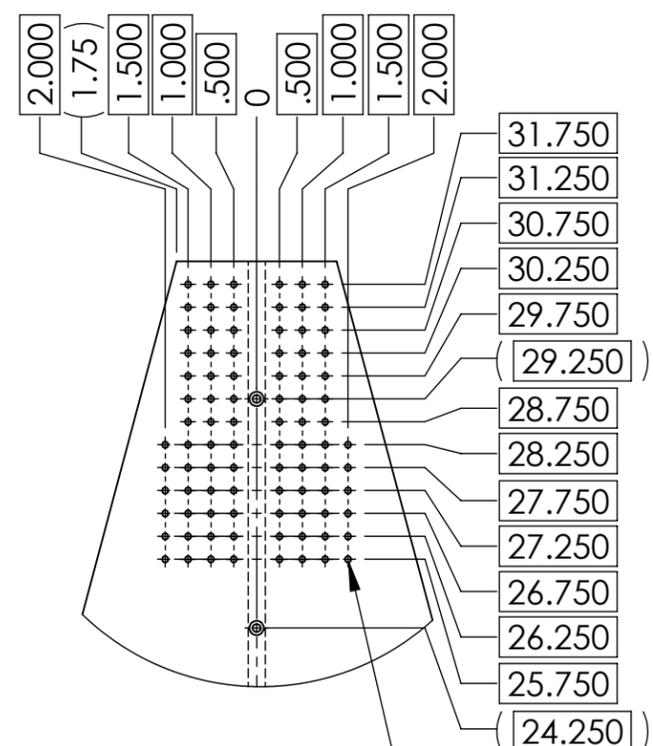


NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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 = 10.29 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.

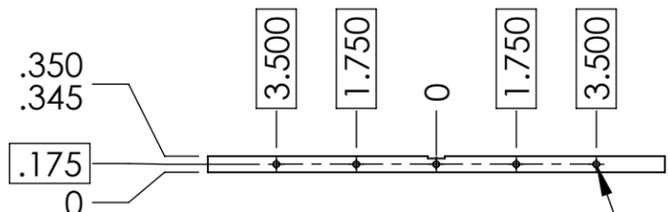
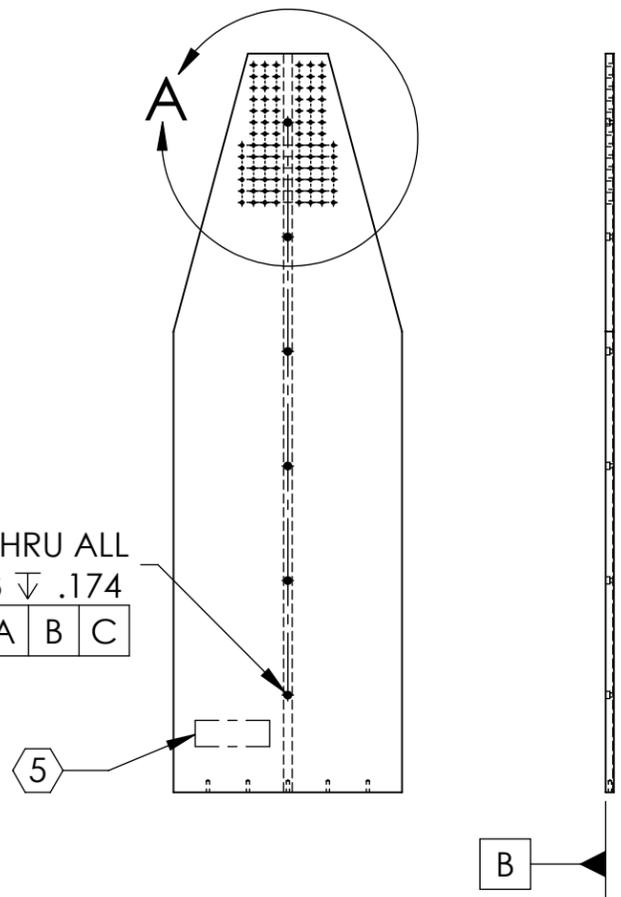
REV.	DATE	DCN #	DRAWING TREE #
v1	25-APR-13	E1300281-x0	E1300170-v1
-	-	-	-
-	-	-	-



DETAIL A
SCALE 1 : 4

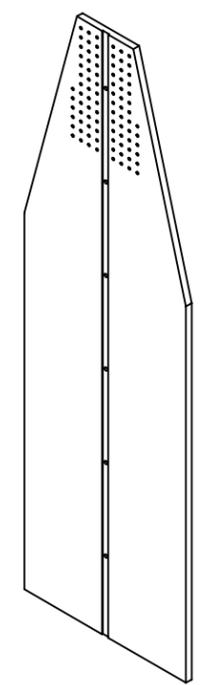
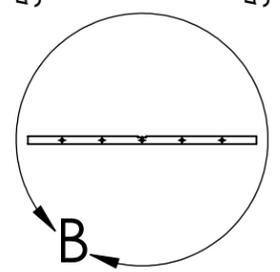
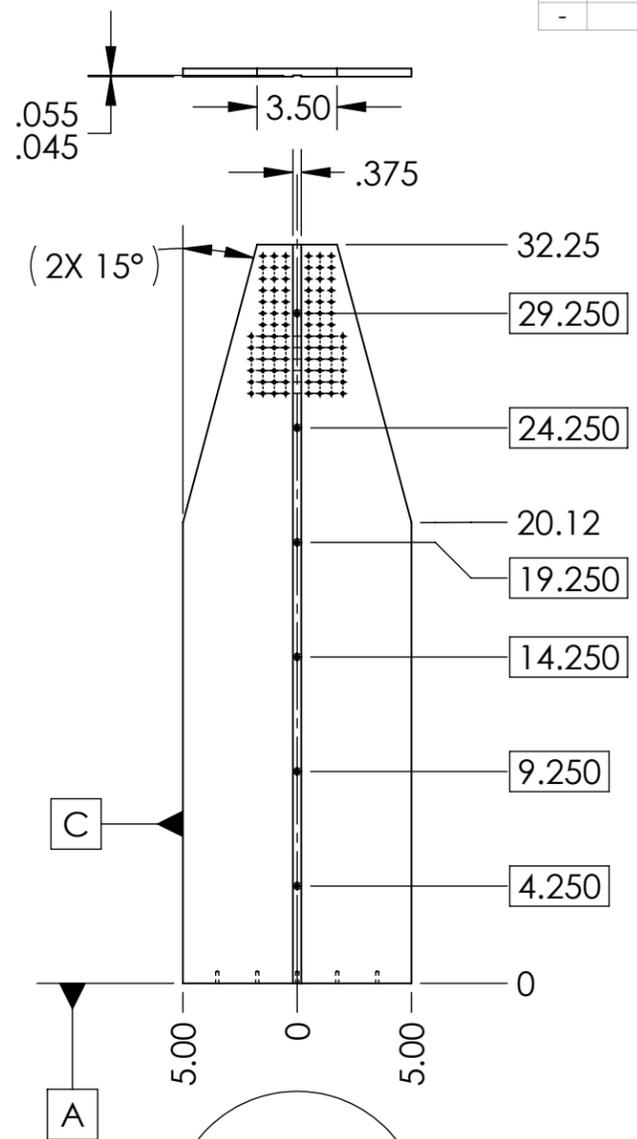
90X ϕ .136
.005 OVERSIZED TAP 8-32
THRU ALL
 ϕ .010 C A B

6X ϕ .177 THRU ALL
 ϕ .313 ∇ .174
 ϕ .010 A B C



DETAIL B
SCALE 1 : 4

5X ϕ .136 ∇ .50
.005 OVERSIZED TAP 8-32 ∇ .43
 ϕ .010 B C A



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX \pm .01
 .XXX \pm .005
 ANGULAR \pm 1.0°

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.

MATERIAL	6061 Alloy	FINISH	63 μ inch
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
DESIGNER	M.JACOBSON	04-FEB-2012	SIZE DWG. NO.
DRAFTER	M.JACOBSON	17-APR-13	B
CHECKER	J. LEWIS	18-APR-13	D1300343
APPROVAL	A. BROOKS	22-APR-13	SCALE: 1:8
NEXT ASSY		D1300198	
PROJECTION:		SHEET 1 OF 1	
REV.		v1	

D1300343_FRONT PLATE, aLIGO TCS HWSX-HWSY PERISCOPE, PART PDM REV: X-001, DRAWING PDM REV: X-005