

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 = 59.5 LBS.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

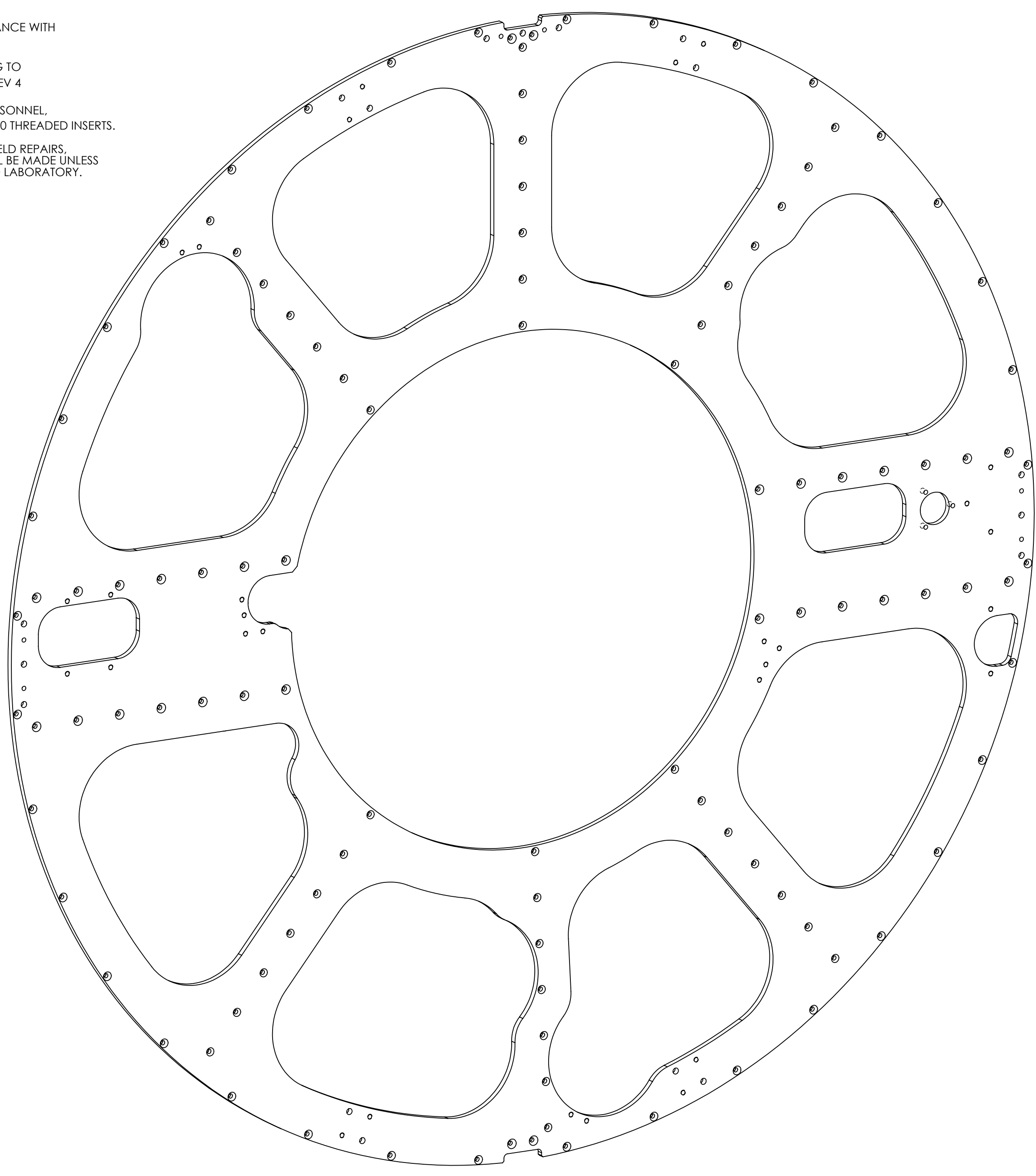
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

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

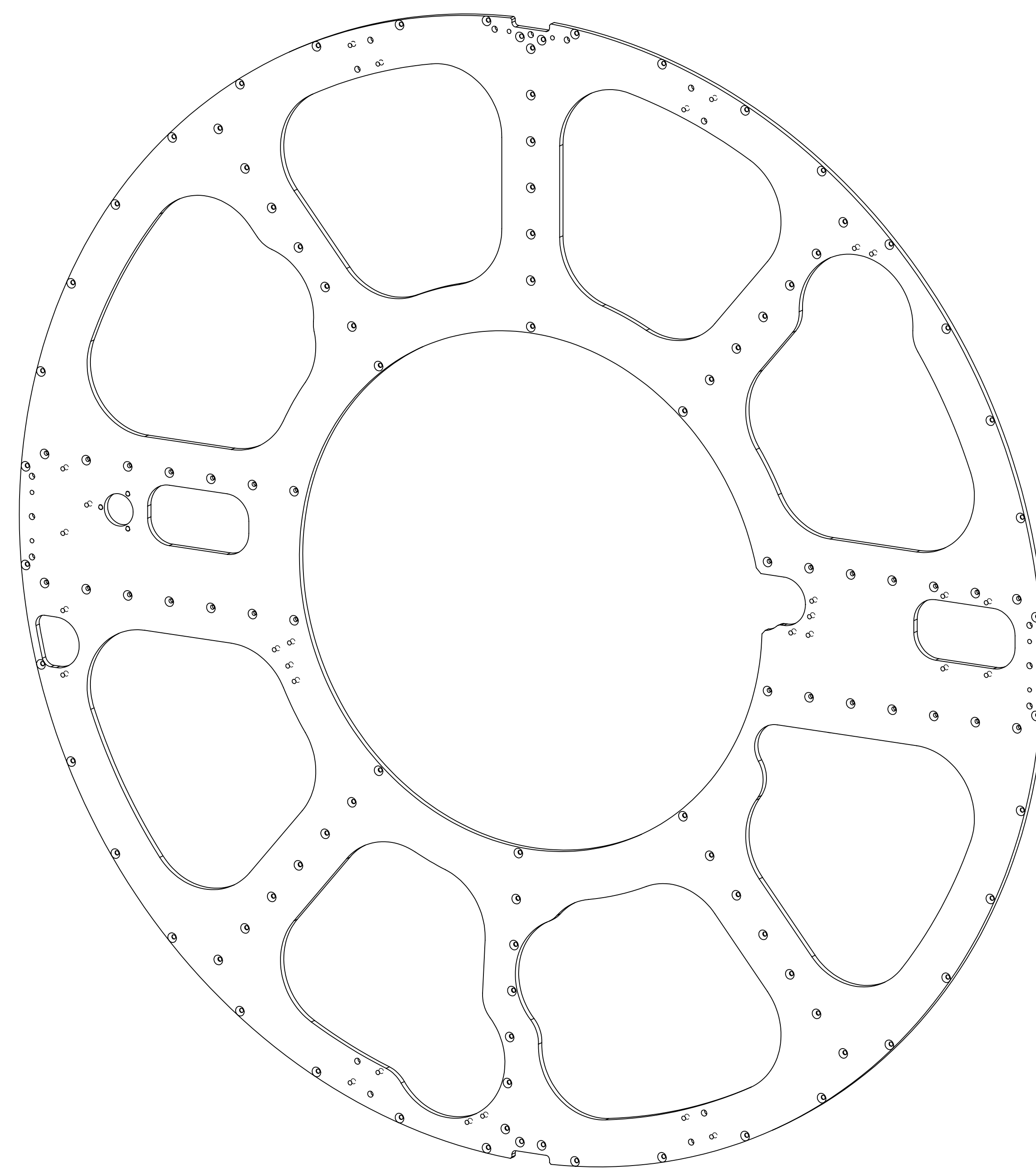
(10) ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

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.

REV.	DATE	DCN #	DRAWING TREE #
V1	26 JUN 2012	E1200700	
V2	13 JUL 2012	E1200700	
V3	20 AUG 2012	E1200700	
V4	03 SEP 2012	E1200700	



**D1200726-1
 (COUNTERSINK OPPOSITE DATUM "A" SURFACE)**

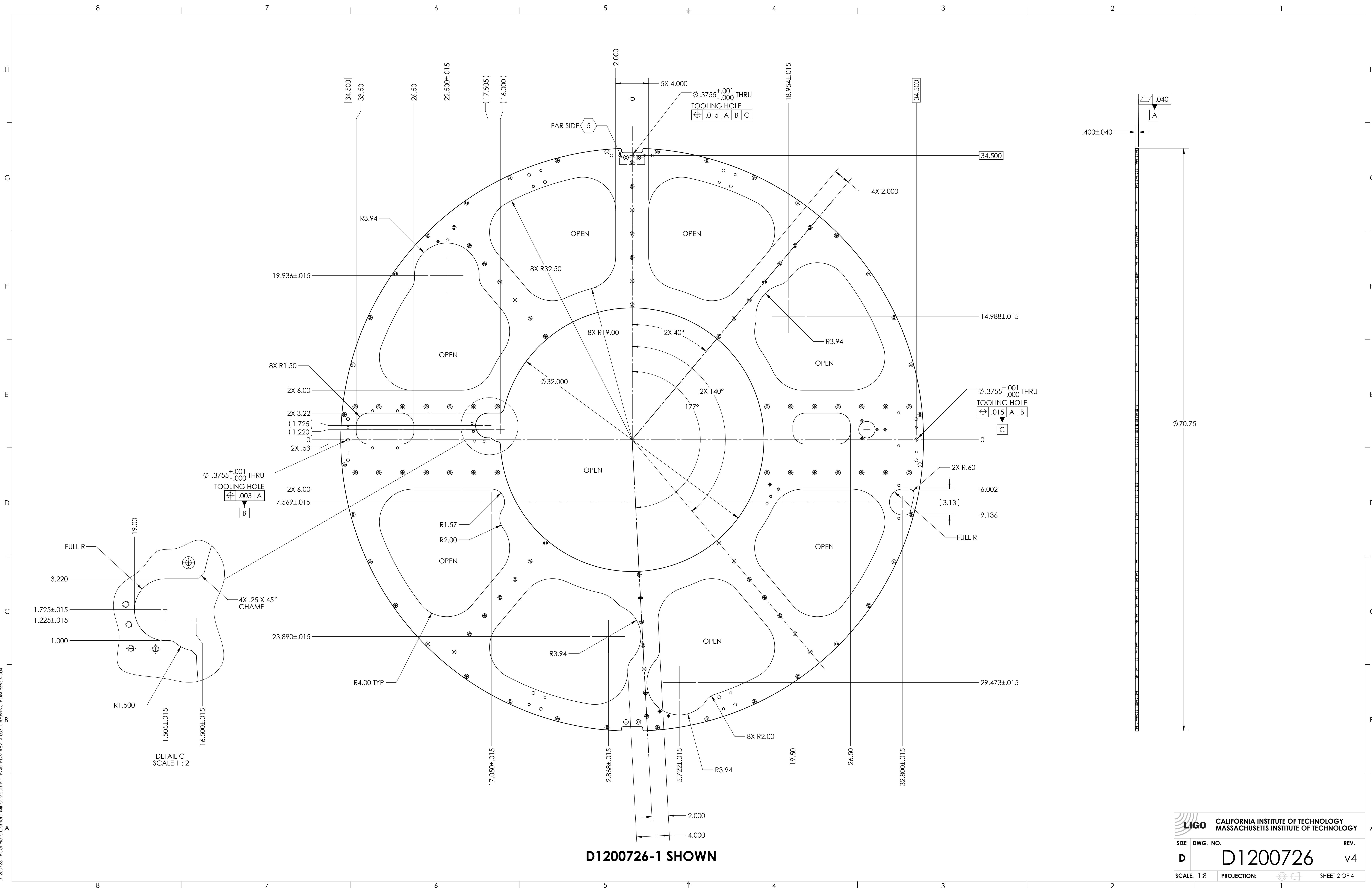


**D1200726-2
 (COUNTERSINK ON DATUM "A" SURFACE)**

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	SUPPLIER
2	9	1185-4EN375	INSERT, HELI-COIL 1/4-20 X .38 LG NITRONIC 60	HELI-COIL
1	1	D1200726-1	PCAL PLATE CAMERA MIRROR MTG	

DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .05 .XXX ± .010 ANGULAR ± 0.5°		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) 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.		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME PCAL PLATE CAMERA MIRROR MTG	
MATERIAL 6061 Alloy		FINISH 63 μinch		NEXT ASSY D1200174		DESIGNER S. SHANKLE 10 JUN 2012 DRAFTER S. SHANKLE 26 JUN 2012 CHECKER S. SHANKLE 26 JUN 2012 APPROVAL S. SHANKLE 26 JUN 2012	
				SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
				SIZE DWG. NO. D D1200726		REV. v4	
				SCALE: 1:8 PROJECTION:		SHEET 1 OF 4	

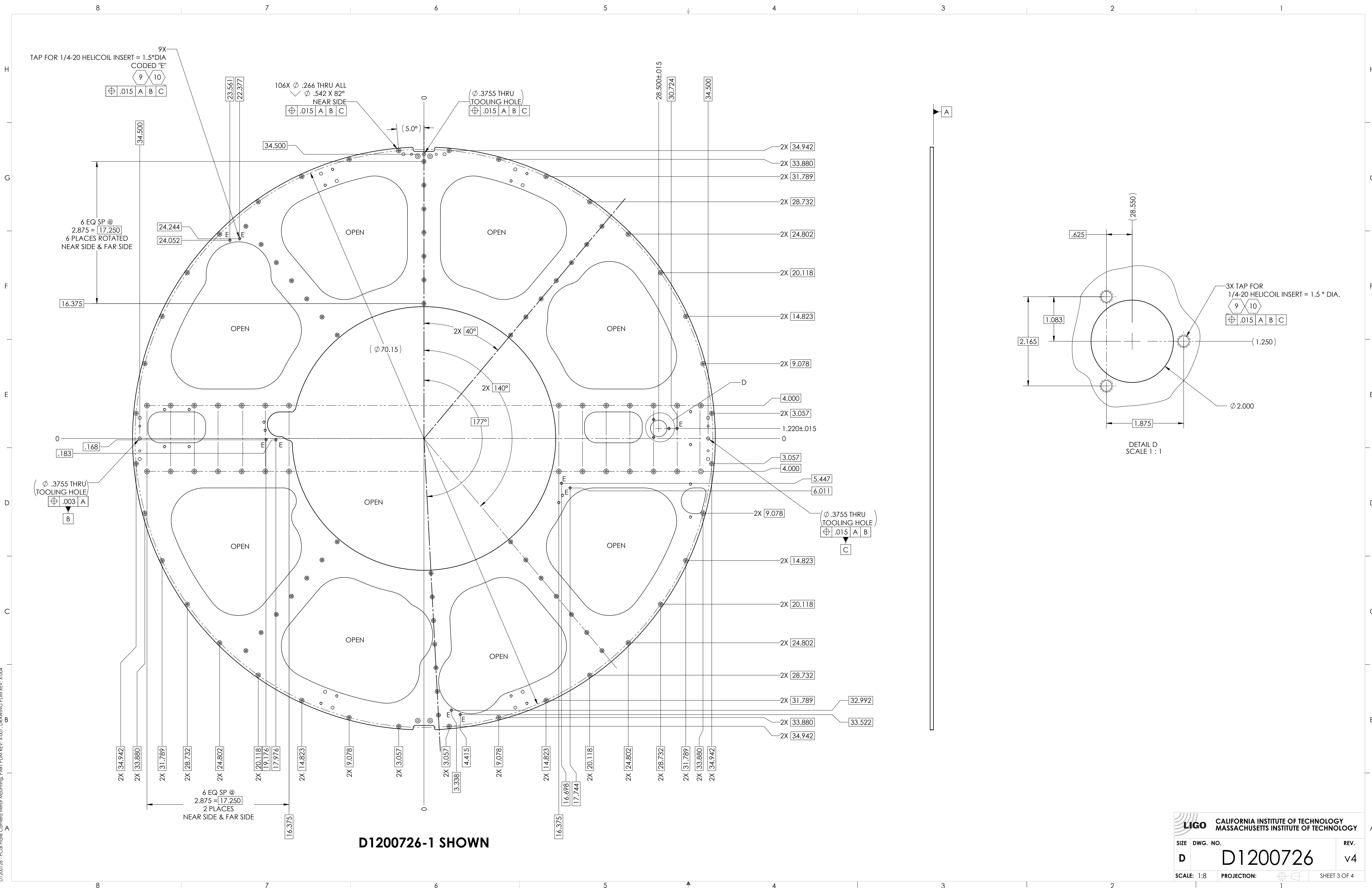
D1200726 - PCAL Plate Camera Mirror Mounting - PART FDM REV: X-007 - DRAWING FDM REV: X-004



D1200726-1 SHOWN

		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE	DWG. NO.	REV.	
D	D1200726	v4	
SCALE: 1:8	PROJECTION:	SHEET 2 OF 4	

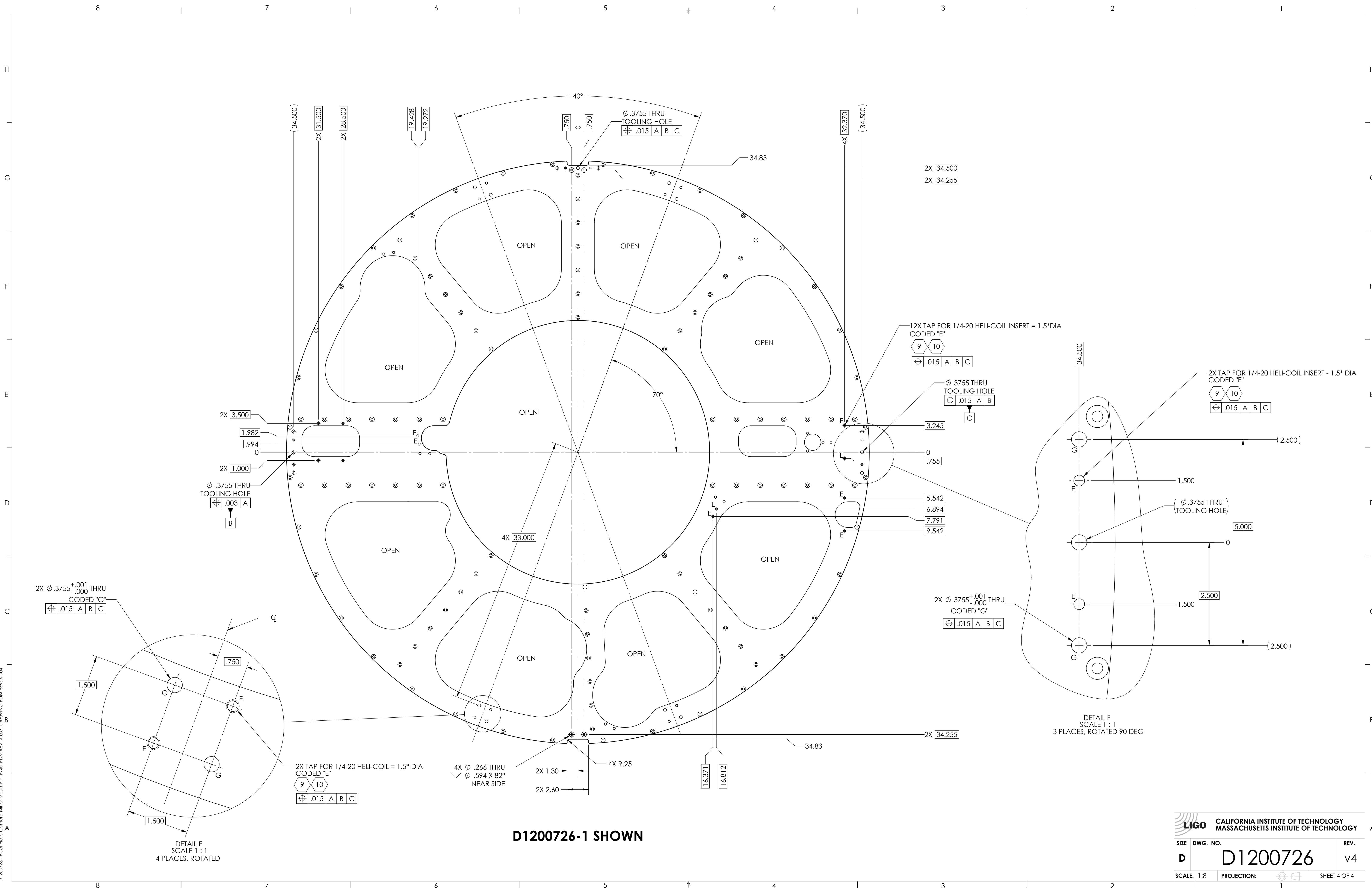
D1200726 - FCI Plate Camera Mirror Mounting - FAR FDM REV: X-007 DRAWING FDM REV: X-004



D1200726-1 SHOWN

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE DWG. NO.	REV.
D D1200726	v4
SCALE: 1:8	PROJECTION:
SHEET 3 OF 4	

D1200726 - FCI File Camera Mirror Mounting - PART FDM REV. X-007 - DRAWING FDM REV. X-004



D1200726-1 SHOWN

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE DWG. NO.	D1200726	v4
SCALE: 1:8	PROJECTION:	SHEET 4 OF 4

D1200726-1 FCD File Camera Mirror Mounting - PAR FDM REV: X-007 DRAWING FDM REV: X-004