

REV.	DATE	DCN #	DRAWING TREE #
v2	16 FEB 2011	E1000883-v2	E1000884-v2

ASSEMBLY STEP #4
EL PIVOT PLATE IS SECURED TO MIRROR USING ASSOCIATED HARDWARE PER E1000884

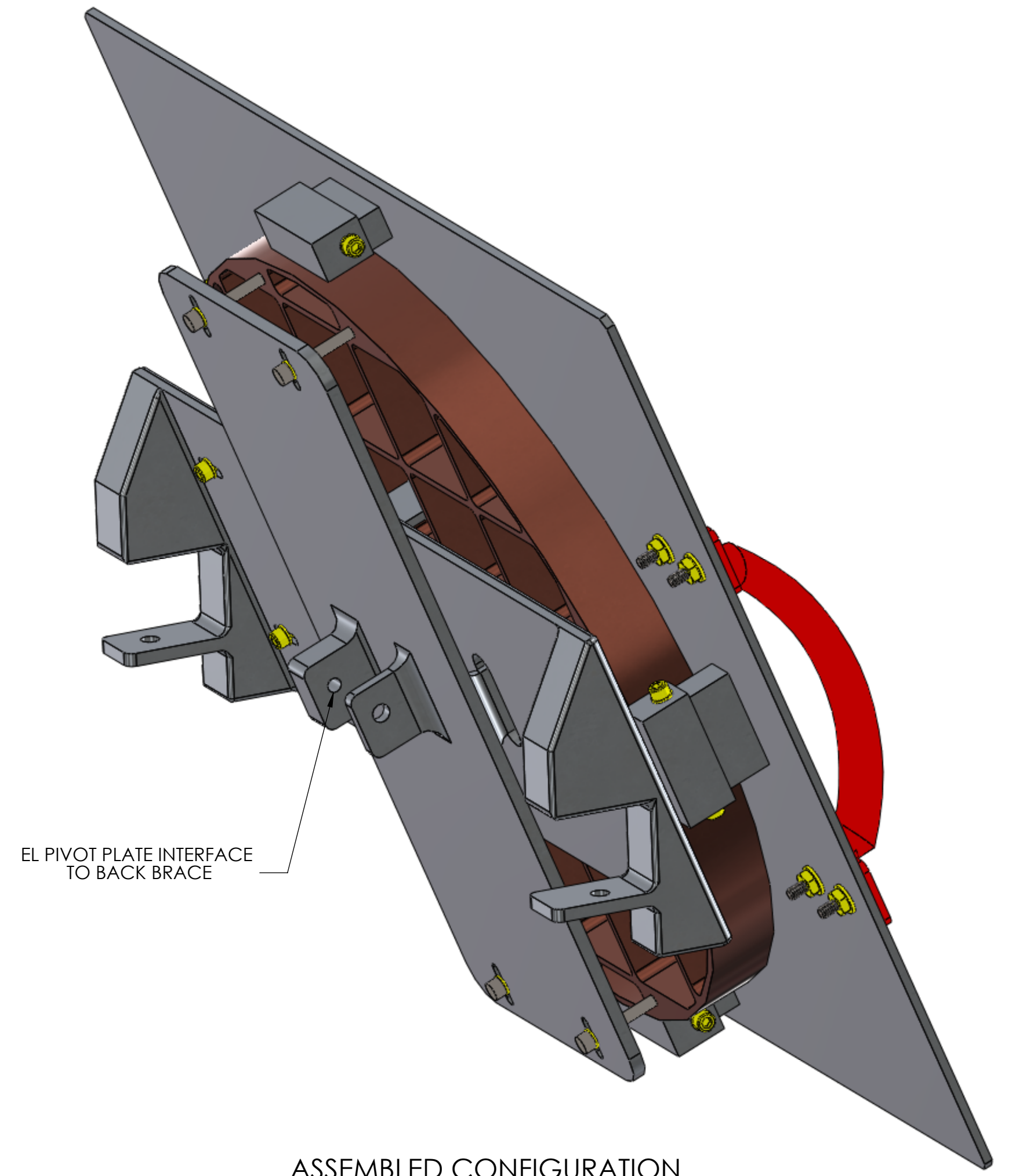
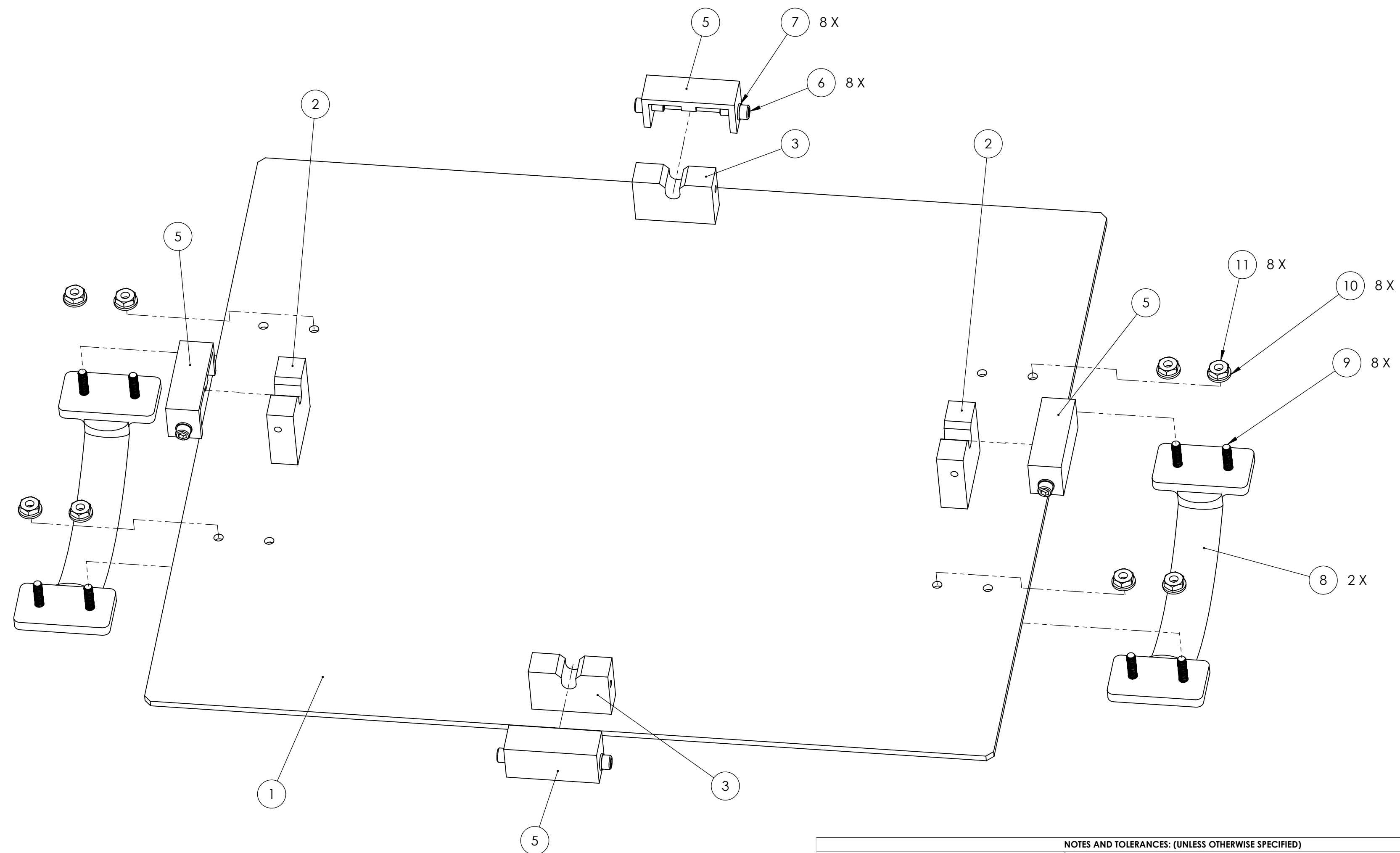
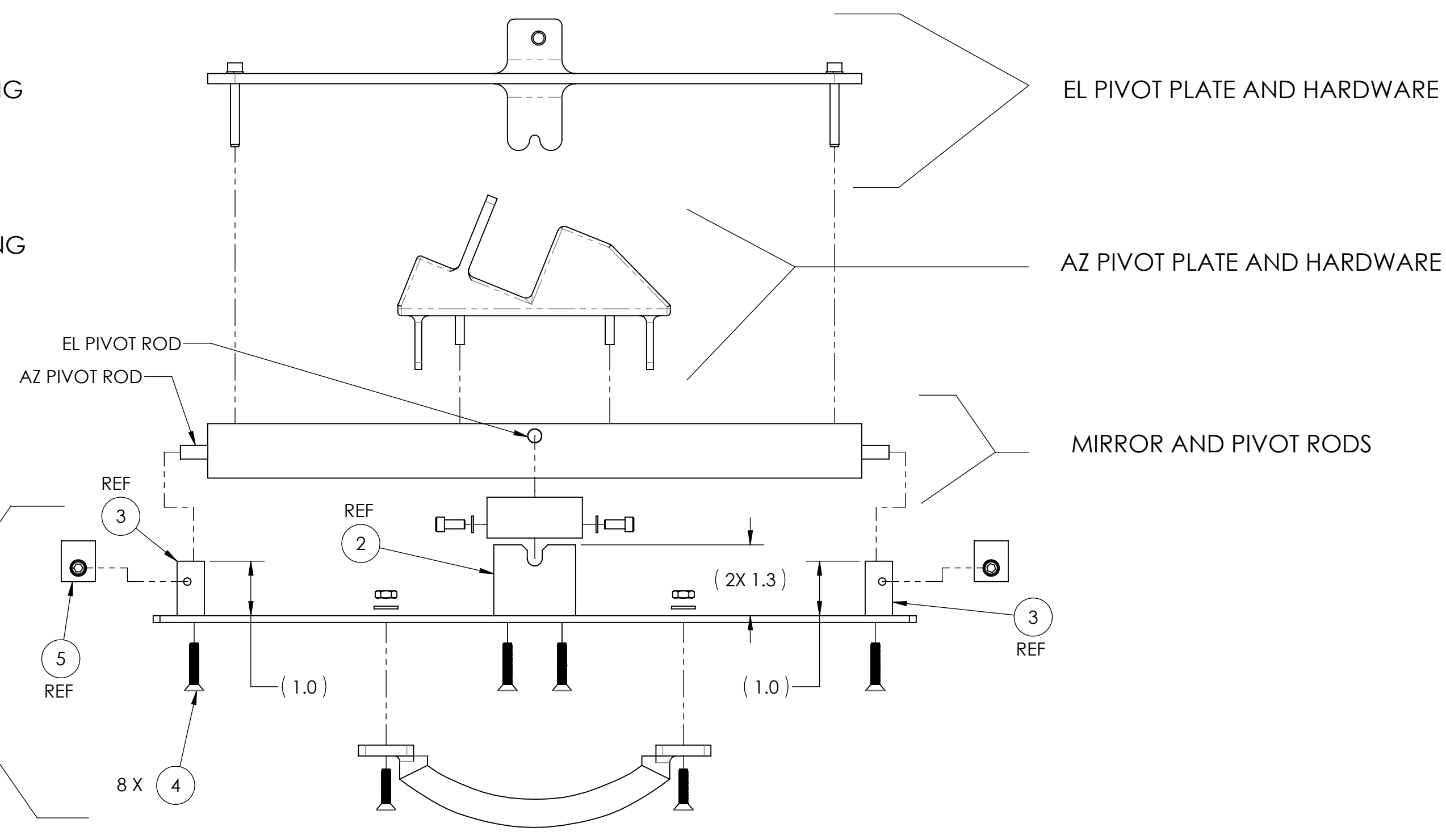
ASSEMBLY STEP #3
AZ PIVOT PLATE IS SECURED TO MIRROR USING ASSOCIATED HARDWARE PER E1000884

ASSEMBLY STEP #1
EL PIVOT ROD RESTS ONTO ITEM 2
AZ PIVOT ROD RESTS ONTO ITEM 3

ASSEMBLY STEP #2
SECURE ITEM 5 TO ITEMS 2 AND 3 USING ITEMS 6 AND 7

ASSEMBLY FIXTURE STEP #0
ITEM 4 SECURES ITEMS 2 AND 3 ONTO ITEM 1

ASSEMBLY STEP #5
SECURE ITEM 8 TO ITEM 1 USING ITEMS 9, 10, 11



ASSEMBLED CONFIGURATION FOR PLACING MIRROR ASSEMBLY WITHIN PARENT ASSEMBY, EITHER D1001742 OR D1002431

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	Default/REQ	SPARE	TOTAL
11	N-832	HEX NUT, #8-32	18-8 SSSL, UC COMPONENTS	8		8
10	96659A103	WASHER, FLAT, #8 (MS 15795 OR EQUIVALENT)	18-8 SSSL, MCMMASTER	8		8
9	FA-812-N	FHSCS 8-32 x 3/4 LONG	18-8 SSSL, UC COMPONENTS	8		8
8	OTS, HOME DEPOT	HANDLE, 5 IN	304, 316 OR 302 SSSL	2		2
7	WF-08	WASHER, FLAT, #8 (NAS 620-C8 OR EQUIVALENT)	18-8 SSSL, UC COMPONENTS	8		8
6	C-806-N	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 0.375 LONG, FULLY THREADED	18-8 SSSL, UC COMPONENTS	8		8
5	D1100285	ALIGO TCS FIXTURE RETAINER	6061 Alloy	4		4
4	FA-808-N	FHSCS 8-32 x 1/2 LONG	18-8 SSSL, UC COMPONENTS	8		8
3	D1100267	ALIGO TCS FIXTURE SHORT SUPPORT GUSSET, H2 UHV STEERING MIRROR ASSY	6061 Alloy	2		2
2	D1100266	ALIGO TCS FIXTURE TALL SUPPORT GUSSET	6061 Alloy	2		2
1	D1100265	ALIGO TCS FIXTURE BASE PLATE, H2 UHV STEERING MIRROR ASSEMBLY	6061 Alloy	1		1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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 DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

TOLERANCES:
 .XX ± .01
 .XXX ± .005

ANGULAR ± 0.5°

MATERIAL N/A **FINISH** N/A μinch

LOGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO **SUB-SYSTEM** AOS

NEXT ASSY D1001742, D1002431

PART NAME ALIGO TCS FIXTURE, H2 UHV MIRROR ASSEMBLY

DESIGNER M. JACOBSON	10 FEB 2011	SIZE DWG. NO.	D1100263	REV. v2
DRAFTER M. JACOBSON	11 FEB 2011	D		
CHECKER J. LEWIS	15 FEB 2011			
APPROVAL P. WILLEMS	16 FEB 2011	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1

D1100265_ALIGO TCS FIXTURE, H2 UHV STEERING MIRROR ASSY, PART PDM REV. X-034, DRAWING PDM REV. X-009