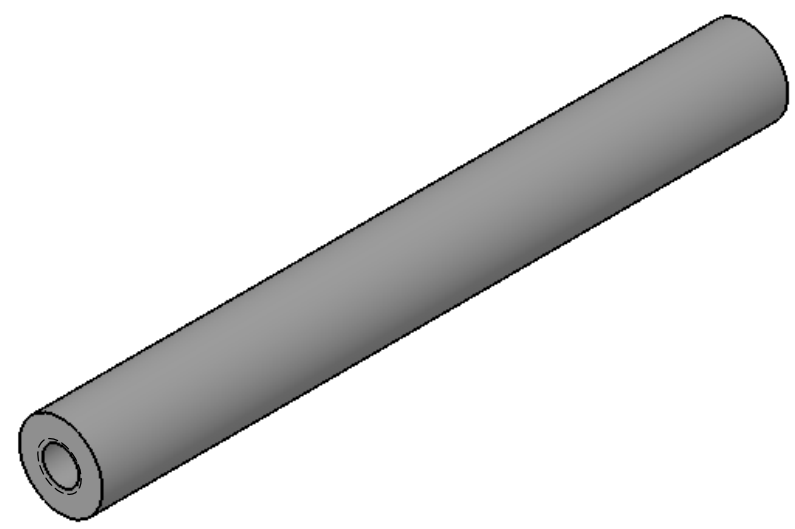


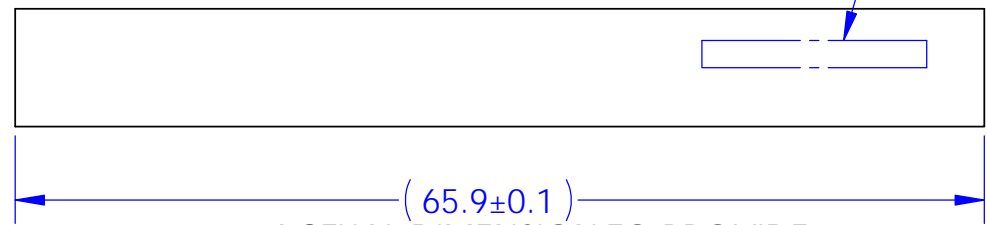
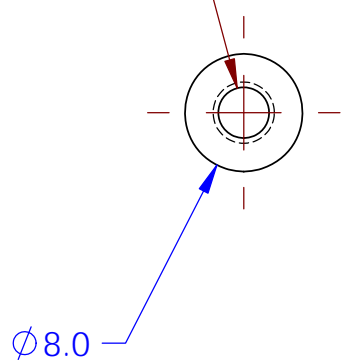
8 7 6 5 4 3 2 1

**NOTES CONTINUED:**  
 ⑤ SCRIBE, ENGRAVE, 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: DXXXXXX-VY, TYPE-XX, S/N XXX

REV.	DATE	DCN #	DRAWING TREE #
v3	8 NOV 2013	E1300849	-
-	-	-	-
-	-	-	-

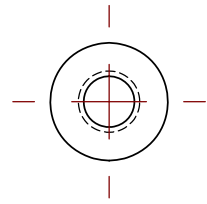


8-32 UNC -2B  $\nabla$  8  
 +0.005 OVERSIZE TAP,  
 BOTH SIDES



ACTUAL DIMENSION TO PROVIDE  
 LOOSE FIT IN D1002149,BS/FM  
 PRISM BONDING BASE PLATE.  
 aLIGO LLO ACTUAL = 64.9mm  
 aLIGO LHO ACTUAL = 65.2mm

SEE NOTE ⑤



D1002151\_aLIGO\_BSFM\_PRISM\_BONDING\_SUPPORT\_CYLINDER, PART PDM REV: X-000, DRAWING PDM REV: X-001

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN MILLIMETERS				LIGO		Bonding Jig Support Cylinder	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.5 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.				SYSTEM	aLIGO SUS	SUB-SYSTEM	BS/FM
TOLERANCES: .X ± 0.1 .XX ± 0.05				NEXT ASSY	D1002148	DESIGNER	M.V.VEGGEL
ANGULAR ± 0.2°						DATE	AUG 2010
MATERIAL				PTFE (general)		FINISH	1.6 µm
						SIZE	DWG. NO.
						B	D1002151
						REVISION	-v3
						SCALE	2:1
						PROJECTION	ASME
						SHEET 1 OF 1	

8 7 6 5 4 3 2 1