

NOTES: UNLESS OTHERWISE SPECIFIED

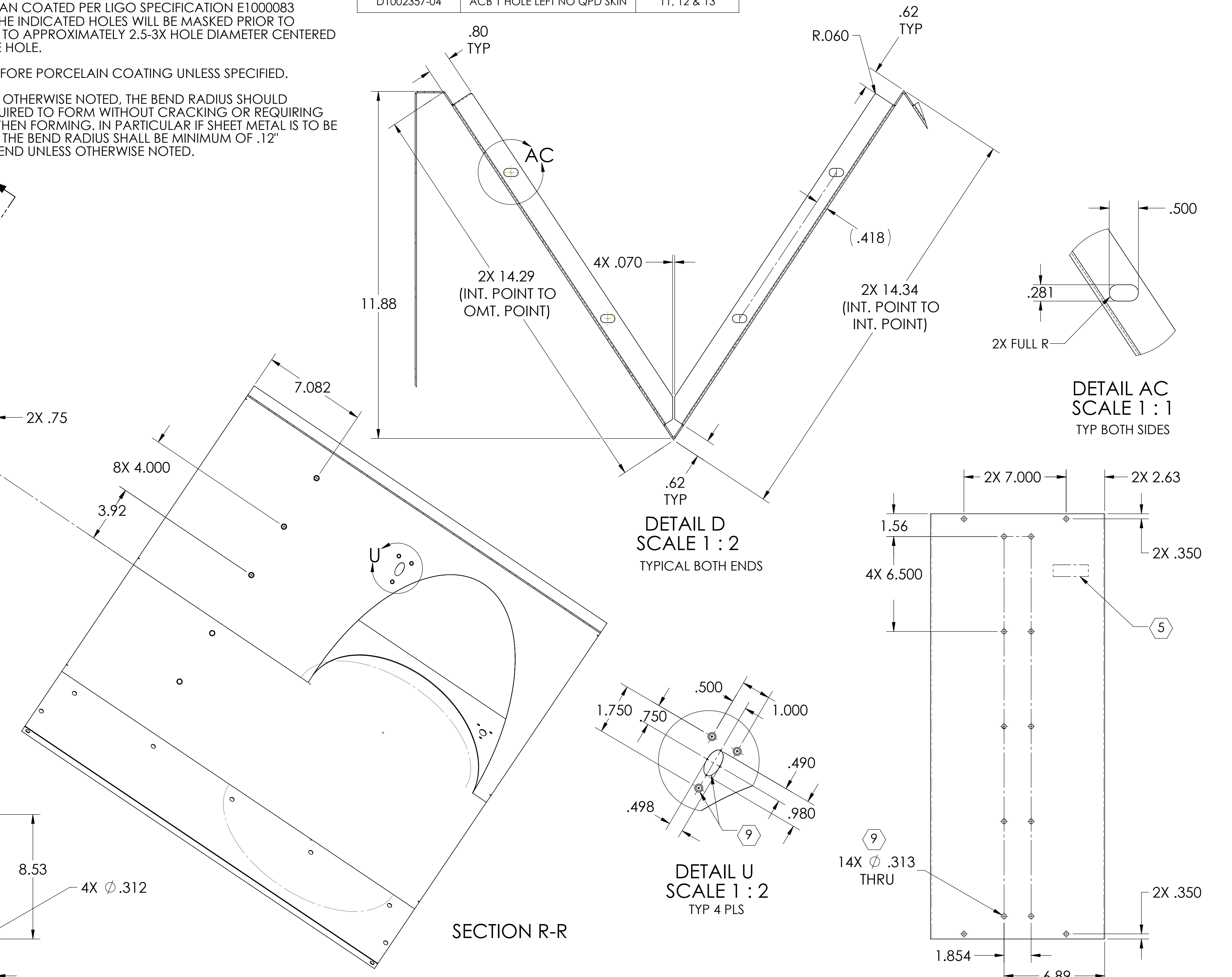
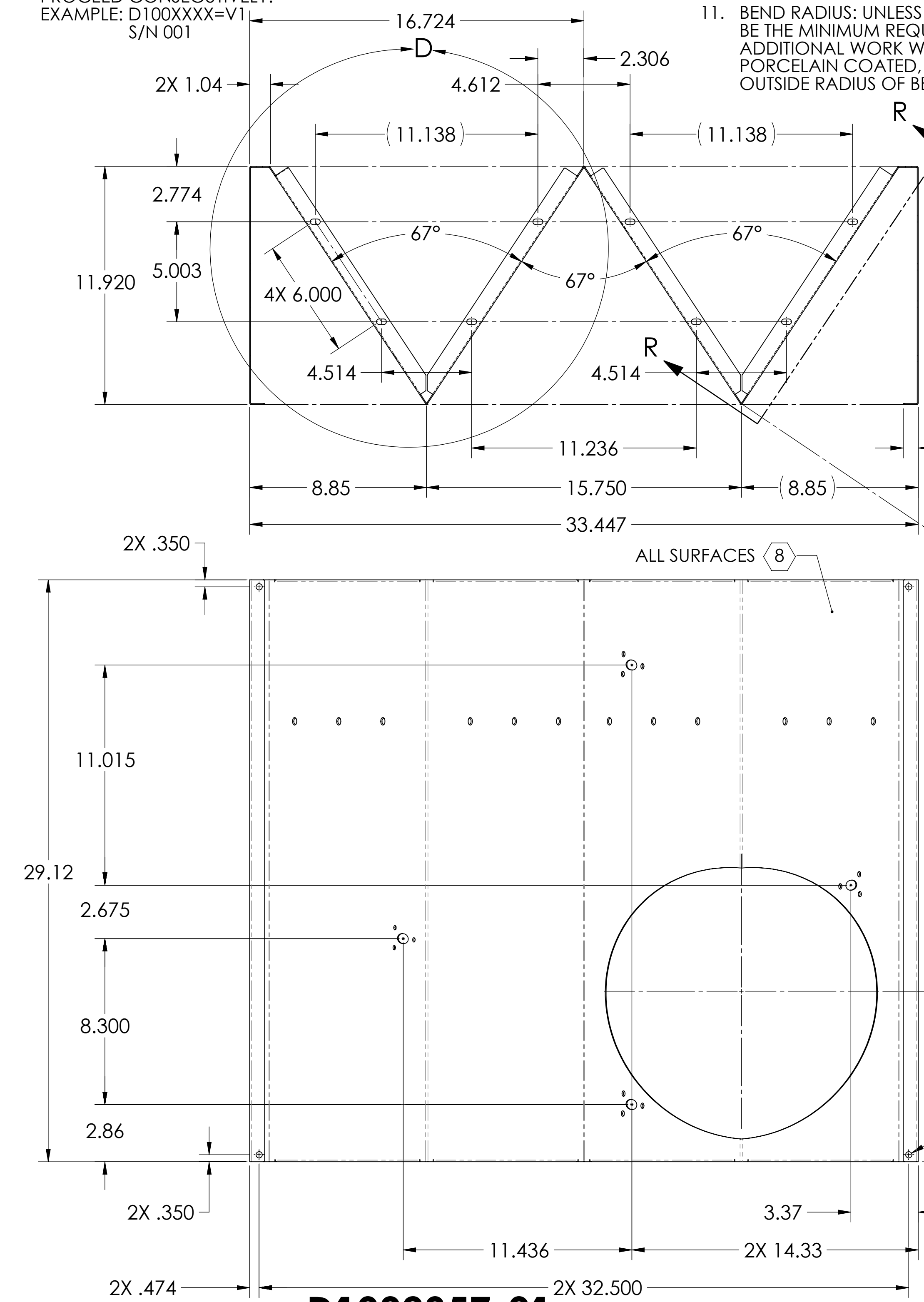
1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES AND BURRS AND ROUND EDGES APPROXIMATELY R.02.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINE FLUIDS MUST BE FULLY SYNTHETIC, FULL WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE PER LIGO DOCUMENT E0900237.
5. MECHANICALLY STAMP (NO INKS OR DYES) PART NUMBER, REVISION AND SERIAL NUMBER .020 DEEP WITH MINIMUM CHARACTER HEIGHT .156 APPROXIMATELY WHERE SHOWN. SERIAL NUMBER WILL START AT 001 AND PROCEED CONSECUTIVELY. EXAMPLE: D100XXX=V1 S/N 001

6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPEC E0900364.
7. ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NO WELD REPAIRS OR PLUGS) UNLESS APPROVED IN ADVANCE, IN WRITING, BY LIGO PER SPECIFICATION E0900364.
8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
9. PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION. THE INDICATED HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING TO APPROXIMATELY 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF THE HOLE.
10. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.
11. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.

12. SEE CAD FILE # D10002357.SLDPR1 TO GENERATE ELLIPSE CURVES.

PART NO.	DESCRIPTION	SEE SHEET NO.
D1002357-01	ACB 1 HOLE RIGHT-QPD SKIN	1, 2, 3 & 4
D1002357-02	ACB 1 HOLE LEFT-QPD SKIN	5, 6 & 7
D1002357-03	ACB 1 HOLE RIGHT NO QPD SKIN	8, 9 & 10
D1002357-04	ACB 1 HOLE LEFT NO QPD SKIN	11, 12 & 13

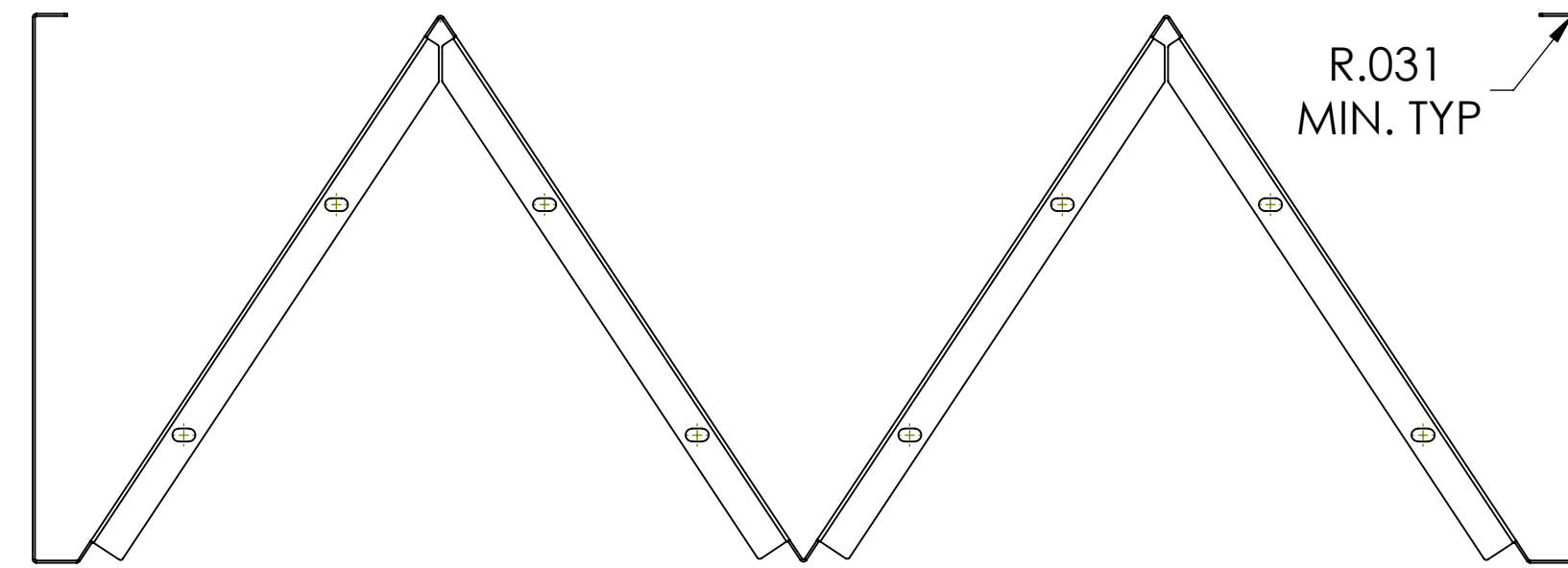
REV.	DATE	DCN #	DRAWING TREE #
v1	03 JAN 2011	E1000868	
v2	20 MAR 2011	E1100216	



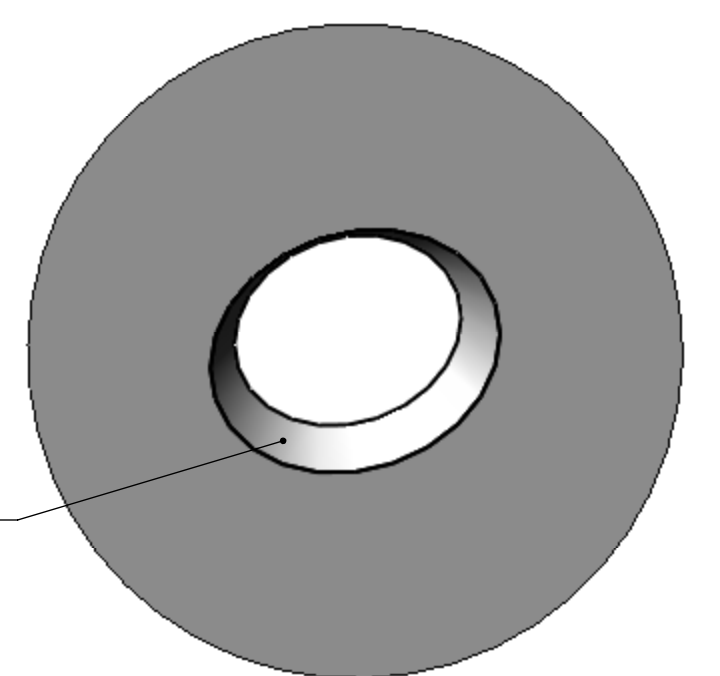
**D1002357-01
ONE HOLE RIGHT QPD SKIN**

DIMENSIONS ARE IN INCHES		TOLERANCES: .XX ± .03 .XXX ± .015		ANGULAR ± 1.0°		MATERIAL 18 GA ENAMEL STL A424 TYPE I		FINISH 9		NEXT ASSY D1002356		PART NAME ACB ONE HOLE SKIN		DESIGNER N.Nguyen		DRAFTER N. NGUYEN		CHECKER M. SMITH		APPROVAL D. COYNE		SIZE D		DWG. NO. D1002357		REV. v2	
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		LIGO		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS		DESIGNER N.Nguyen		20 DEC 2010		D		SCALE: 1:4		PROJECTION:		SHEET 1 OF 13							

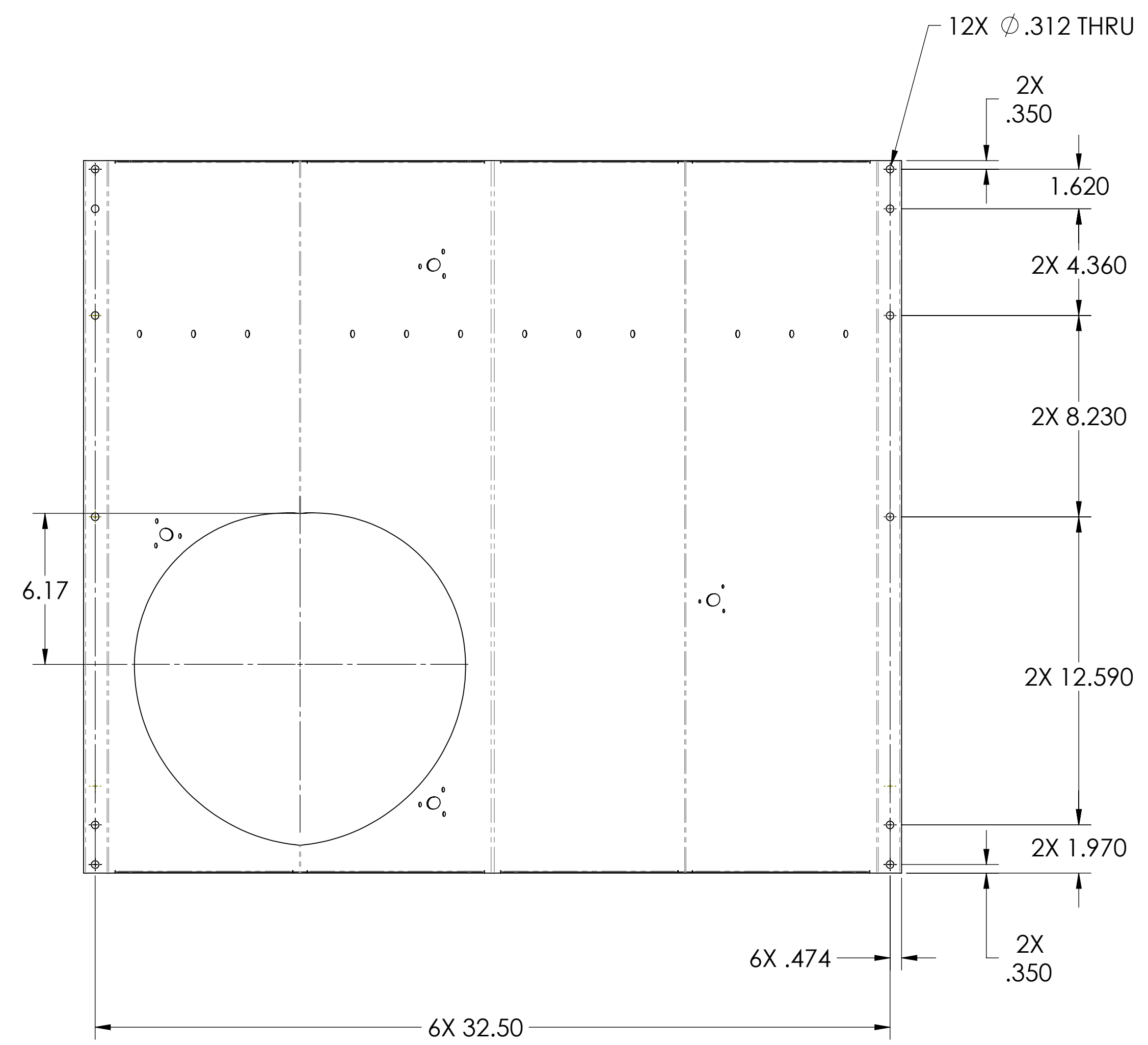
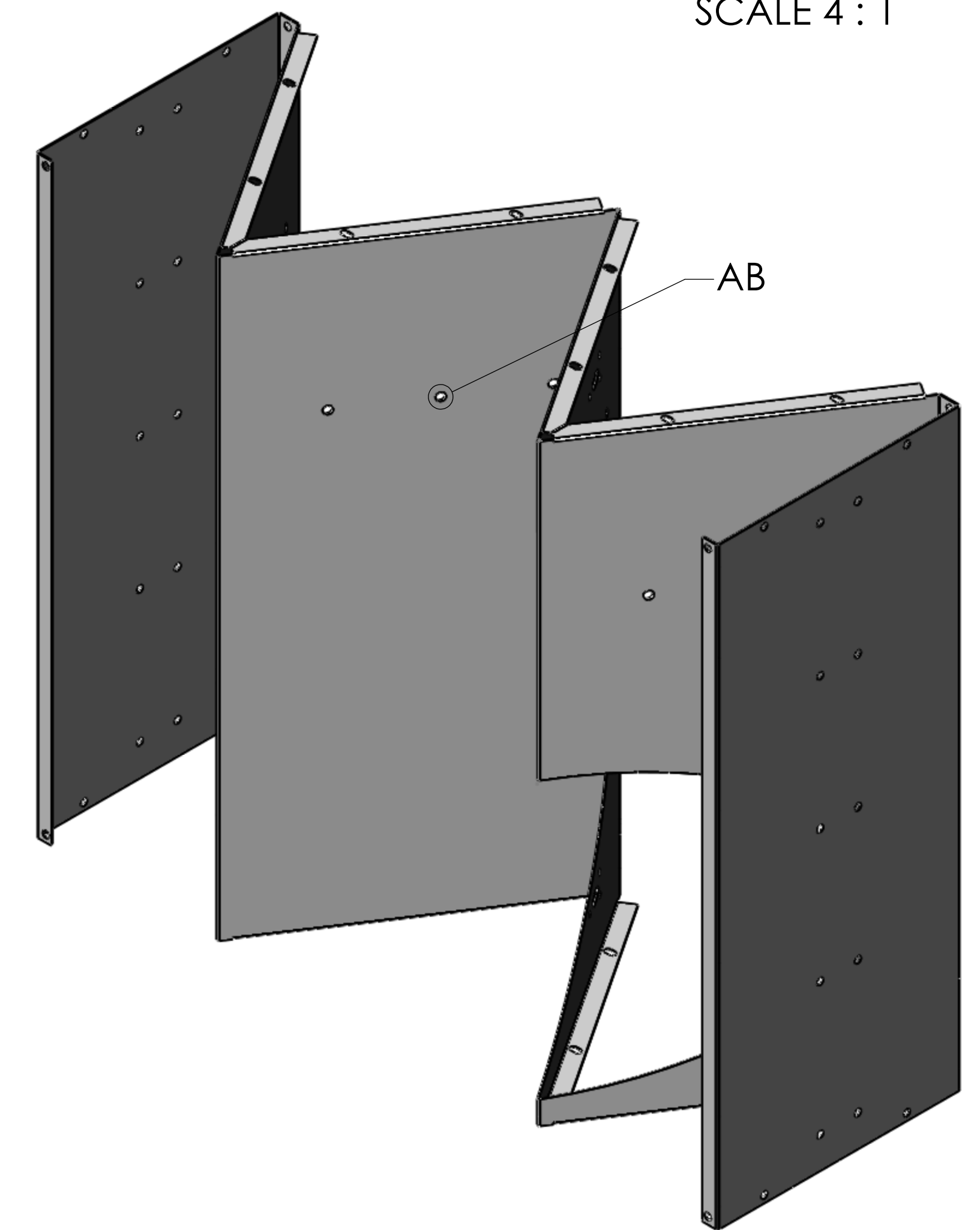
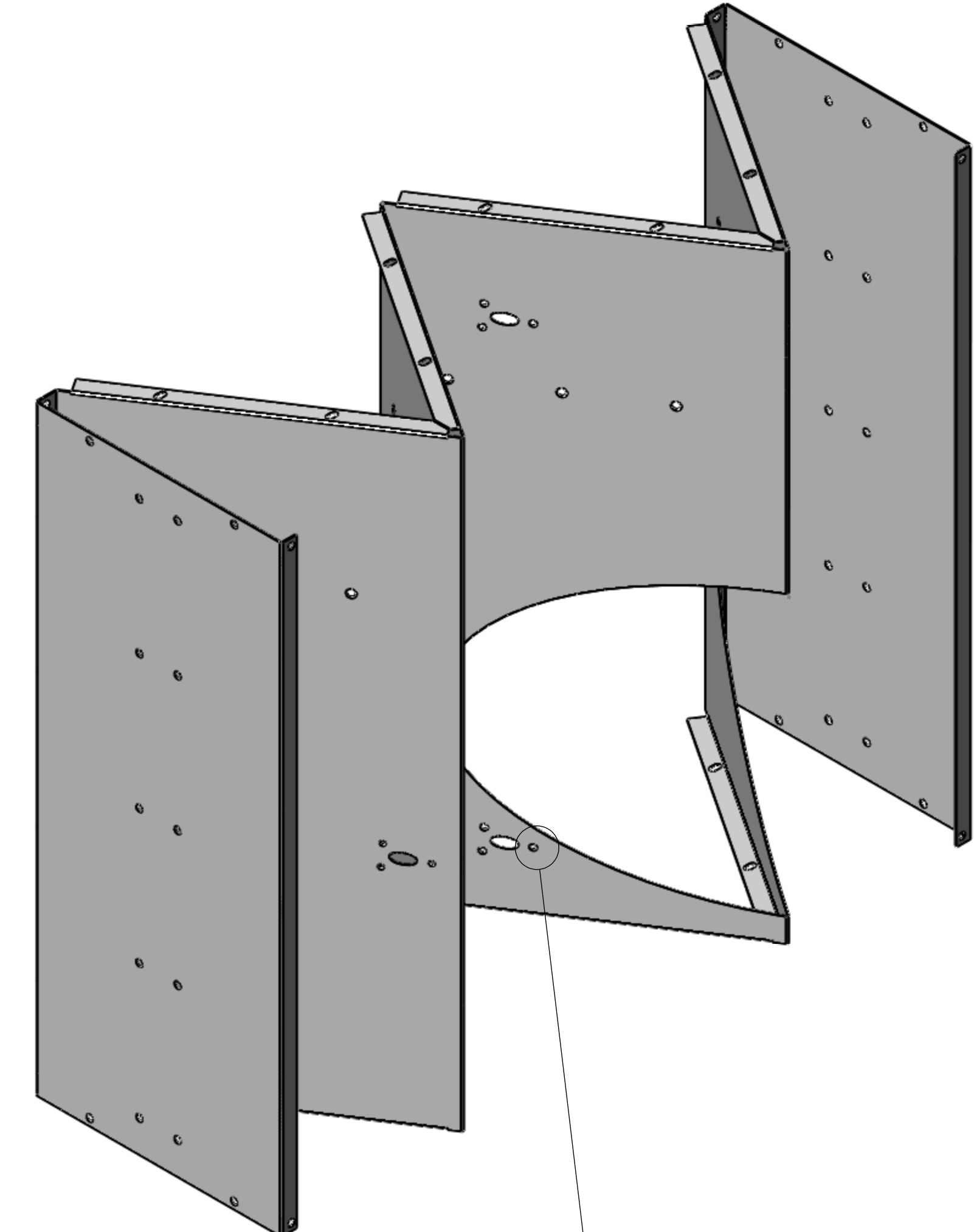
D:\002357_Audi\GO_ACS_SLC_ARM_Covily\Bottle_1 Hole Skin_P1.PART.PDM.REV.X-017_DRAWING.PDM.REV.X-016



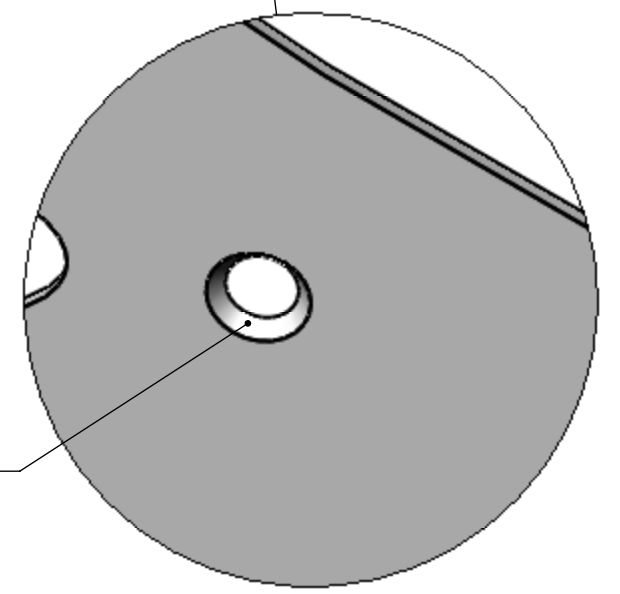
12X MASK THIS COUNTERSINK HOLE AND WITHIN .63 DIA OF OPPOSITE SIDE PRIOR TO PORCELAINIZING.



DETAIL AB
SCALE 4 : 1



12X MASK THIS COUNTERSINK AREA PRIOR TO PORCELAINIZING



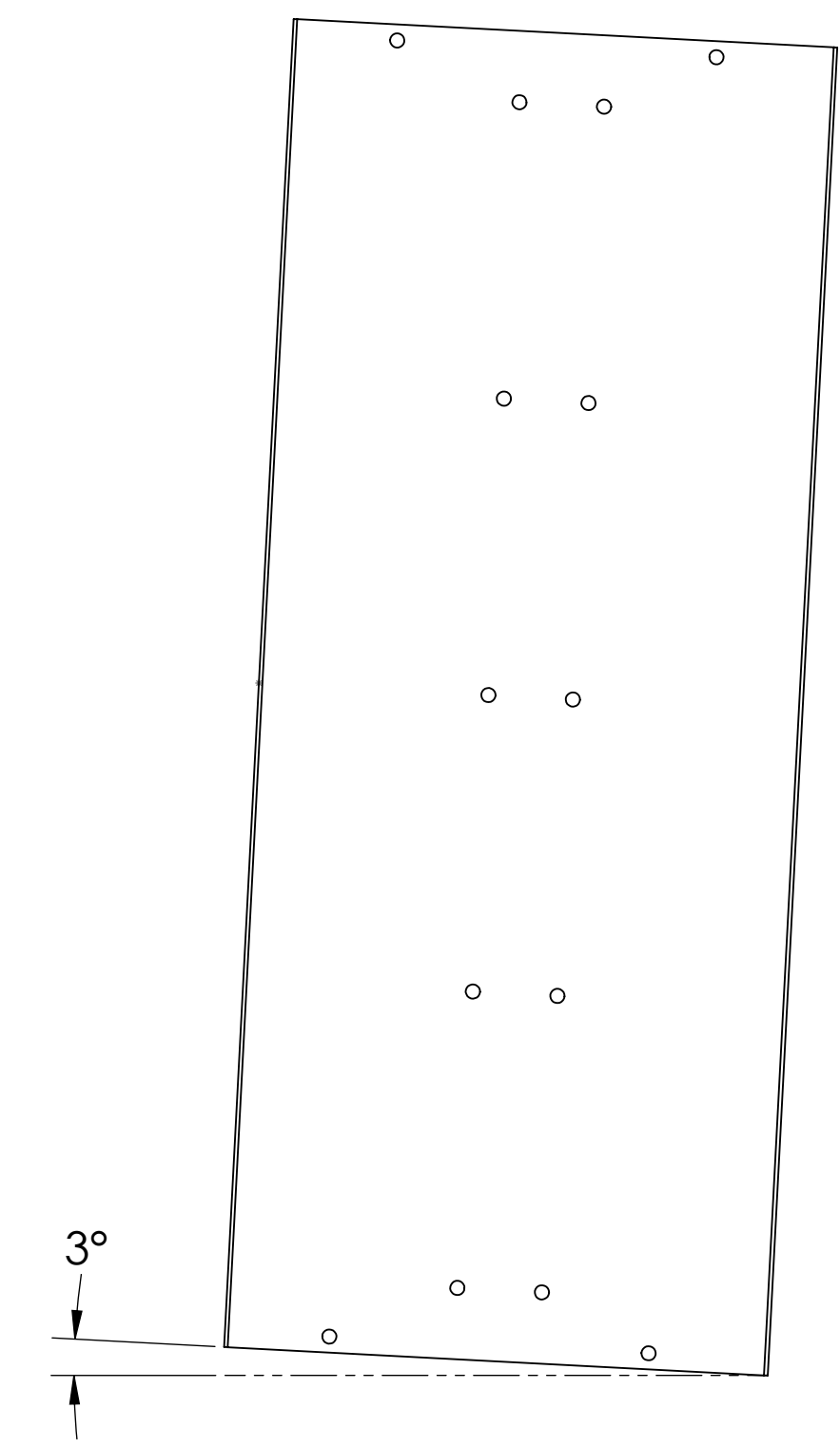
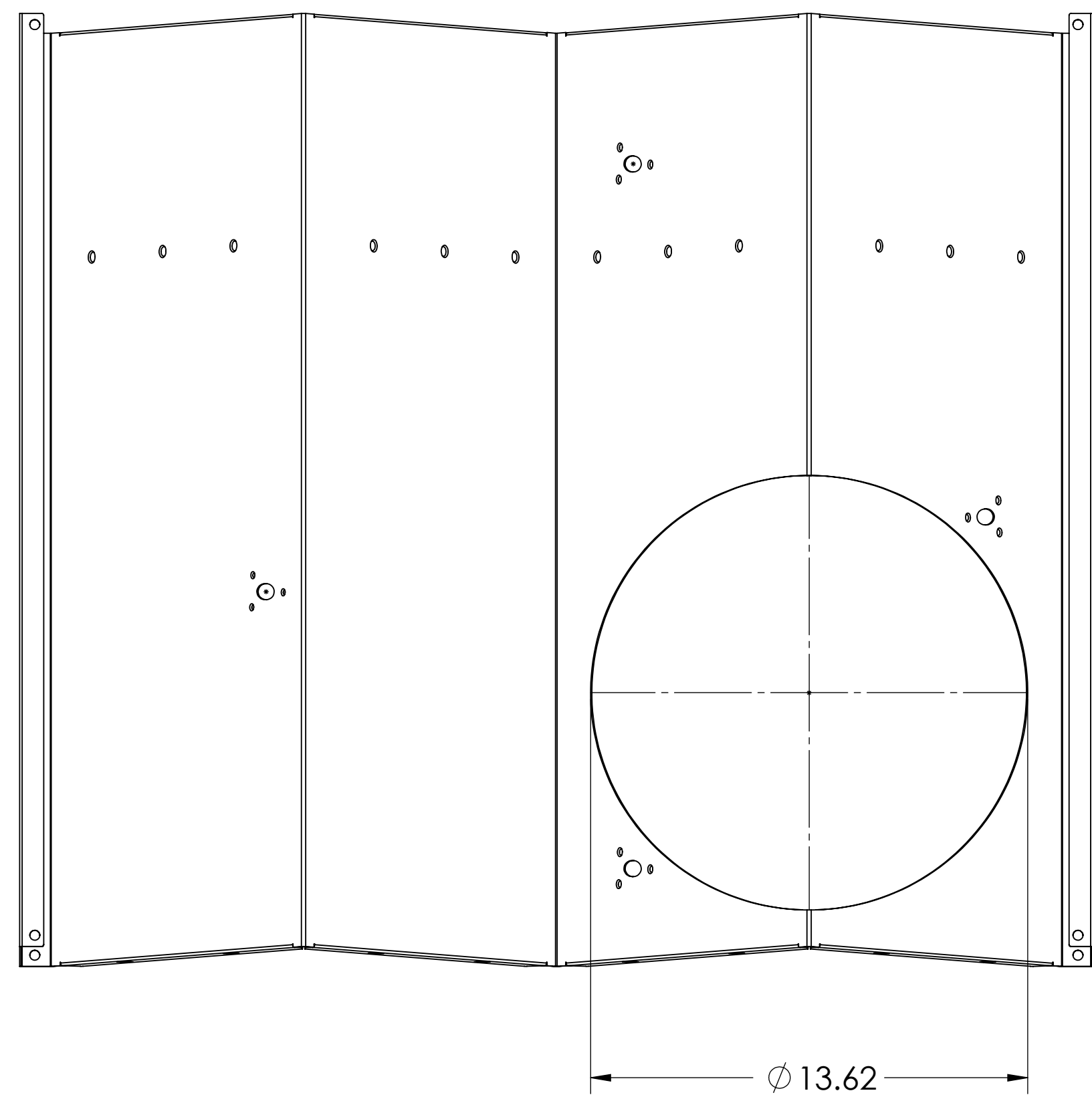
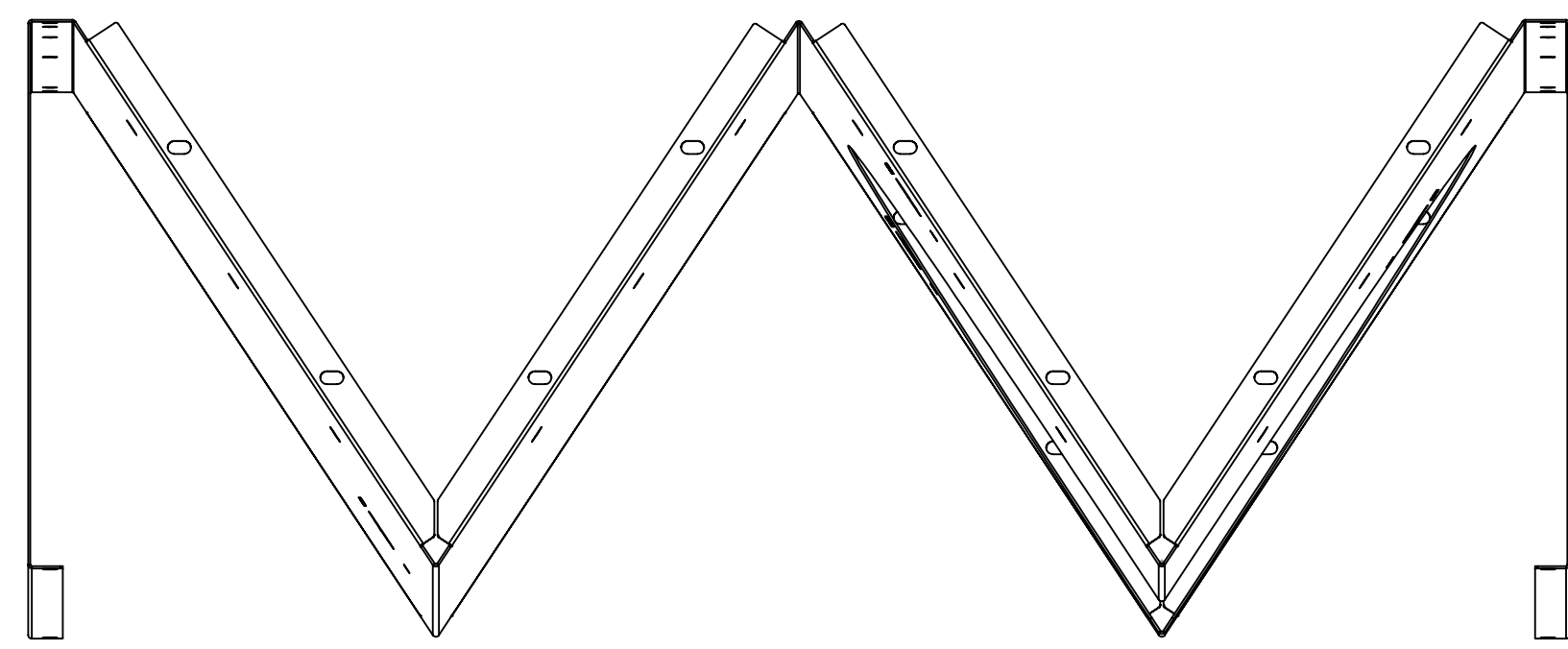
COUNTERSINK DETAIL
SCALE 1.5 : 1

D1002357-01
ONE HOLE RIGHT QPD SKIN

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
1	D1002357-01	ACB 1 HOLE RIGHT-QPD SKIN	ENAMEL STL A424 TYPE I	1		1

CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY
 SIZE DWG. NO. **D1002357** REV. **v2**
 SCALE: 1:4 PROJECTION: SHEET 2 OF 13

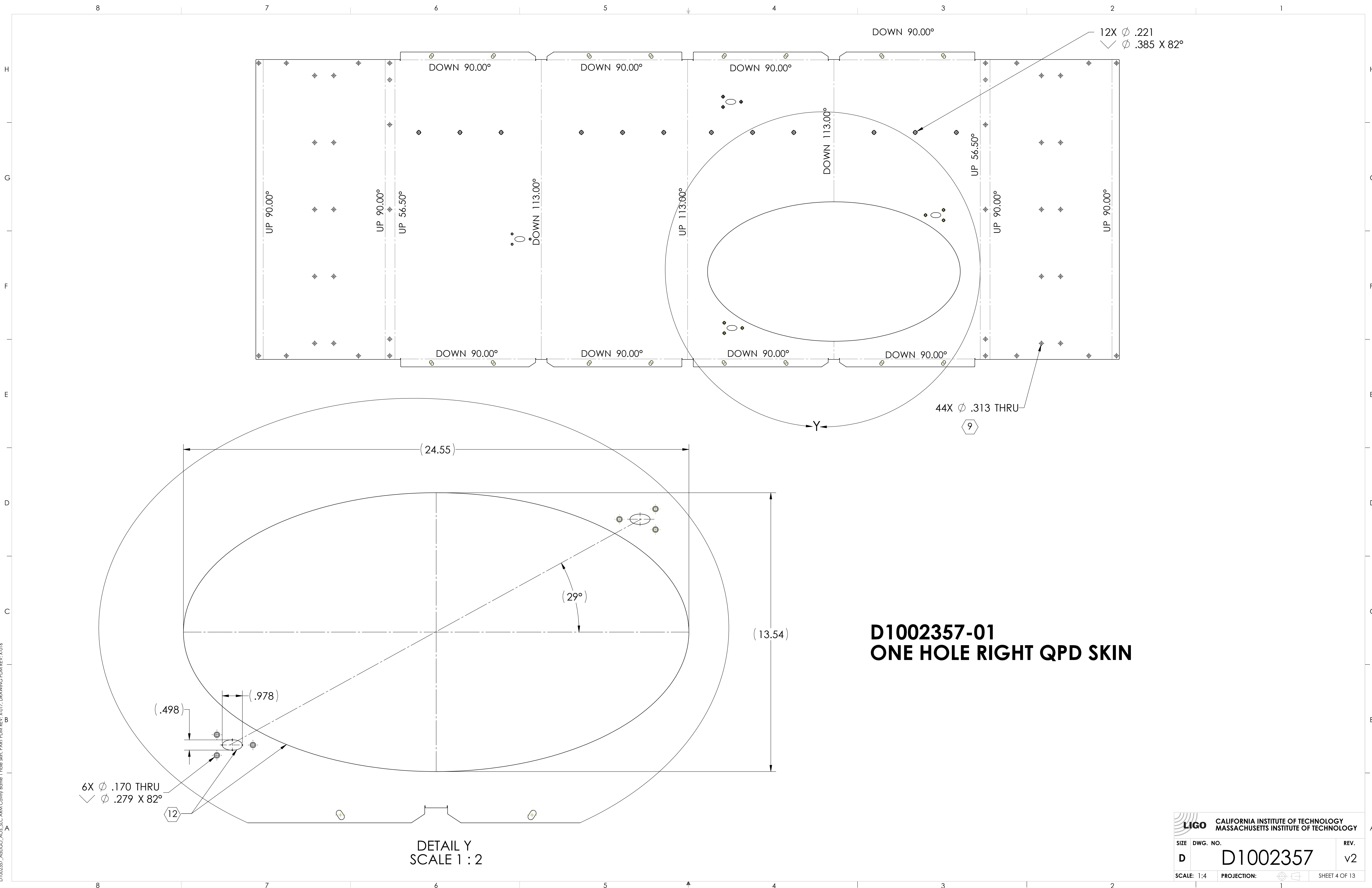
D:\002357_Adu\GO_ACS_SLC_ARM_Coupler\Bottle_1\1016_Skin_PART.PDM REV. X-017_DRAWING.PDM REV. X-016



D1002357-01
ONE HOLE LEFT QPD SKIN
3 ° TILT

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE	DWG. NO.	REV.
D	D1002357-01	v2
SCALE: 1:4	PROJECTION:	SHEET 3 OF 13

D1002357_AduLIGO_AOS_SLC_ARM_Cavity_Baffle_1 Hole_Skin_PART.PDM_REV.X.017_DRAWING.PDM_REV.X.016

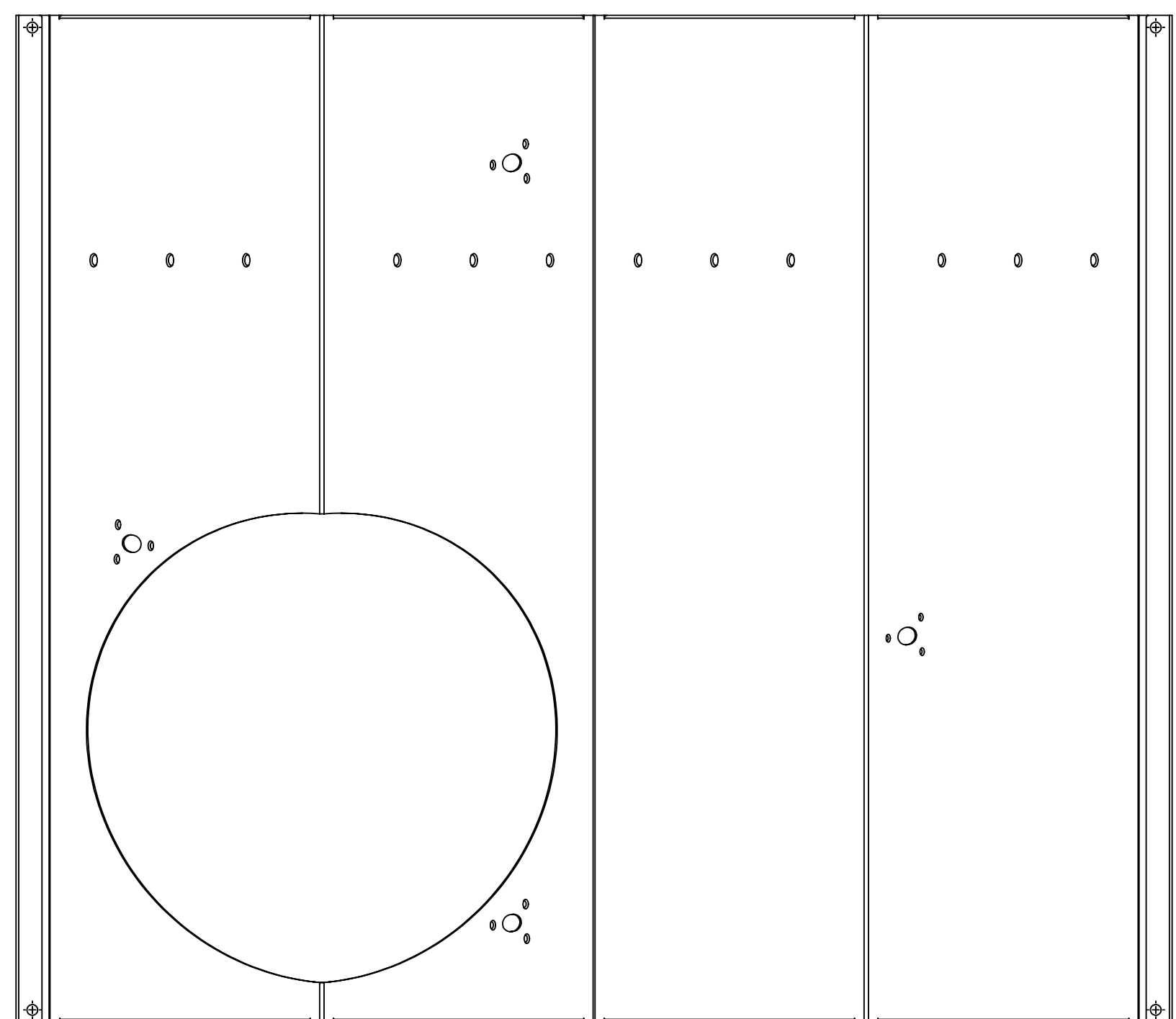
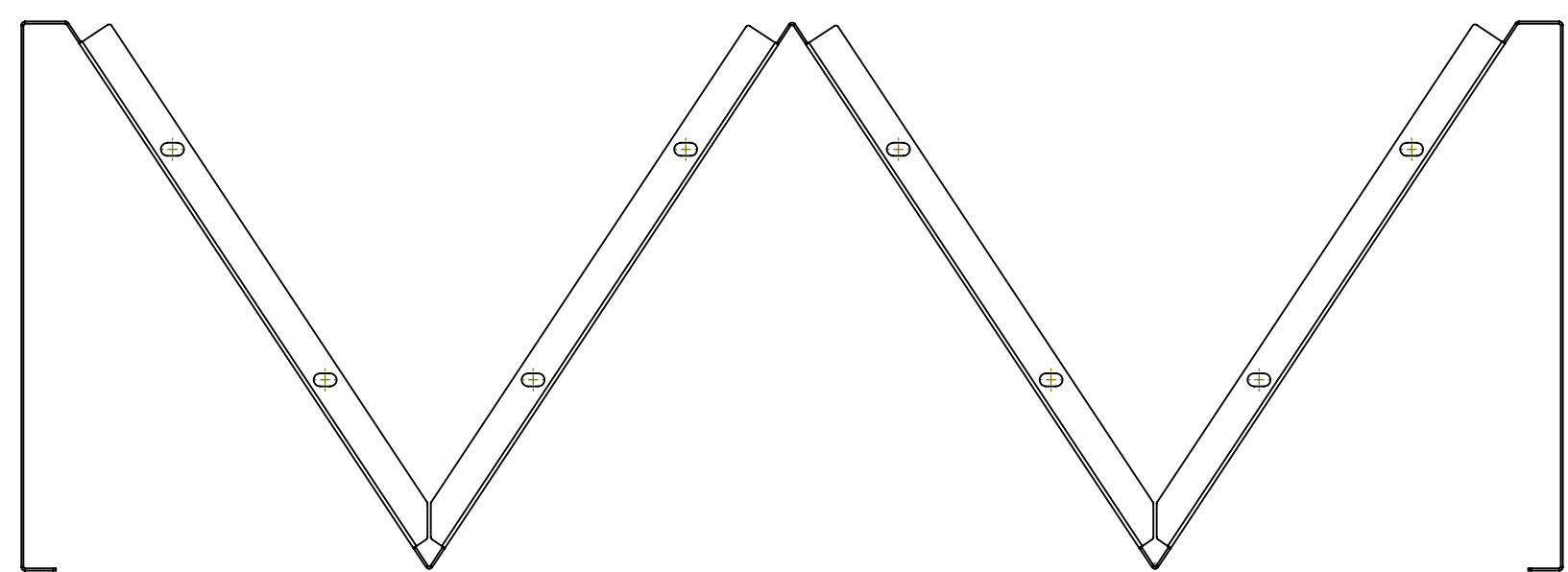
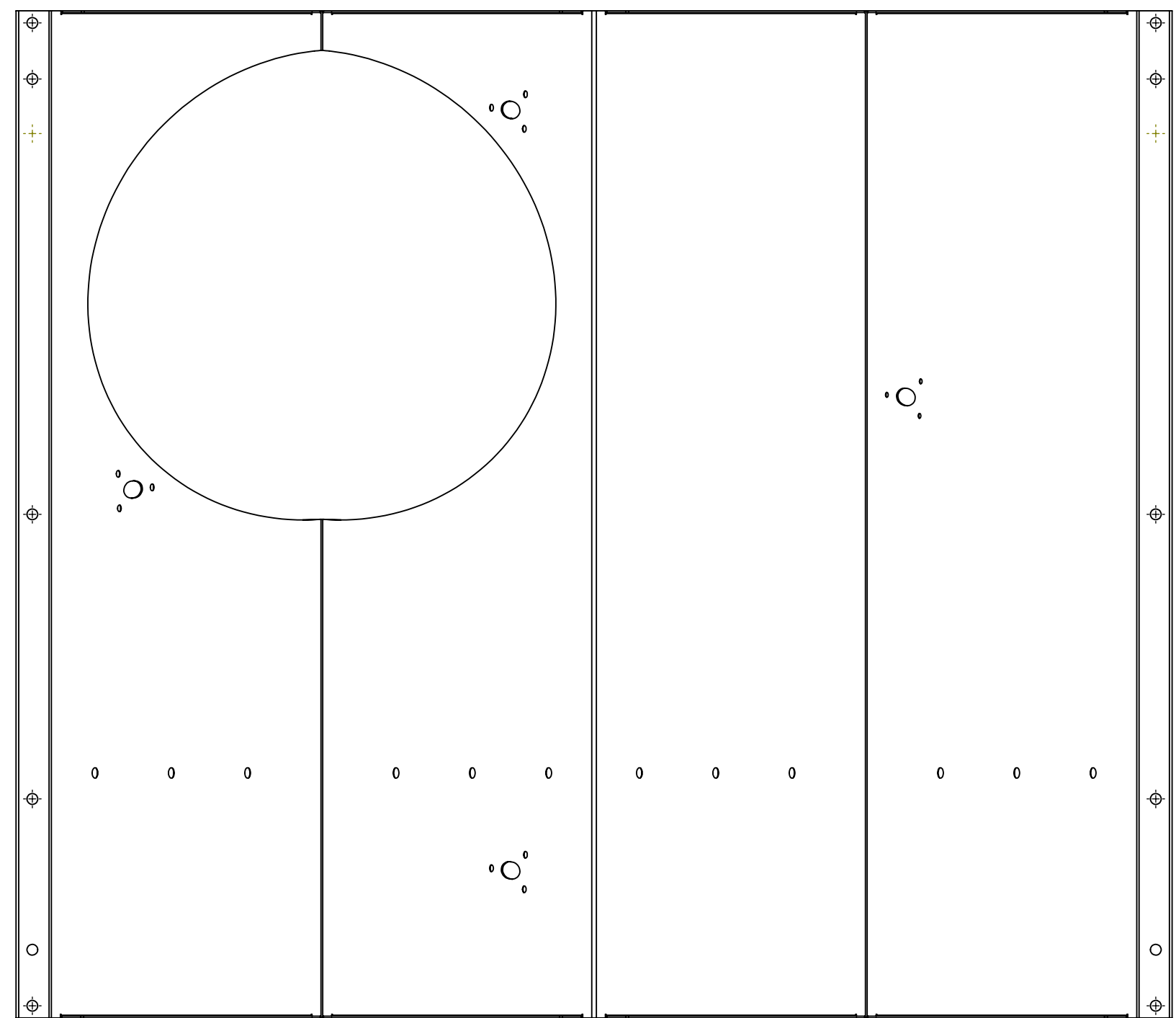


**D1002357-01
ONE HOLE RIGHT QPD SKIN**

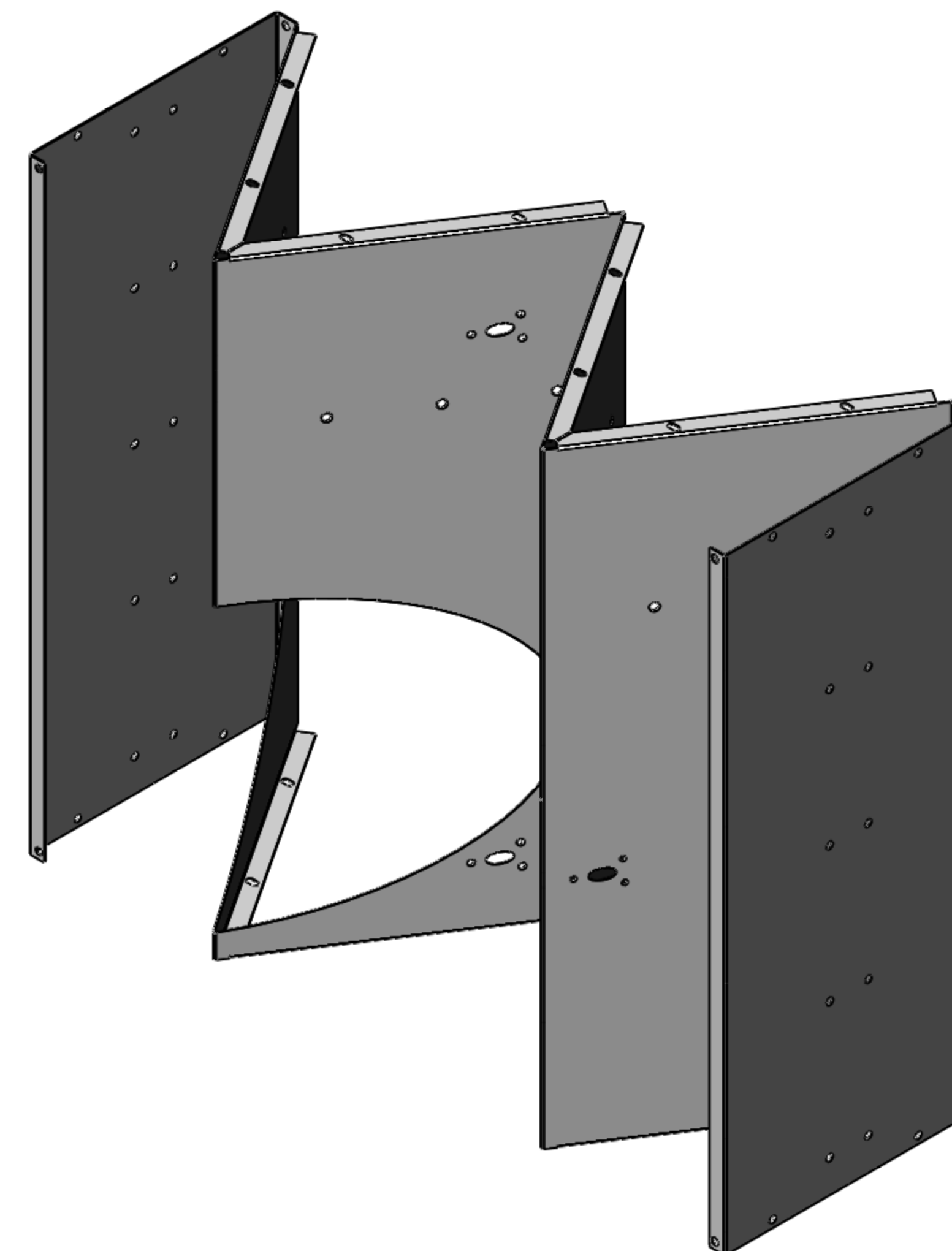
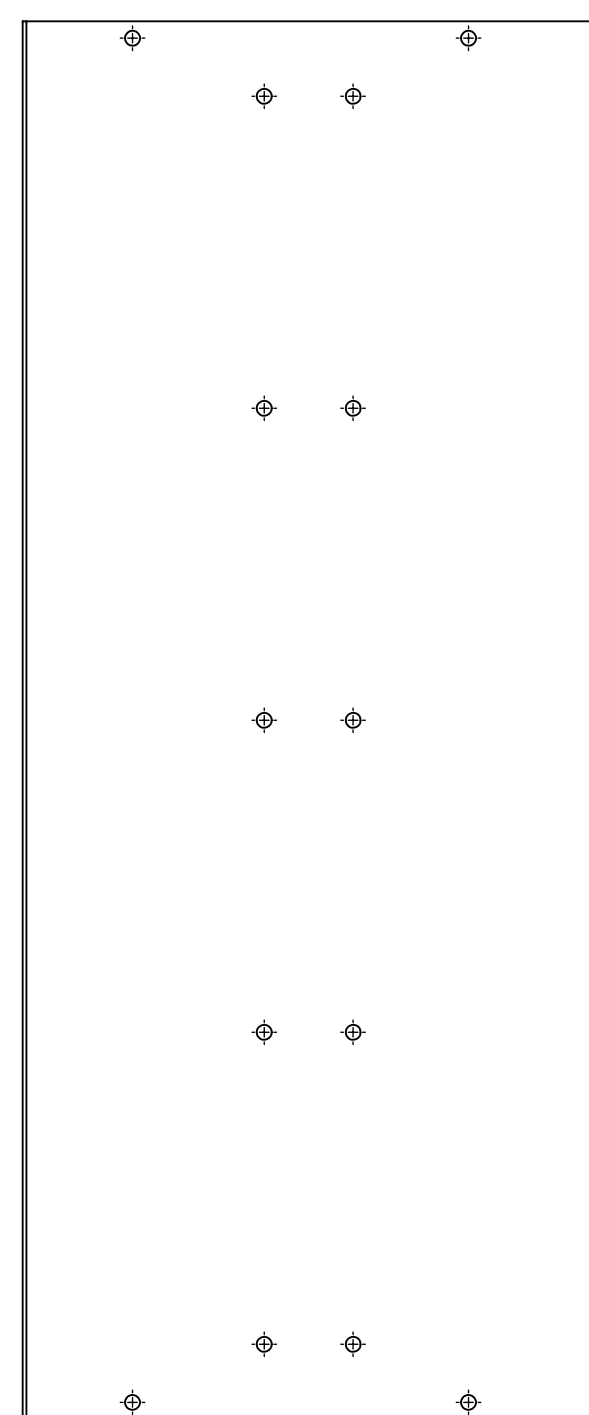
DETAIL Y
SCALE 1 : 2

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE DWG. NO.	REV.
D D1002357	v2
SCALE: 1:4	PROJECTION:
SHEET 4 OF 13	

D1002357_AduLIGO_ACS_SLC_ARM_Covily_Baffle_1 Hole Skin_PART PDM REV. X-017_DRAWING PDM REV. X-016



16.72



**D1002357-02
ONE HOLE LEFT QPD SKIN
SEE D1002357-01 FOR DIMS NOT SHOWN**

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
1	D1002357-02	ACB 1 HOLE LEFT-QPD SKIN	ENAMEL STL A424 TYPE I	1		1

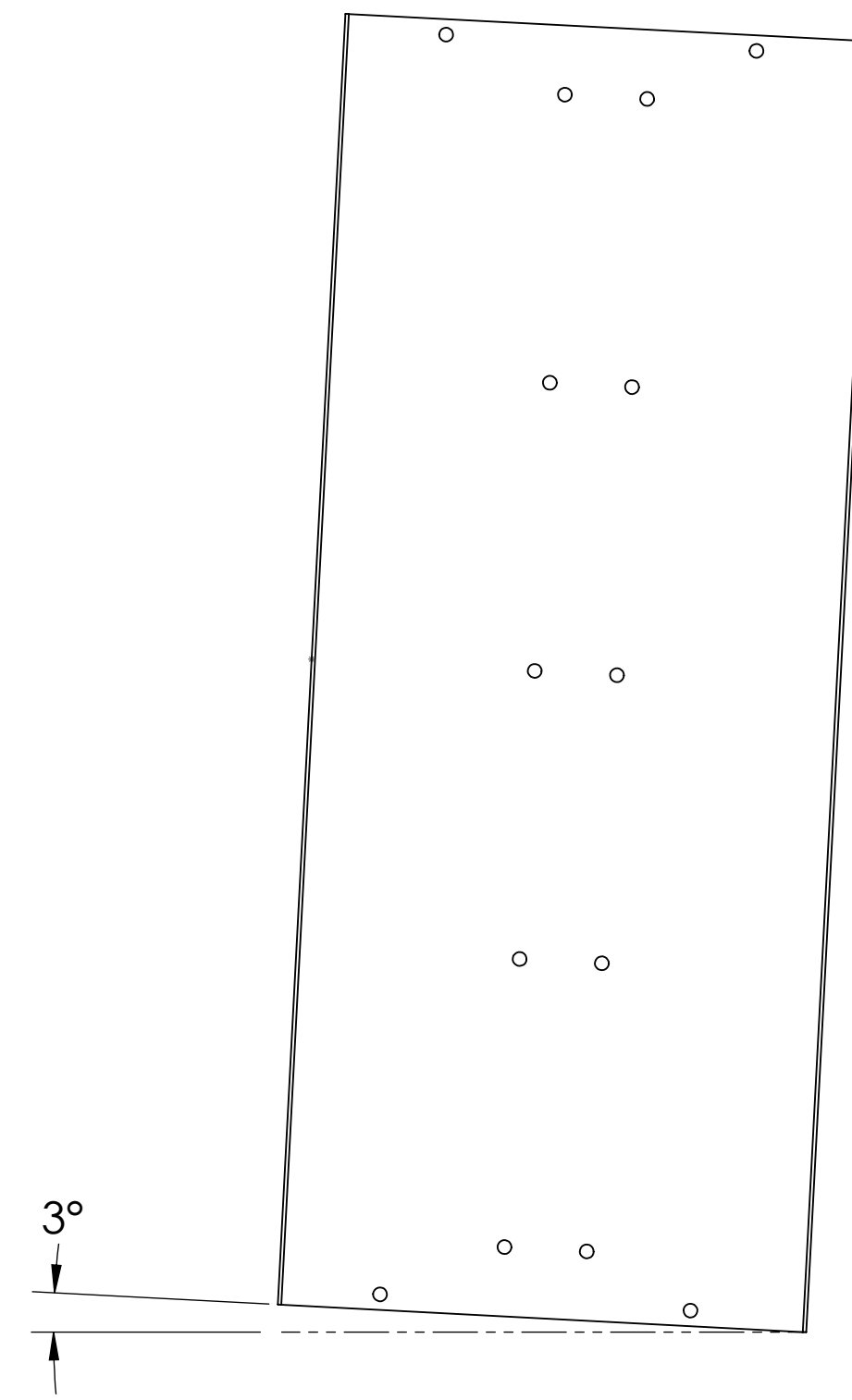
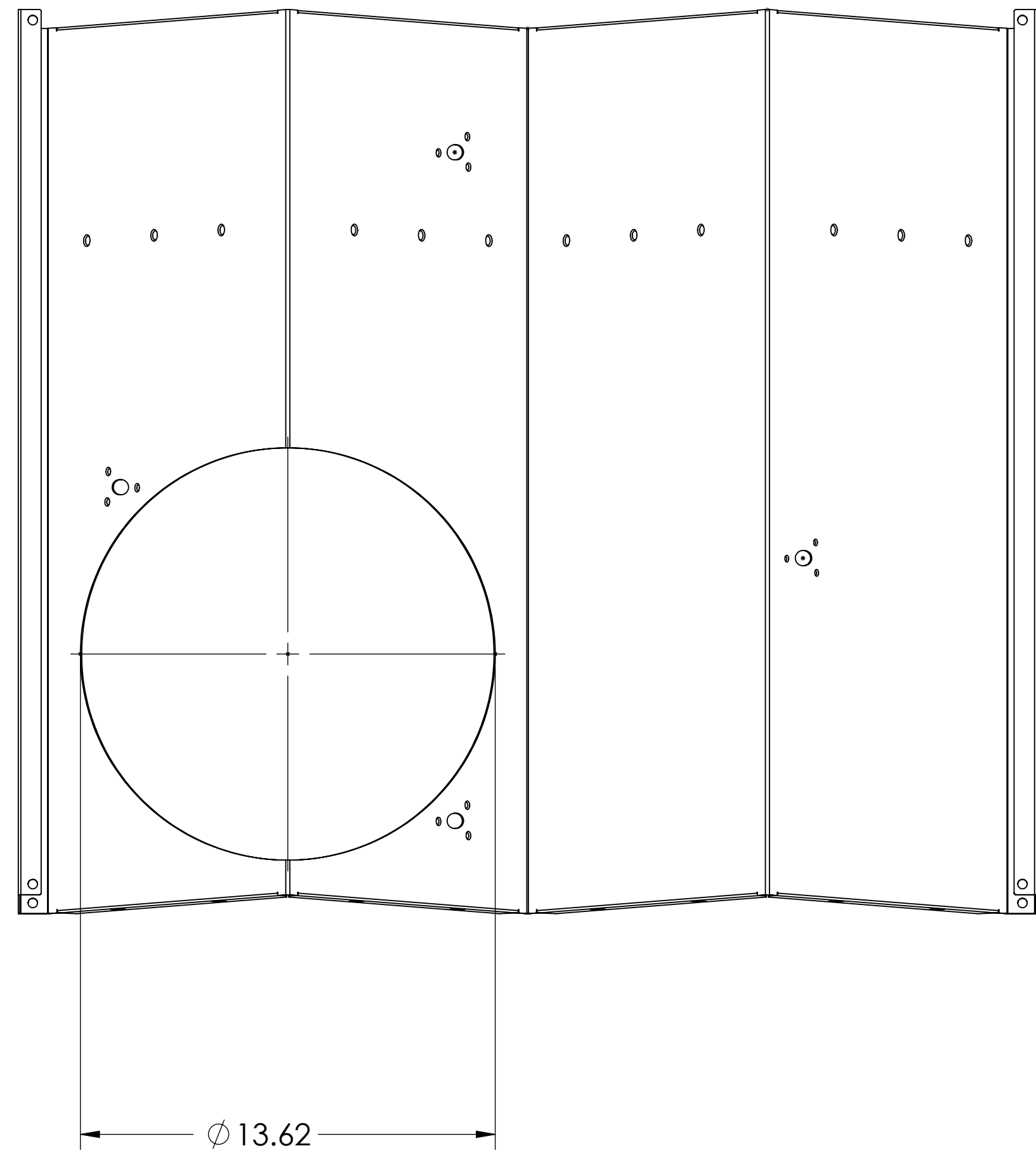
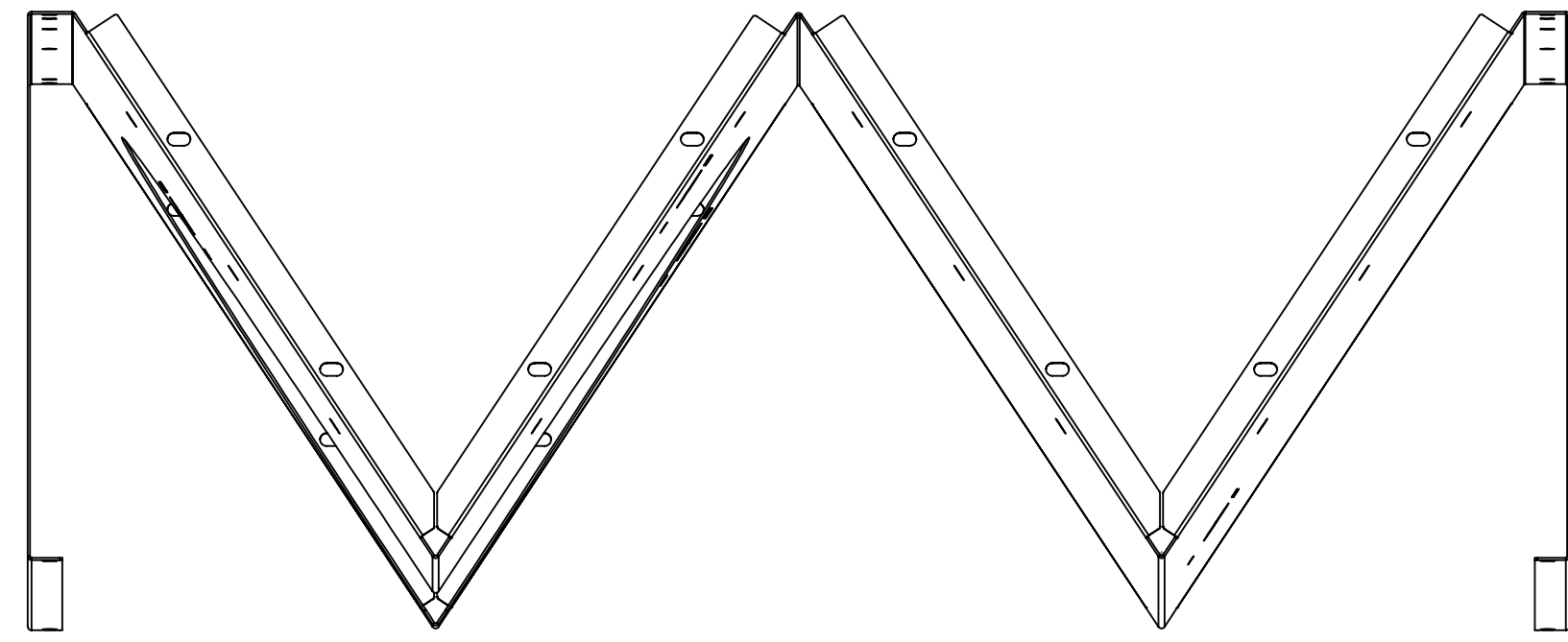
PARTS LIST

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MASSACHUSETTS INSTITUTE OF TECHNOLOGY


SIZE DWG. NO. REV.
D **D1002357** v2

SCALE: 1:4 PROJECTION: SHEET 5 OF 13

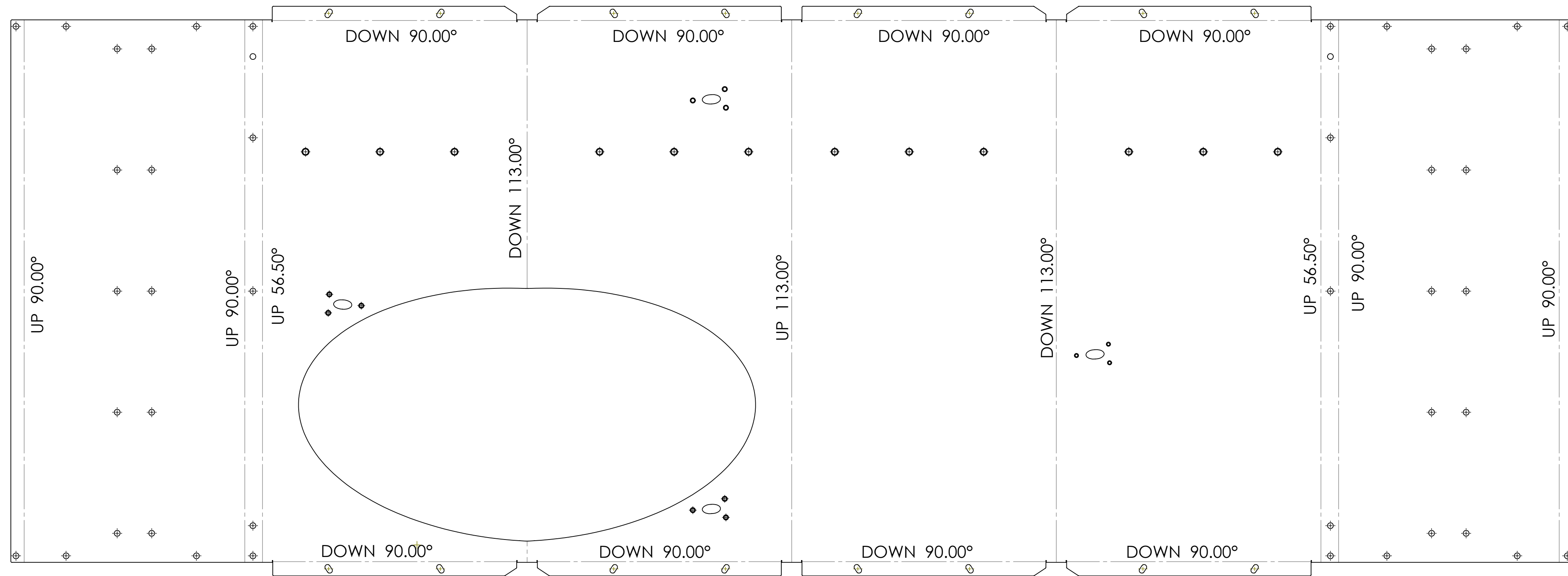
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D1002357-02
ONE HOLE LEFT QPD SKIN
3° TILT

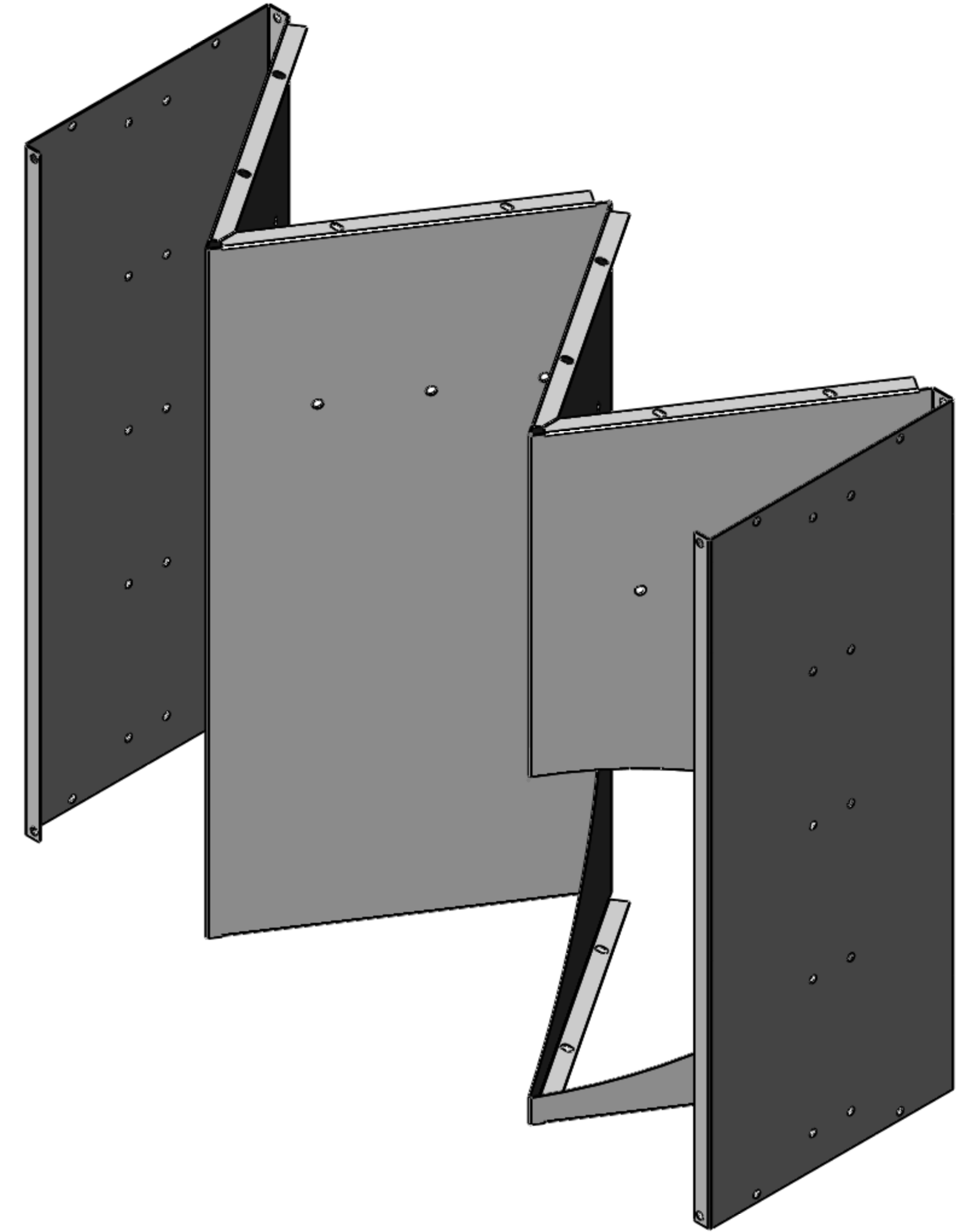
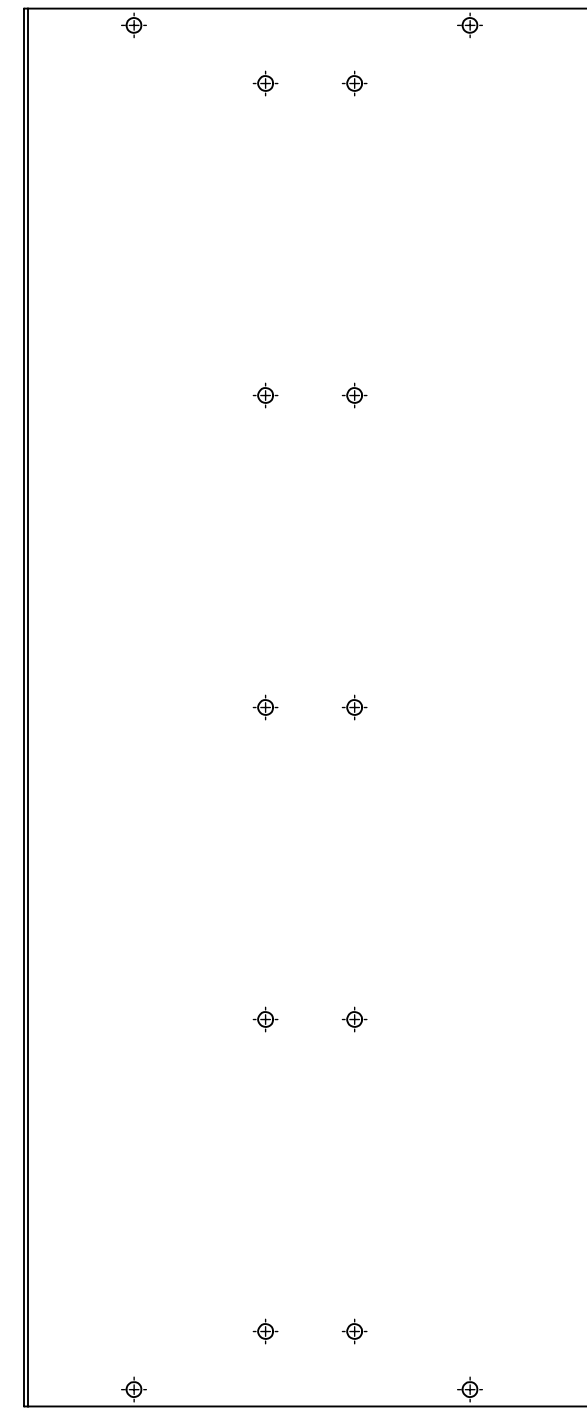
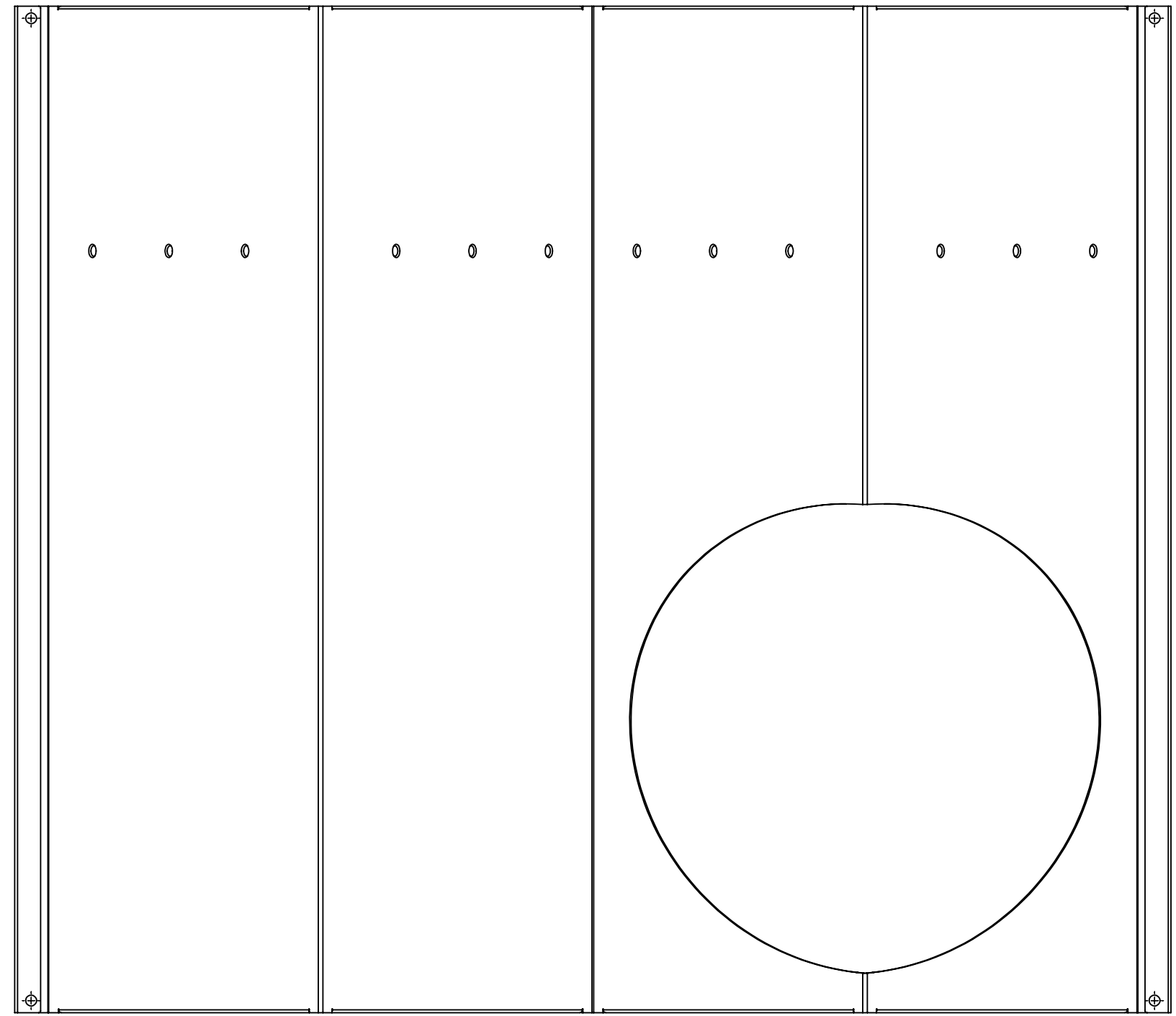
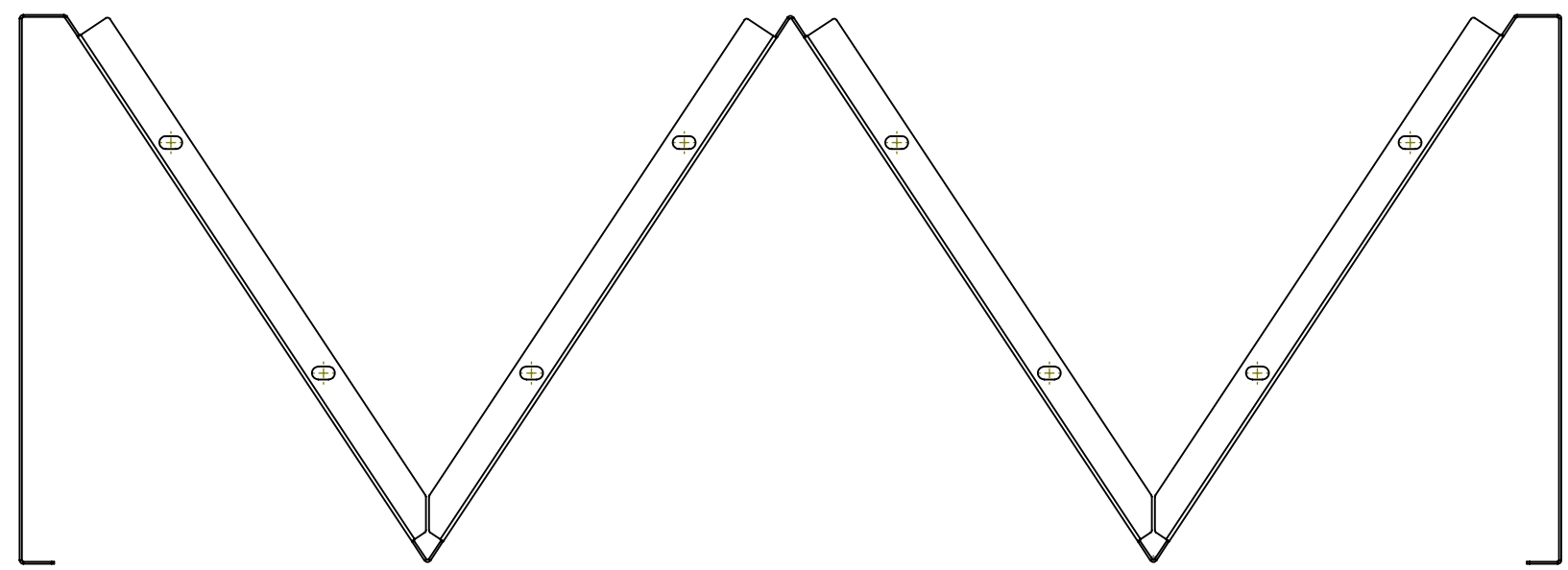
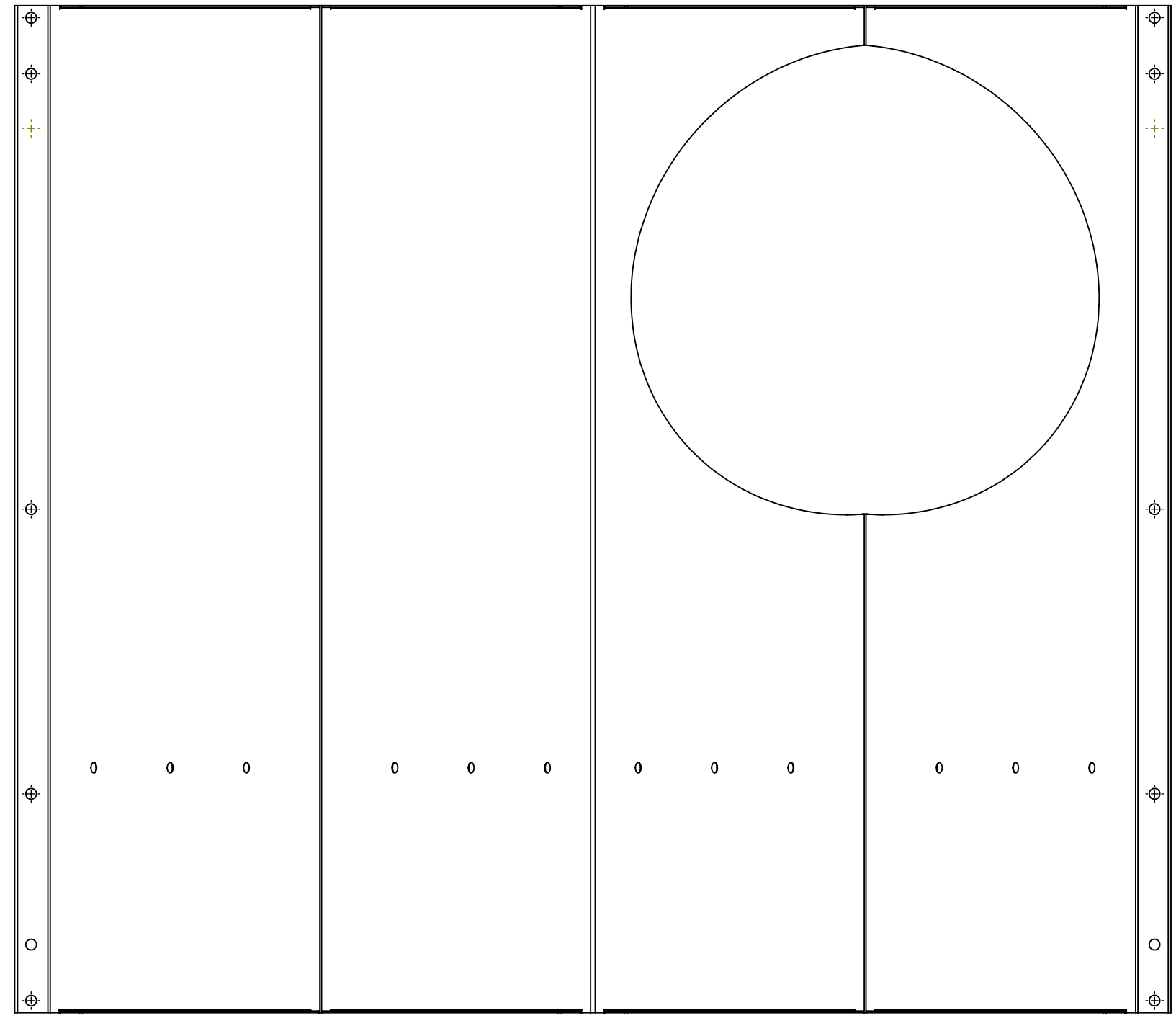
 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
D	D1002357-02	v2
SCALE: 1:4	PROJECTION:	SHEET 6 OF 13

D1002357_AduIGO_AOS_SLC_ARM_Cavity_Baffle_1 Hole_Skin_PART.PDM_REV.X.017_DRAWING.PDM_REV.X.016



D1002357-02
ONE HOLE LEFT QPD SKIN
SEE D1002357-01 FOR DIMS NOT SHOWN

D1002357_AduLIGO_AOS_SLC_ARM_Covly_Baffle_1 Hole Skin_PART PDM REV. X.017_DRAWING PDM REV. X.016



D1002357-03
ONE HOLE RIGHT NO QPD SKIN
SEE D1002357-01 FOR DIMS NOT SHOWN

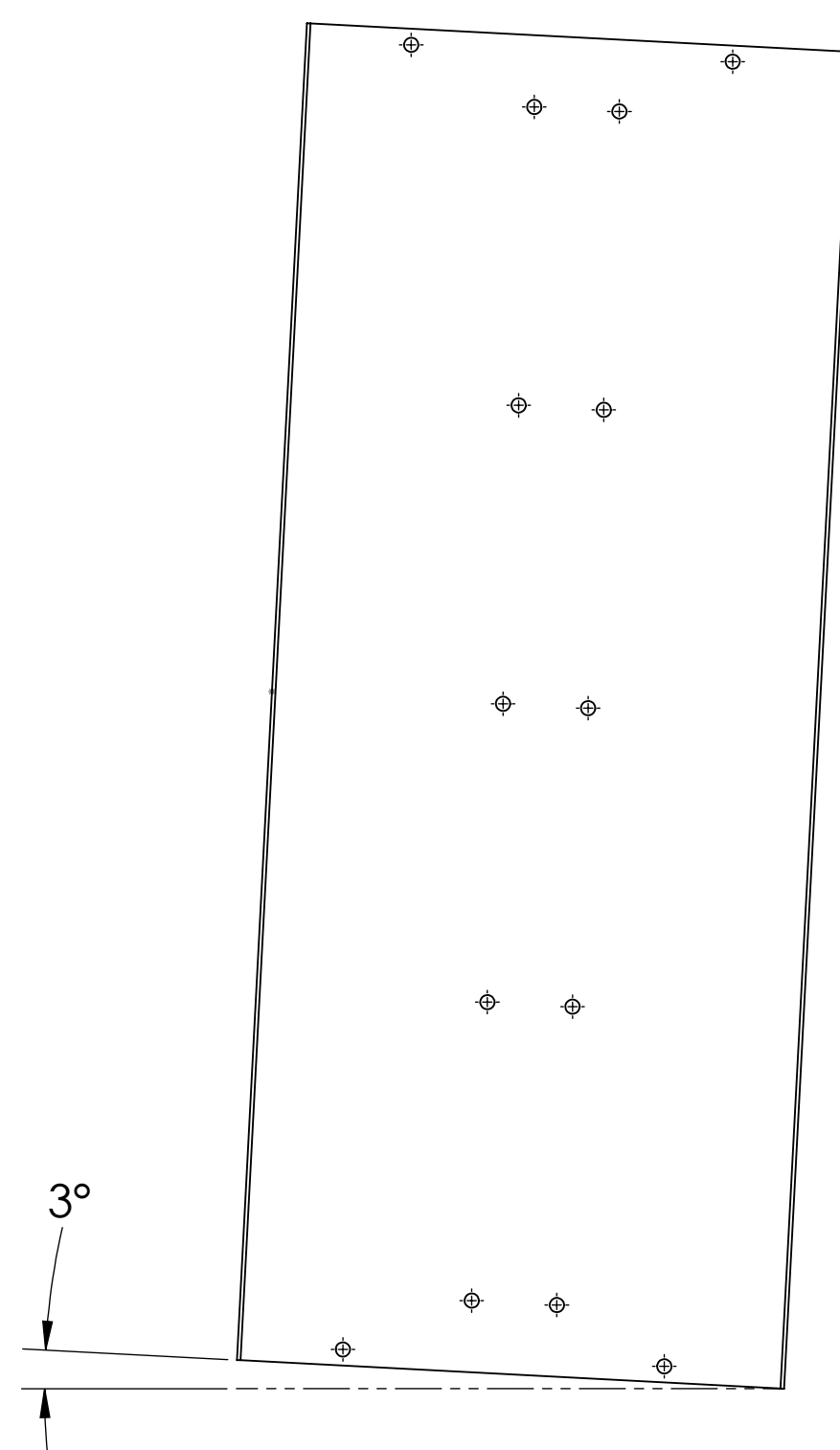
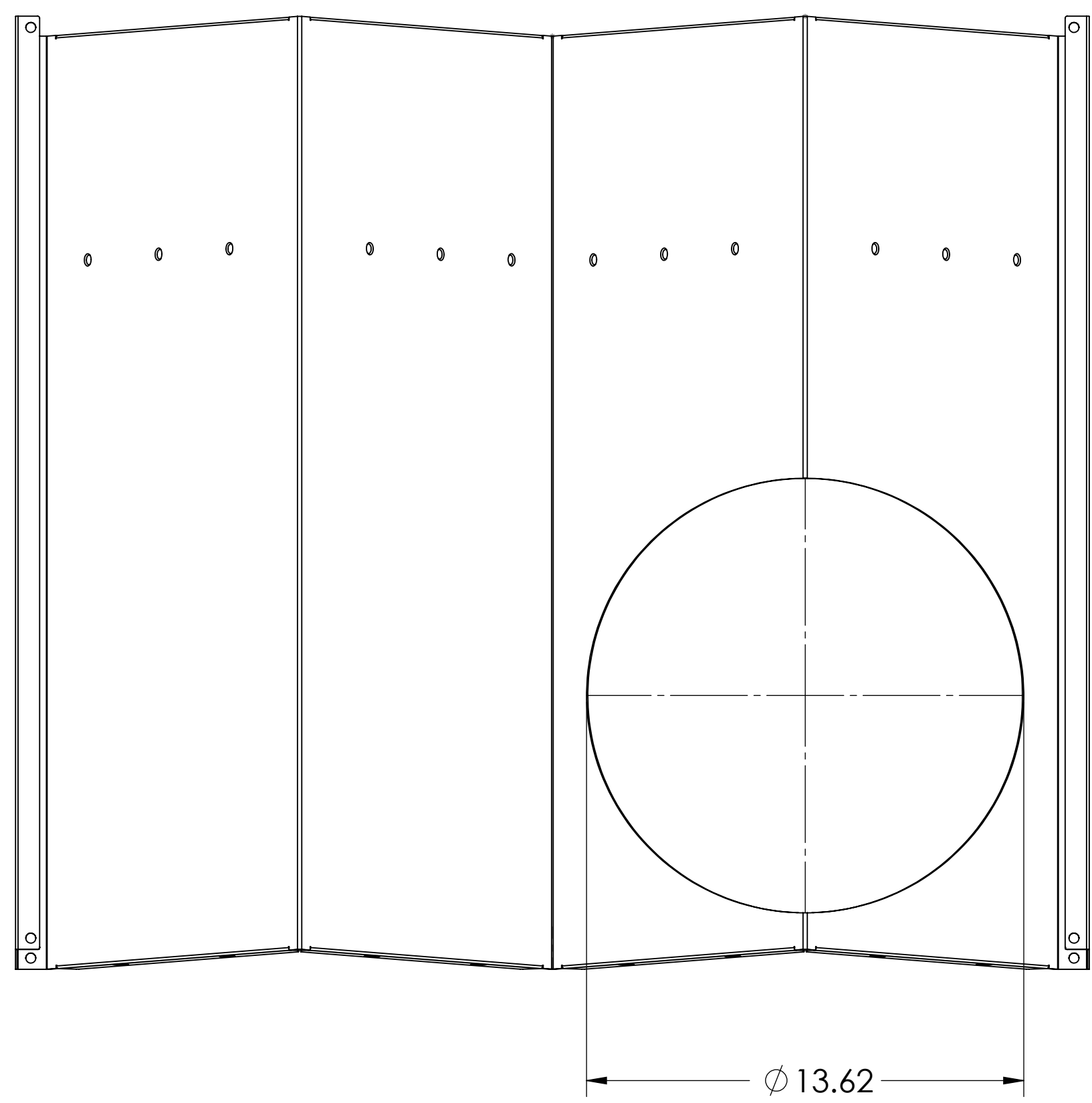
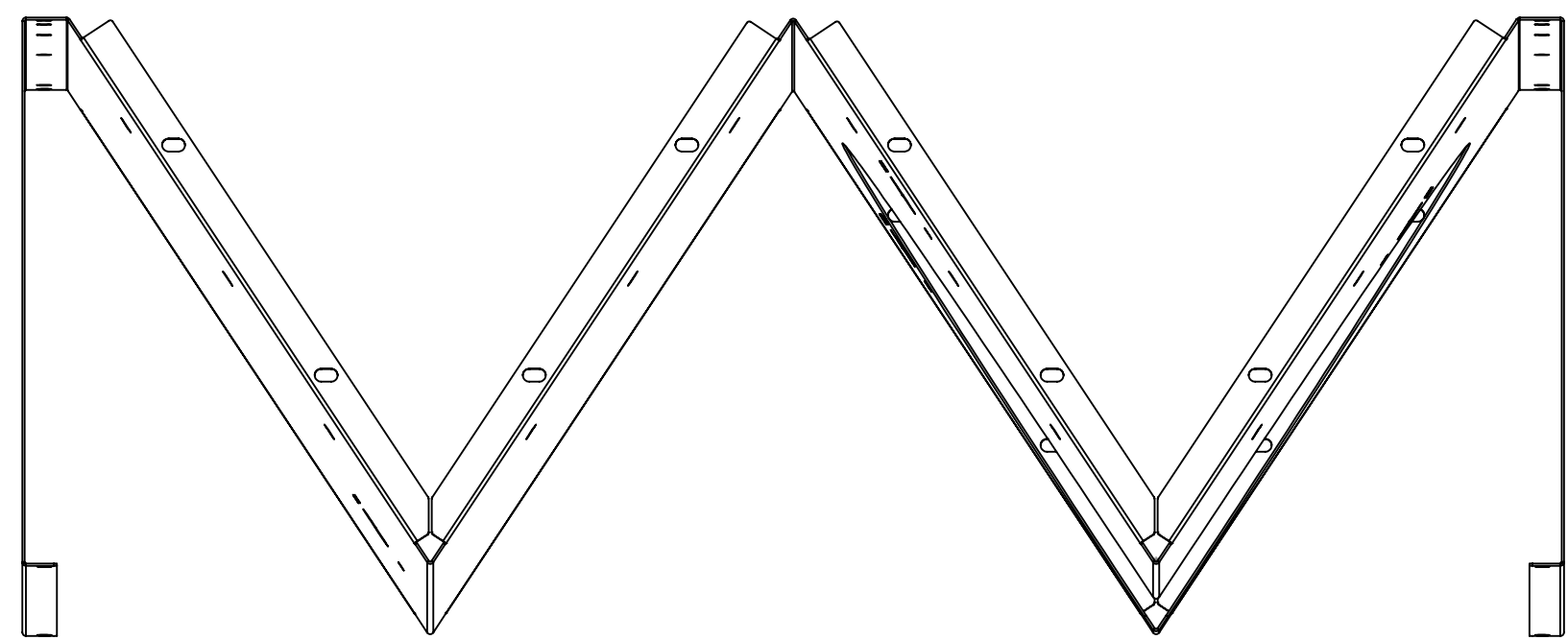
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
1	D1002357-03	ACB 1 HOLE RIGHT NO QPD SKIN	ENAMEL STL A424 TYPE I	1		1

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
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SIZE DWG. NO. **D1002357** REV. **v2**

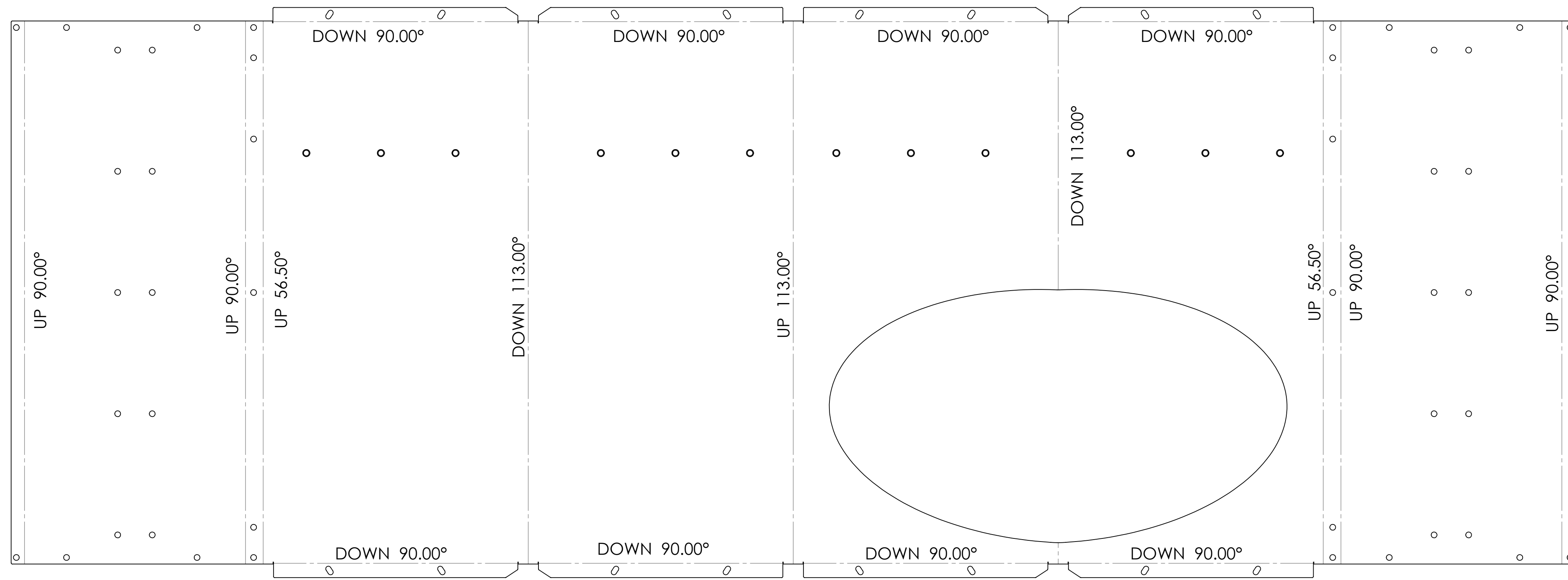
SCALE: 1:4 PROJECTION: SHEET 8 OF 13

D:\002357_Adu\GO_ACS_SLC_ARM_Covily_Bottle_1 Hole Skin_PART PDM REV. X-017_DRAWING PDM REV. X-016



D1002357-03
ONE HOLE RIGHT NO QPD SKIN
3° TILT

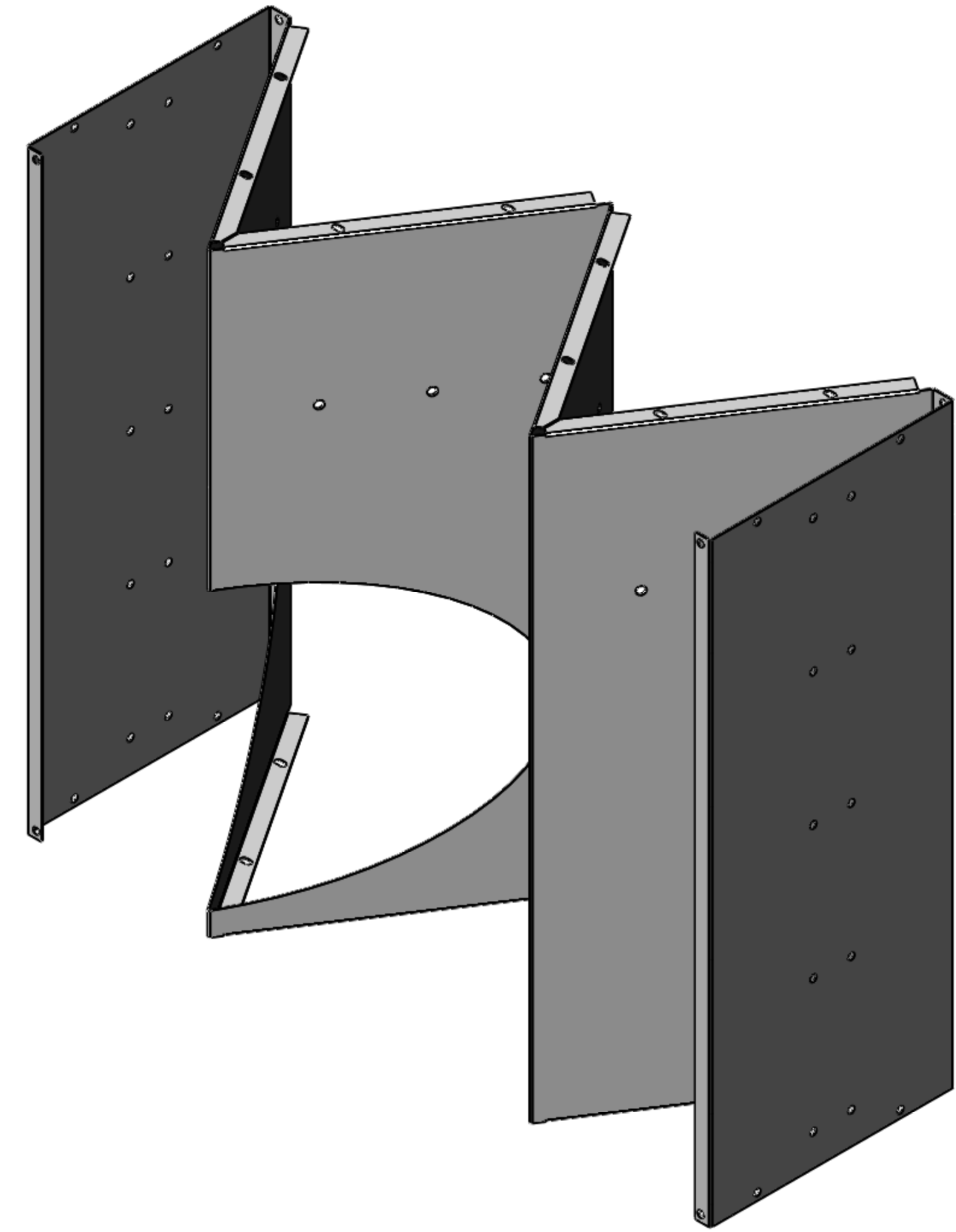
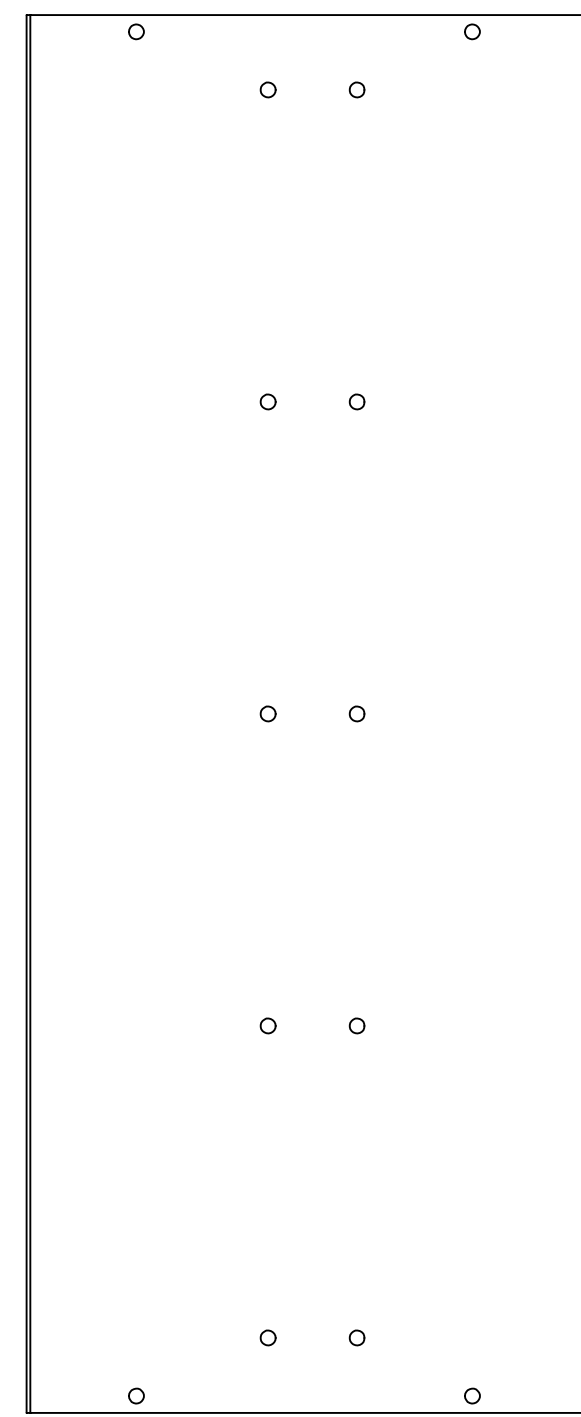
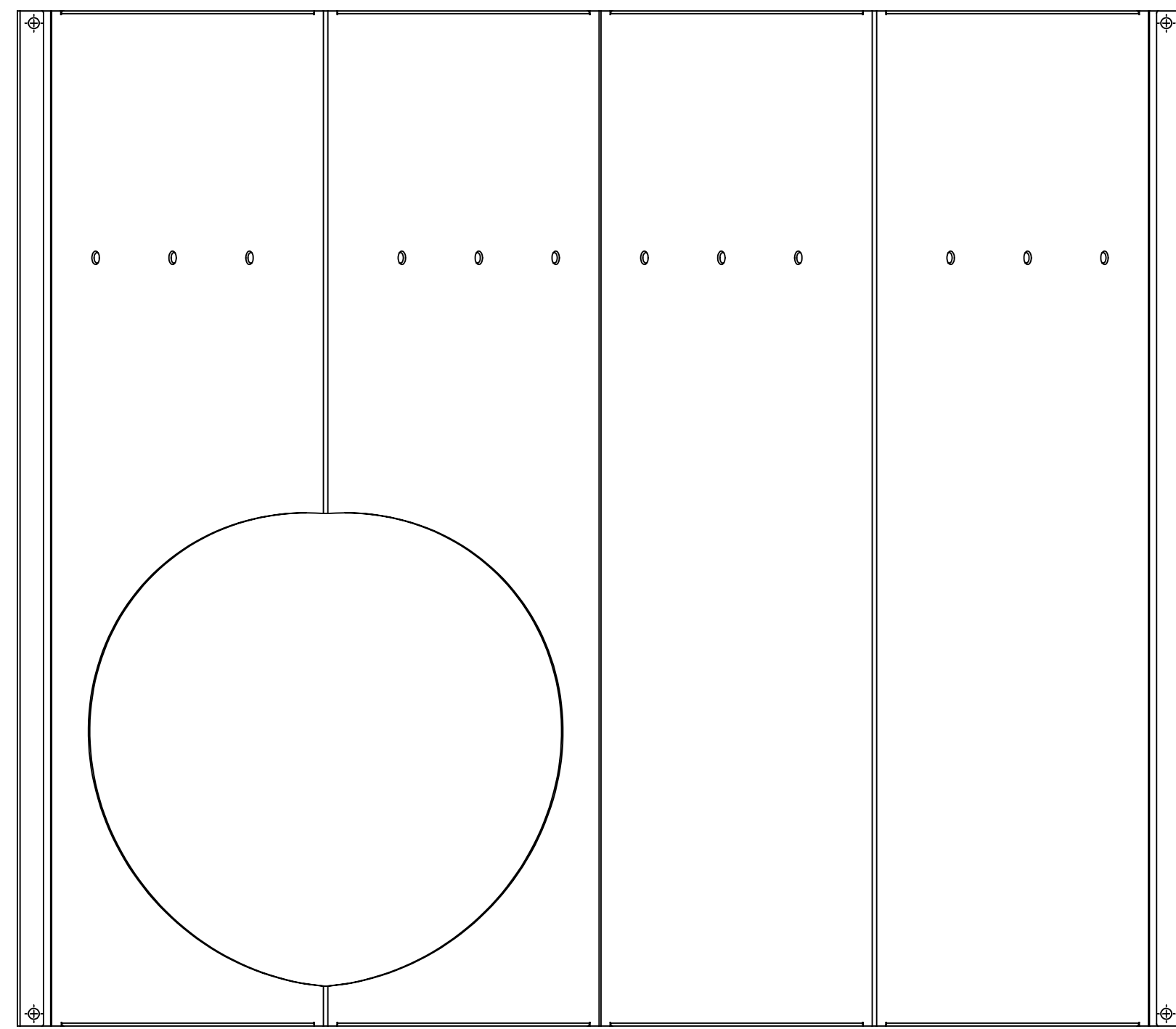
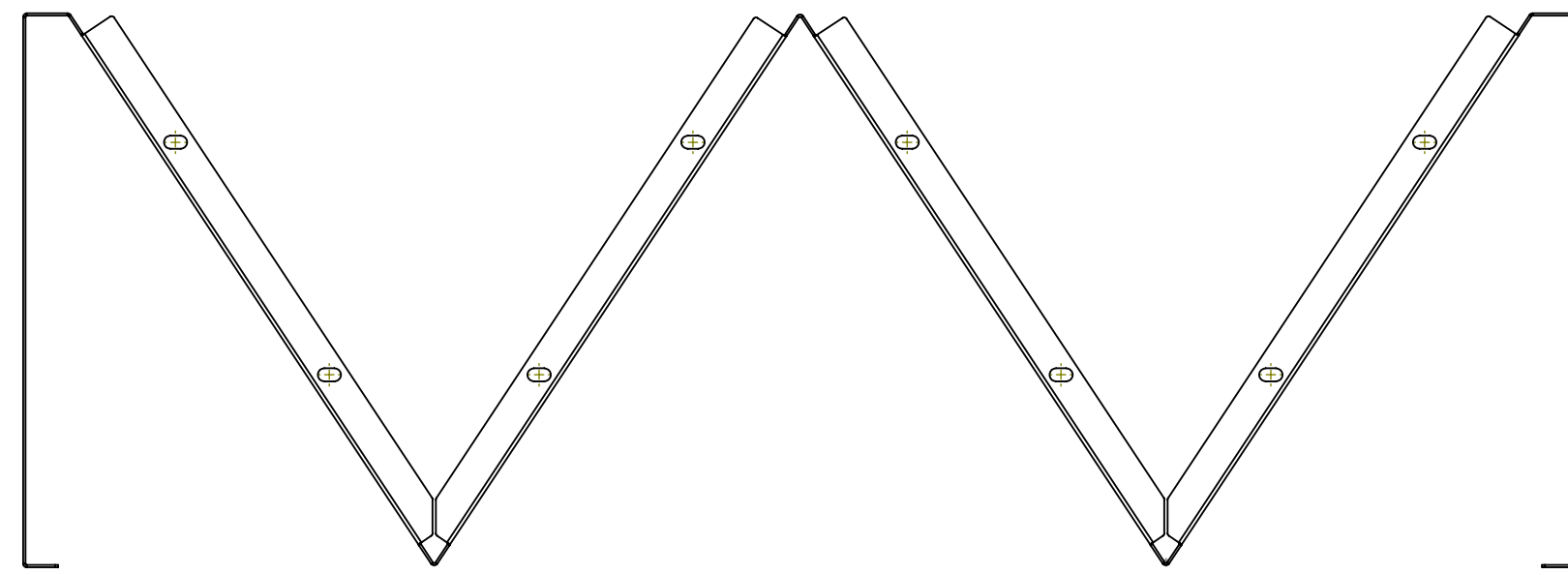
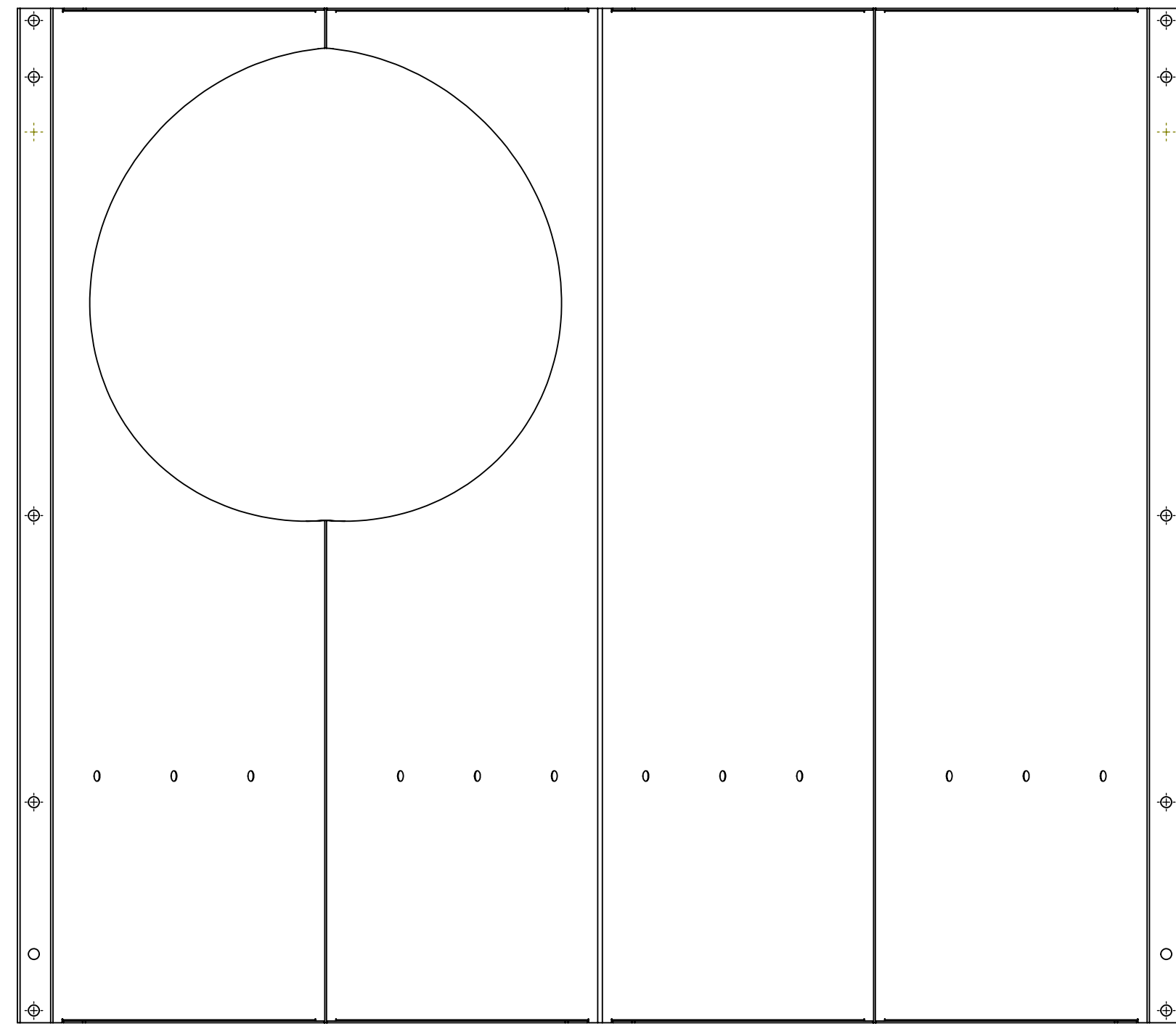
D1002357_AduLIGO_AOS_SLC_ARM_Covily_Bottle_1 Hole Skin_PART PDM REV. X.017_DRAWING PDM REV. X.016



D1002357-03
ONE HOLE RIGHT NO QPD SKIN
SEE D1002357-01 FOR DIMS NOT SHOWN

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV. v2
SIZE D	DWG. NO. D1002357	
SCALE: 1:4	PROJECTION:	SHEET 10 OF 13

D1002357_AduLIGO_AOS_SLC_ARM_Cavity_Bottle_1 Hole_Skin_PART.PDM_REV.X.017_DRAWING.PDM_REV.X.016



D1002357-04
ONE HOLE LEFT NO QPD SKIN
SEE D1002357-01 FOR DIMS NOT SHOWN

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
1	D1002357-04	ACB 1 HOLE LEFT NO QPD SKIN	ENAMEL STL A424 TYPE I	1		1

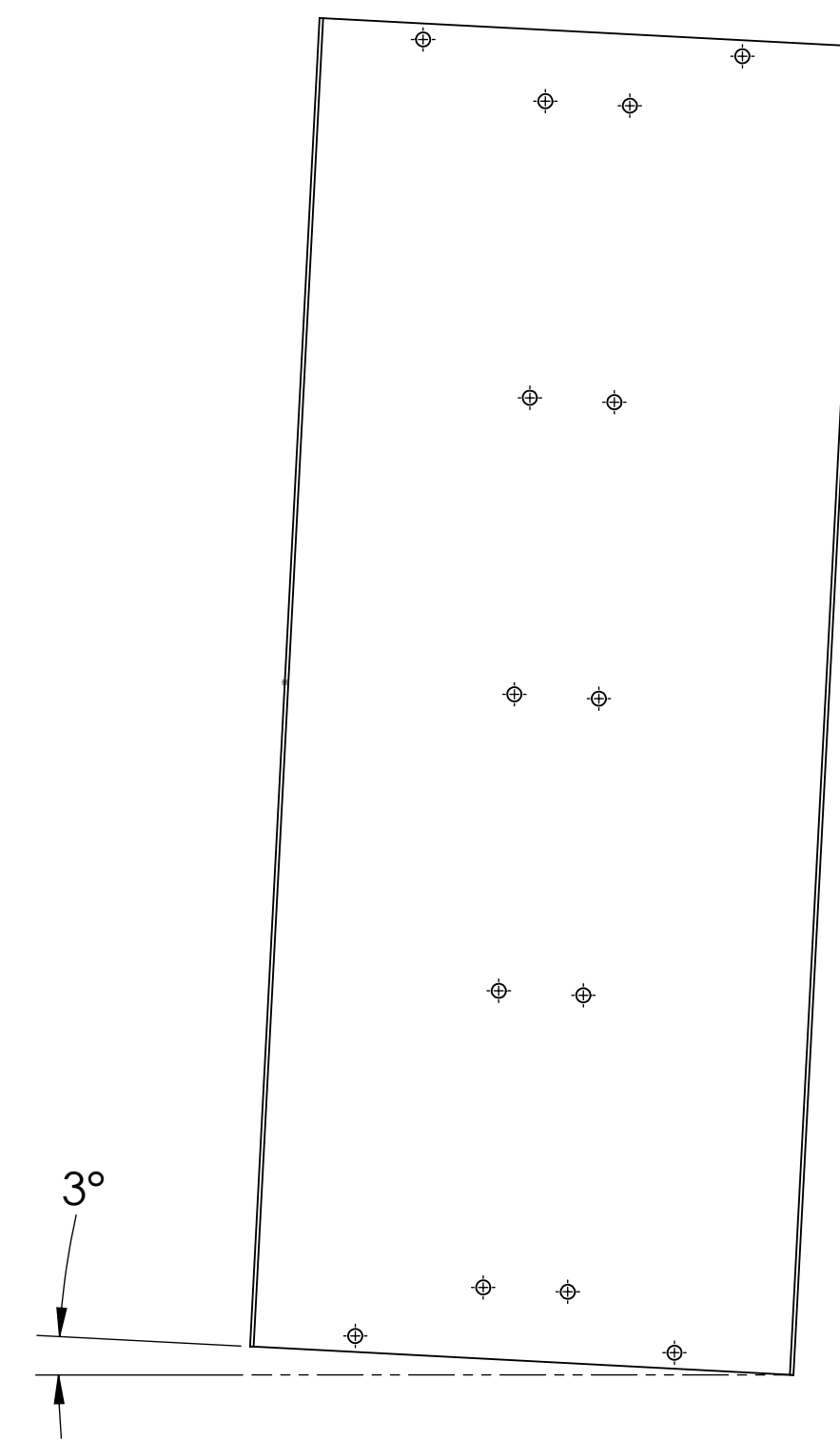
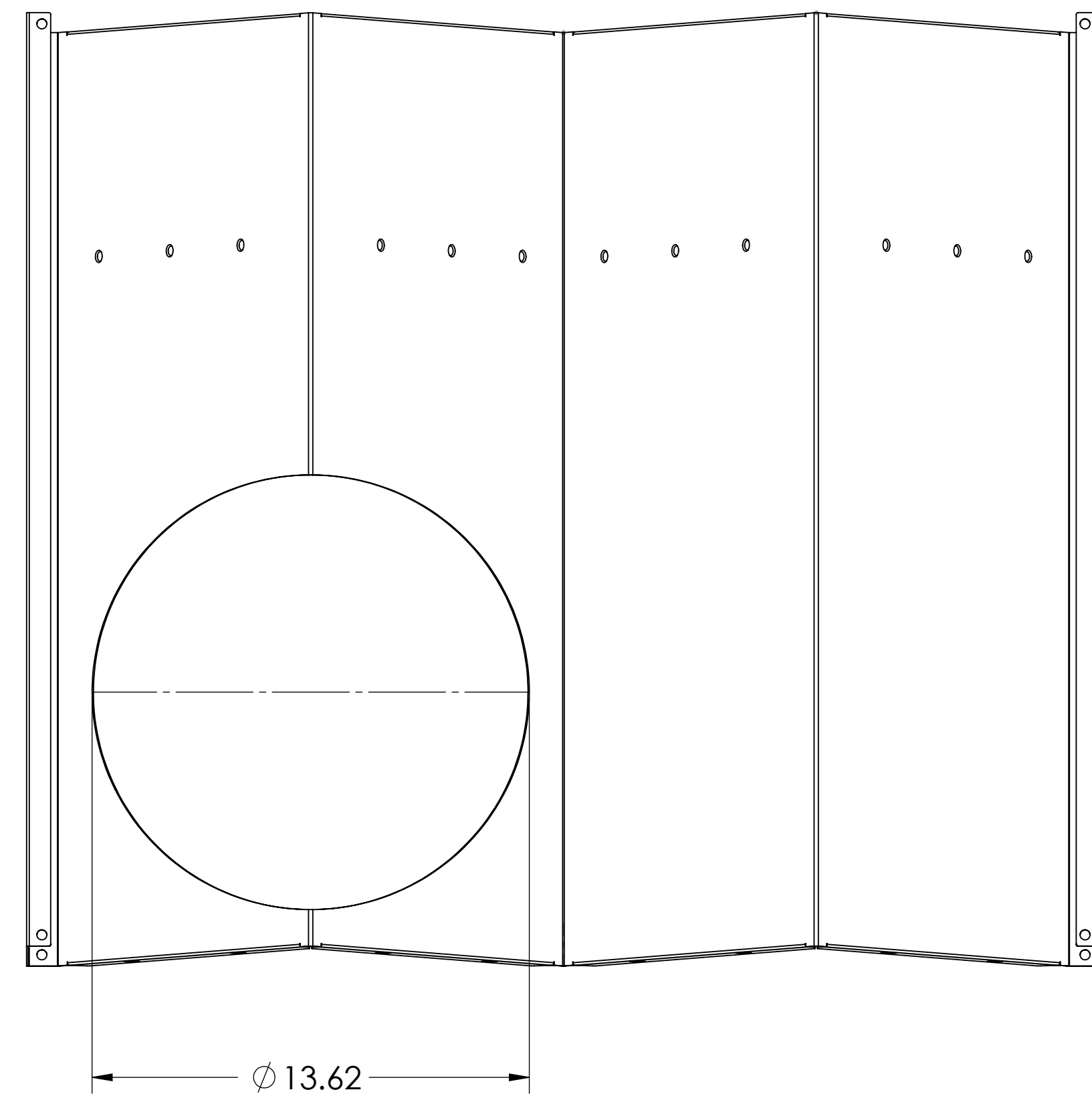
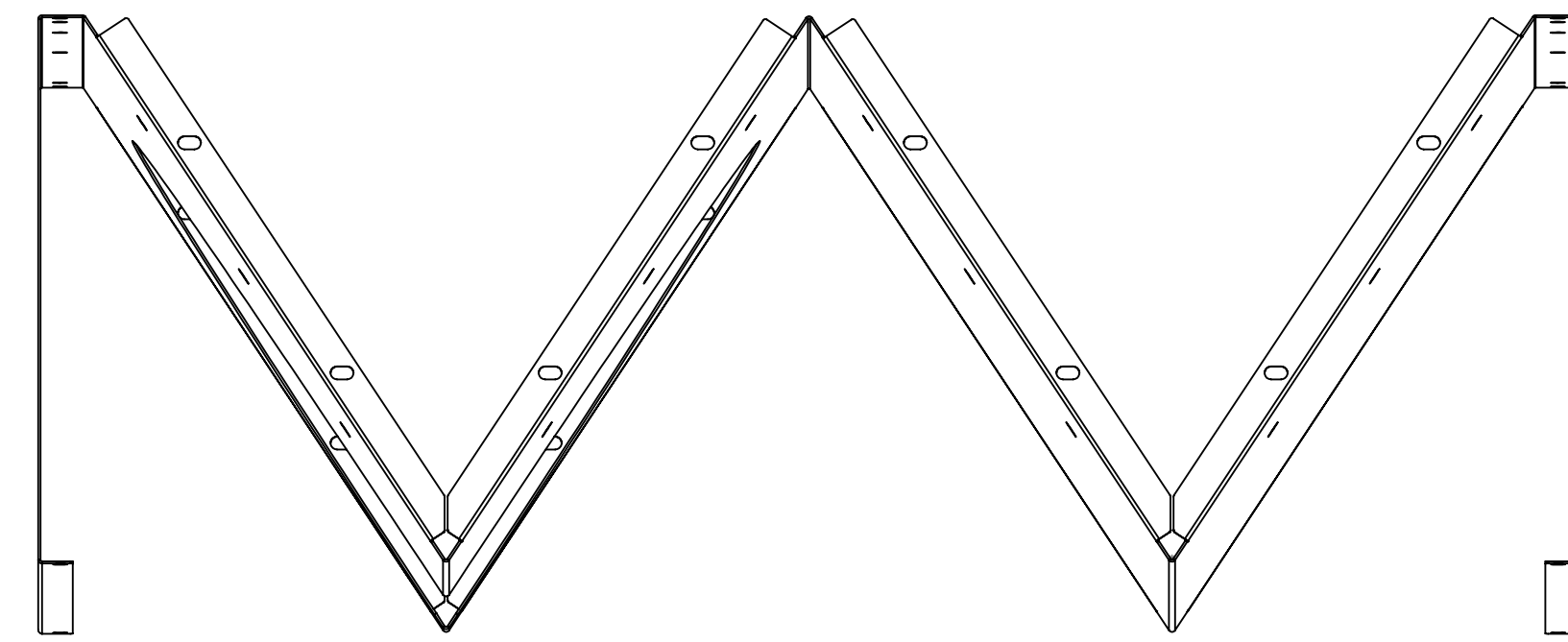
PARTS LIST

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE DWG. NO. REV.
D **D1002357** v2

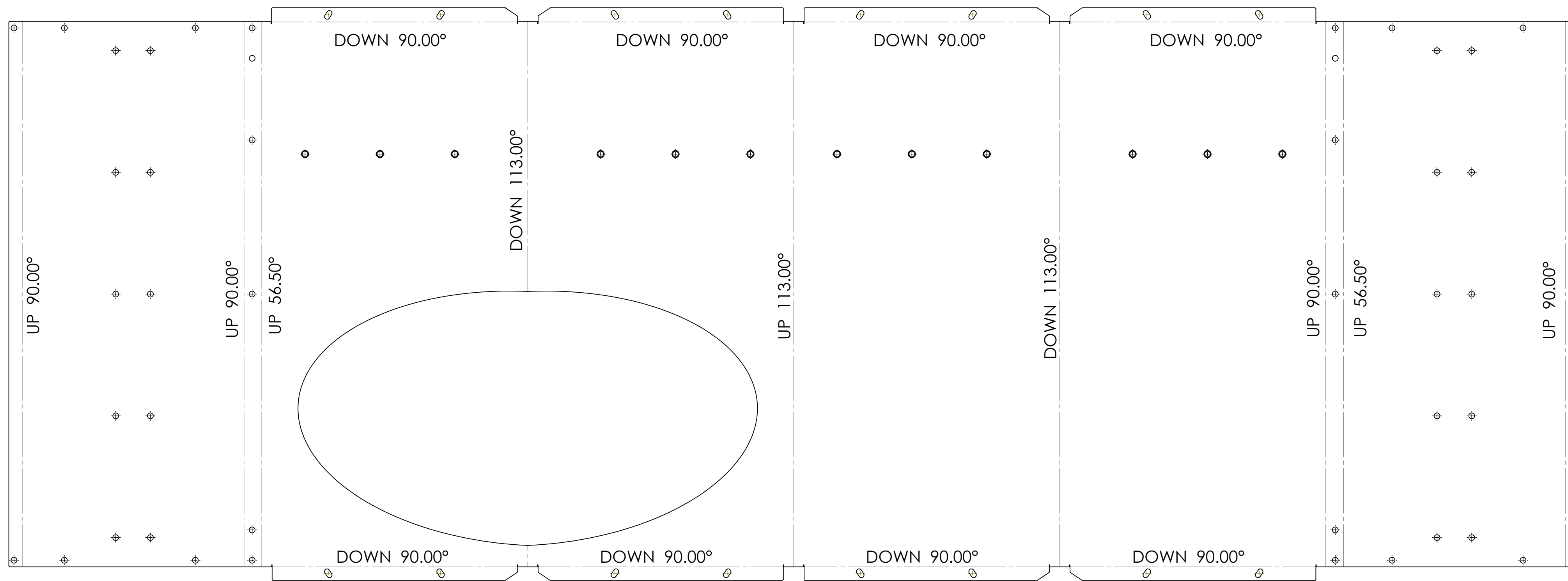
SCALE: 1:4 PROJECTION: SHEET 11 OF 13

D1002357_AduIGO_ACS_SLC_ARM_Covily_Baffle_1 Hole Skin_PART PDM REV. X-017_DRAWING PDM REV. X-016



D1002357-04
ONE HOLE LEFT NO QPD SKIN
3° TILT

D:\002357_AduLIGO_AOS_SLC_ARM_Cavity_Baffle_1 Hole_Skin_PART.PDM_REV.X.017.DRAWING.PDM_REV.X.016



D1002357-04
ONE HOLE LEFT NO QPD SKIN
SEE D1002357-01 FOR DIMS NOT SHOWN

D1002357_AduLIGO_AOS_SLC_ARM_Covly_Bottle_1 Hole Skin_PART PDM REV. X.017_DRAWING PDM REV. X.016