

REV.	DATE	DCN #	DRAWING TREE #
v1	01 Mar. 2010	E1000115	E1000025

NOTES CONTINUED:

5. SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXX-VY, TYPE-XX, S/N XXX.

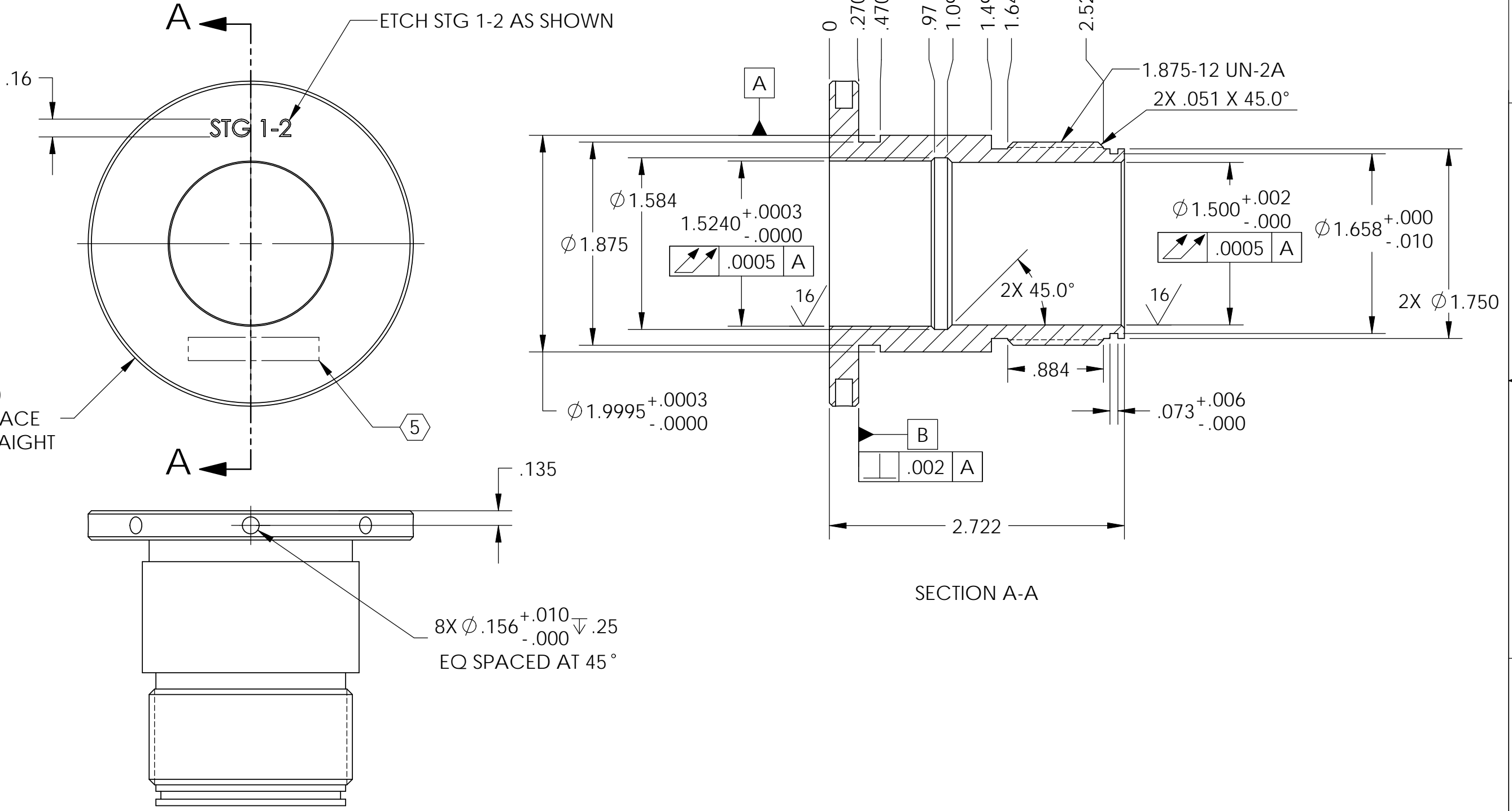
6. APPROXIMATE WEIGHT = 1.161 LB.

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

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

9. BEFORE FINAL MACHINING HEAT TREAT TO RC57 PER AMS-H-6875A.

10. COAT ALL SURFACES WITH OERLIKON BALZERS BALINIT C-WC/C. ALL DIMENSIONS APPLY AFTER COATING.



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		Sleeve, Stage 1-2 Locker, aLIGO BSC-ISI	
TOLERANCES: .XX ± .015 .XXX ± .005				SUB-SYSTEM SEI		DESIGNER	A.STEIN 01 Mar. 2010
ANGULAR ± .5°				NEXT ASSY D1000855		DRAFTER	M.HILLARD 01 Mar. 2010
MATERIAL AISI 440C PER AMS 5630				FINISH 63 μinch		CHECKER	F.MATICHERD 01 Mar. 2010
						APPROVAL	K.MASON 01 Mar. 2010
						SIZE	DWG. NO. D1000875
						REV.	v1
						SCALE	1:1
						PROJECTION	ASME
						SHEET 1 OF 1	

D1000875 Sleeve, Stage 1-2 Locker, aLIGO BSC-ISI, PART PDM REV: X-002, DRAWING PDM REV: X-002