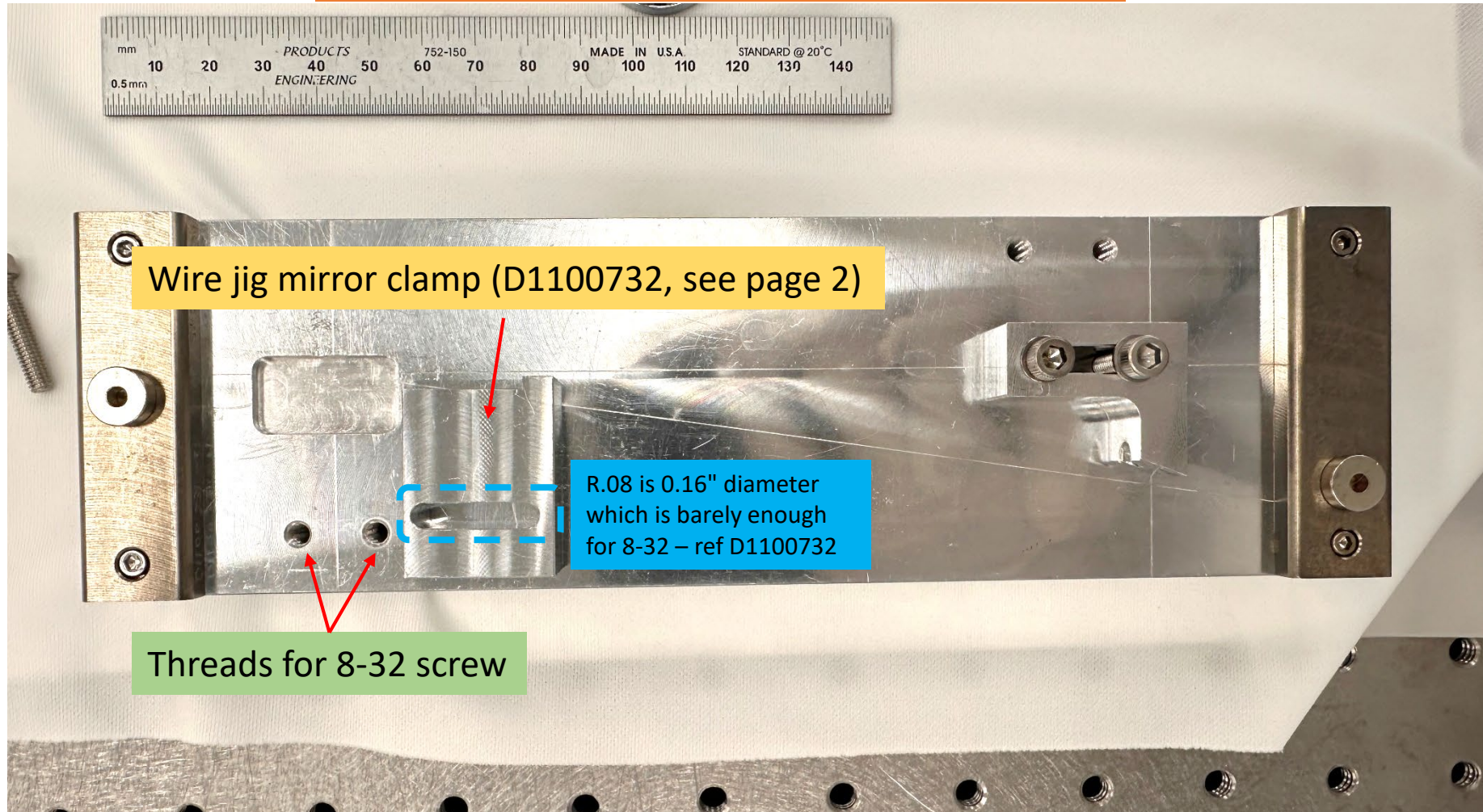


Tip Tilt Wire Jig Assembly



NOTES CONTINUED:

⑤ SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE-DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR TYPE (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
EXAMPLE (PART): 001-v1
EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD

6. APPROXIMATE WEIGHT = X.XXX LB.

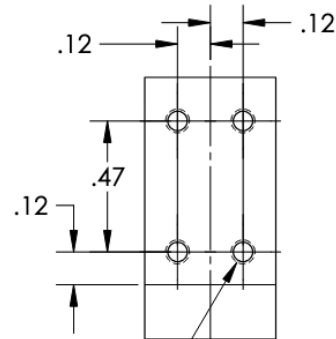
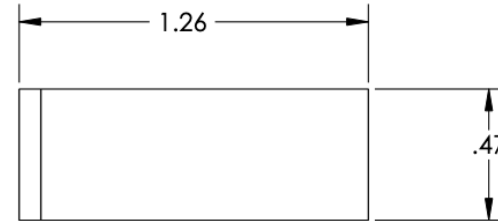
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364.

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

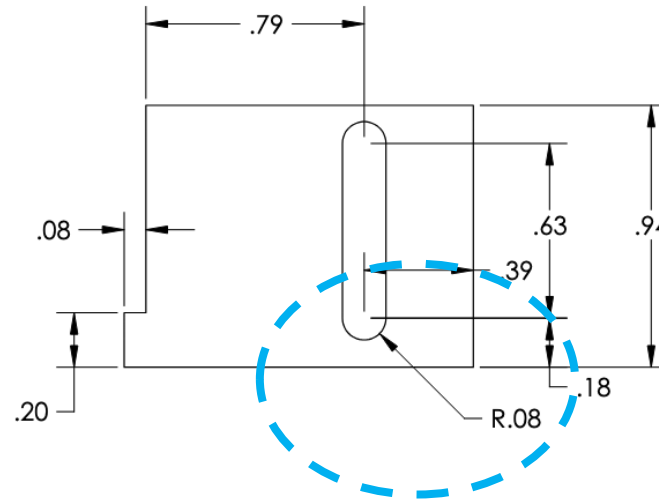
11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

12. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

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



4x #10-32 UNC, OVERSIZED +0.005



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN	1. INTERPRET DRAWING PER ASME Y14.5-1994.
TOLERANCES:	2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
.XX ±	3. DO NOT SCALE FROM DRAWING.
.XXX ±	4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.
ANGULAR ± °	MATERIAL
	6061-T6 Al
	FINISH
	63 μinch

LIGO	CALIFORNIA INSTITUTE OF TECHNOLOGY	PART NAME
MASSACHUSETTS INSTITUTE OF TECHNOLOGY		Tip-Tilt Wire Jig Mirro Clamp
SYSTEM	SUB-SYSTEM	DESIGNER
ADVANCED LIGO	ISC	BJJ Slagmolen
NEXT ASSY		19 Aug 2009
Tip-Tilt Wire Jig Assembly		SIZE
		DWG. NO.
		A
		D1100732
		SCALE: 2:1
		PROJECTION:
		SHEET 1 OF 1

D1100732_v1_Tip-Tilt_Wire_Jig_Mirro_Clamp, PART PDM REV: , DRAWING PDM REV: