

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. APPROXIMATE WEIGHT = 1.23 LB [.56 KG].

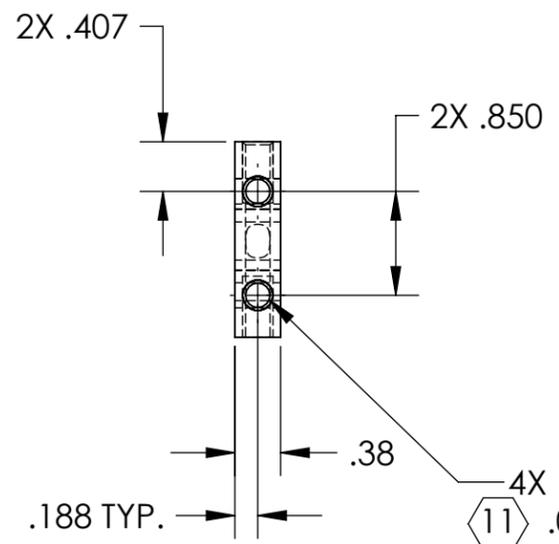
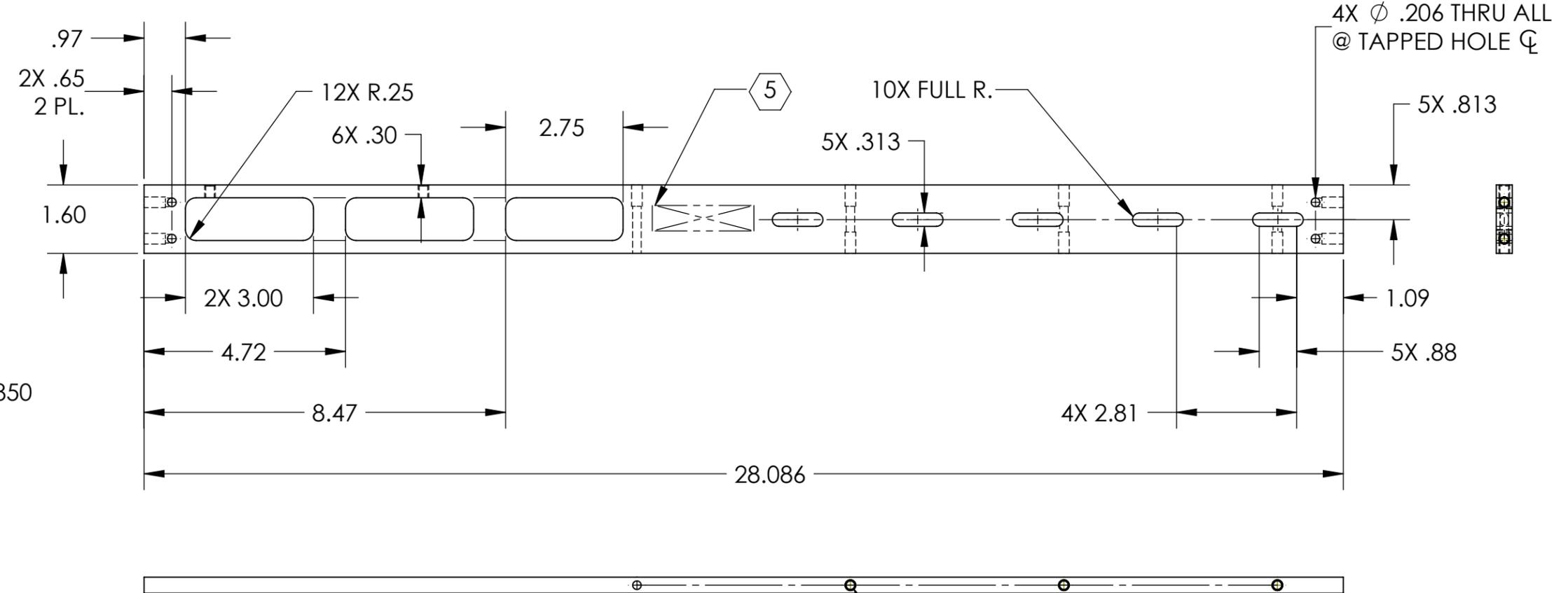
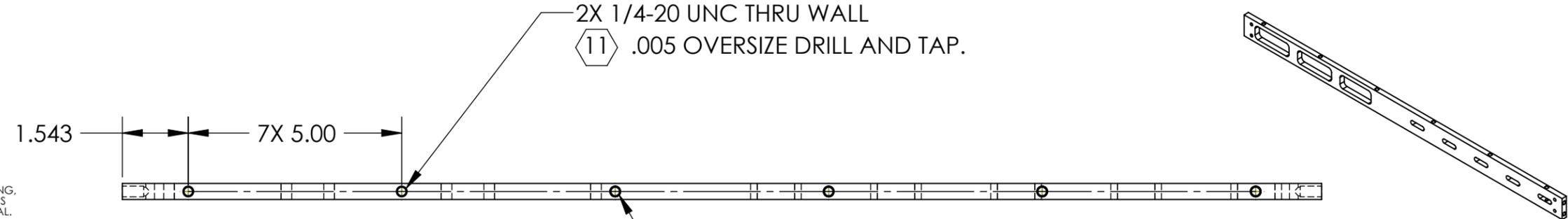
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

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

9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.

10. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 DEC 2010	E1000762-v1	-
v2	11 NOV 2011	E1100080-v1	-
v3	24 MAR 2012	E1200317-x0	-



DETAIL A
SCALE 2 : 3
BOTH ENDS

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES, .005 - .015.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± 1.0°

MATERIAL	6061-T6 Al	FINISH	63 μinch Ra
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		qLIGO OPTICS TABLE GUSSET PLATE, SMALL	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	AOS	DESIGNER	K. MAILAND
NEXT ASSY	D1001160	DRFTER	M. MILLER	DATE	10/09/210
		CHECKER	SEE DCC	DATE	11/09/2010
		APPROVAL	SEE DCC	DATE	SEE DCC
				SIZE	DWG. NO.
				B	D1001164
				REV.	v3
				SCALE:	1:3
				PROJECTION:	
				SHEET 1 OF 1	

D1001164 qLIGO OPTICS TABLE GUSSET PLATE, SMALL, PART PDM REV: X-036, DRAWING PDM REV: X-038