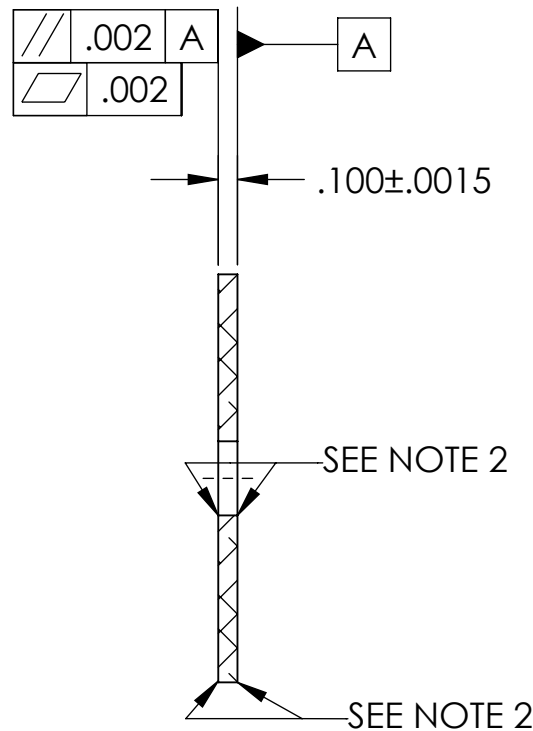
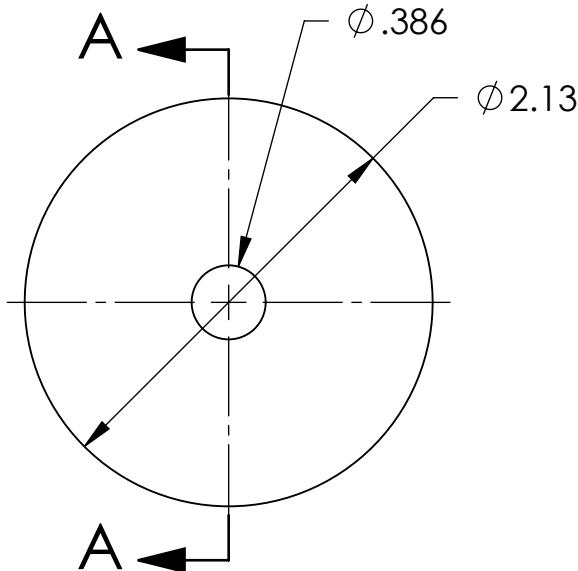


NOTES CONTINUED:

- 5. BAG AND TAG PARTS SEPARATELY WITH THEIR DRAWING PART NUMBER, REVISION, AND SERIAL NUMBER. SERIAL NUMBERS START AT 001 (UNLESS OTHERWISE SPECIFIED) FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY.
EXAMPLE:
DXXXXXX-vY
S/N-001
- 6. APPROXIMATE WEIGHT = .10 LB [44.2 G].
- 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.
- 9. WATERJET CUT FROM .125 SHEET STOCK.
- 10. DOUBLE ASC GRIND TO $\sqrt{63}$ µinch Ra AND ELECTROPOLISH TO REMOVE .0005 PER SURFACE.

REV.	DATE	DCN #	DRAWING TREE #
v1	15 MAR 2011	E1100080-v1	-
v2	27 JUN 2011	E1100351	-
v3	26 MAR 2012	E1200317-x0	-



SECTION A-A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:

.XX ± .01
.XXX ± .005

ANGULAR ± °

- 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

304 SSTL

FINISH



CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM

ADVANCED LIGO

SUB-SYSTEM

AOS

NEXT ASSY

D1003120

PART NAME

ALIGO ETM
TELESCOPE TUBE LARGE WASHER

DESIGNER K. MAILAND 10 MAY 2010

DRAFTER C. CONLEY 15 MAR 2011

CHECKER SEE DCC SEE DCC

APPROVAL SEE DCC SEE DCC

SIZE DWG. NO.

A D1001108

REV.

v3

SCALE: NONE PROJECTION:



SHEET 1 OF 1