

**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 = 0.020 LBS.

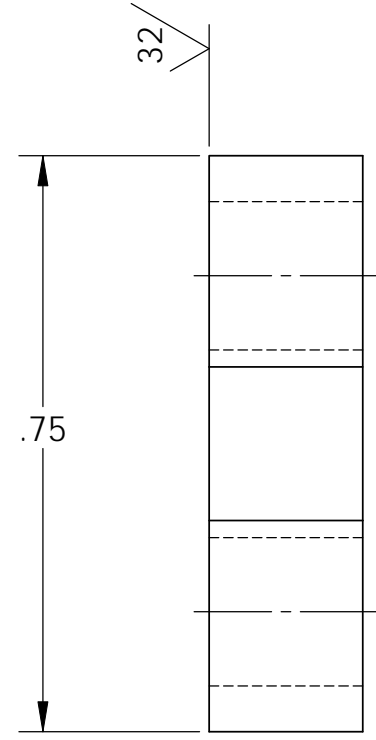
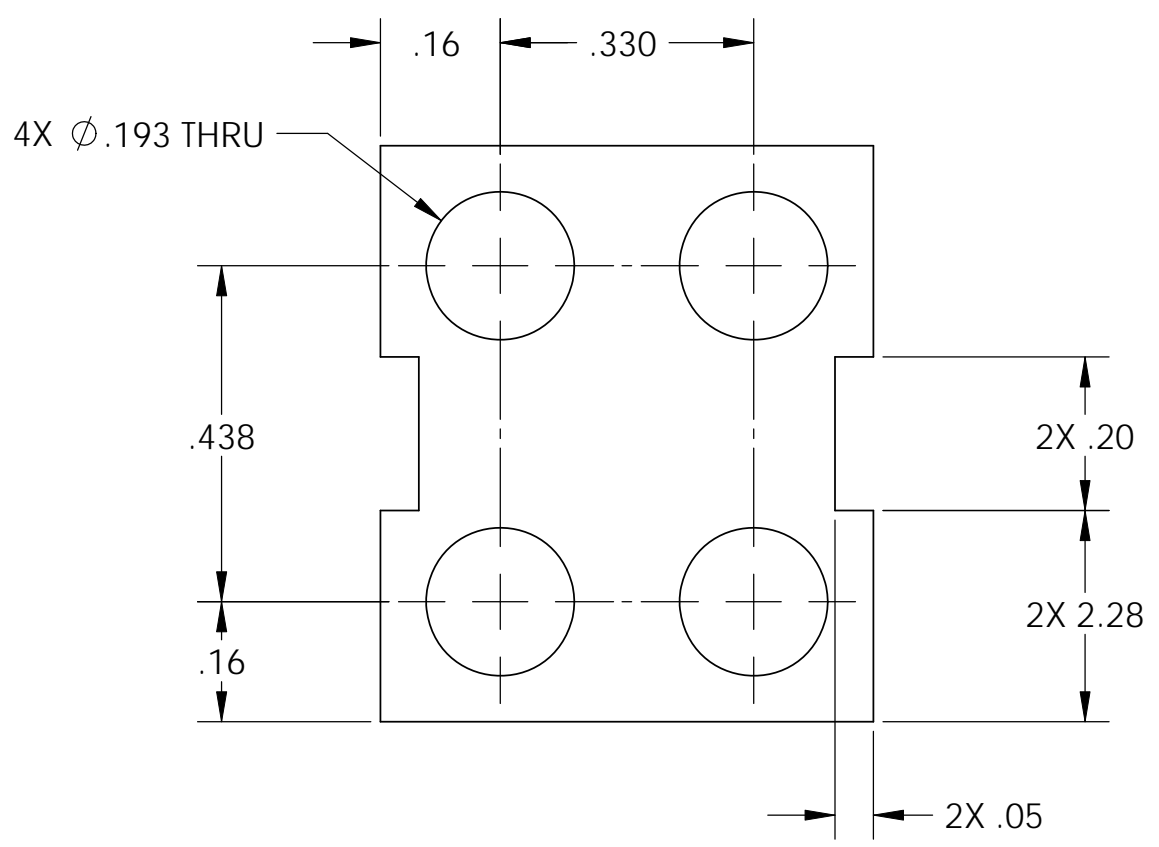
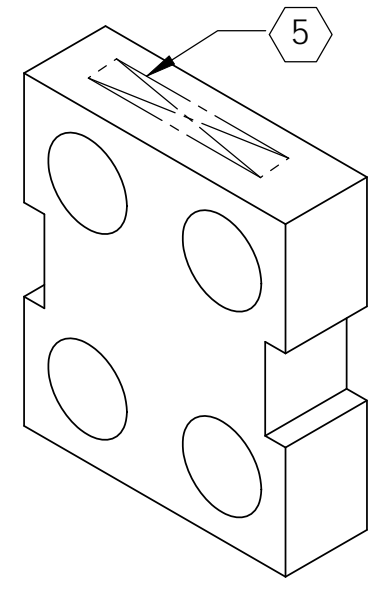
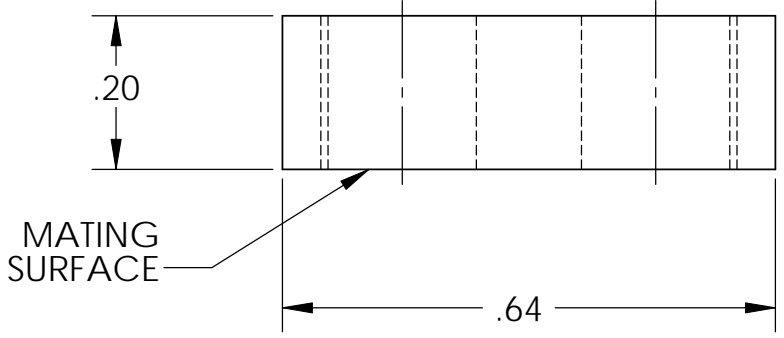
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

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

9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

⑩ SURFACE FINISH ON ALL PART TO BE 63  $\mu$ inch Ra EXCEPT WHERE SPECIFIED.

REV.	DATE	DCN #	BOM #
v1	22 JUN 2011	E1100351	E1100626
-	-	-	-
-	-	-	-



D1002239 aLIGO TMS Tele Wire Clamp Jaw, PART PDM REV: X-006, DRAWING PDM REV: X-000

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				PART NAME	
DIMENSIONS ARE IN INCHES		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWINGS. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		aLIGO TMS TELESCOPE WIRE CLAMP JAW	
TOLERANCES: .XX ± .02 .XXX ± .010		MATERIAL 304 SSSL		FINISH ⑩ $\mu$ inch Ra	
ANGULAR ± 1.0°		NEXT ASSY D1101162		SCALE: 4:1	
		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
		DESIGNER K. MAILAND		18 AUG 2010	
		DRAFTER J. TERRAZAS		22 JUN 2011	
		CHECKER		APPROVAL	
		DWG. NO. D1002239		REV. v1	
		PROJECTION:		SHEET 1 OF 1	