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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 = .08 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 #
-	-	-	-
-	-	-	-
-	-	-	-

D

C

B

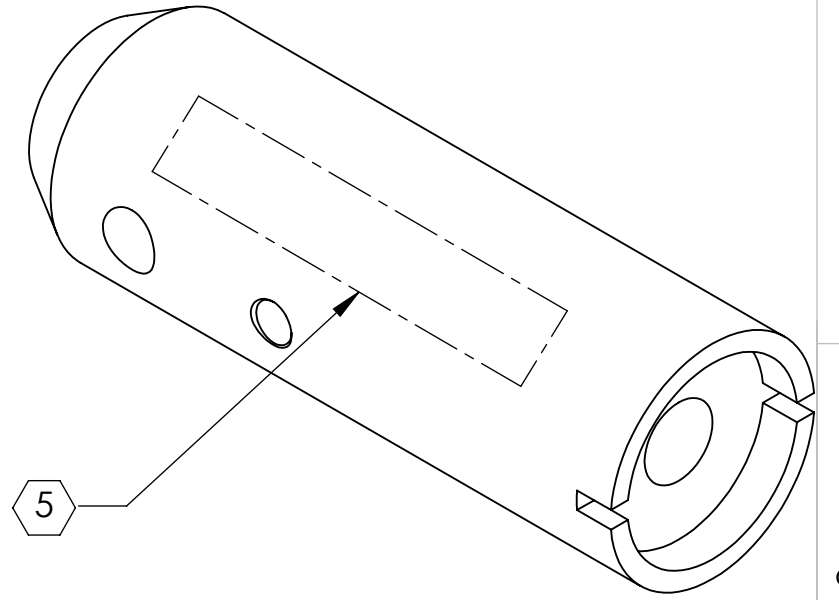
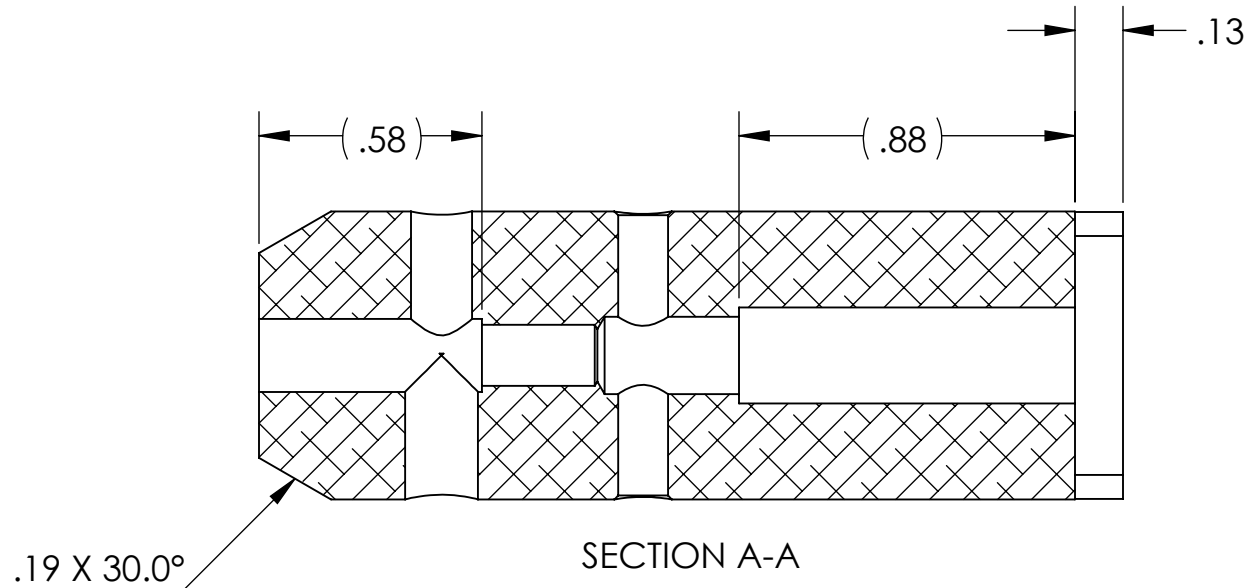
A

D

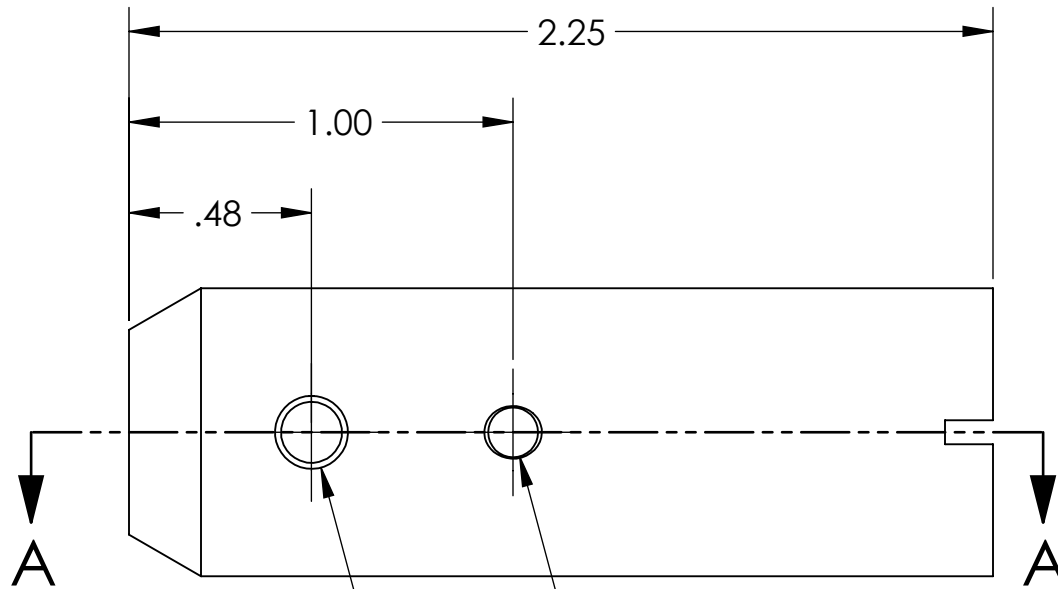
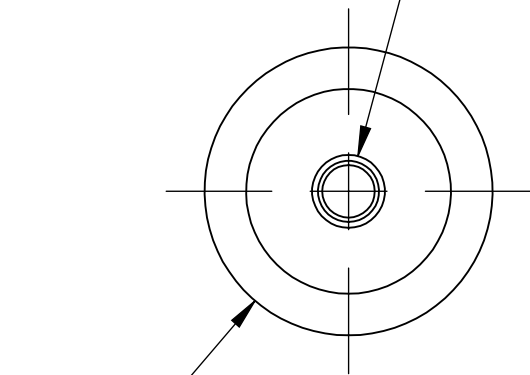
C

B

A



$\phi .159 \nabla .874$
 10-32 UNF - 2B $\nabla .580$

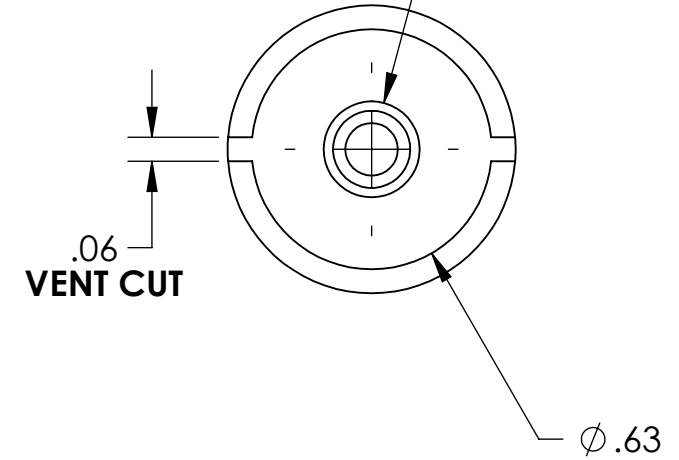


$\phi .159$ THRU ALL
 10-32 UNF - 2B $\nabla .380$

$\phi .130$ THRU ALL
 $\checkmark \phi .150 \times 90^\circ$, NEAR SIDE
 $\checkmark \phi .150 \times 90^\circ$, FAR SIDE

VENT HOLE

$\phi .201 \nabla 1.225$
 1/4-20 UNC - 2B $\nabla .875$



D1300590 OPTICAL MOUNT POST, aLIGO, PART PDM REV: X-000, DRAWING PDM REV: X-000

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX $\pm .01$.XXX $\pm .005$	
ANGULAR $\pm 0.5^\circ$	
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.	
MATERIAL	6061-T6 Al
FINISH	63 μ inch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	PART NAME		
	2.25in OPTICAL MOUNT POST, aLIGO		
	DESIGNER	SBARNUM 21 JUN 2013	
	DRAFTER	SBARNUM 21 JUN 2013	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	ISC
CHECKER		APPROVAL	PFRITSCHEL 24 JUN 2013
NEXT ASSY		SCALE:	2:1

SIZE	DWG. NO.	REV.
B	D1300590	v2
PROJECTION:	SHEET 1 OF 1	

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