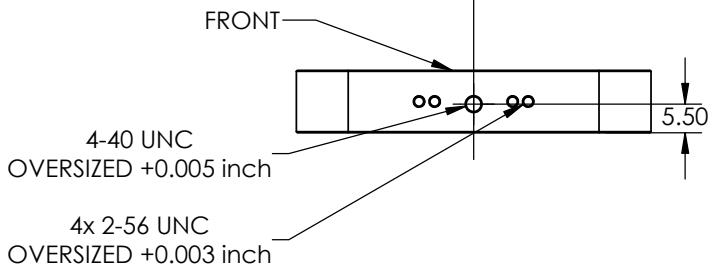
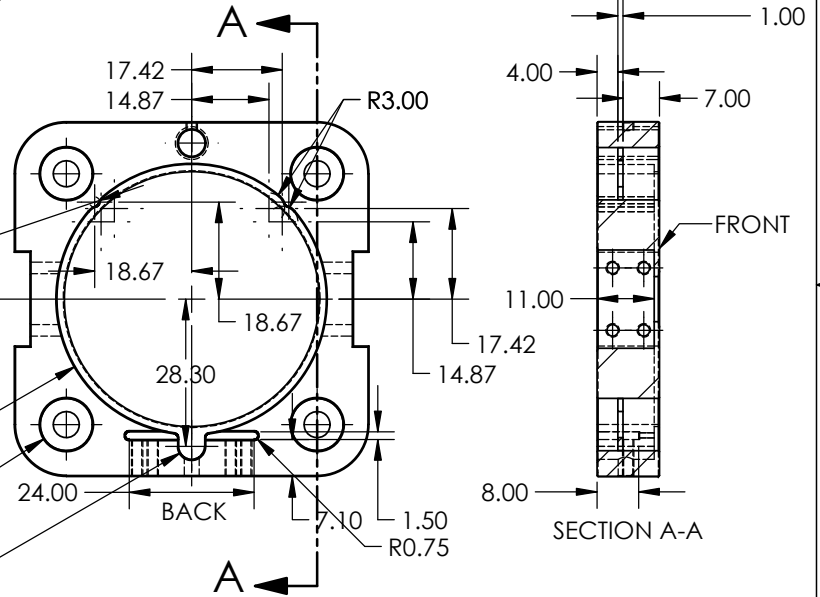
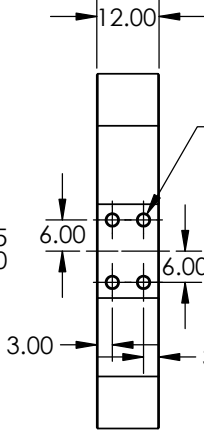
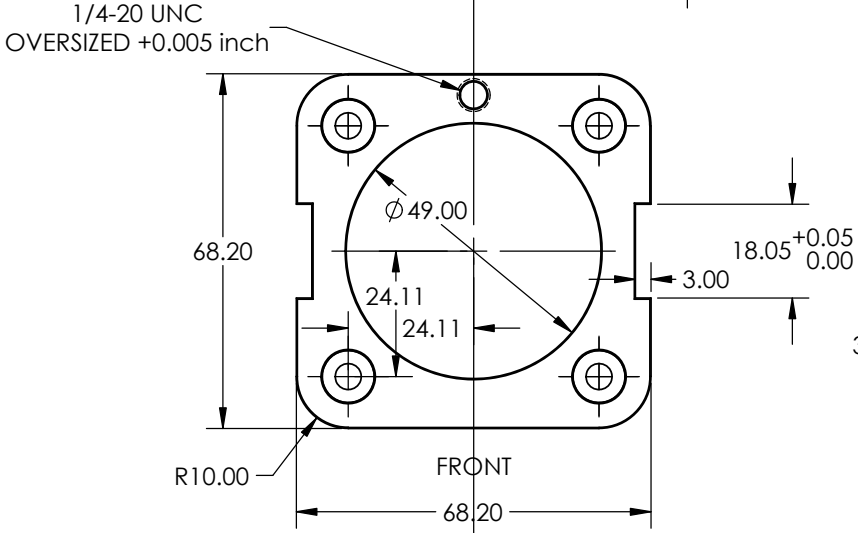
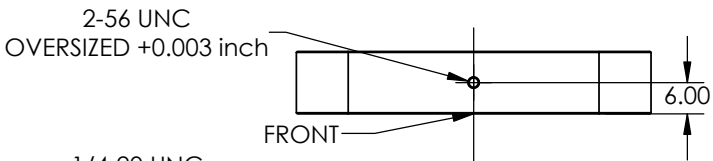
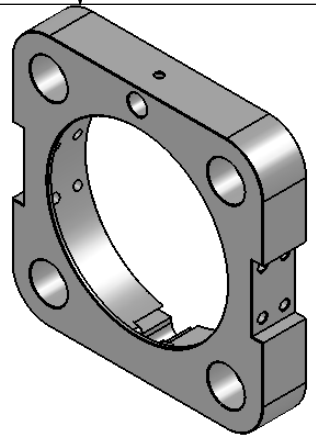


8 7 6 5 4 3 2 1

**NOTES CONTINUED:**  
 Ⓞ SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED.  
 EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

- 6. APPROXIMATE WEIGHT = X.XXX 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 SP900364.
- 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.

REV.	DATE	DCN #	DRAWING TREE #
-	-	-	-
-	-	-	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN MILLIMETERS		LIGO		Tip-Tilt Mirror Holder	
1. INTERPRET DRAWING PER ASME Y14.5-1994.		LIGO LABORATORY		DESIGNER	K. Aral
2. REMOVE ALL SHARP EDGES, R.02 MIN.		SUB-SYSTEM		DATE	18 Dec 2012
3. DO NOT SCALE FROM DRAWING.		40m		DRAFTER	K. Aral
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		NEXT ASSY		CHECKER	
TOLERANCES:		Tip-Tilt Mirror Assembly (40m)		APPROVAL	
XX ± .10		MATERIAL		SCALE: 1:1	
XXX ± .010		SUS304		PROJECTION:	
ANGULAR ± 0.5°		FINISH		DWG. NO. D1201574	
		32 Qnch		REV. v1	
				SHEET 1 OF 1	

D1001428\_v2\_Tip-Tilt\_Mirror\_Holder\_PART PDM REV: v2, DRAWING PDM REV:

6 5 4 3 2 1