

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 = 11.334 LB

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.

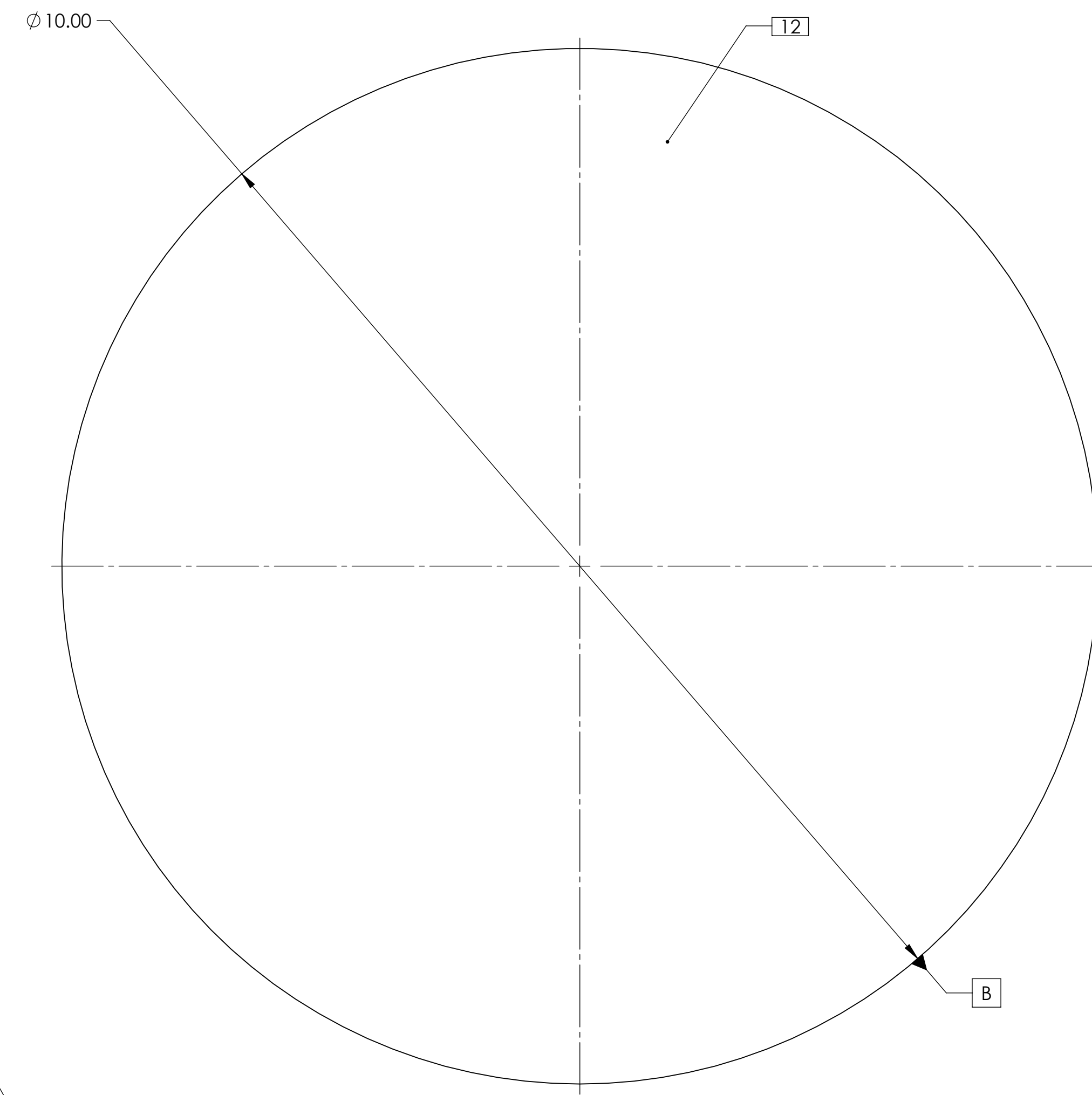
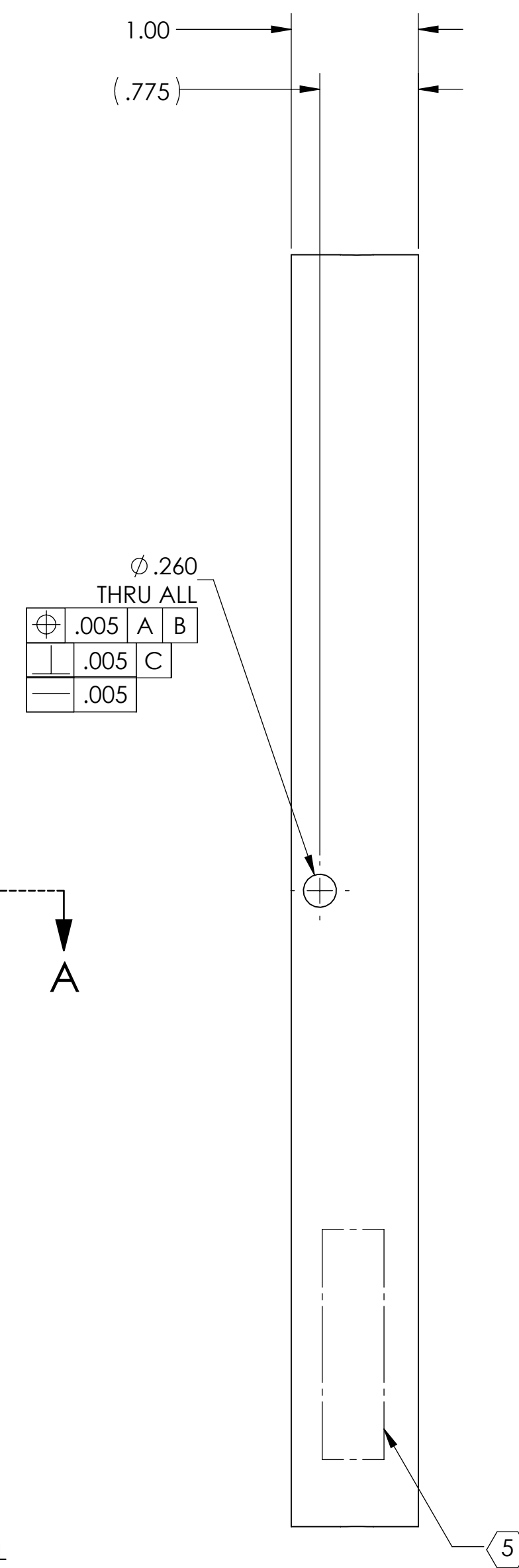
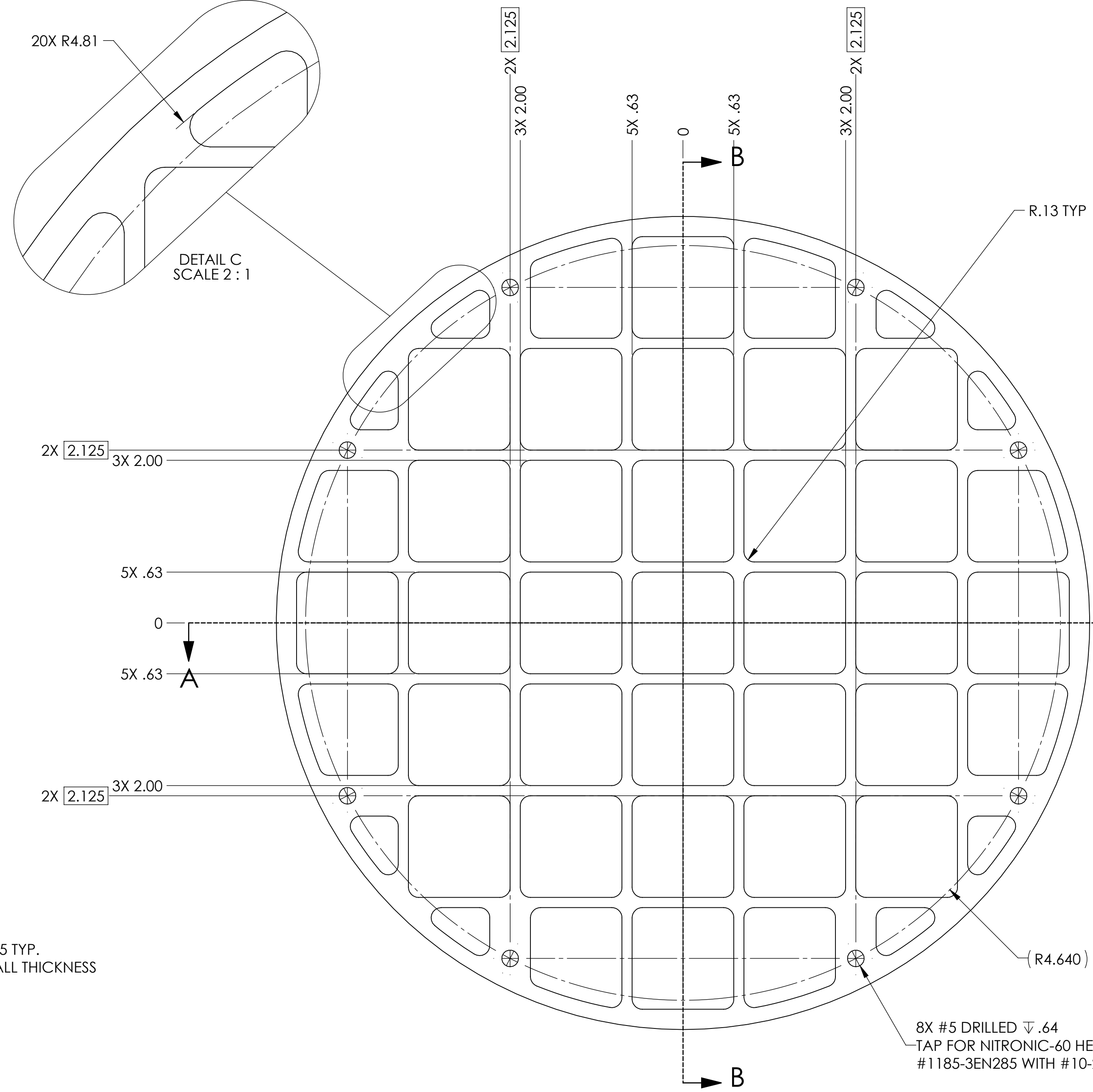
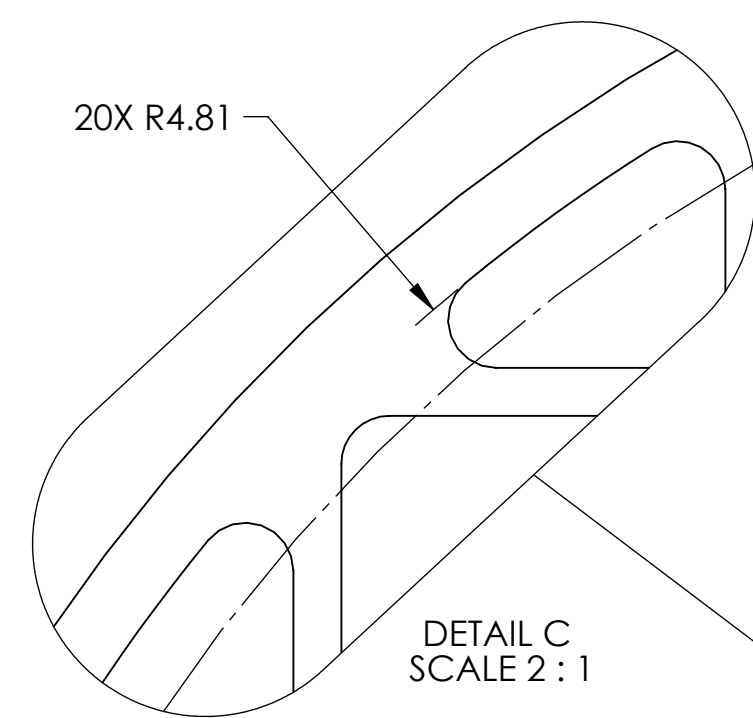
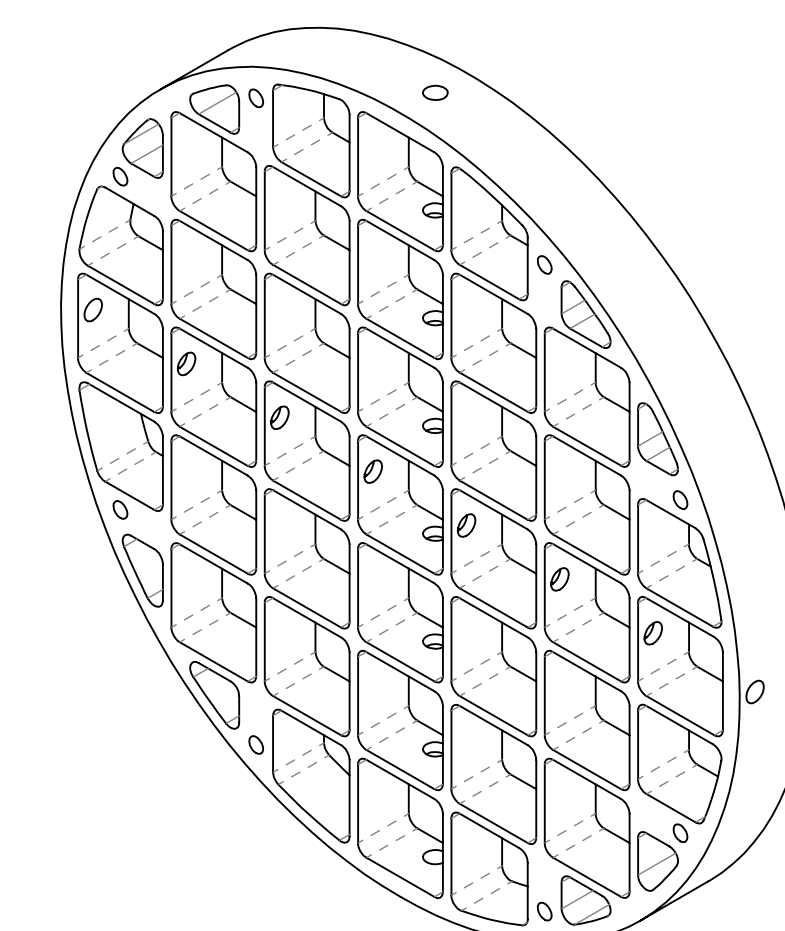
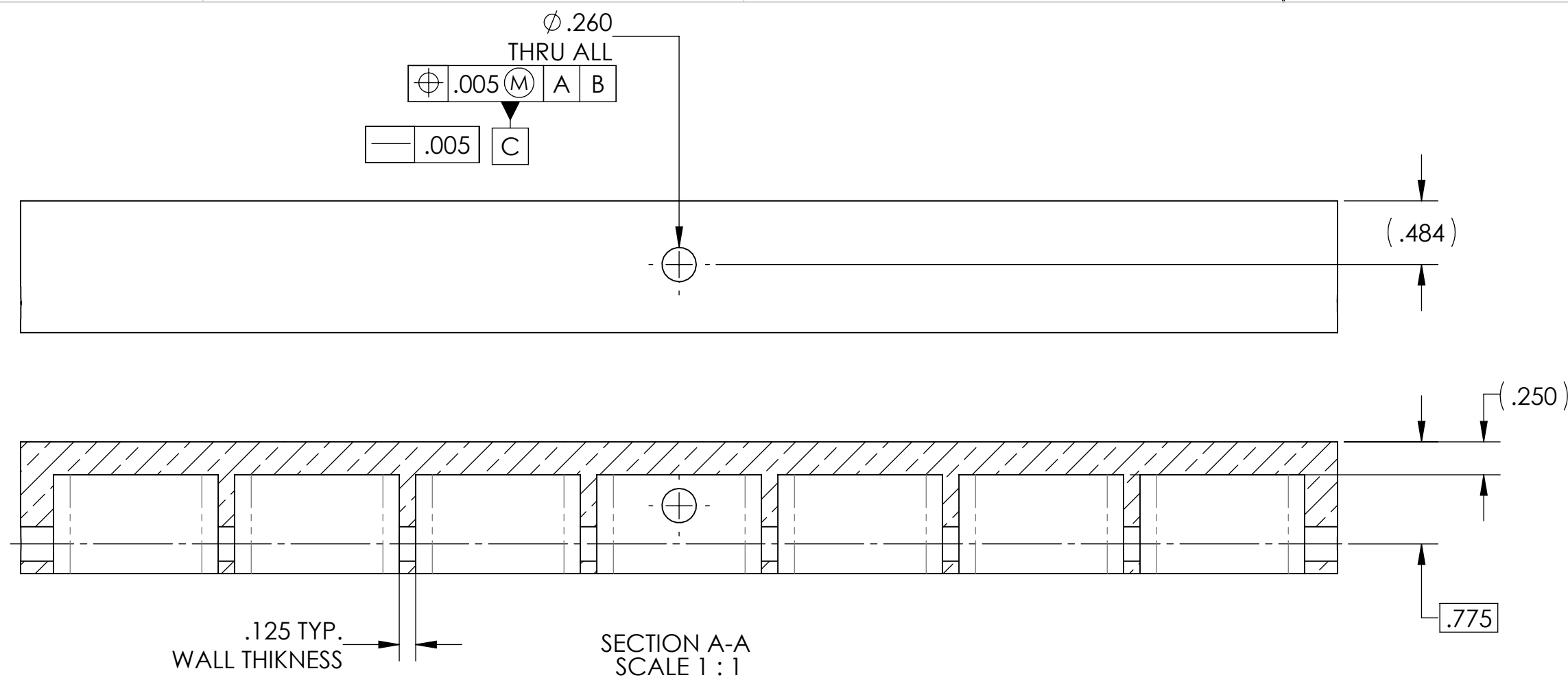
9 ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

10 ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

11 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.

12) (LAMBDA/10) FINISH FOR 10.6 um LASER
 99% REFLECTIVITY
 20-10 SCRATCH-DIG
 HARD GOLD COATING

REV.	DATE	DCN #	DRAWING TREE #
v1	06-MAR-12	E1200002-v1	E1200003-v1
-	-	-	-
-	-	-	-



SECTION B-B

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
1. INTERPRET DRAWING PER ASME Y14.5-1994.	
2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED 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.	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± 1.0°	
MATERIAL	FINISH
Cu, 110 Alloy	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS
NEXT ASSY	
D1101851-1, D1101851-2	

PART NAME				TCS CO2P STEERING MIRROR 2, H1-L1			
DESIGNER	M. JACOBSON	08 DEC 2011	SIZE	DWG. NO.		REV.	
DRAFTER	M. JACOBSON	05-MAR-12	D	D1102171		v1	
CHECKER	J.LEWIS	06-MAR-12	SCALE:	1:1	PROJECTION:		
APPROVAL	A. HEPTONSTALL	05-MAR-12	SHEET 1 OF 1				

D1102171 LIGO TCS CO2P STEERING MIRROR 2, H1-L1, PART PDM REV: X.020, DRAWING PDM REV: X.015