

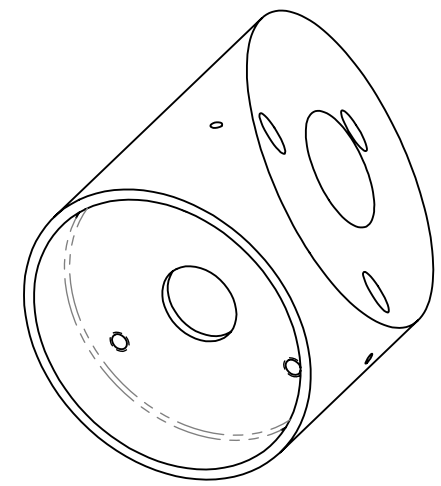
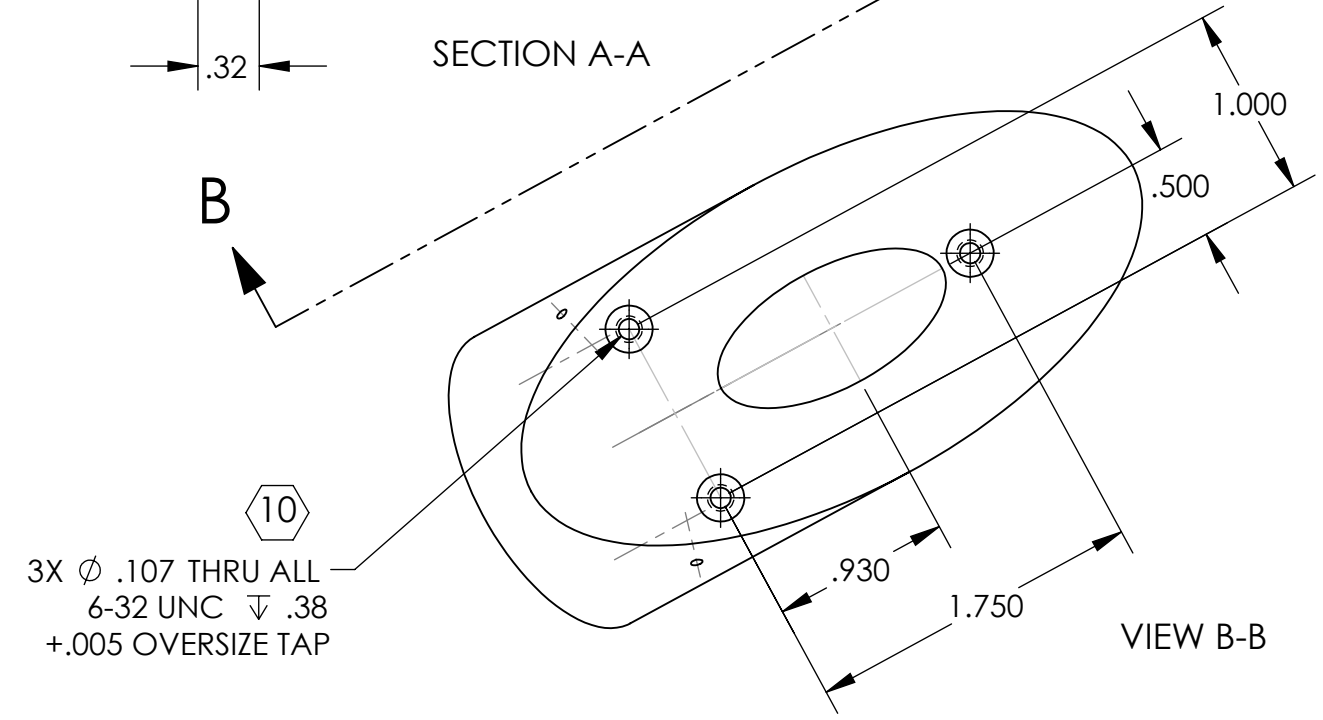
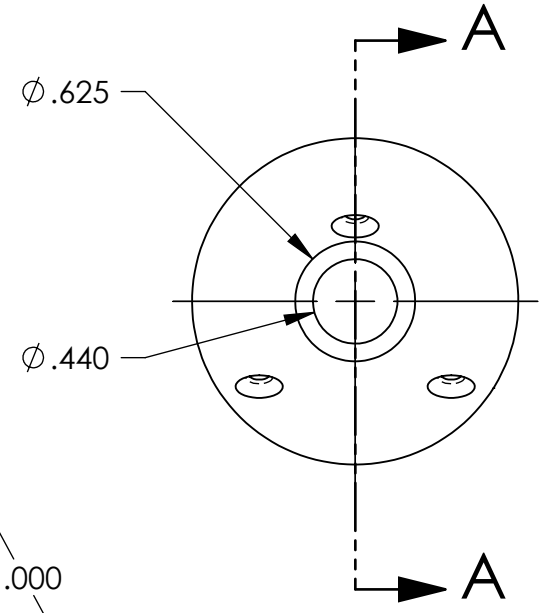
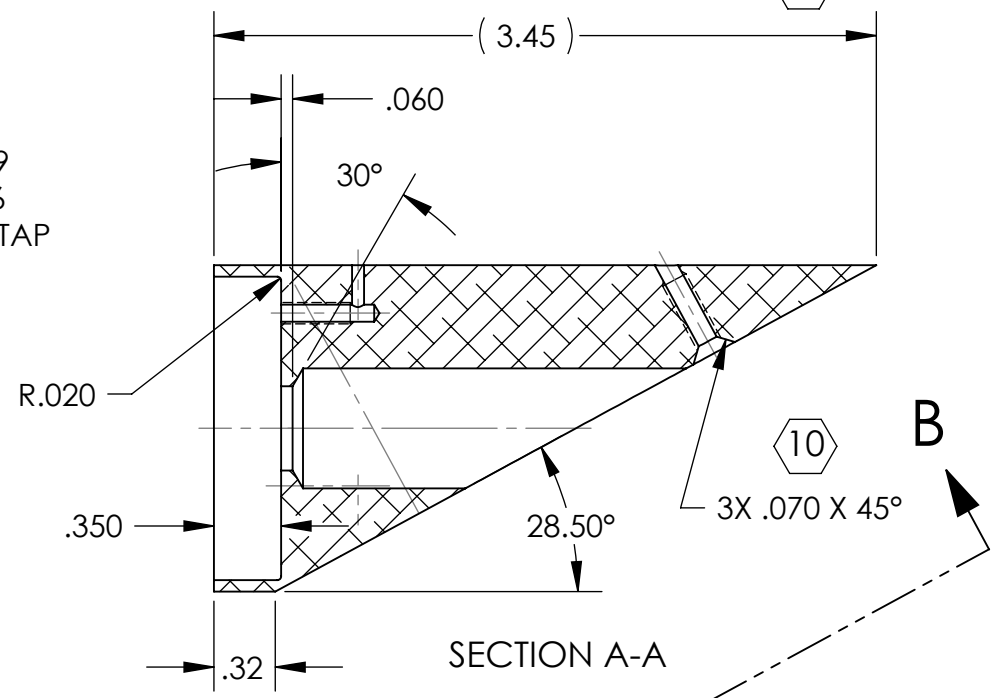
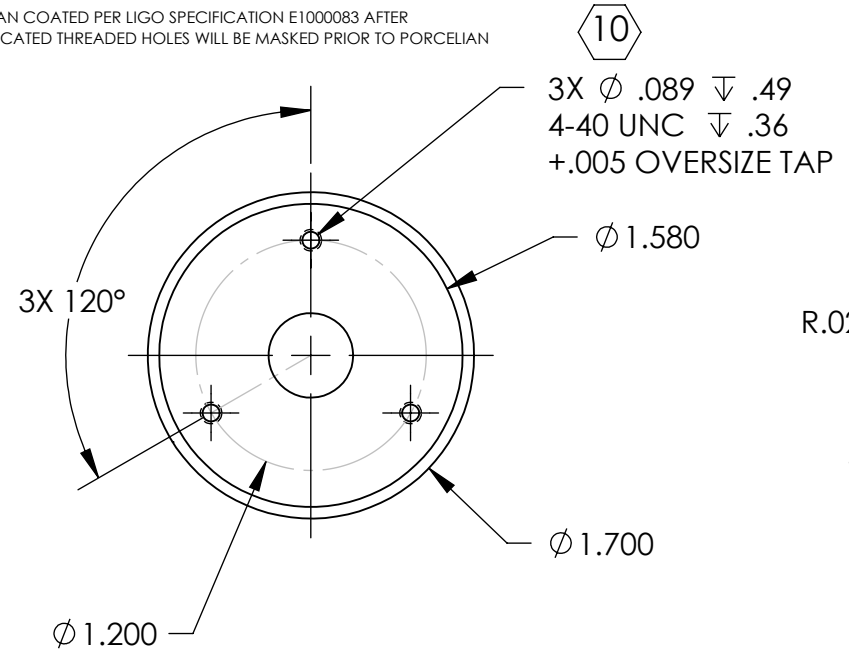
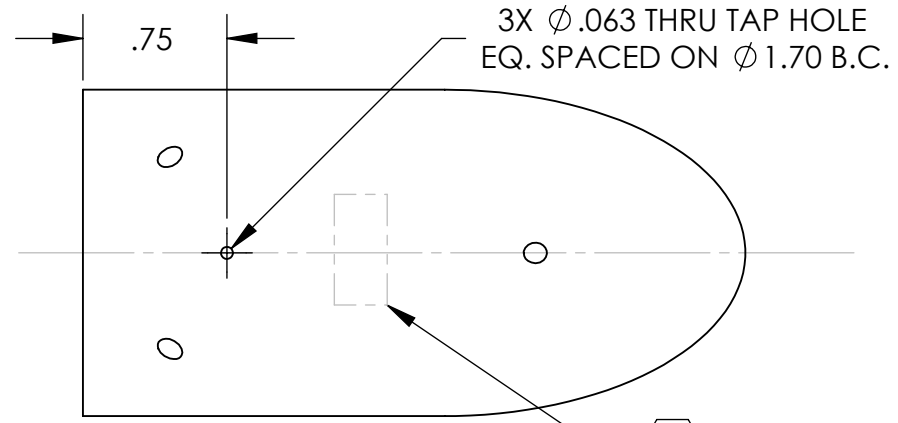
D1003025\_AdlIGO\_AOS\_SLC Photodetector Housing, PART PDM REV: X-020, DRAWING PDM REV: X-026

8 7 6 5 4 3 2 1

**NOTES: UNLESS OTHERWISE SPECIFIED**

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES 0.005" TO 0.015".
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. REFER TO LIGO E0900237 FOR LIST OF APPROVED COOLANTS.
5. SCRIBE, ENGRAVE OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY .020 DEEP WITH MINIMUM .156 HIGH CHARACTER. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT  
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
6. APPROXIMATE WEIGHT =0.894 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364.
8. PART SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. 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.
10. PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION. THE INDICATED THREADED HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING.

REV.	DATE	DCN #	DRAWING TREE #
v1	06 MAR 2011	E1000285	-
v2	07 APR 2011	E1100216	-
-	-	-	-



**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

DIMENSIONS ARE IN INCHES

TOLERANCES:  
.XX  $\pm$  .01  
.XXX  $\pm$  .005

ANGULAR  $\pm$  0.5°

MATERIAL 304 SSSL

FINISH NOTE 10

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM AOS

NEXT ASSY D1003013

PART NAME			SIZE DWG. NO.			REV.
PD HOUSING			B			v2
DESIGNER	N. Nguyen	17 Nov 2010	D1003025			
DRAFTER	N. Nguyen	20 Nov 2010				
CHECKER	M. Smith	01 Dec 2010				
APPROVAL						
SCALE: 1:1			PROJECTION:			SHEET 1 OF 1

8 7 6 5 4 3 2 1