

D1102103\_Advanced\_LIGO\_SUS\_HSTS\_Glass\_Optic\_Secondary\_Prism\_Placement\_Fixture, PART PDM REV: X-004, DRAWING PDM REV:

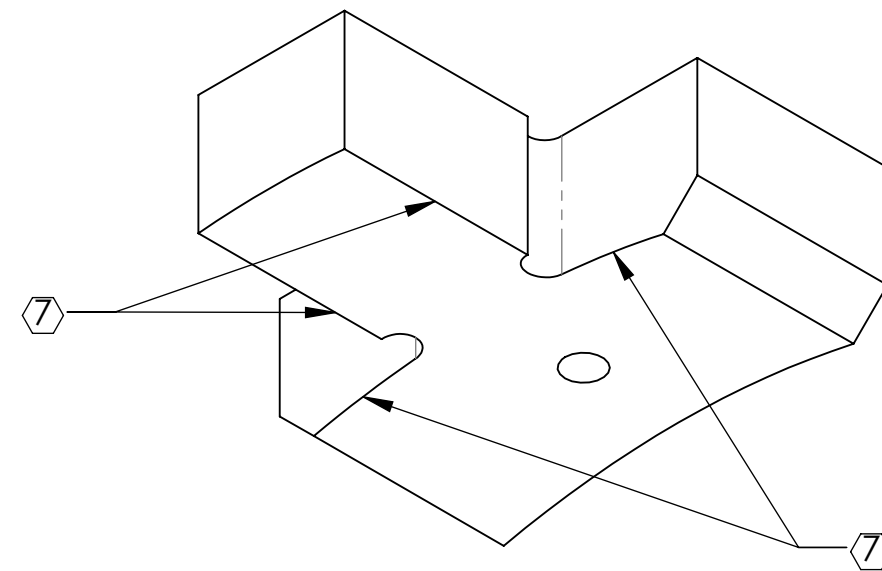
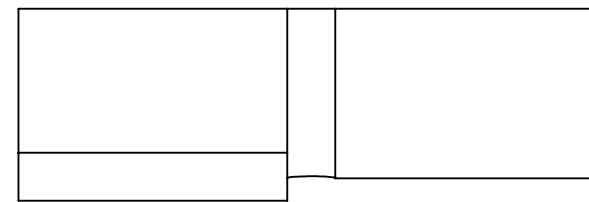
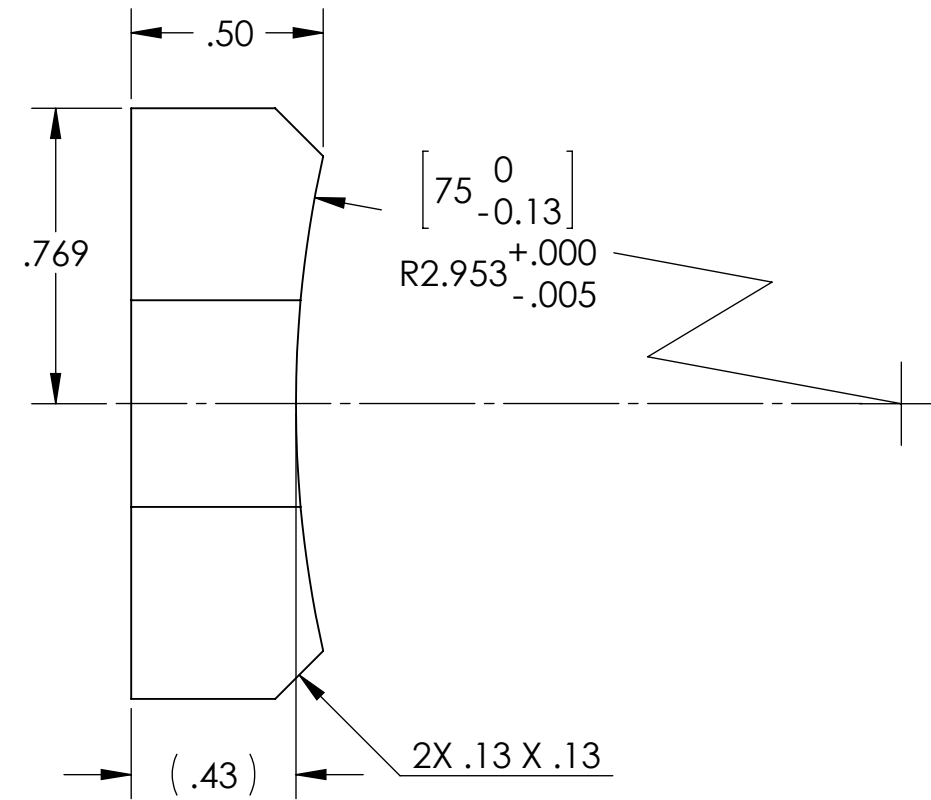
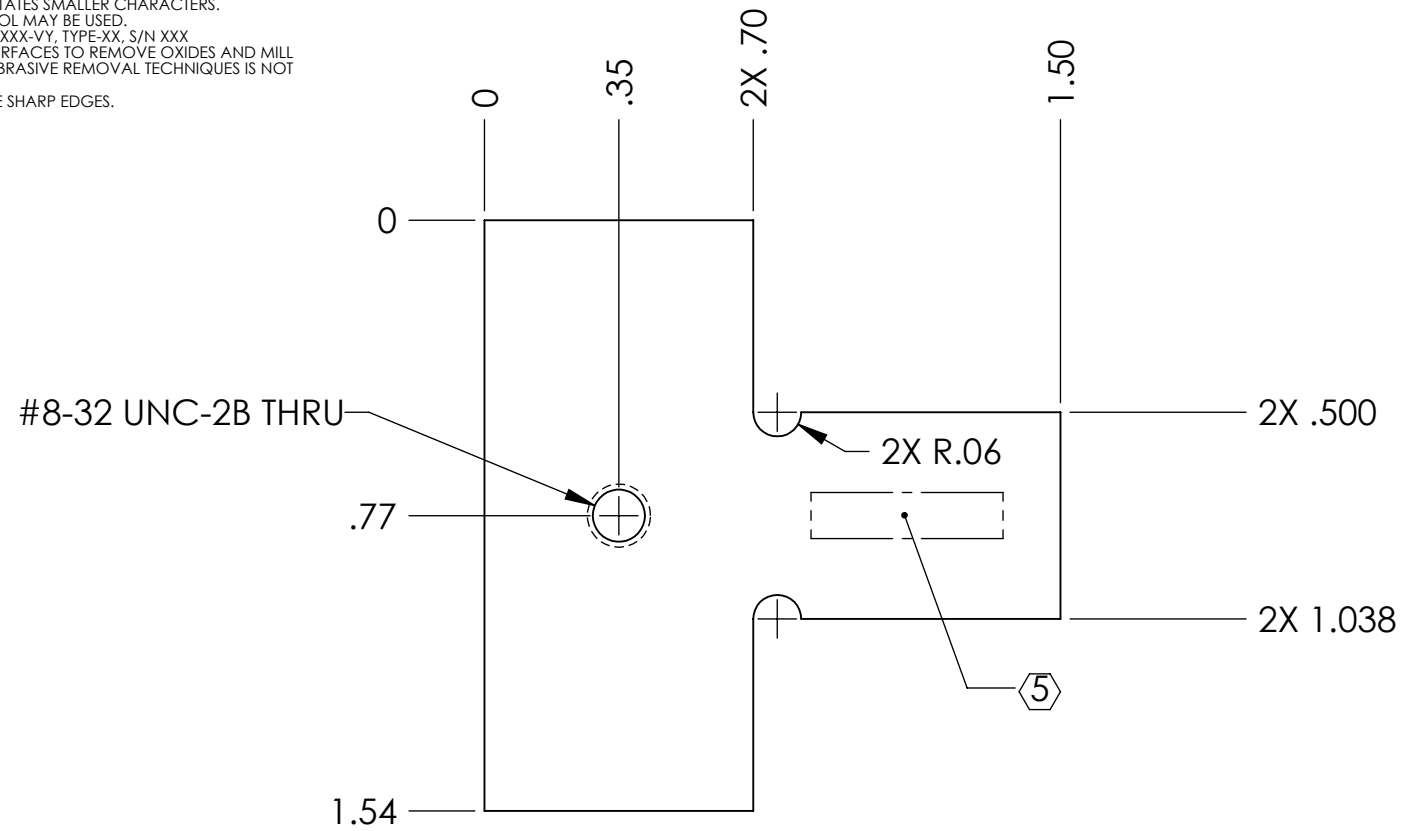
**NOTES CONTINUED:**

5. SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED.  
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

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

7. DO NOT REMOVE SHARP EDGES.

REV.	DATE	DCN #	DRAWING TREE #
v1	28 OCT 2011	E1101061	E1000035
-	-	-	-
-	-	-	-



**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

DIMENSIONS ARE IN INCHES [MM]

TOLERANCES:  
 .XX ± .01  
 .XXX ± .005  
 ANGULAR ± 0.5°

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.

MATERIAL PTFE FINISH 63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	PART NAME		SECONDARY PRISM PLACEMENT FIXTURE, GLASS OPTIC				
	SYSTEM <b>ADVANCED LIGO</b>	SUB-SYSTEM <b>SUS</b>	DESIGNER D. BRIDGES	DATE 31 OCT 2011	SIZE DWG. NO. <b>B</b>	REV. <b>v1</b>	
NEXT ASSY HSTS OVERALL ASSY AND FIXTURES	DRAFTER D. BRIDGES	DATE 31 OCT 2011	CHECKER B. MOORE	DATE 01 NOV 2011	SCALE: 2:1	PROJECTION:	SHEET 1 OF 1