

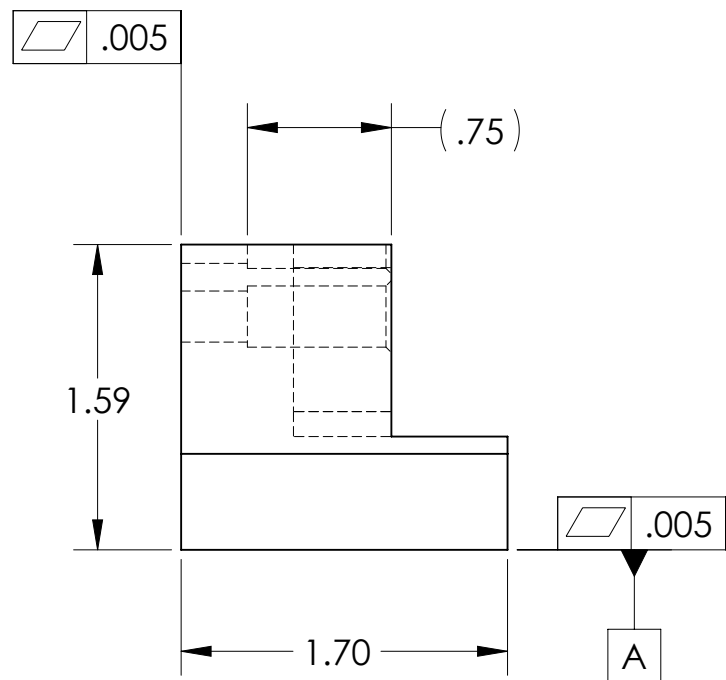
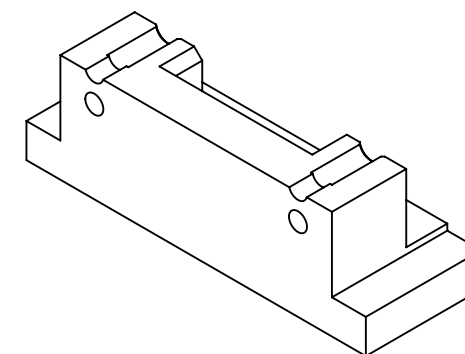
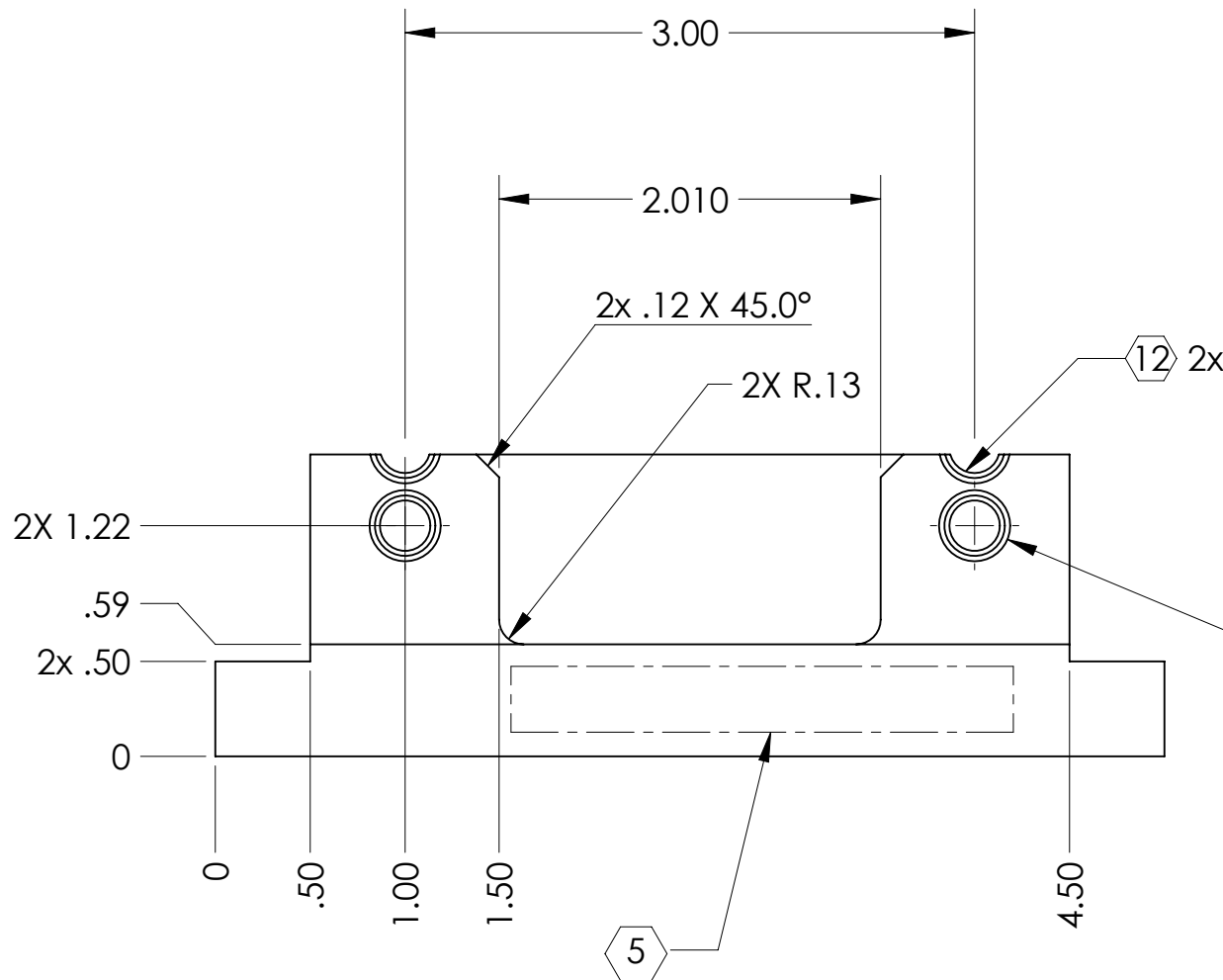
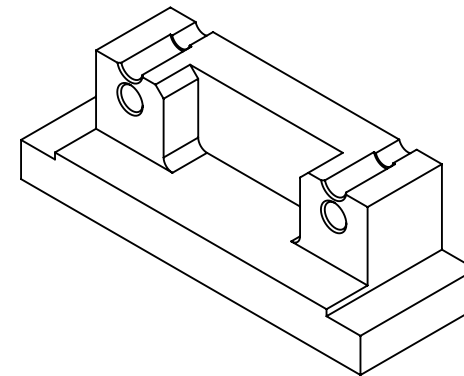
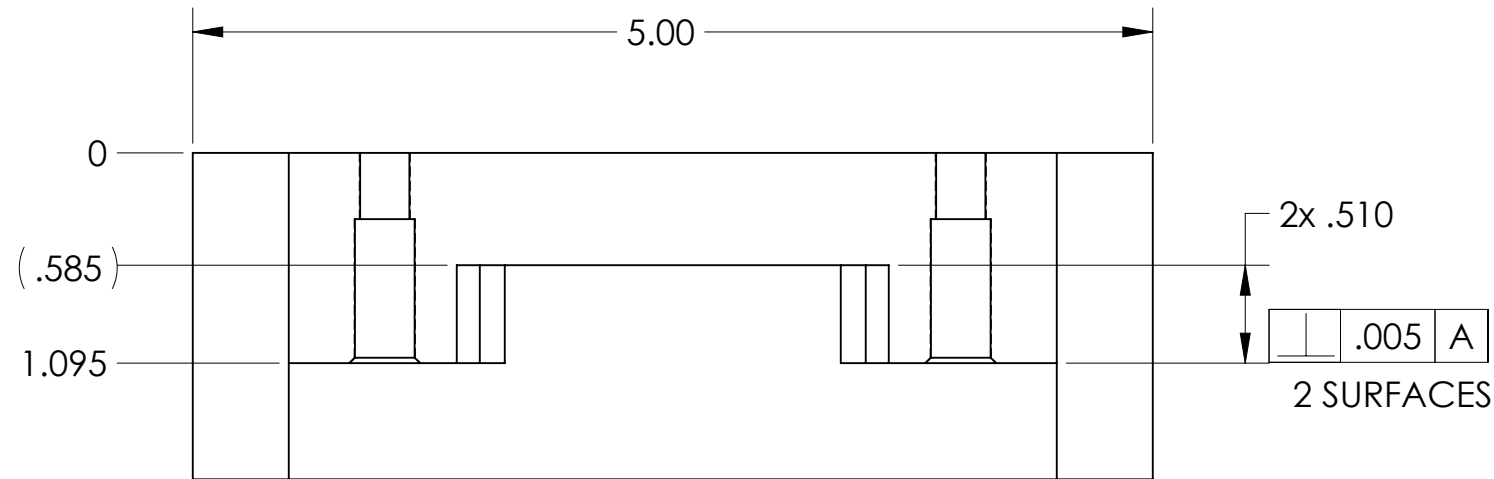
NOTES CONTINUED:

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 = 0.78 LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
- 10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
- 11. 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.

⑫ NO LONGER USED FEATURES FROM THE -v1 VERSION OF THIS PART.

REV.	DATE	DCN #	DRAWING TREE #
v1	29 MAY 2013	-	-
v2	1 NOV 2013	E1300835-x0	-
-	-	-	-



Ø .27 THRU  
 Ø .32 ± .015  
 ✓ Ø X 90°  
 TAP FOR 1/4-20 HELICOIL INSERT = 2.0 \* DIA.

D1003326 ISC Fast Shutter Base aLIGO, PART PDM REV.: DRAWING PDM REV.: X-002

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED 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.		ISC Fast Shutter Base, aLIGO	
MATERIAL 6061-T6 Al		FINISH 63 µinch		SYSTEM ADVANCED LIGO		SUB-SYSTEM ISC	
NEXT ASSY D1003318				DESIGNER SBARNUM	DATE MAY 2013	SIZE DWG. NO. B	REV. v2
				DRAFTER SBARNUM	DATE 21 MAY 2013	D1003326	
				CHECKER JLEWIS			
				APPROVAL PFRITSCHEL	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1