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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 = 5.55 LB [2.52 KG].

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

8. 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.

9 MATERIAL: 2" X 5" RECTANGULAR TUBING, 1/8" WALL, SHARP CORNERED, 6061-T6 ALUMINUM ALLOY.

10 SPECIFIED FINISH APPLIES ONLY TO MACHINED SURFACES, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364.

11 ELECTRO-POLISH CUT & DRILLED PART PER LIGO SPECIFICATION E0900364, SECTION 5.1.2. PRE-ELECTRO-POLISHED SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

| REV. | DATE | DCN # | DRAWING TREE # |
|------|-------------|----------|----------------|
| v1 | 01 MAR 2011 | E1100086 | - |
| v2 | 30 JAN 2012 | E1100351 | - |
| - | - | - | - |

D

D

C

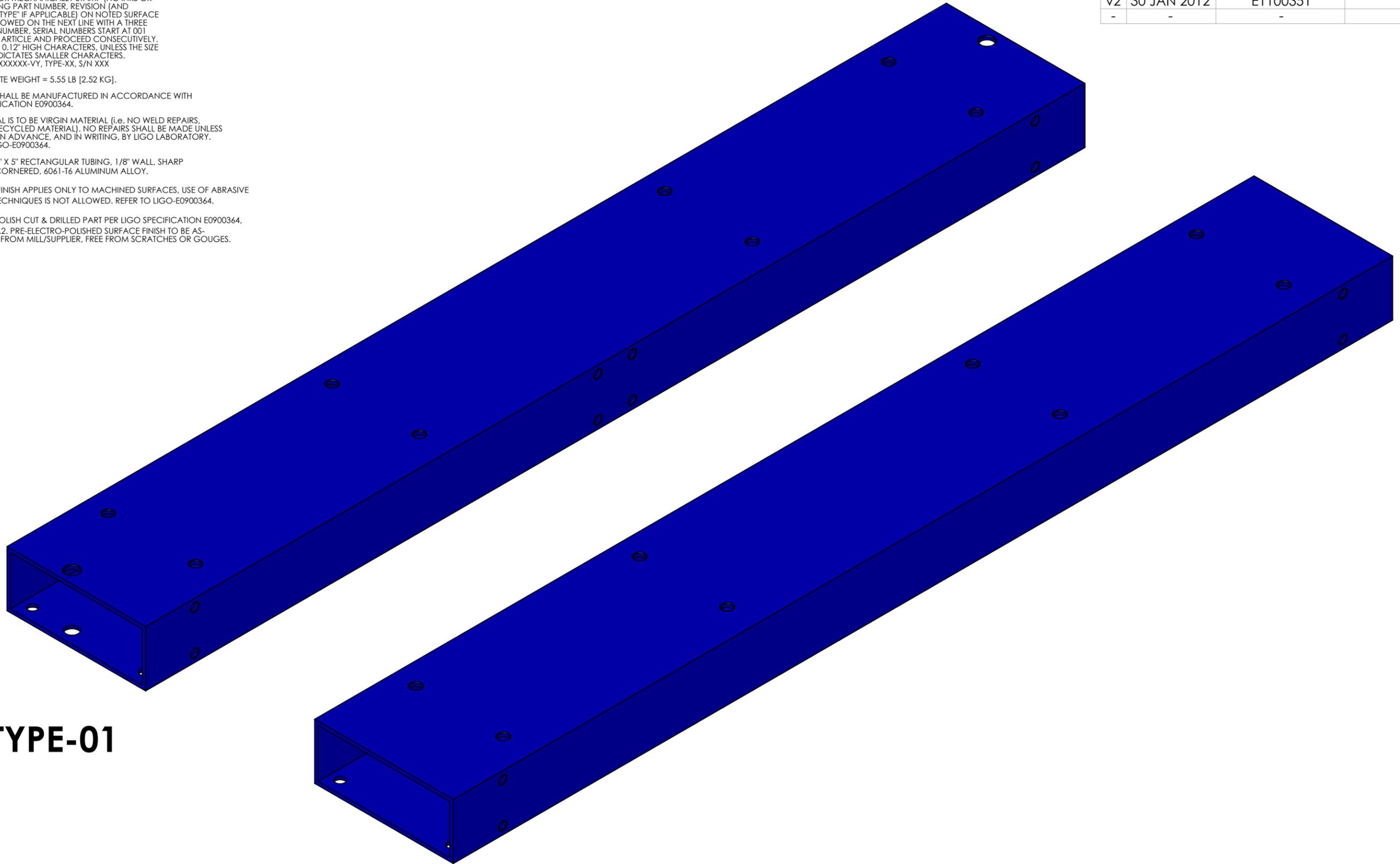
C

B

B

A

A



TYPE-01

TYPE-02

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± 0.5°

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.

MATERIAL



FINISH

63 μinch Ra



NEXT ASSY

D1101130

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO

SUB-SYSTEM AOS

PART NAME TMS TELESCOPE SAFETY SUPPORT BEAM

DESIGNER C. CONLEY 10 FEB 2011

DRAFTER C. CONLEY 22 FEB 2011

CHECKER SEE DCN

APPROVAL SEE DCN

SIZE DWG. NO. B D1100264

REV. v2

SCALE: NONE PROJECTION: 1st ANGLE SHEET 1 OF 2

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D1100264 TMS Telescope Safety Support Beam, PART PDM REV: X-058, DRAWING PDM REV: X-029

D1100264 TMS Telescope Safety Support Beam, PART PDM REV: X-058, DRAWING PDM REV: X-029

