

NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.

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

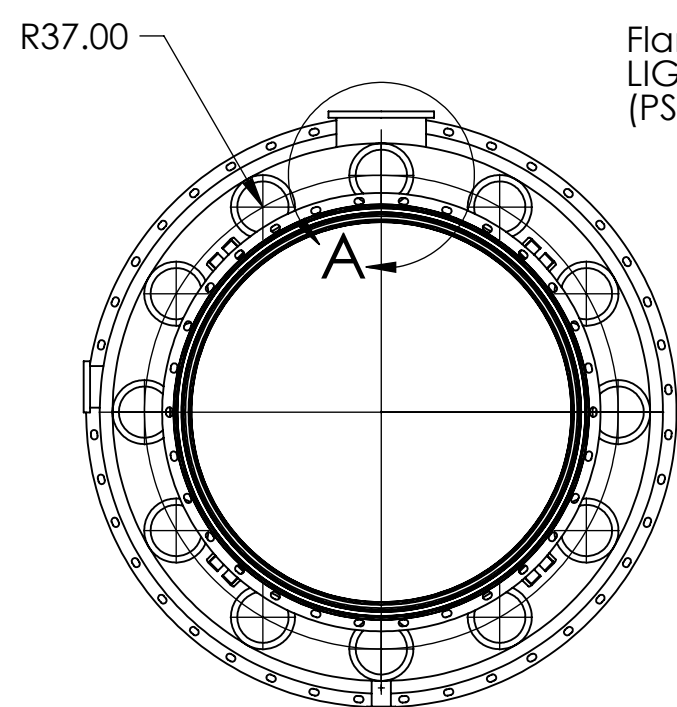
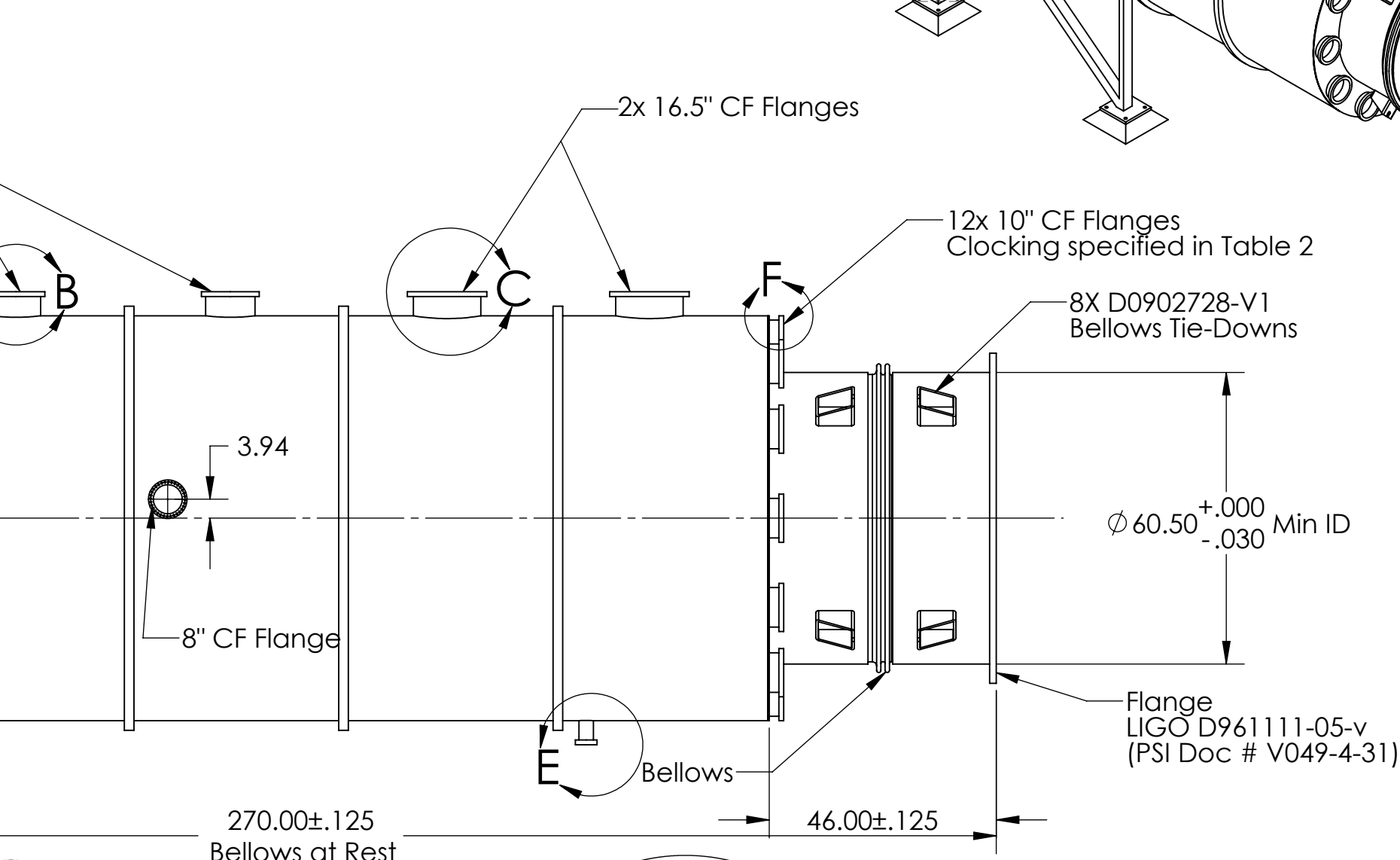
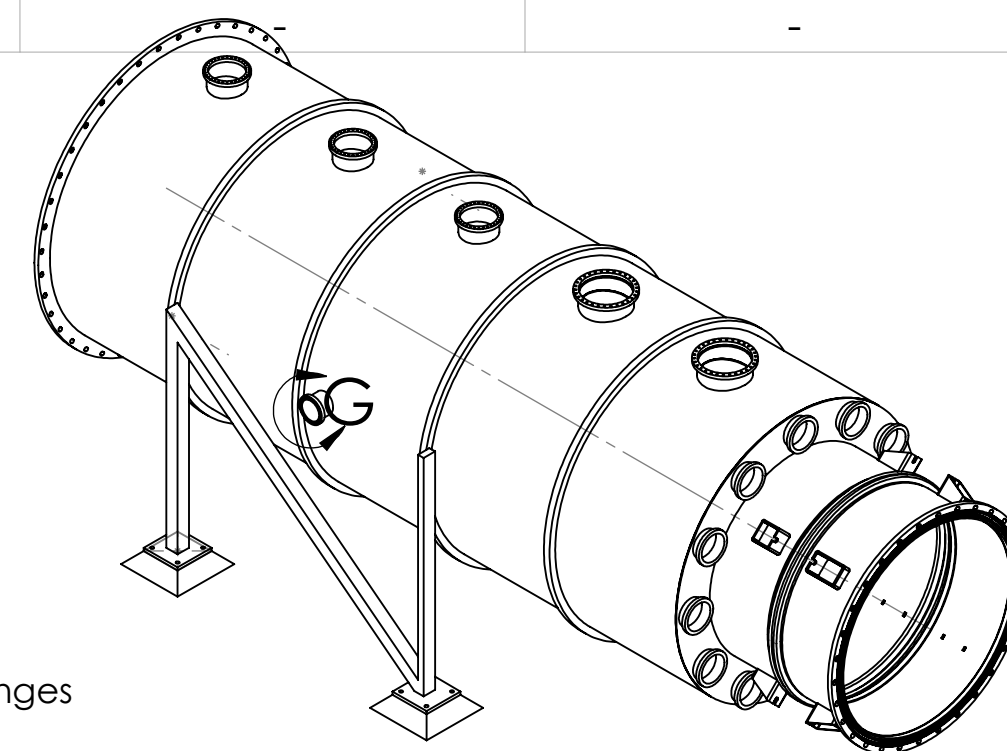
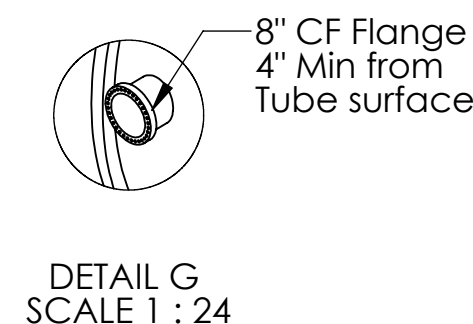
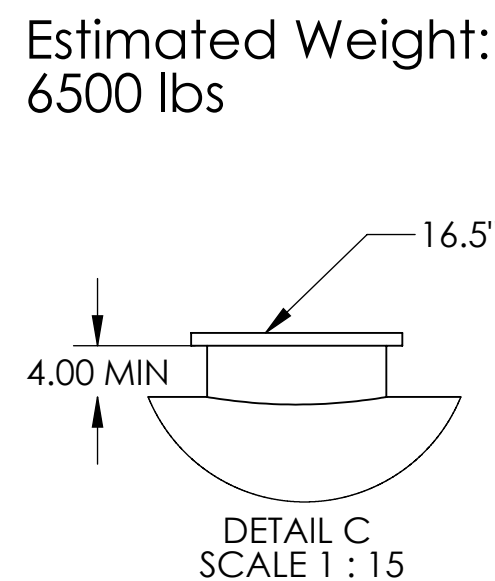
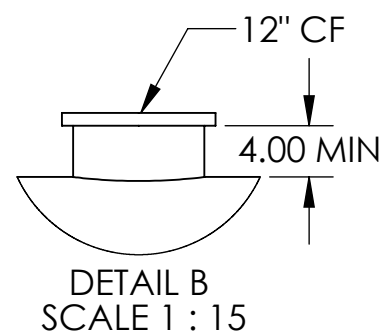
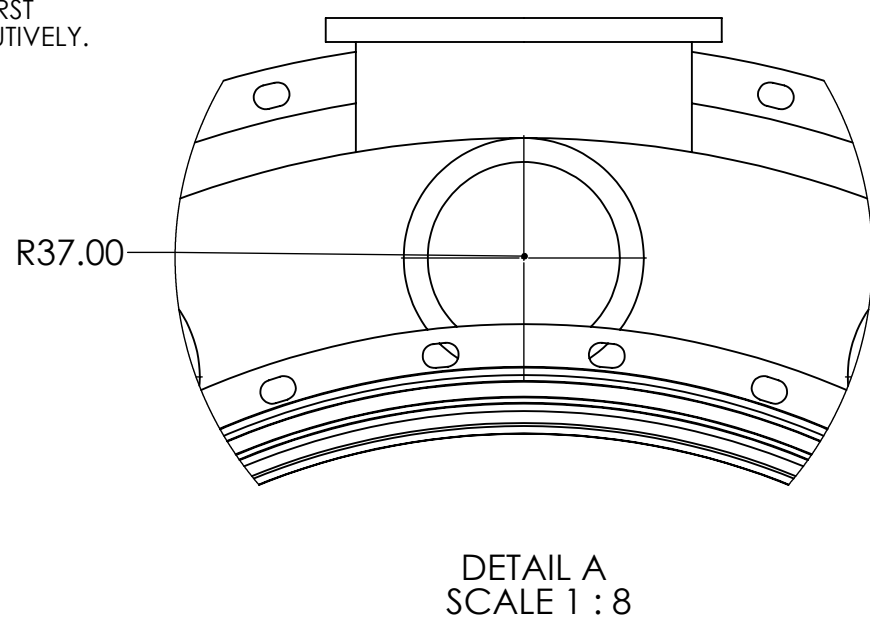


Table 1: Required Tag Numbers

LAMCB1
LAMCB2
WAMCB1
WAMCB2
WAMCB3
WAMCB4

Flange LIGO D961105-03-v (PSI Doc# V049-4-21)

Table 2: Viewport Clocking
12 o'clock = 0°

Hole Clock Position	LAMCB1 WAMCB1	LAMCB2 WAMCB2	WAMCB3	WAMCB4
1	30°	23°	30°	30°
2	60°	60°	60°	60°
3	90°	90°	90°	90°
4	120°	120°	120°	120°
5	150°	157°	150°	146°
6	175°	180°	190°	172°
7	201°	210°	215°	194°
8	240°	240°	240°	240°
9	270°	270°	270°	270°
10	300°	300°	300°	300°
11	339°	330°	322°	346°
12	365°	360°	344°	368°

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES, R.02 MIN.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.

MATERIAL: AISI 304
 FINISH: μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: FMP
 SUB-SYSTEM: VE
 NEXT ASSY:

PART NAME: ADLIGO MCB Tube Section

DESIGNER	SIZE	DWG. NO.	REV.
DRAFTER	c	D0902631	5
CHECKER	SCALE: 1:48	PROJECTION:	SHEET 1 OF 1
APPROVAL			