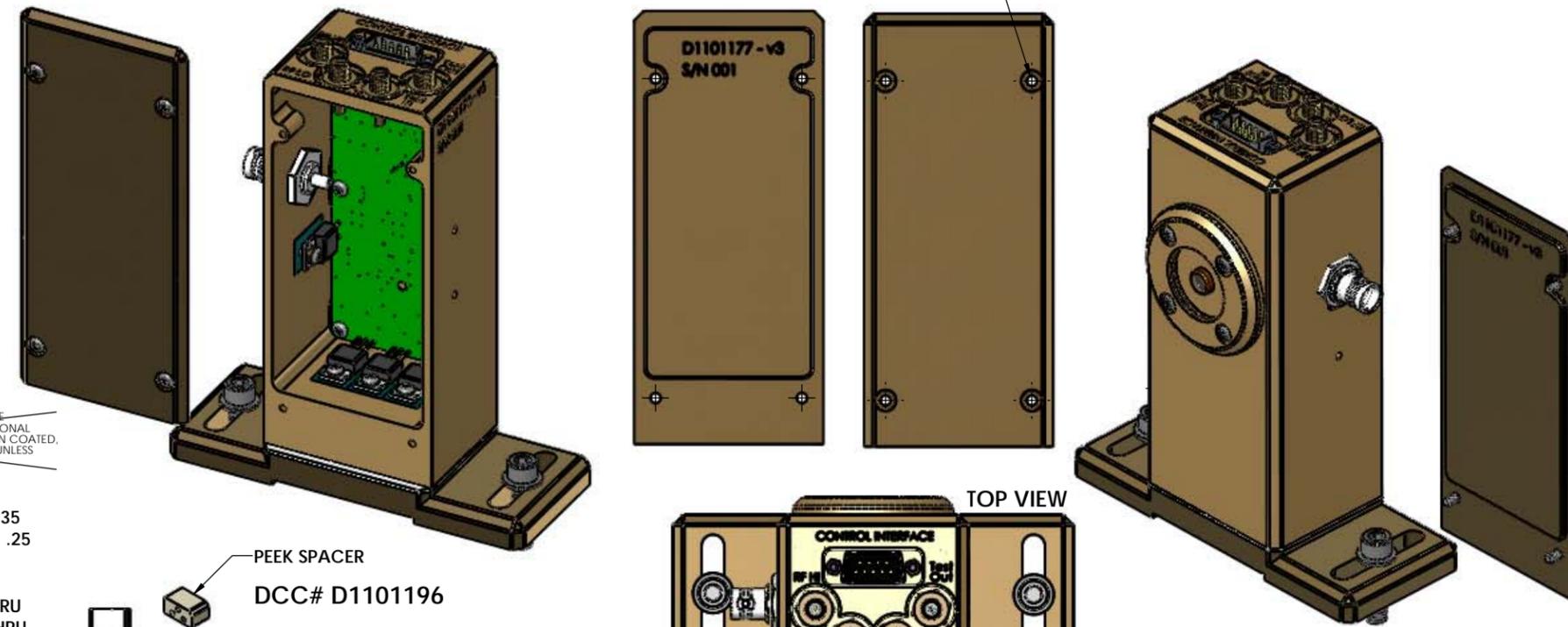


- NOTES CONTINUED:
- SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR 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
 - APPROXIMATE WEIGHT = X.XXX LB.
 - MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-ED900364
 - ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - ALL HET-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HET-COIL PRODUCT CATALOG, HC2000, REV. 4.
 - ALL HET-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
 - 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-ED900364.
 - SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
 - 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.
 - DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.
 - 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 A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.

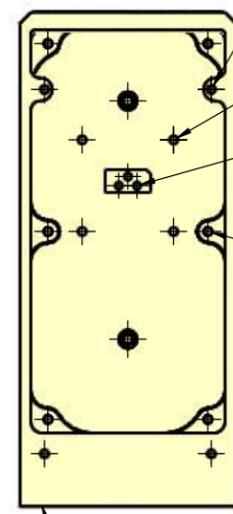
NOTES 9, 10, 13, 14 and 15 DO NOT APPLY TO THIS PART

DCC# 1101177
LID

4x Ø.129 THRU ALL



REAR VIEW



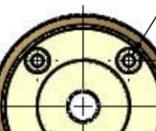
4x Ø.089 ±.35
#4-40 UNC ±.25

4x Ø.089 THRU
#4-40 UNC THRU

Ø.078 THRU

6x Ø.089 ±.25
#4-40 UNC ±.22

FRONT VIEW



4x Ø.129 THRU ALL

1.000

PEEK SPACER

DCC# D1101196



REAR VIEW

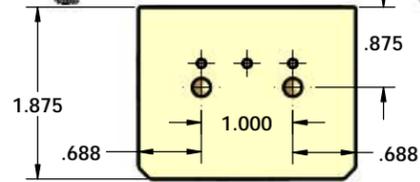


MACHINED ALUMINUM
DCC# D1101176

DCC# 1101179

ALUMINA INSULATING SPACER
0.050"

Ø.257 THRU



BOTTOM VIEW
(MAIN BODY)

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN
TOLERANCES:
XX ±
XXX ±
ANGULAR ± °

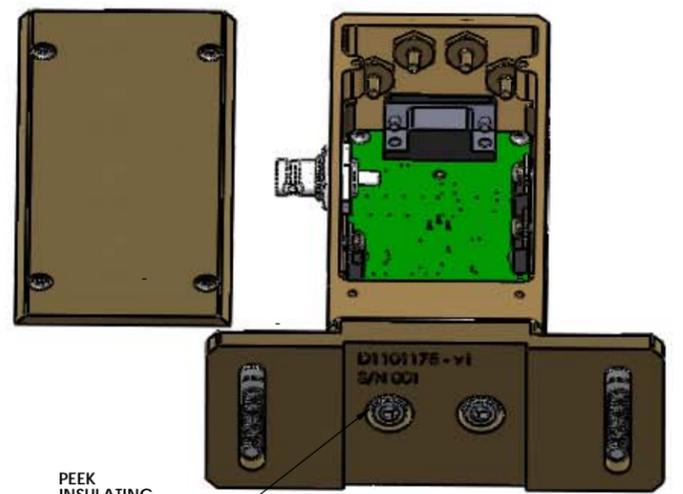
1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL Material <not specified>
FINISH µinch

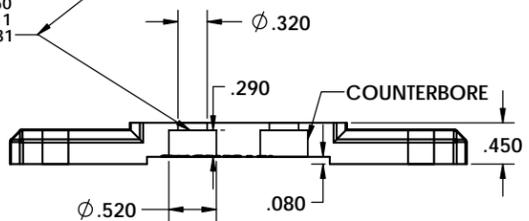
INTERCHANGEABILITY LISTING

AS OF THIS DATE	THIS DCC # (PART NUMBER)	IS EQUIVALENT TO	THIS DCC # (PART NUMBER)	WITH THESE DIFFERENCES
FEB/21/2012	D1101175-v2 (BASE)	=	D1102417-v1 (BASE)	DIFFERENT ENGRAVED PART #
FEB/21/2012	D1101177-v4 (LID)	=	D1102419-v1 (LID)	DIFFERENT ENGRAVED PART #
FEB/21/2012	D1101179-v (ALUMINA SPACER)	=	D1102421-v1 (ALUMINA SPACER)	

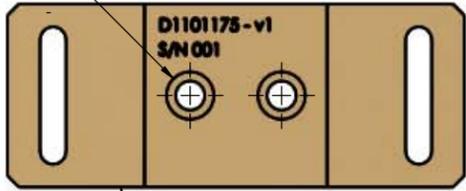
REV.	DATE	DCN #	DRAWING TREE #



PEEK INSULATING WASHER
I.D. 0.250
O.D. 0.511
THICK 0.031

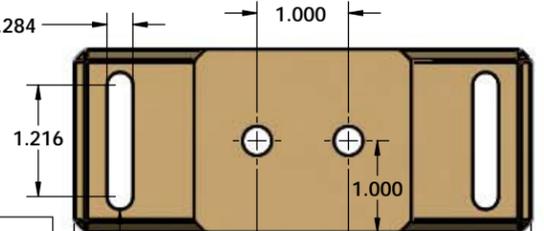
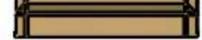


BOTTOM VIEW



MACHINED ALUMINUM
DCC# D1101175

SIDE VIEW



TOP VIEW

DCC# 1101175

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME
LSC IN-AIR ENCLOSURE - TOP ASSEMBLY

SYSTEM
SUB-SYSTEM ISC
NEXT ASSY

DESIGNER R.ABBOTT JUL/11/2012
DRAFTER E.BROWN JUL/11/2012
CHECKER
APPROVAL

SIZE DWG. NO. D D1101174
REV. v5

SCALE: 1:1 PROJECTION: SHEET 1 OF 1

D1101174_LSC_AIR_05_Exploded - TOP ASSEMBLY DRAW PART FROM REV. X.000 DRAWING FROM REV. X.004