

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

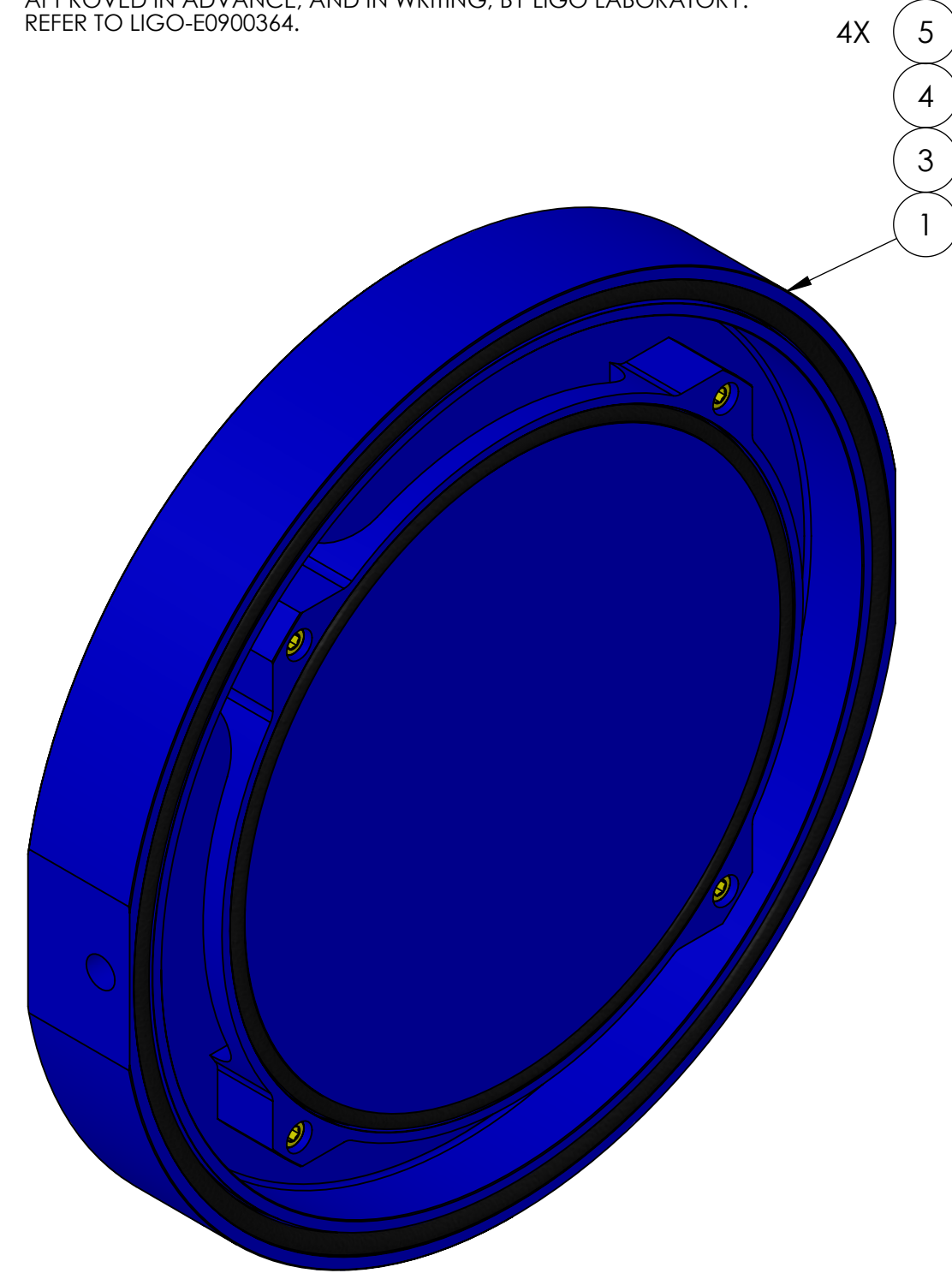
6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

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

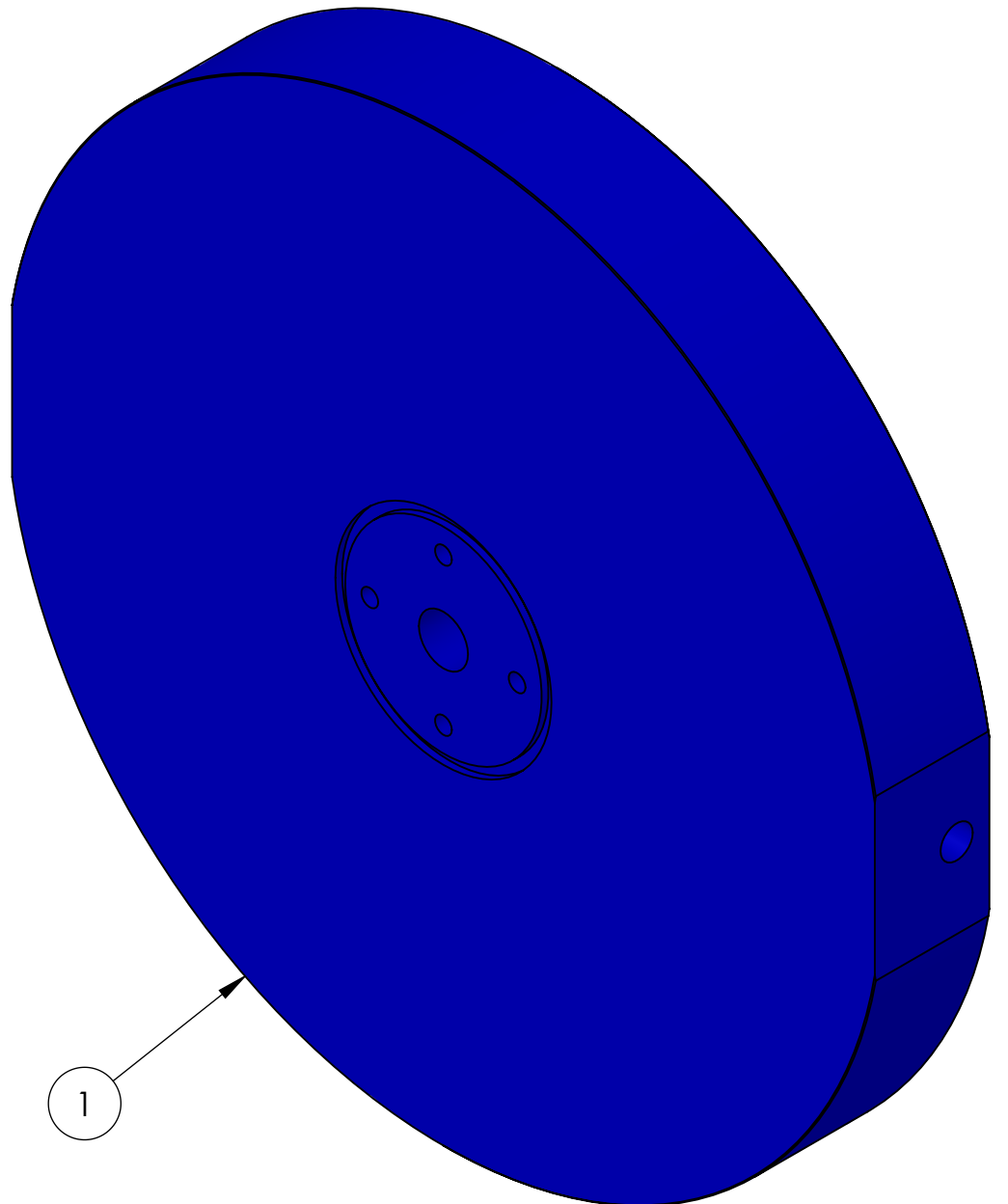
8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

-101 DETAIL

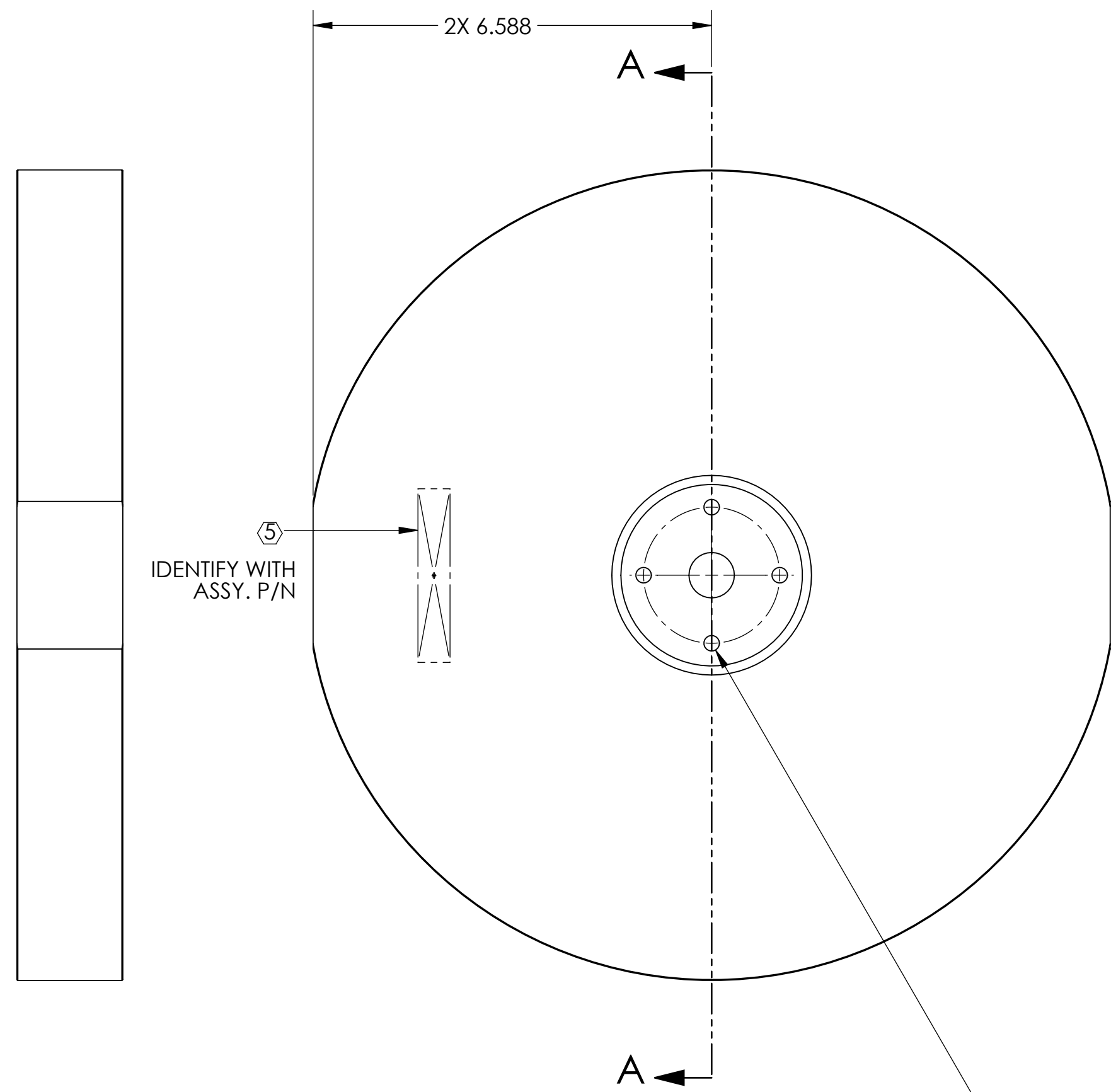
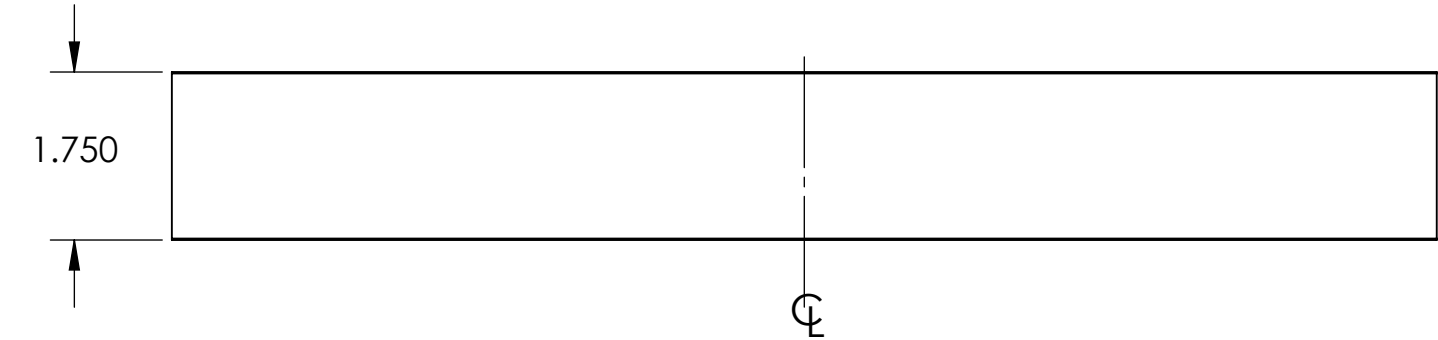
REV.	DATE	DCN #	DRAWING TREE #
v1	12 AUG 2015	-	-
v2	03 SEP 2015	-	-
v3	18 SEP 2015	E1500340-X0	-



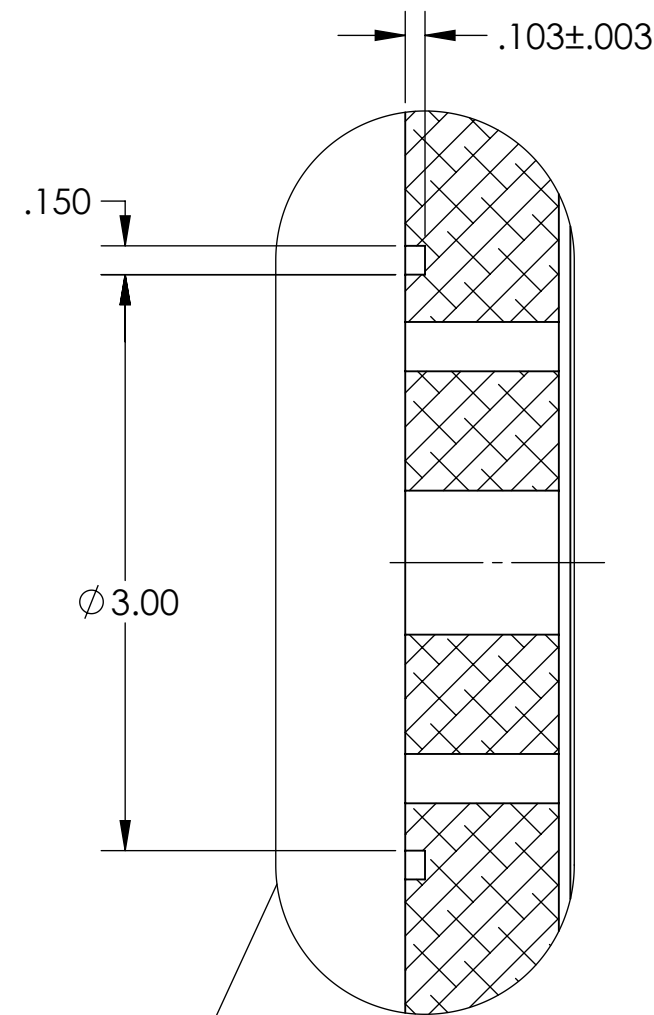
ISO VIEW, REAR-RIGHT



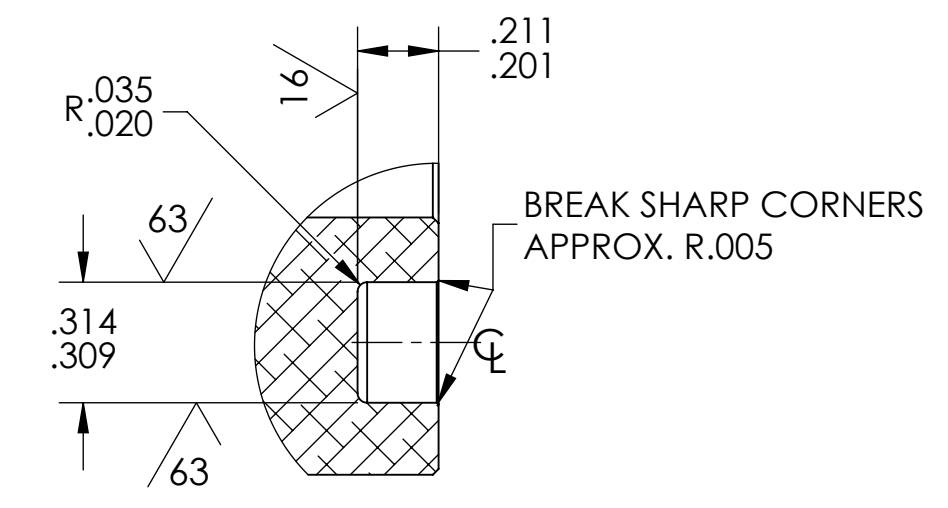
ISO VIEW, FRONT-RIGHT



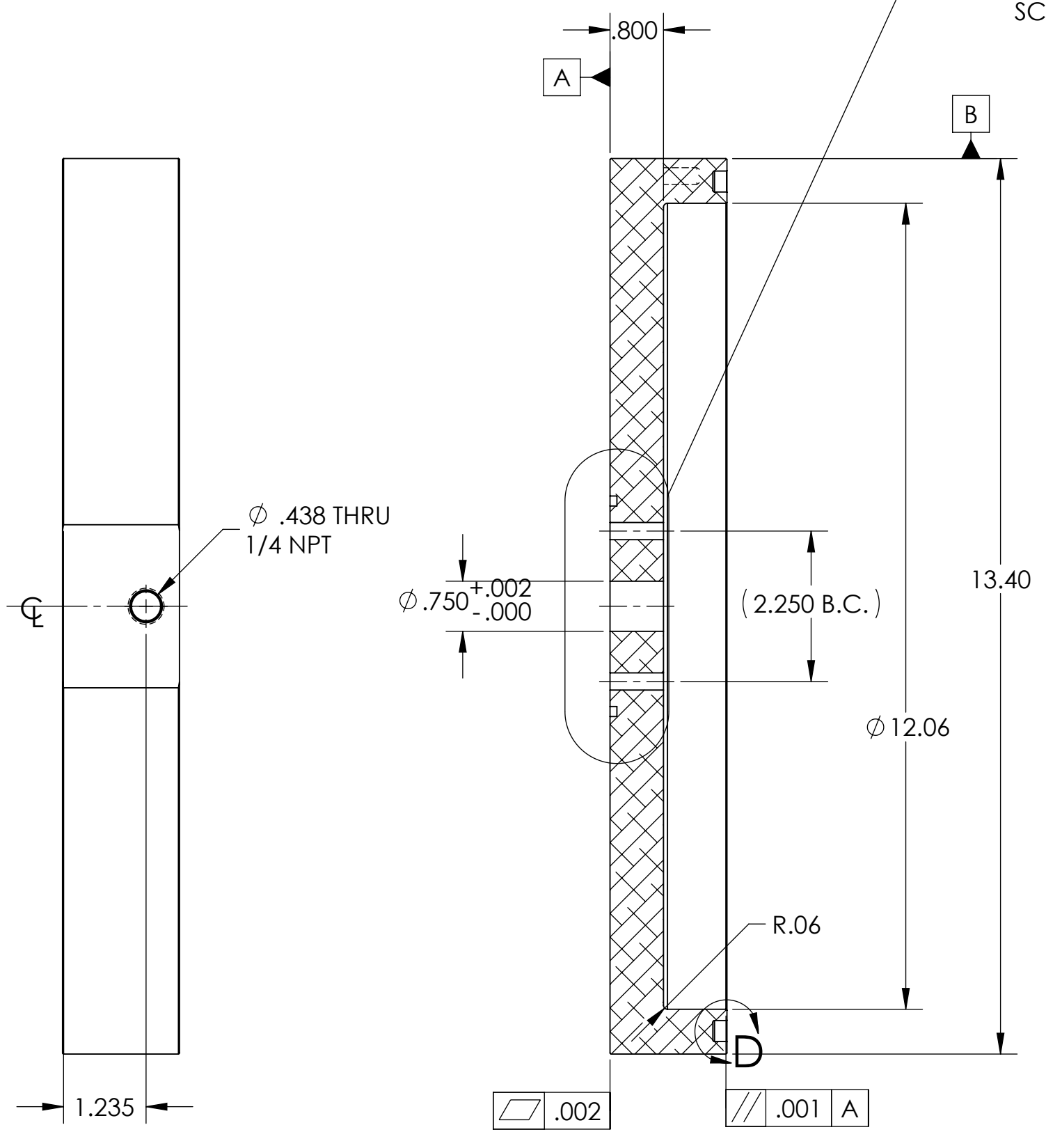
4X ϕ .257 THRU ALL
 EQ. SP. SPACED ON A ϕ 2.250 B.C.



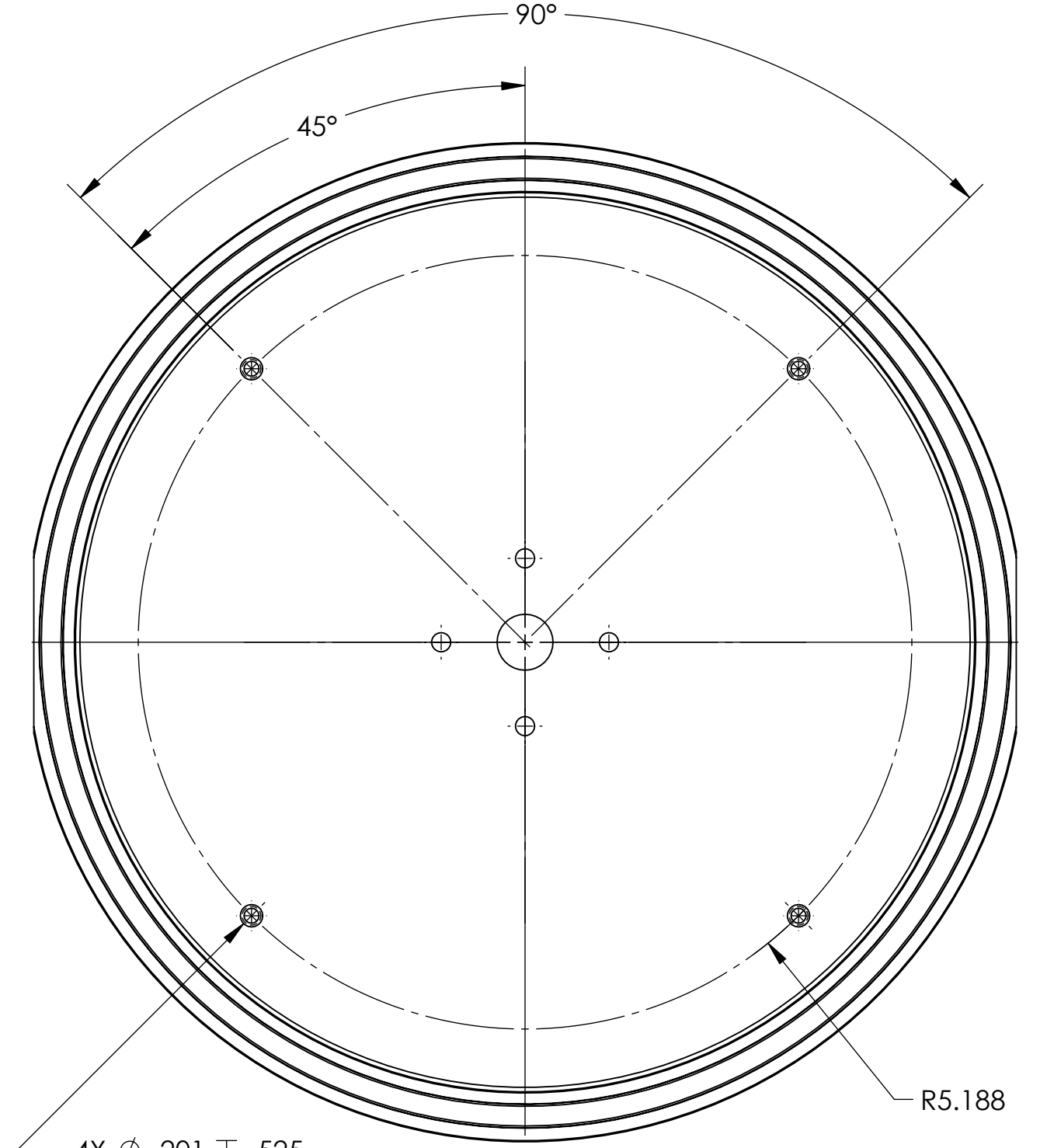
DETAIL C
 SCALE 1 : 1



DETAIL D
 SCALE 2 : 1



SECTION A-A



4X ϕ .201 ∇ .525
 1/4-20 UNC - 2B ∇ .375
 ∇ ϕ .300 X 90°, NEAR SIDE
 EQ. SP. ABOUT ϕ 10.375 B.C.

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.
5	78062 HOLO-KROME	SCREW, SHC, 1/4-20 X 1.00 LG.	18-8 SS316	4
4	2-454 PARKER OR EQ.	O-RING, 1/4 WIDTH, 12.5 ID X 13.00 OD	FLUOROELASTOMER	1
3	2-374 PARKER OR EQ.	O-RING, 3/16 WIDTH, 9.25 ID X 9.63 OD	FLUOROELASTOMER	1
2	D1500241-102	AERM VACUUM PLATE, OUTER RING	6061-T6 AL	1
1	D1500241-101	AERM VACUUM PLATE	6061-T6 AL	1

PARTS LIST

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.	
3. DO NOT SCALE FROM DRAWING.	
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
DIMENSIONS ARE IN INCHES	
TOLERANCES:	
.XX \pm .01	
.XXX \pm .005	
ANGULAR \pm 0.5°	
MATERIAL	N/A
FINISH	N/A μ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: COC

NEXT ASSY: D1002605

PART NAME: ERGO ARM, AERM VACUUM PLATE ASSY.

DESIGNER: E.SANCHEZ 12 AUG 2015 SIZE: D DWG. NO.: D1500241 REV.: v3

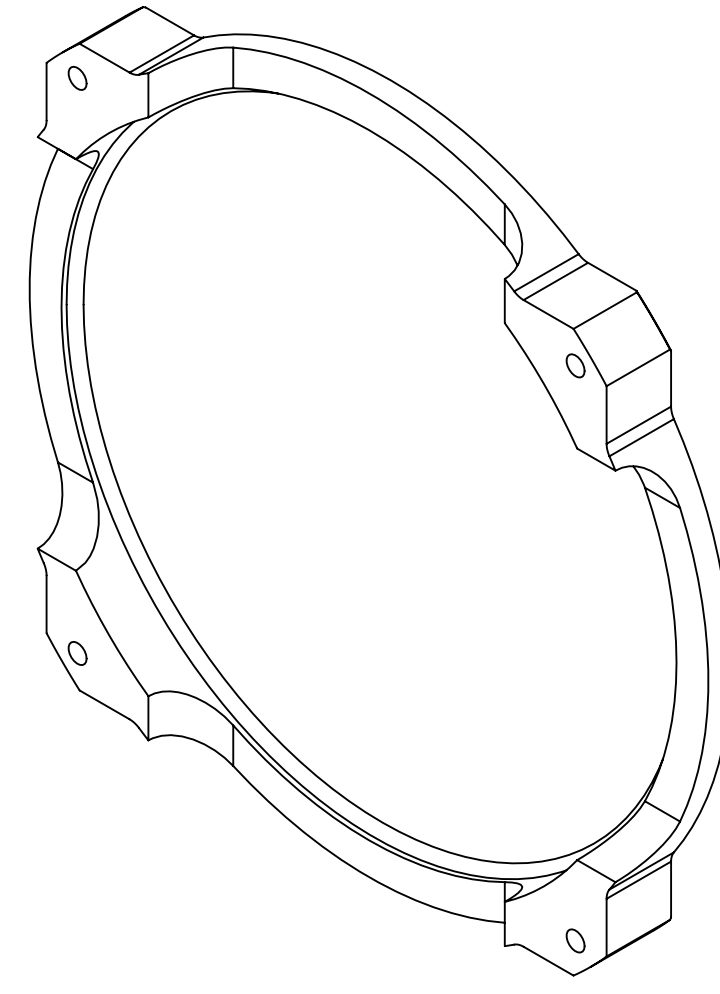
DRAFTER: E.SANCHEZ 12 AUG 2015

CHECKER: SEE DCC SEE DCC

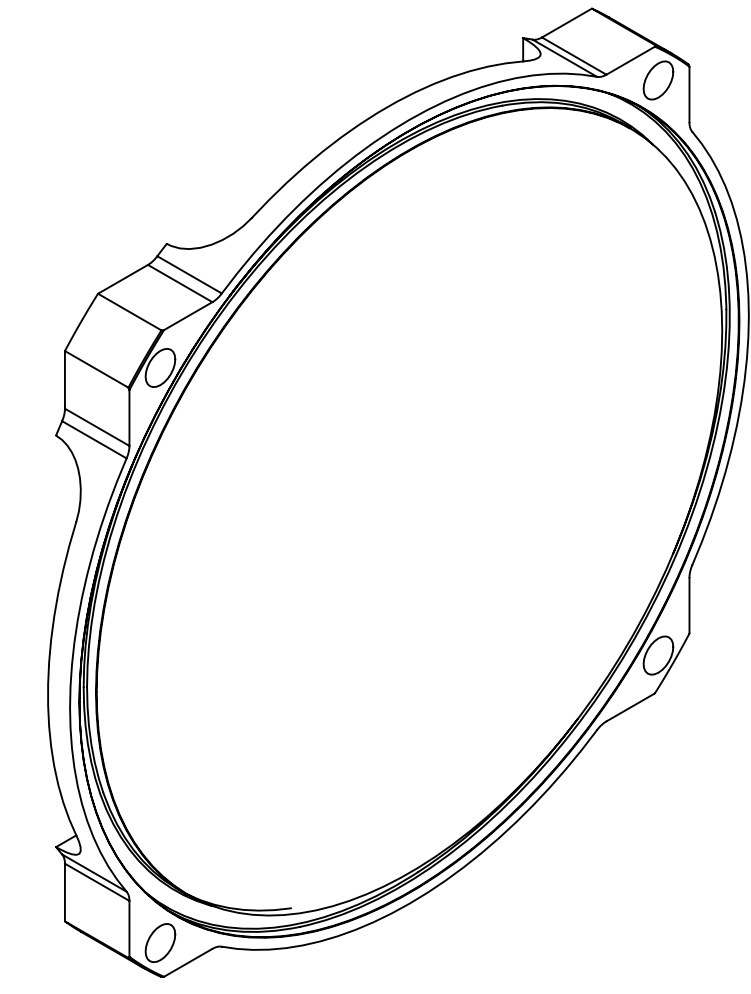
APPROVAL: SEE DCC SEE DCC

SCALE: 1:2 PROJECTION: SHEET 1 OF 2

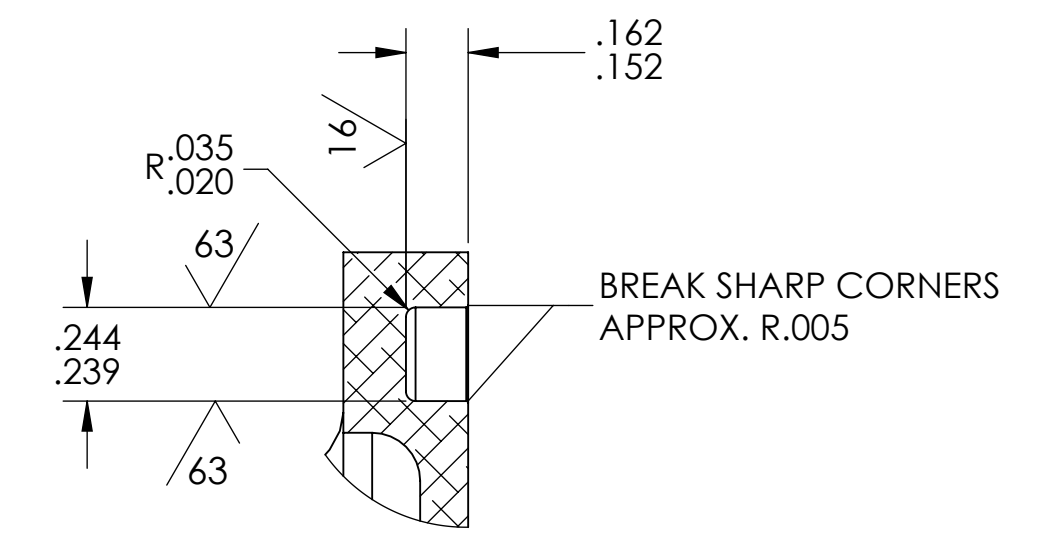
-102 DETAIL



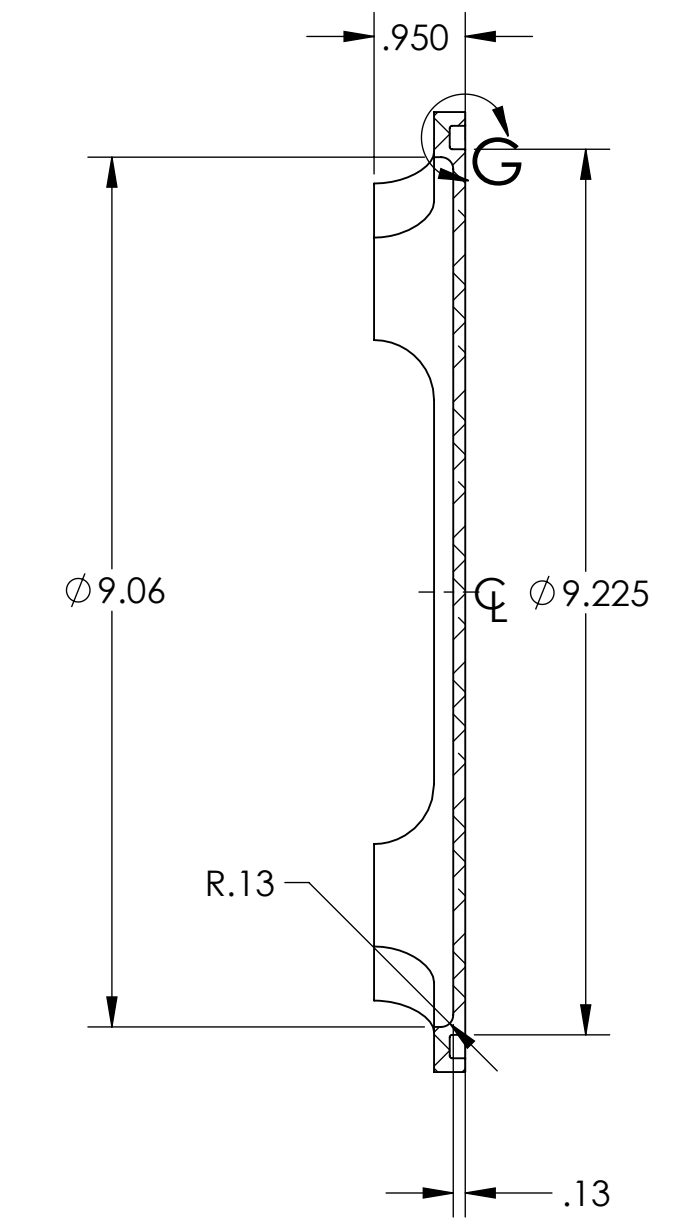
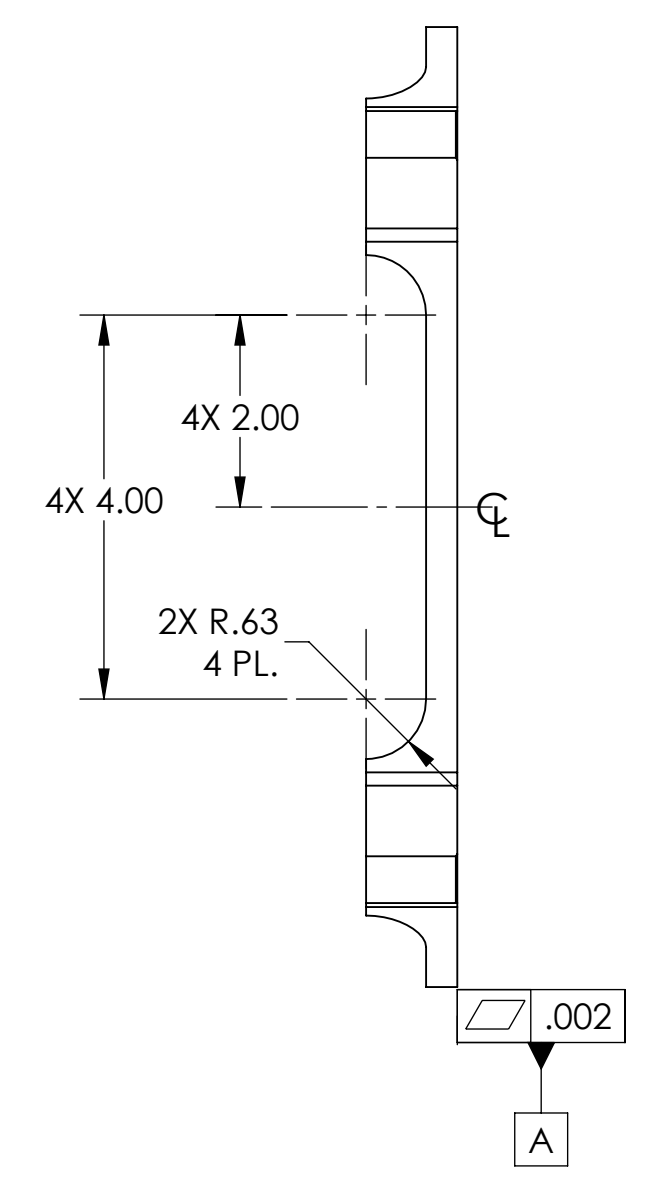
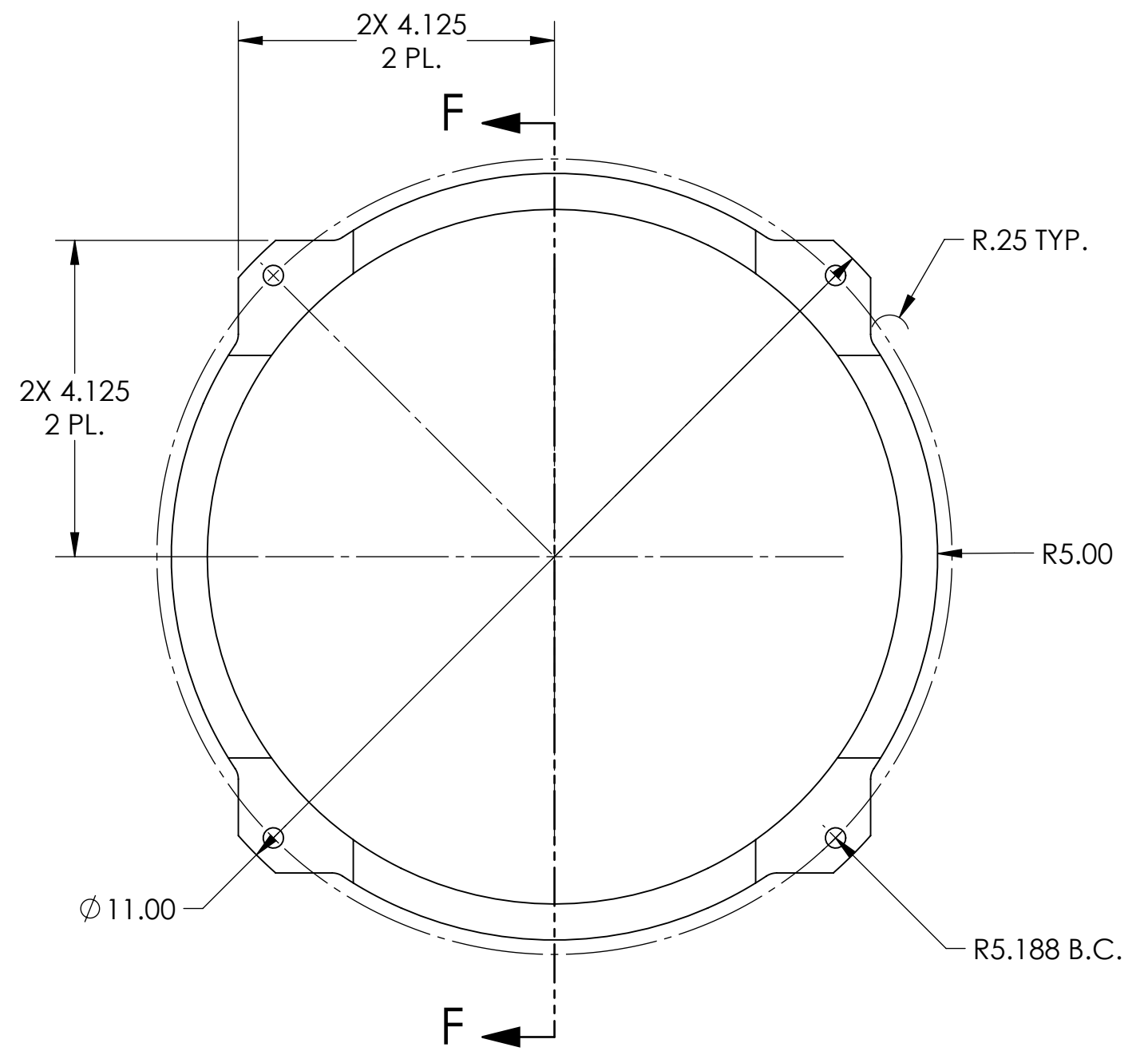
ISO VIEW, FRONT-RIGHT



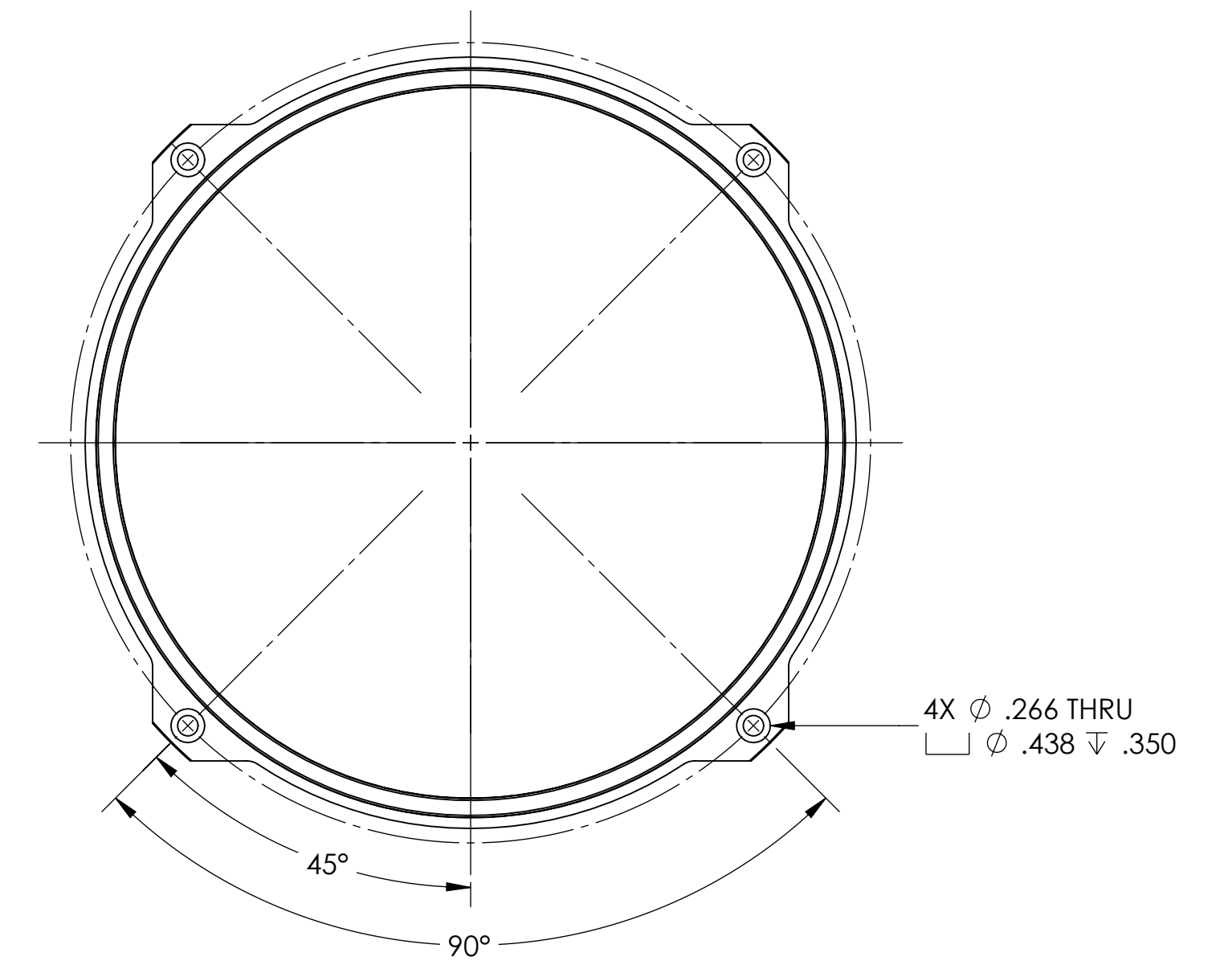
ISO VIEW, REAR-RIGHT



DETAIL G
SCALE 2:1



SECTION F-F



CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
D	D1500241	v3
SCALE: 1:2	PROJECTION:	SHEET 2 OF 2

D1500241 (LIGO) COCC ERGO ARM. AERIA VACUUM PLATE ASSY.: PART PDM REV: X-005. DRAWING PDM REV: X-009