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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 = .23 LB [.10 KG].

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

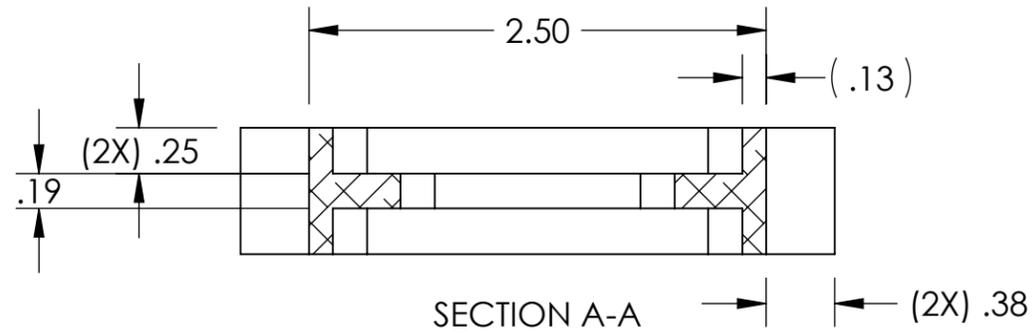
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE. THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS. REFER TO LIGO-E0900364.

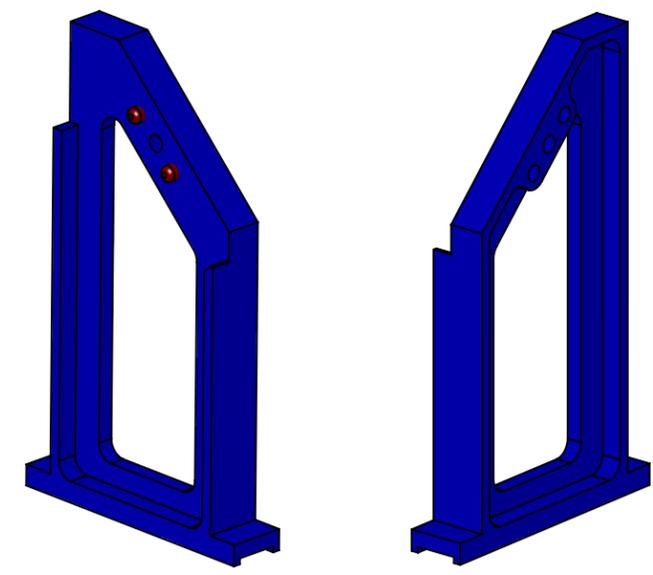
10. NOTED HOLE: .005" OVERSIZE BOTH DRILL & TAP.

11. AT NOTED LOCATIONS, DRILL THRU FOR 3/16 DOWEL PIN, LIGHT PRESS FIT (LPF). PINS TO BE INSTALLED BY LIGO, AS NOTED, POST CLEAN & BAKE. INSTALL MCMASTER-CARR P/N 97395A455 OR EQUIVALENT.

12. FOR FIRST ARTICLE (S/N 001): PINS ARE PRE-INSTALLED (BEFORE CLEAN & BAKE). DO NOT REMOVE.



REV.	DATE	DCN #	DRAWING TREE #
v1	25 APR 2011	E1100351-v1	-
-	-	-	-
-	-	-	-



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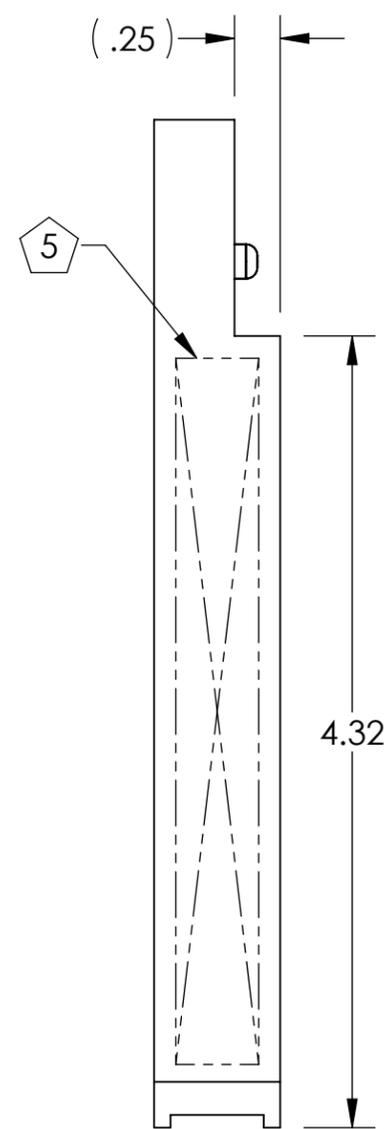
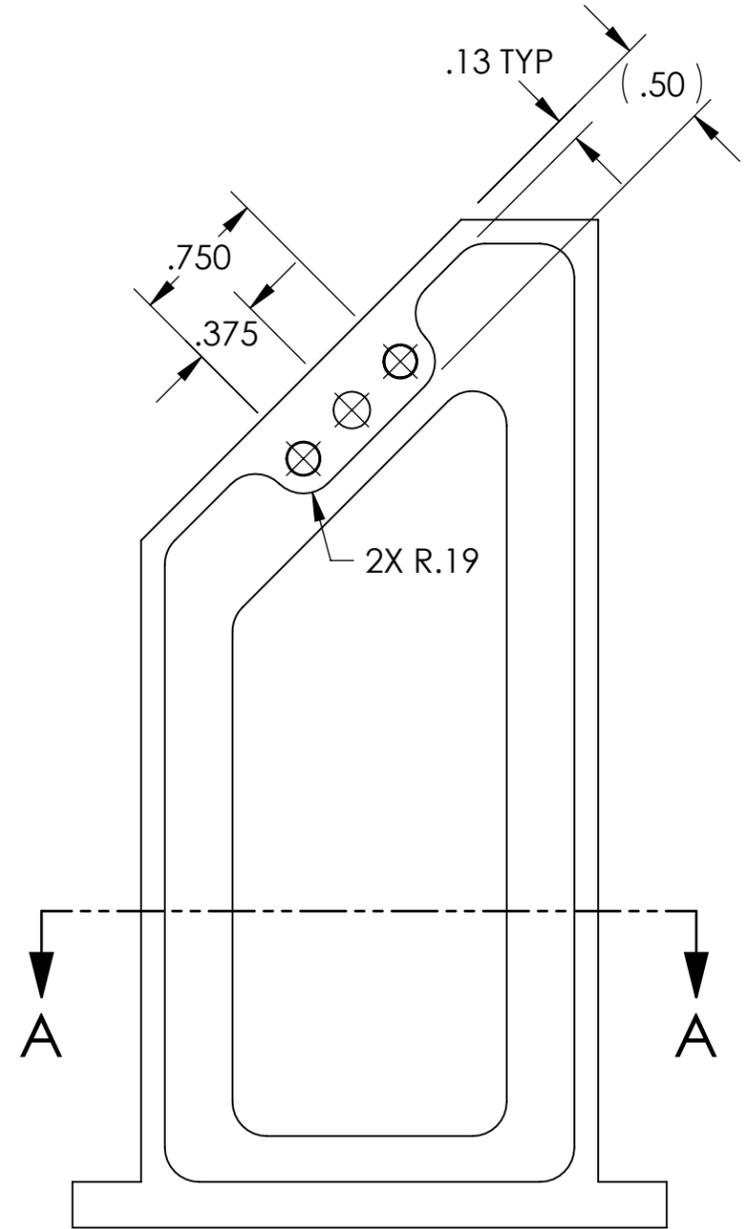
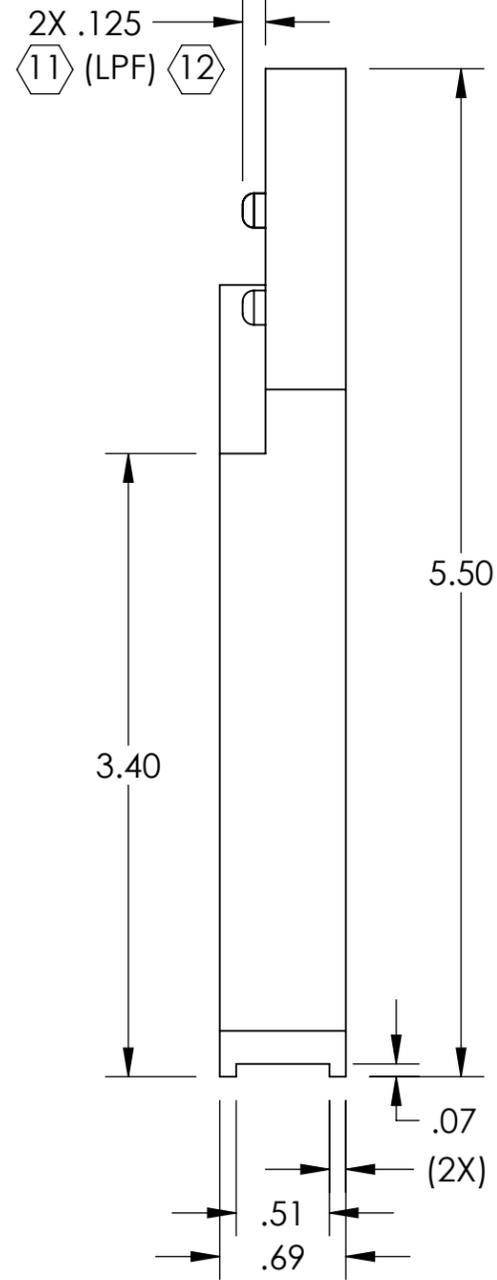
C

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NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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.

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .01
 .XXX ± .005

ANGULAR ± 0.5°

MATERIAL		FINISH		NEXT ASSY	
6061-T6 Al		63 μinch Ra		D1000484	

DESIGNER		DATE		SIZE		DWG. NO.		REV.	
I. ROMERO		23 SEP 2010		B		D1002504		v1	
DRAFTER		DATE		SCALE		PROJECTION		SHEET	
M. MILLER		25 APR 2011		NONE		FIRST ANGLE		1 OF 2	

D1002504 TMS, SISKIYOU MOUNT BRACKET, LOWER OUTBOARD, PART PDM REV: X-013, DRAWING PDM REV: X-010

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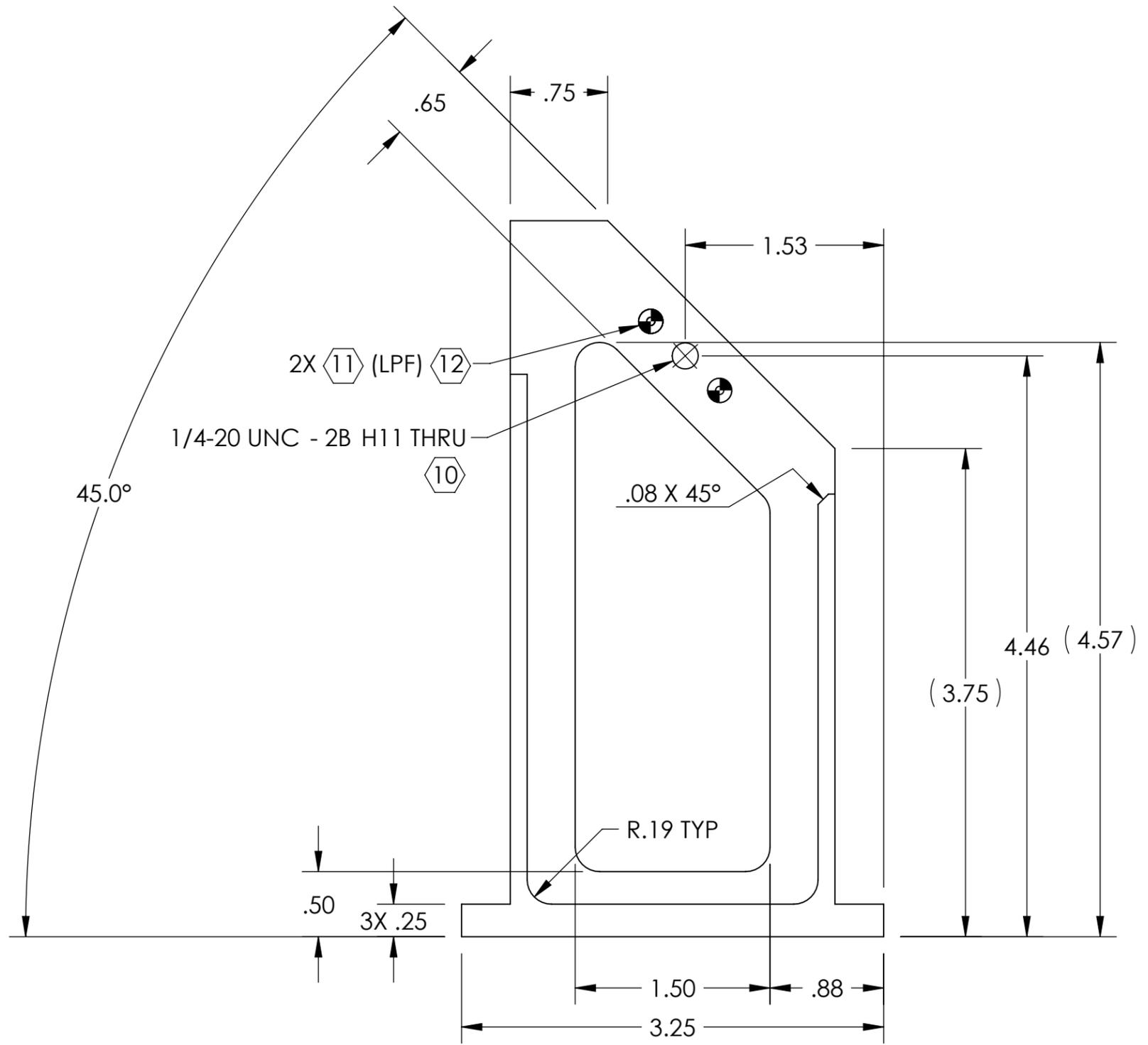
4

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D1002504 TMS, SISKIYOU MOUNT BRACKET, LOWER OUTBOARD, PART PDM REV: X-013, DRAWING PDM REV: X-010



VIEW B-B

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
B	D1002504	v1
SCALE: NONE	PROJECTION:	SHEET 2 OF 2