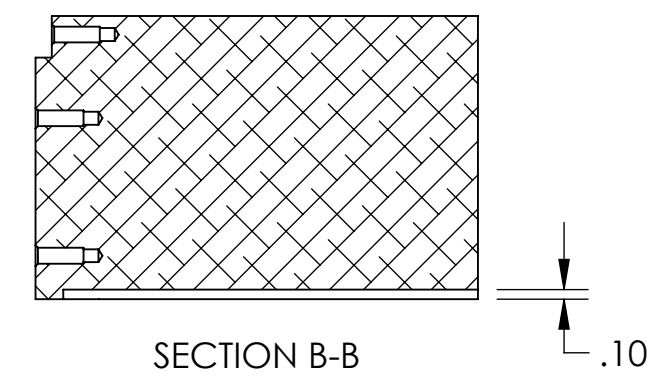
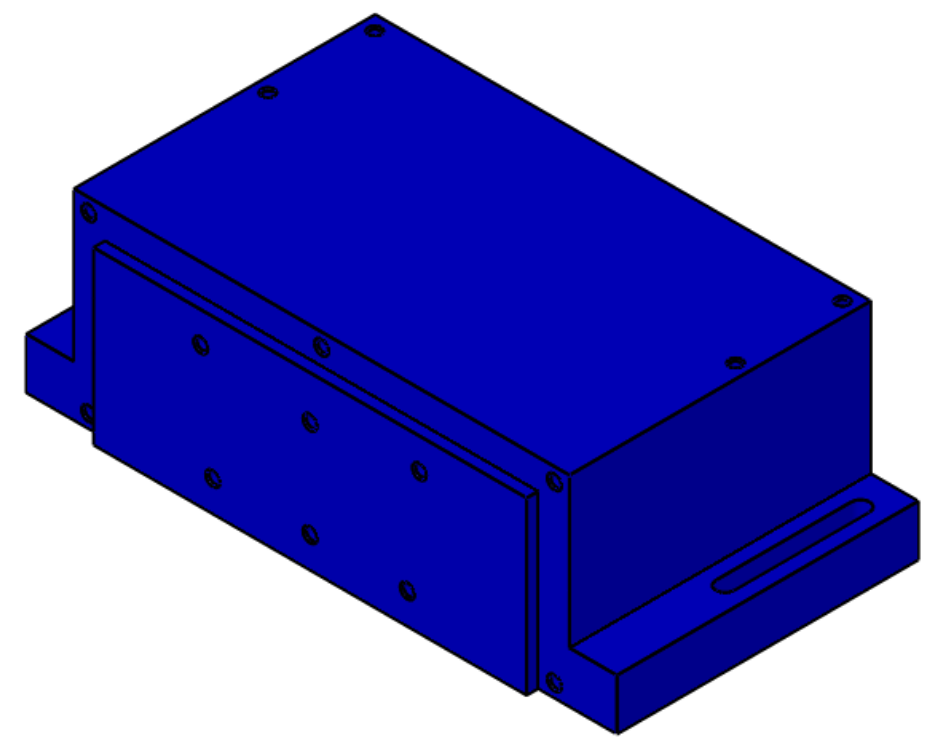
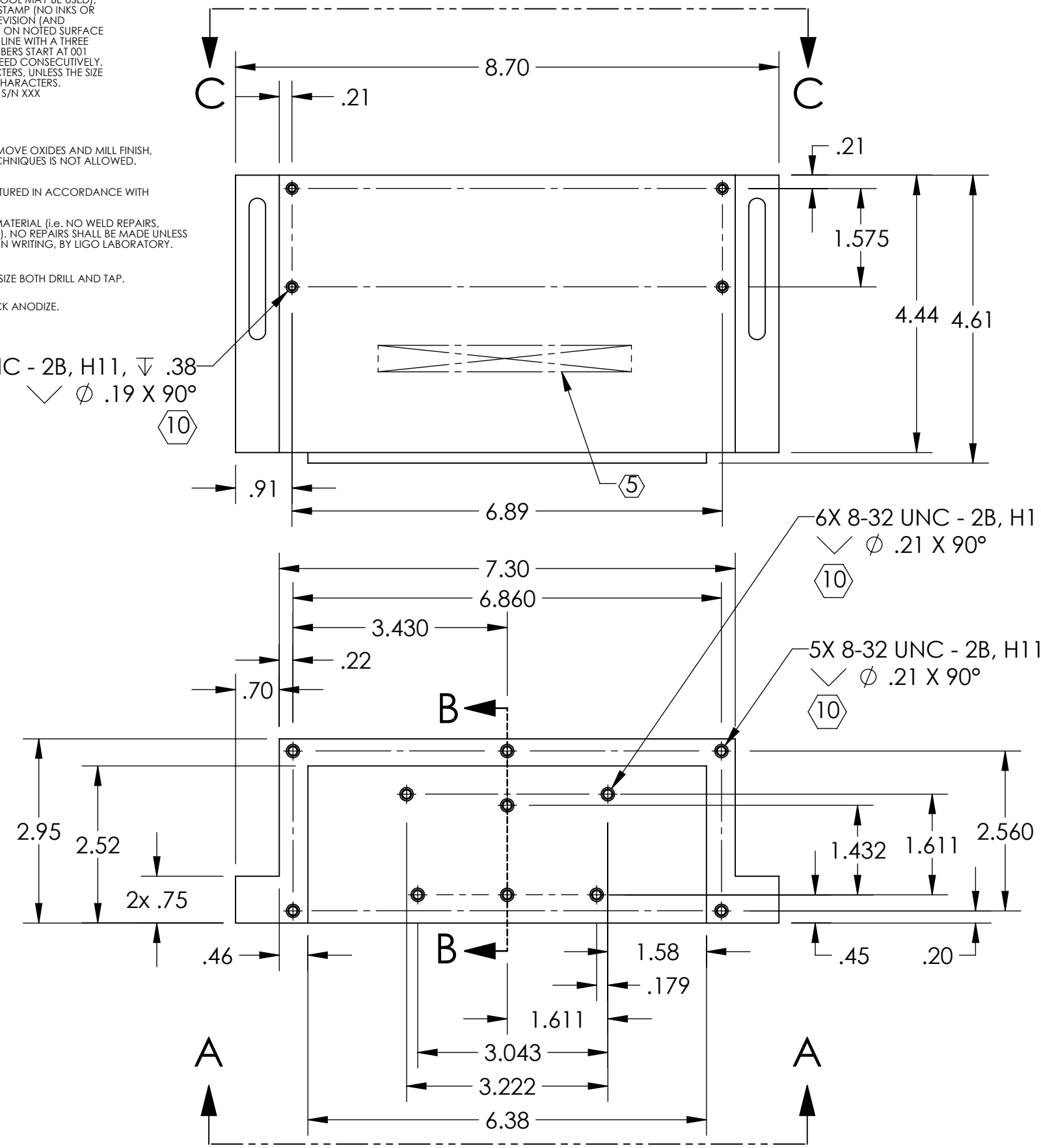


NOTES CONTINUED:
 (5) SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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. WEIGHT: 9.63 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 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.
- (10) ALL TAPPED HOLES: 0.005 OVERSIZE BOTH DRILL AND TAP.
- (11) TUMBLE DEBURR, CLEAN & BLACK ANODIZE.

| REV. | DATE | DCN # | BOM # |
|------|-------------|-------|-------|
| v1 | 20 JUN 2012 | - | - |
| v2 | 30 JUL 2012 | - | - |
| v3 | 03 AUG 2012 | - | - |



D1200681 aLIGO Photon Calibrator Laser Mounting Block, PART PDM REV: X-008, DRAWING PDM REV: X-014

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

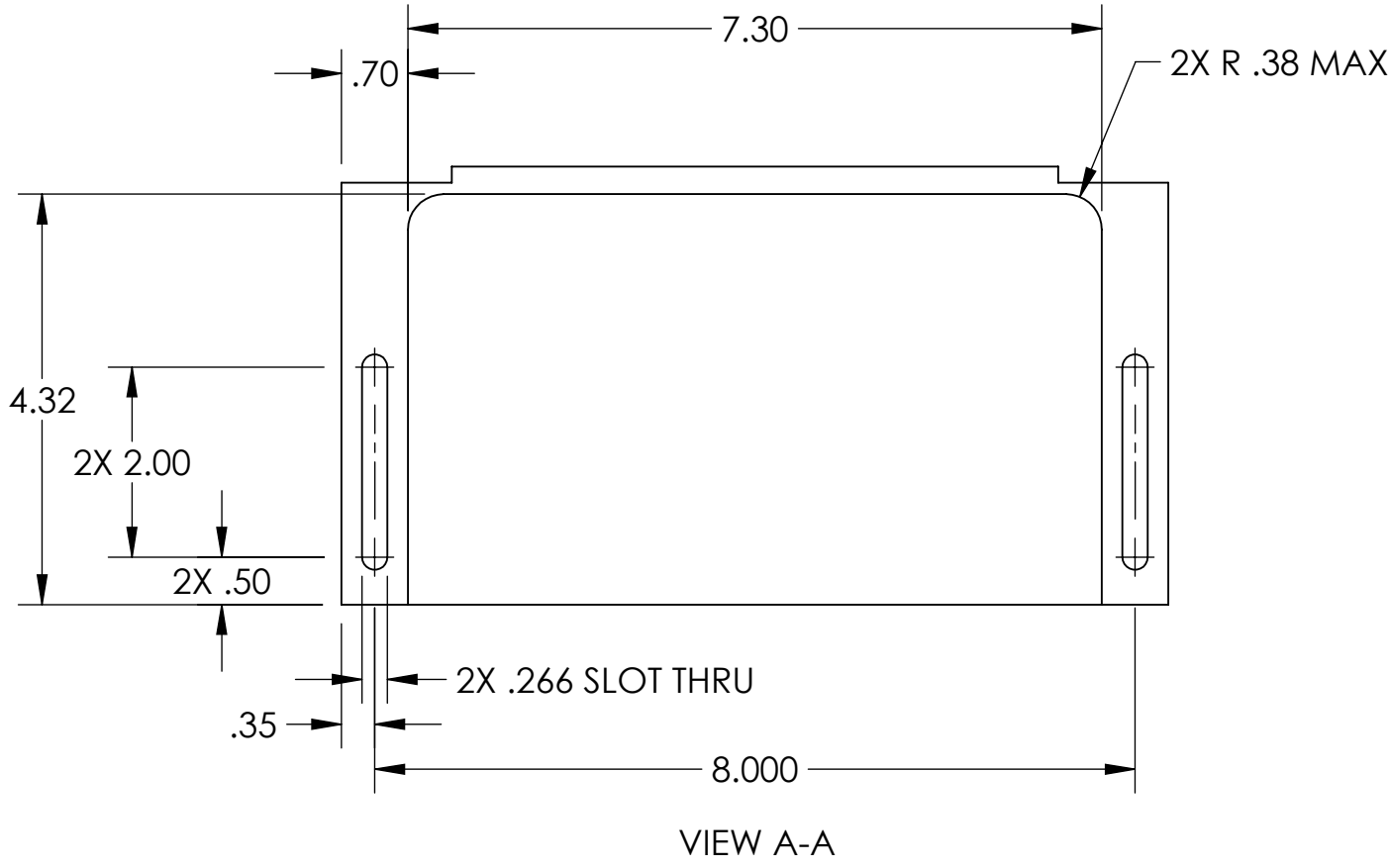
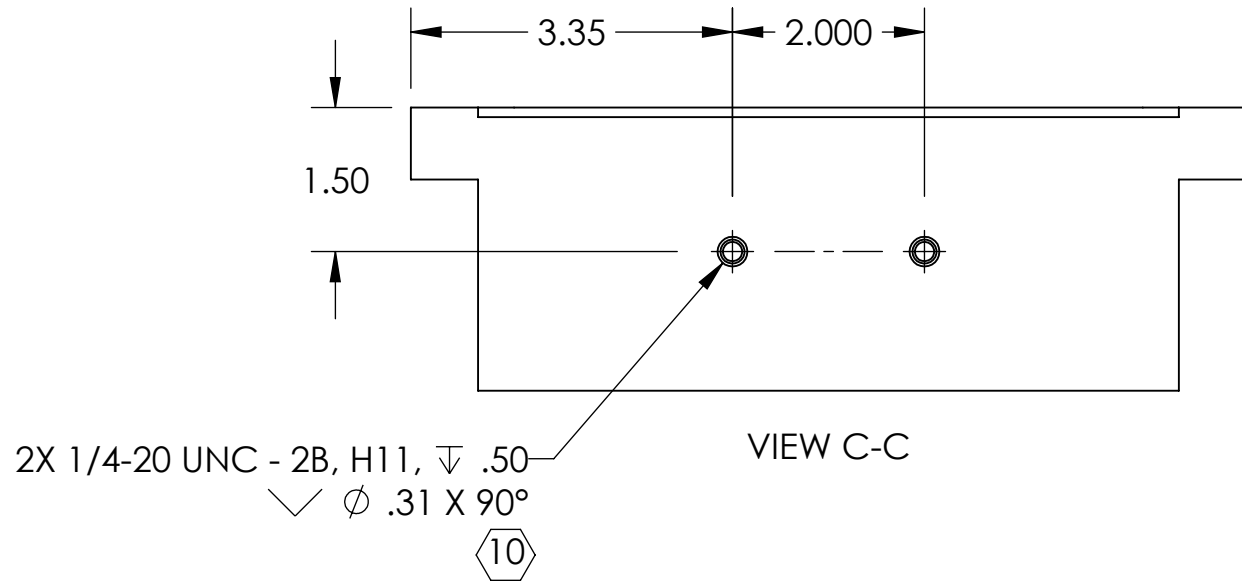
TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 0.1°

MATERIAL: 6061-T6 Al
 FINISH: 63 μ inch (11)

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 SUCH AS CINCINNATI MILACRON'S CIMTECH 410.

| | | | | | |
|---|---------------|------------|-----------|---|-------------------------|
| CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY | | PART NAME | | aLIGO PHOTON CALIBRATOR LASER MOUNTING BLOCK | |
| SYSTEM | ADVANCED LIGO | SUB-SYSTEM | AOS | DESIGNER | J. BERLINER 17 APR 2012 |
| NEXT ASSY | D1201072 | DRFTER | C. CONLEY | CHECKER | 25 JUL 2012 |
| | | | | SIZE | DWG. NO. |
| | | | | B | D1200681 |
| | | | | REVISION | v3 |
| | | | | SCALE | NONE PROJECTION: |
| | | | | SHEET 1 OF 2 | |

D1200681 aLIGO Photon Calibrator Laser Mounting Block, PART PDM REV: X-008, DRAWING PDM REV: X-014



LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

| | | |
|-------------|----------|--------------|
| SIZE | DWG. NO. | REV. |
| B | D1200681 | v3 |
| SCALE: NONE | | PROJECTION: |
| | | SHEET 2 OF 2 |