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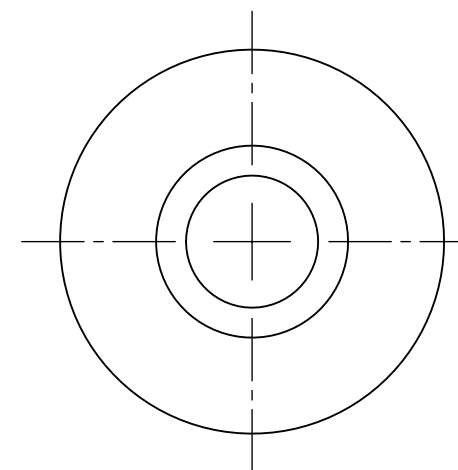
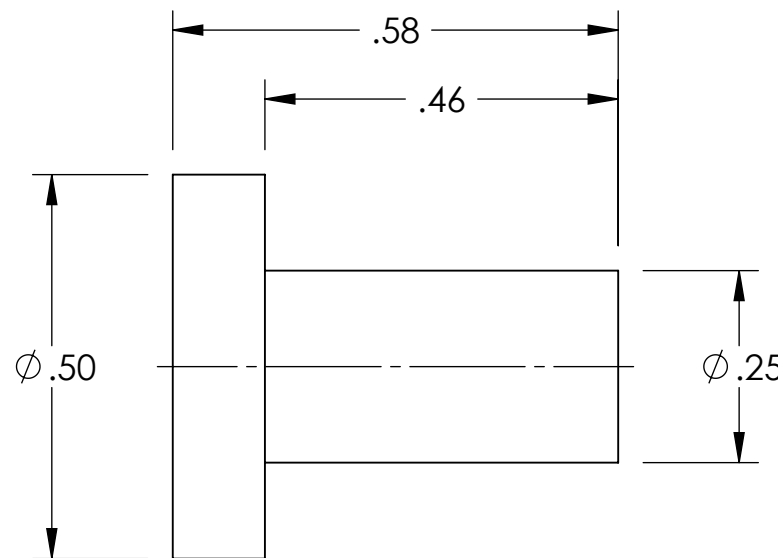
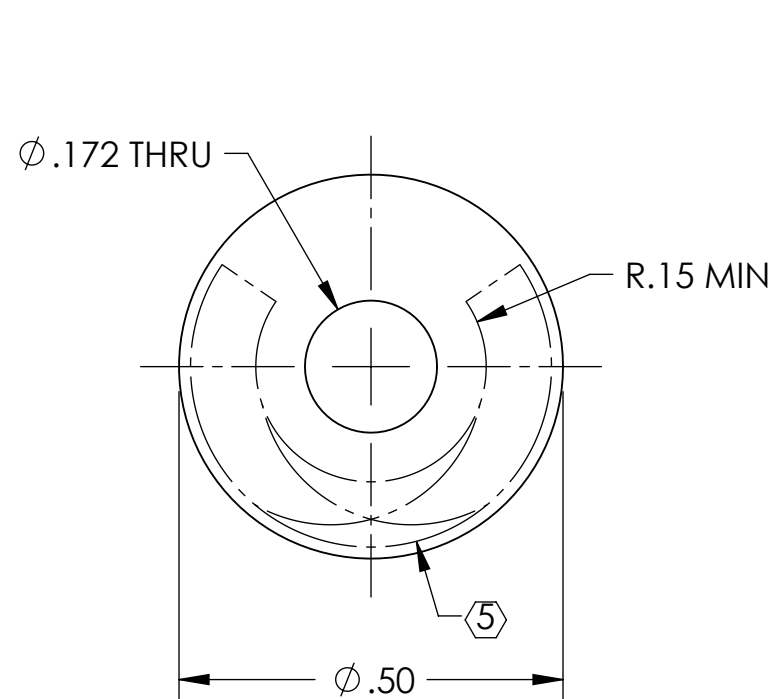
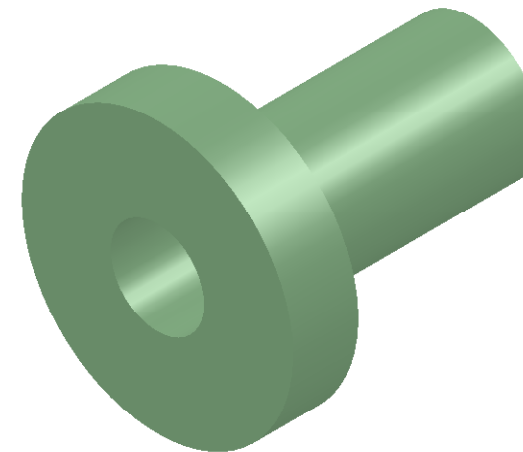
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NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE OF PART FOLLOWED WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.06" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N XXX
- 6. APPROXIMATE WEIGHT = .10 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. LIGO INTERNAL NOTE:  
CLEAN & BAKE CLASS B PER LIGO-E960022, SECTION 11.

REV.	DATE	DCN #	DRAWING TREE #
v1	27 JUL 2011	E1100351	-
-	-	-	-
-	-	-	-



D1101362 TMS Tooling Fixture Clamp, PART PDM REV: X-012, DRAWING PDM REV: X-006

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES  
 TOLERANCES:  
 .XX ± .02  
 .XXX ± .010  
 ANGULAR ± 1.0°

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 6061-T6 Al FINISH 63 μinch Ra

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM AOS  
 NEXT ASSY D1101361

PART NAME TMS TOOLING FIXTURE CLAMP

DESIGNER	K. MAILAND	12 JUL 2011	SIZE	DWG. NO.	REV.
DRAFTER	J. TERRAZAS		B	D1101362	v1
CHECKER			SCALE: 4:1	PROJECTION:	SHEET 1 OF 1
APPROVAL					

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