

NOTES CONTINUED:

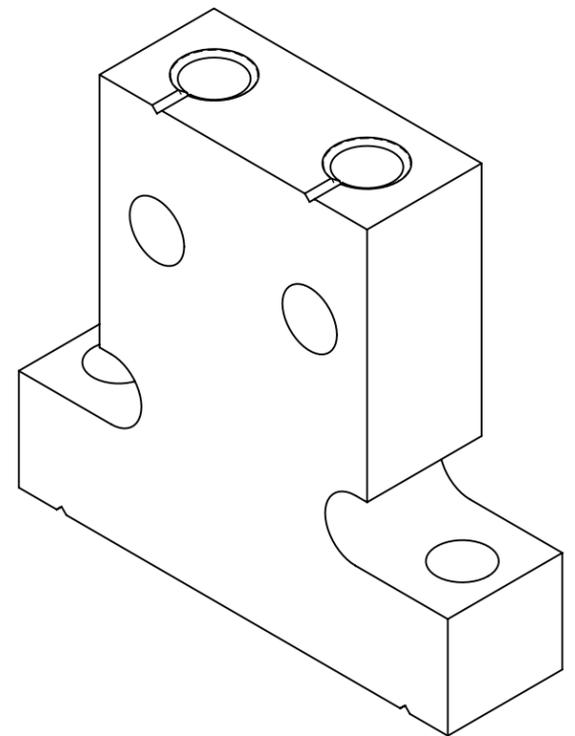
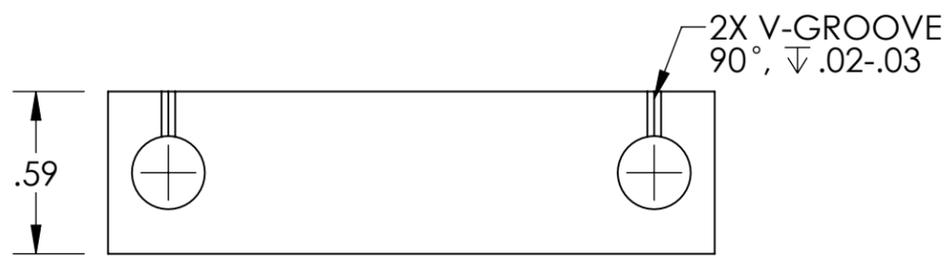
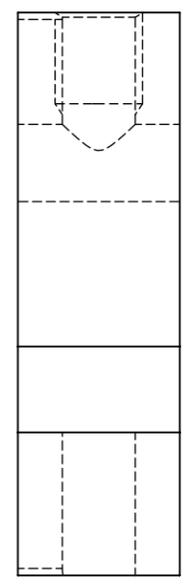
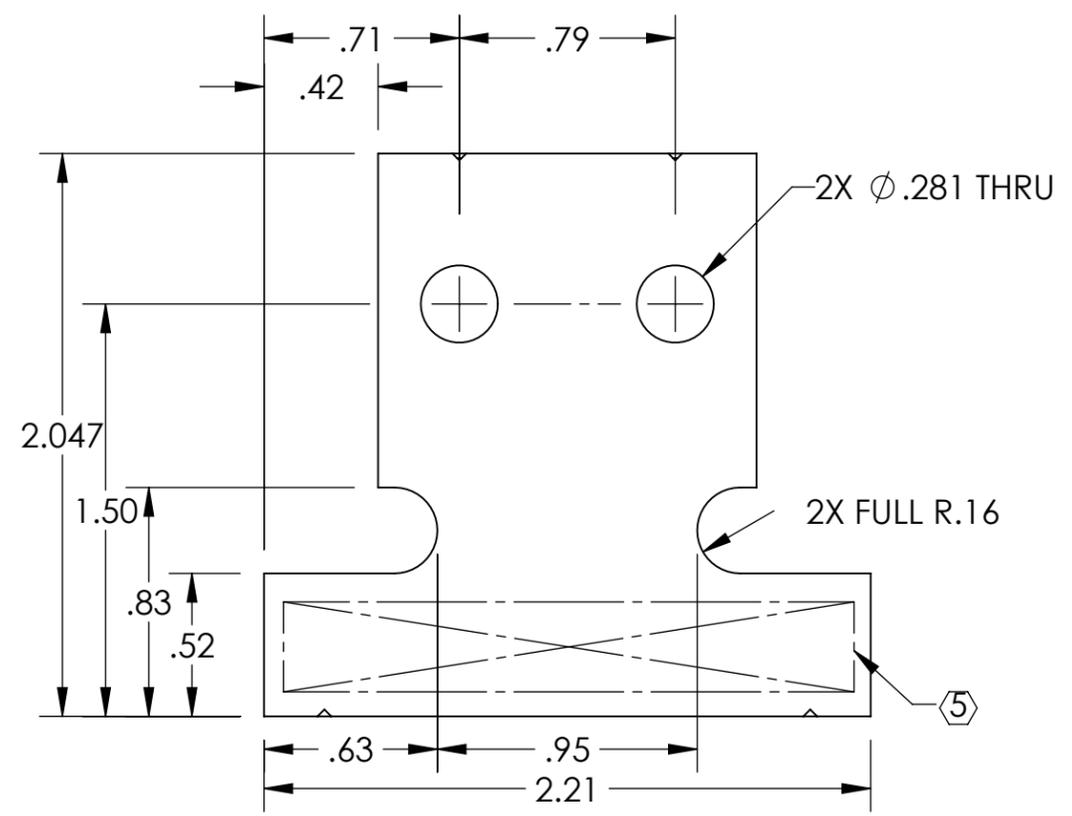
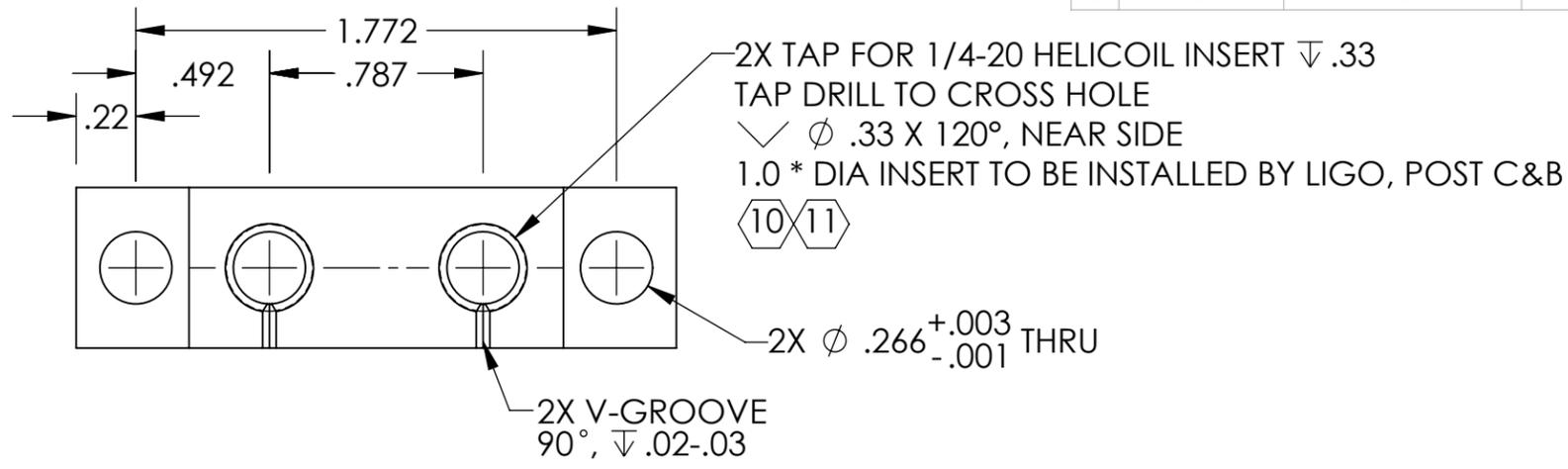
⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

- 6. MASS: 0.210 KG [0.463 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 PREPARE HELICOIL TAPPED HOLES ACCORDING TO EMHART HELICOIL PRODUCT CATALOG HC2000. DO NOT INSTALL HELICOILS.

⑪ INTERNAL NOTE: HELICOILS TO BE INSTALLED BY LIGO, POST C&B. USE ONLY NITRONIC 60 HELICOILS.

REV.	DATE	DCN #	DRAWING TREE #
v1	29 MAR 2012	E1101214	-
-	-	-	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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 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	304 SSTL	FINISH	63 μinch Ra
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		αLIGO TMS MASS SPACER	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	AOS	DESIGNER	K. MAILAND 29 FEB 2012
NEXT ASSY	D1101527	CHECKER	SEE DCN	DRAFTER	J. TERRAZAS 29 MAR 2012
		APPROVAL	SEE DCN	SIZE	DWG. NO. B D1200531
				REV.	v1
				SCALE: NONE	PROJECTION:
					SHEET 1 OF 1

D1200531 αLIGO TMS Mass Spacer, PART PDM REV: X-001, DRAWING PDM REV: X-000