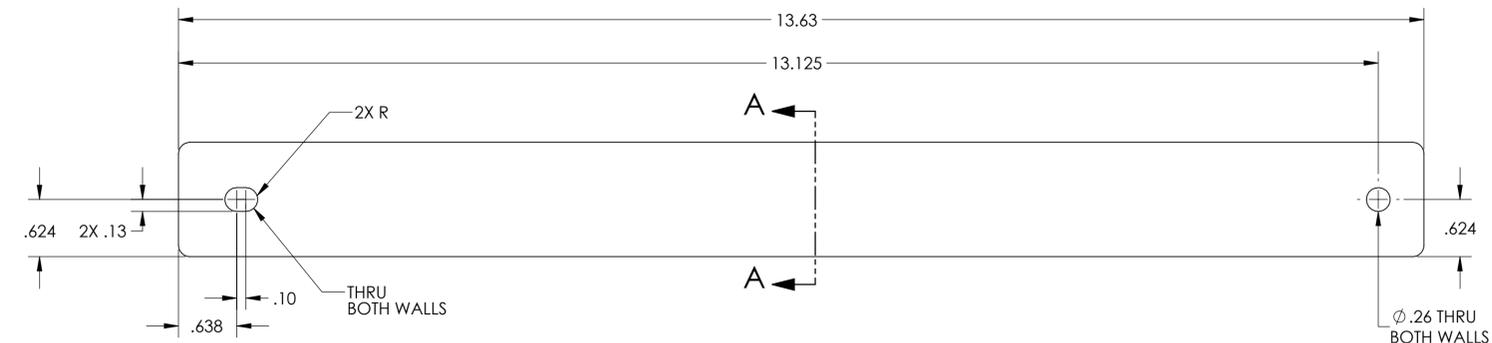


D:\1102380_01\GCO TCS CO2P SM2 ASSY SHORT SUPPORT PART PDM\REV-K.028_DRAWING_PDM_REV-K.005

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 = .715 LB.
 7. ELECTROPOLISH ALL SURFACES TO REMOVE .0005-.001 OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. MUST USE AN ELECTRODE INSIDE THE TUBE TO ALSO ELECTROPOLISH INTERIOR WALLS.
 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.

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



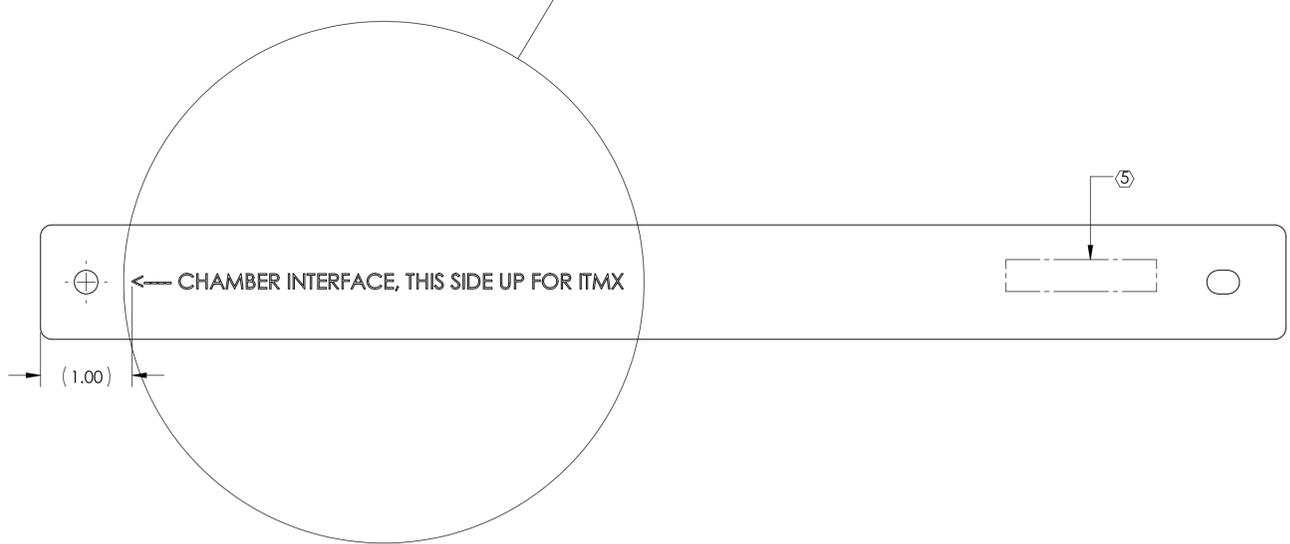
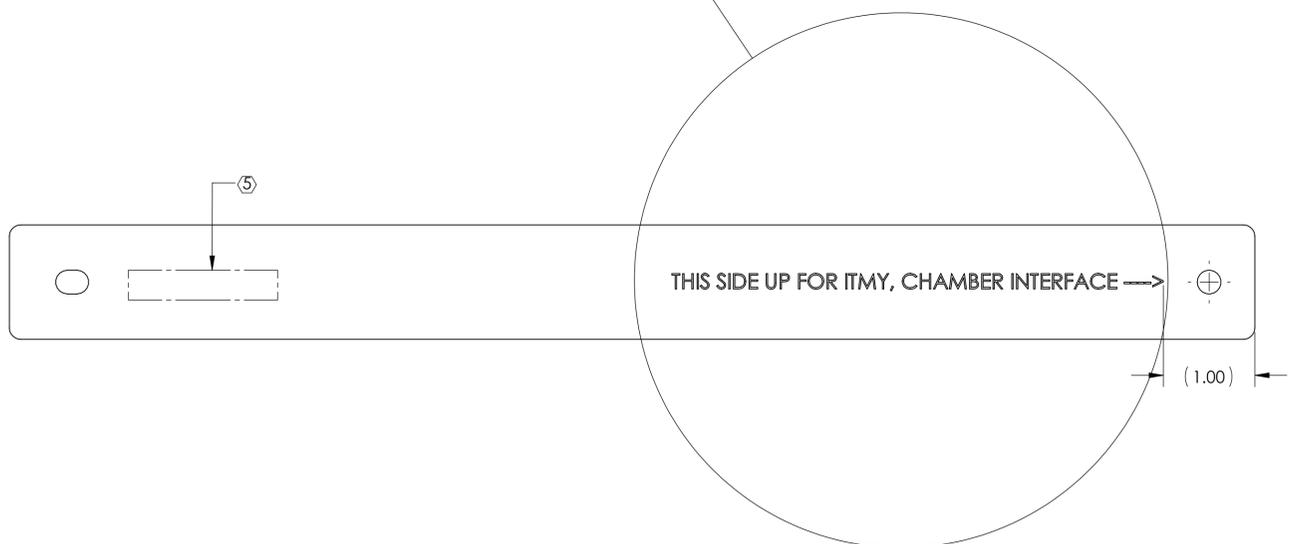
BASIC
 MATERIAL: 1.25 SQ. .125 WALL
 6063-T5 TUBING

(.17 APPROX.) THIS SIDE UP FOR ITMY, CHAMBER INTERFACE →

← CHAMBER INTERFACE, THIS SIDE UP FOR ITMX (.17 APPROX)

DETAIL C
 SCALE 2 : 1

DETAIL B
 SCALE 2 : 1



-02
 MATERIAL: MAKE FROM BASIC

-01
 MATERIAL: MAKE FROM BASIC

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME			
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.		ADVANCED LIGO		aLIGO TCS CO2P SM2 ASSY SHORT SUPPORT			
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°		6063-T5		63 μinch		D1102380	
MATERIAL: 6063-T5		FINISH: 63 μinch		NEXT ASSY: D1101851-1, D1101851-2		DESIGNER: M.JACOBSON 19-DEC-2011 DRAFTER: E. SANCHEZ 27 JAN 2012 CHECKER: J. LEWIS 06-MAR-12 APPROVAL: A.HEPTONSTALL 05-MAR-12	
				SYSTEM: AOS SUB-SYSTEM: AOS		SIZE: D DWG. NO.: D1102380 SCALE: 1:1 PROJECTION:	
				SHEET 1 OF 1		REV. v1	