

7 6 5 4 3 2 1

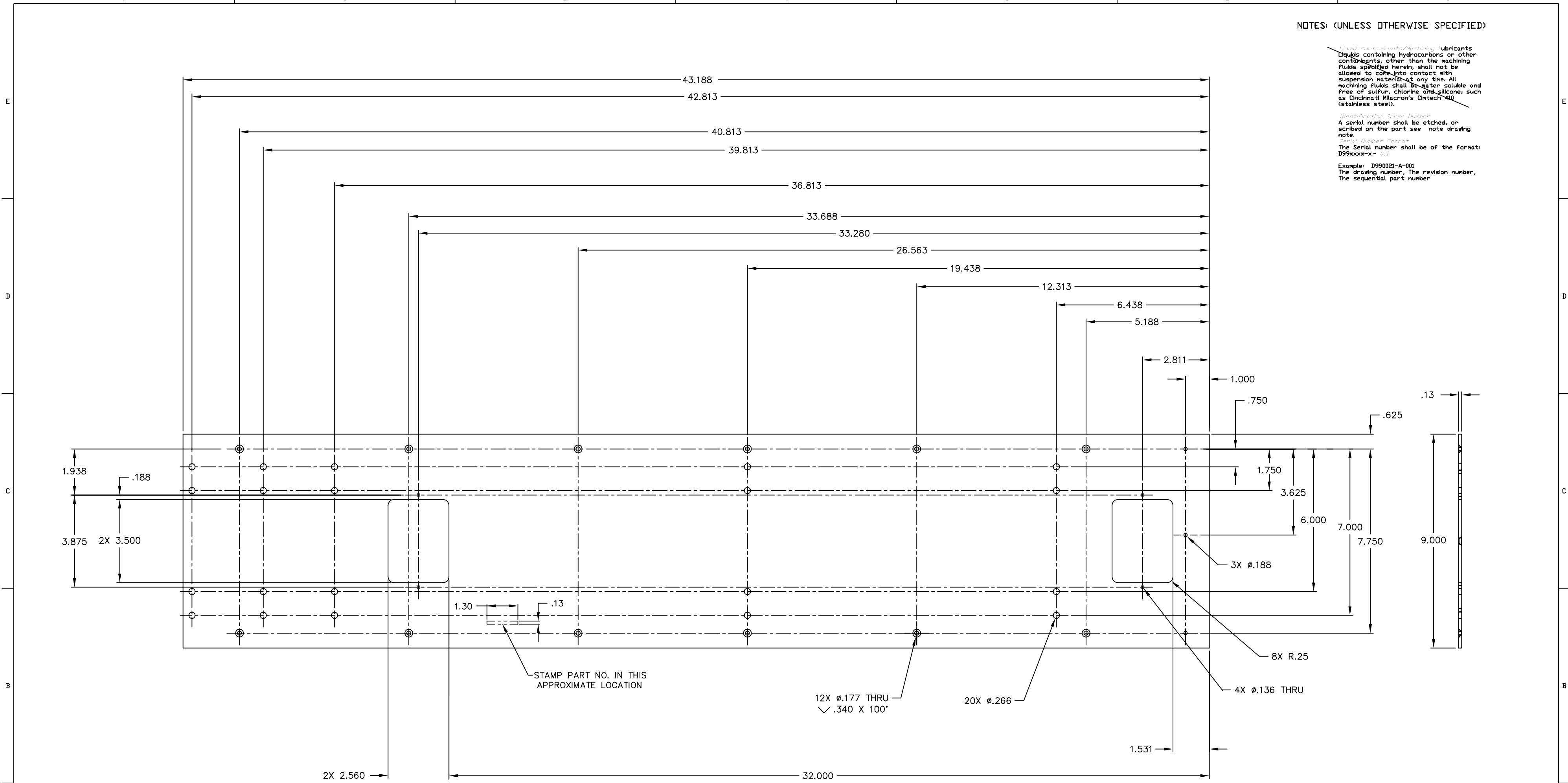
NOTES: (UNLESS OTHERWISE SPECIFIED)

Liquids containing hydrocarbons or other contaminants, other than the machining fluids specified herein, shall not be allowed to come into contact with suspension material at any time. All machining fluids shall be water soluble and free of sulfur, chlorine and silicone such as Cincinnati Milacron's Cimtech 400 (stainless steel).

Identification, Serial Number
A serial number shall be etched, or scribed on the part see note drawing note.

Serial Number Format
The Serial number shall be of the format: D99xxxx-x-01

Example: D990021-A-001
The drawing number, the revision number, the sequential part number



REF. MAKE 1 PER ASSEMBLY

REF	QTY	PART or DRWG No.	DESCRIPTION	MATERIAL
PARTS and MATERIAL LIST				
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY				
SHEET, LOWER, BOX TUBE				
XXX	XXX			
TOLERANCES:		UNLESS OTHERWISE SPECIFIED		
DIMENSIONS ARE IN INCHES				
FRACTIONAL ± 1/16	THREE PLACE DECIMAL ± .005			
ANGULAR ± .25°	FINISHED SURFACE RMS 63			
ANGULAR MACH ± BEND ±	BREAK CORNERS IN: .015 OUT: .015			
TWO PLACE DECIMAL ± .01	REMOVE ALL BURRS			
MATERIAL: 6061-T6 ALUM SHEET .125 Thk	HEAT TREAT: /	FINISH:		
USED ON: XXX	NEXT ASS'Y: XXX			
REV	DESCRIPTION	DCN NUMBER	APPR'D	CHECK
00	PRE-RELEASE	-	-	-
01	FOR FABRICATION	-	-	-
02		-	-	-
03		-	-	-
04		-	-	-
05		-	-	-
06		-	-	-
07		-	-	-
08		-	-	-
09		-	-	-
10		-	-	-
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13		-	-	-
14		-	-	-
15		-	-	-
16		-	-	-
17		-	-	-
18		-	-	-
19		-	-	-
20		-	-	-
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22		-	-	-
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27		-	-	-
28		-	-	-
29		-	-	-
30		-	-	-
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32		-	-	-
33		-	-	-
34		-	-	-
35		-	-	-
36		-	-	-
37		-	-	-
38		-	-	-
39		-	-	-
40		-	-	-
41		-	-	-
42		-	-	-
43		-	-	-
44		-	-	-
45		-	-	-
46		-	-	-
47		-	-	-
48		-	-	-
49		-	-	-
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51		-	-	-
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58		-	-	-
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90		-	-	-
91		-	-	-
92		-	-	-
93		-	-	-
94		-	-	-
95		-	-	-
96		-	-	-
97		-	-	-
98		-	-	-
99		-	-	-
100		-	-	-

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