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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. MASS: 2.434 KG [5.367 LB].

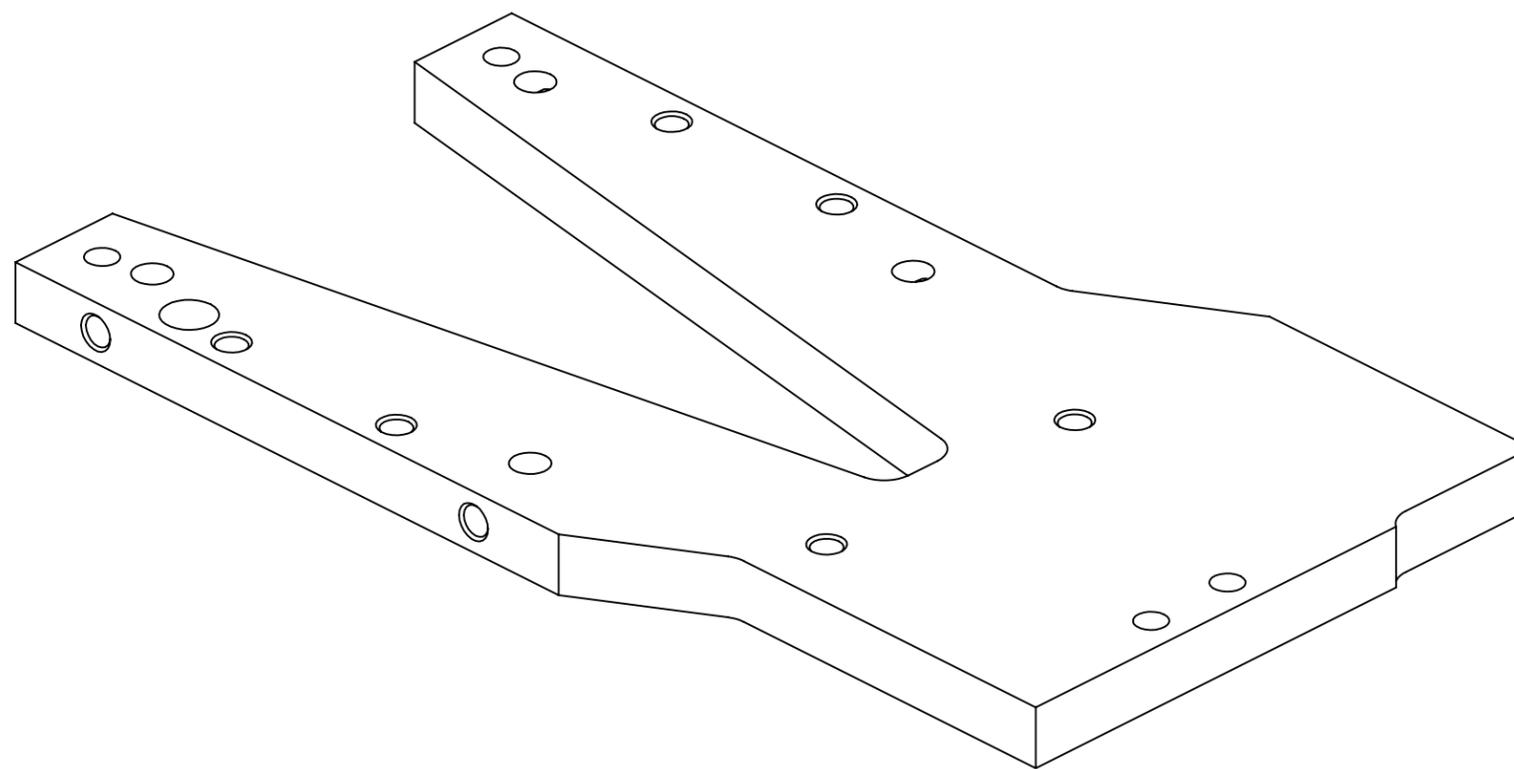
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

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 PART 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 ALL TAPPED HOLES: 0.005 OVERSIZE BOTH DRILL AND TAP.

REV.	DATE	DCN #	DRAWING TREE #
v1	25 MAR 2012	E1101214	
v2	11 APR 2012	E1101214	



D1101511 aLIGO TMS Upper Mass Top Plate, PART PDM REV: X-035, DRAWING PDM REV: X-012

D

D

C

C

B

B

A

A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES  
TOLERANCES:  
.XX ± .01  
.XXX ± .005  
ANGULAR ± 1.0°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.

MATERIAL 304 SSSL FINISH 63 µinch Ra

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SYSTEM **ADVANCED LIGO** SUB-SYSTEM **AOS**

NEXT ASSY **D1101527**

PART NAME **aLIGO TMS INTERMEDIATE MASS TOP PLATE**

DESIGNER	K. MAILAND	19 MAR 2012	SIZE	DWG. NO.	REV.
DRAFTER	C. CONLEY	25 MAR 2012	<b>B</b>	<b>D1101511</b>	<b>v2</b>
CHECKER	SEE DCN		SCALE: NONE	PROJECTION:	
APPROVAL	SEE DCN				SHEET 1 OF 3

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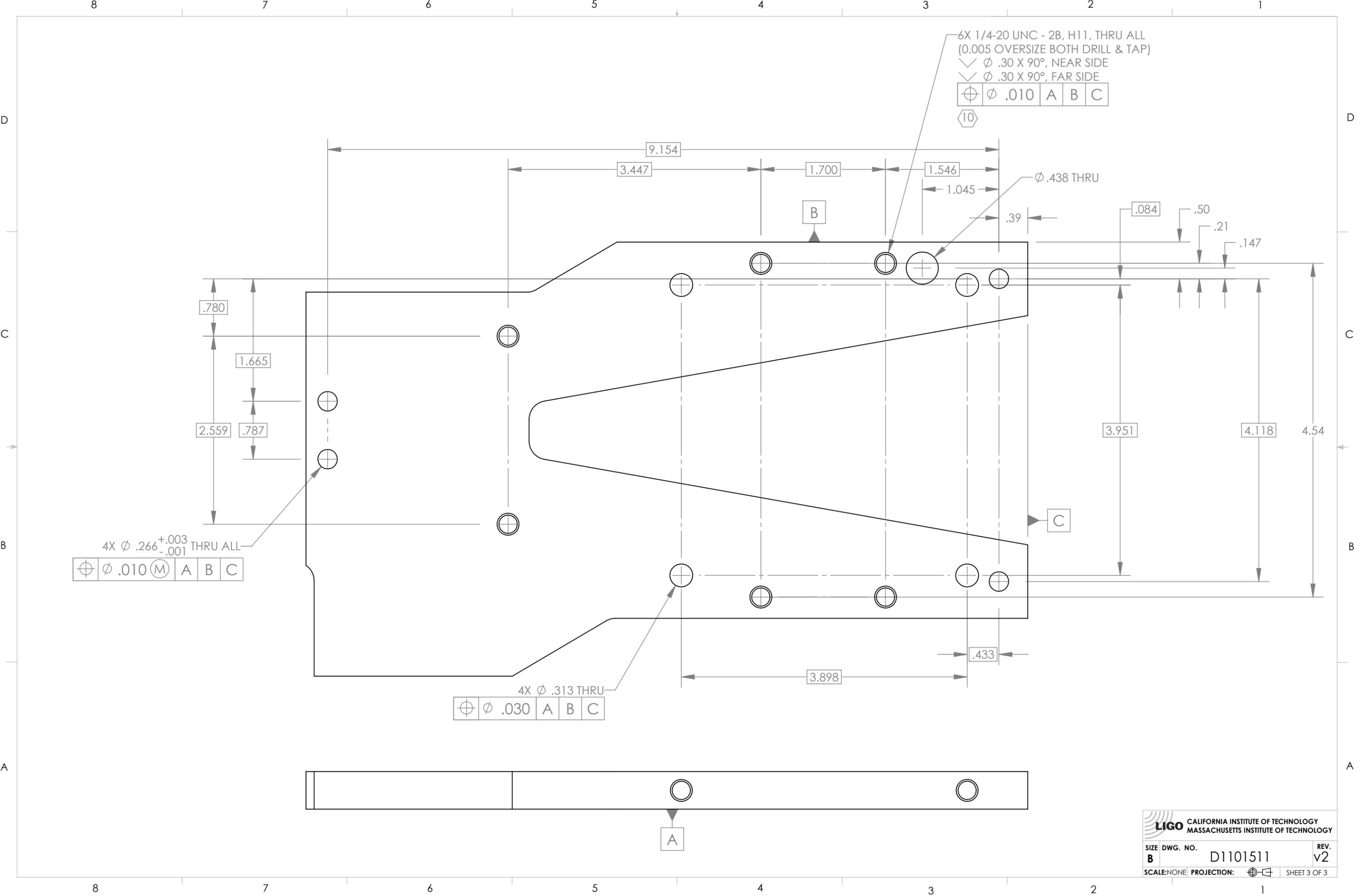
3

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D1101511 aLIGO TMS Upper Mass Top Plate, PART PDM REV: X-035, DRAWING PDM REV: X-012



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SIZE	DWG. NO.	REV.
B	D1101511	v2
SCALE: NONE	PROJECTION:	SHEET 3 OF 3