

- 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.XXXX 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 ED900364.
 - ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMMART HELI-COIL PRODUCT CATALOG, HC2000, REV. 4
 - ALL HELI-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 BY 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.

ENGLISH (IMPERIAL)
1.035"-40 THREAD (SM1)

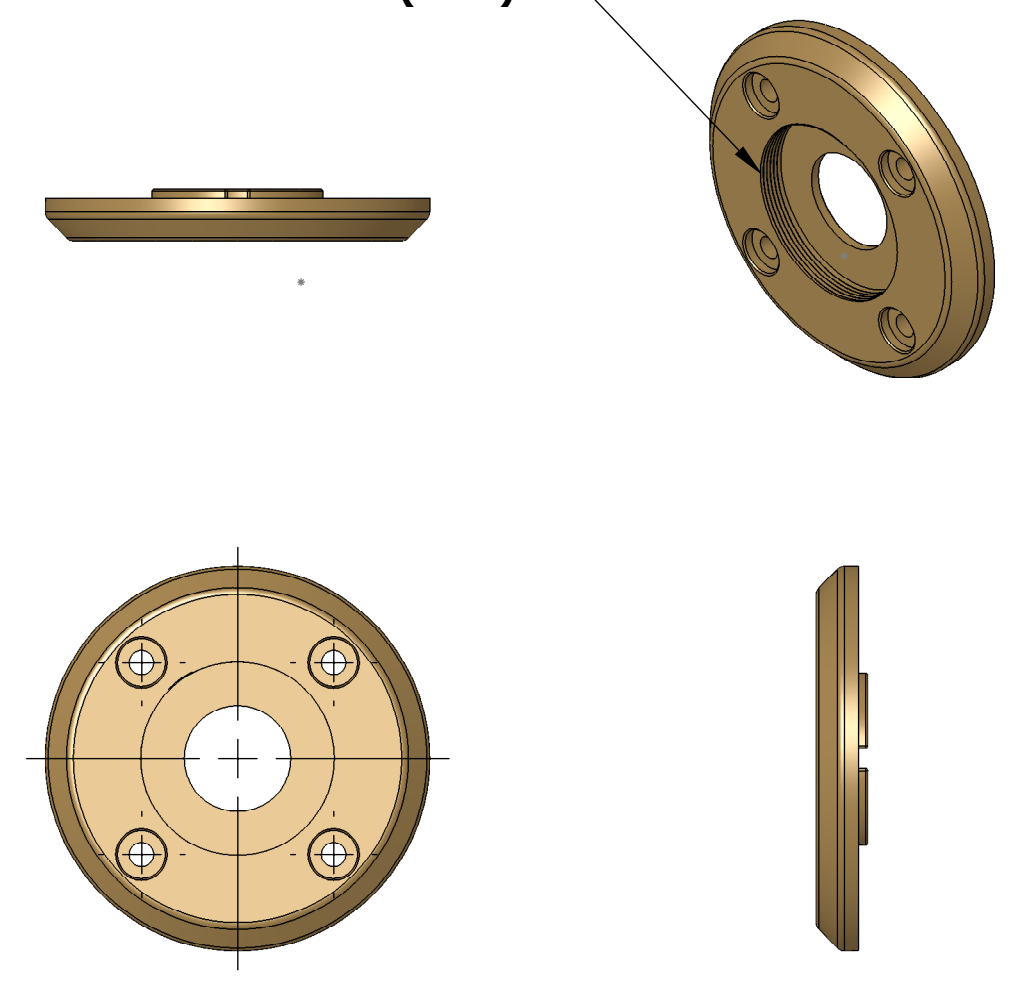
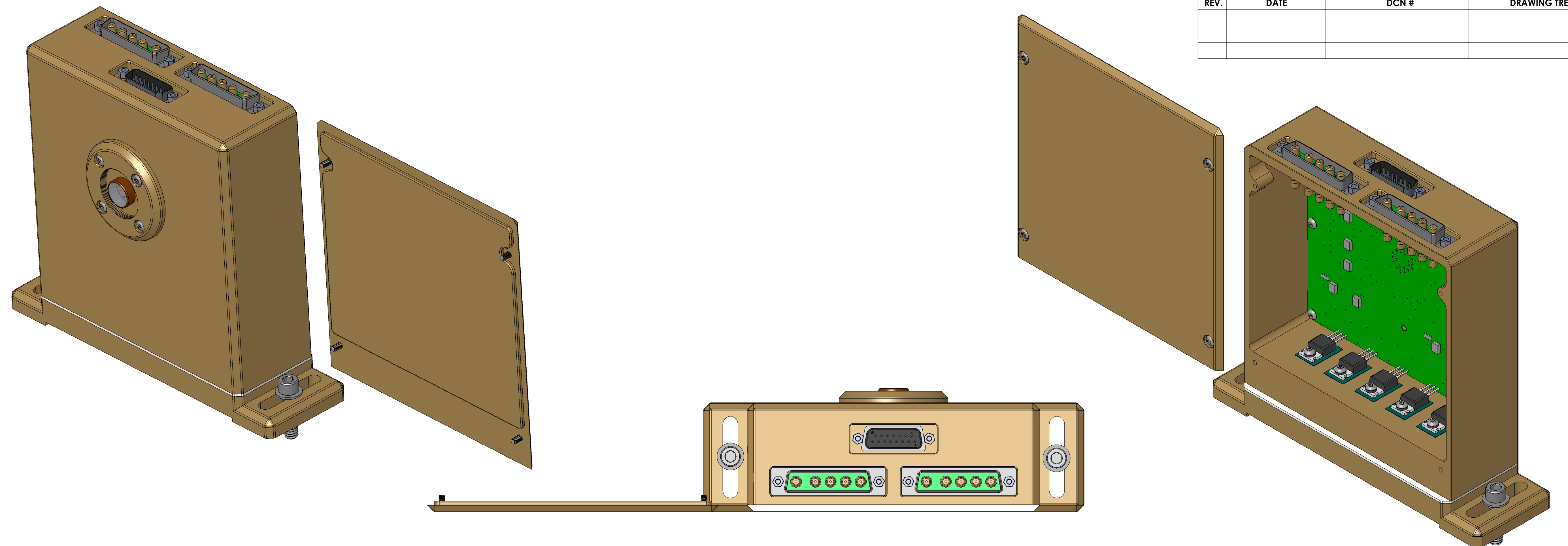
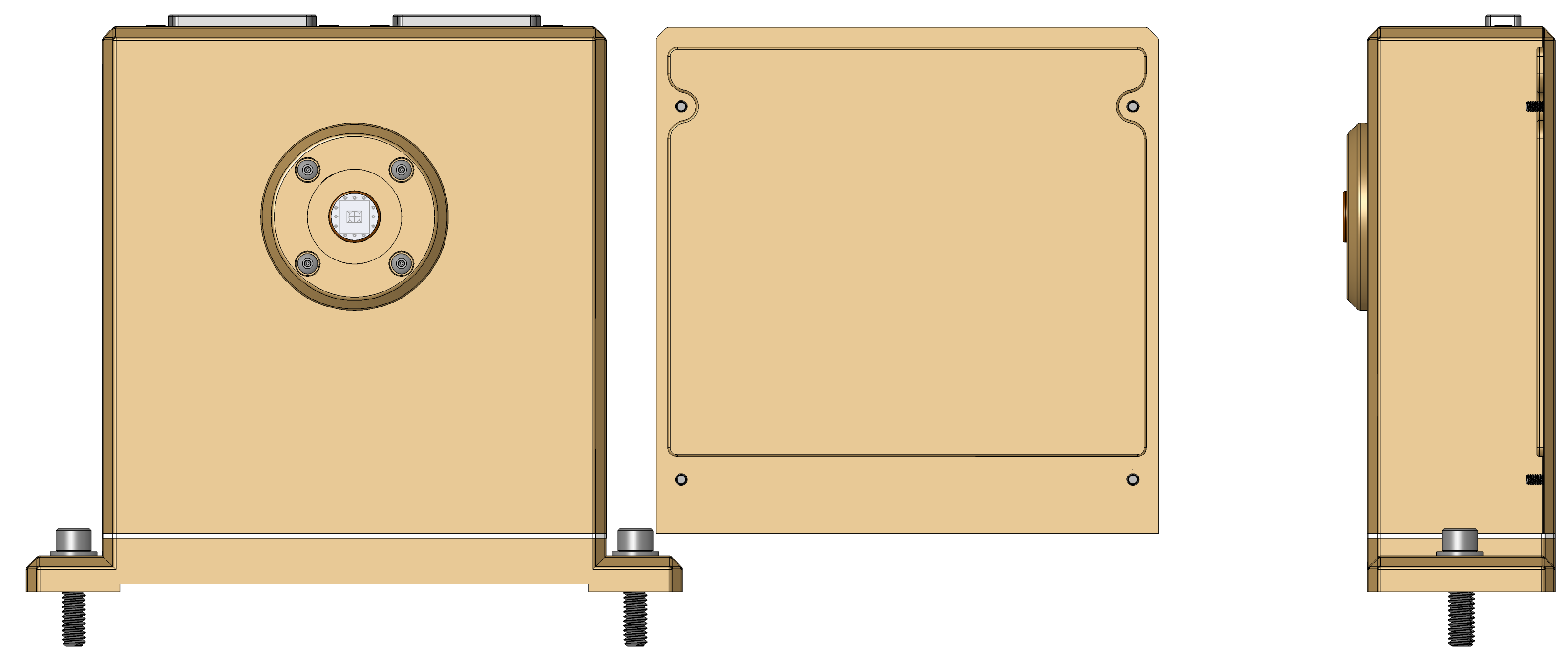


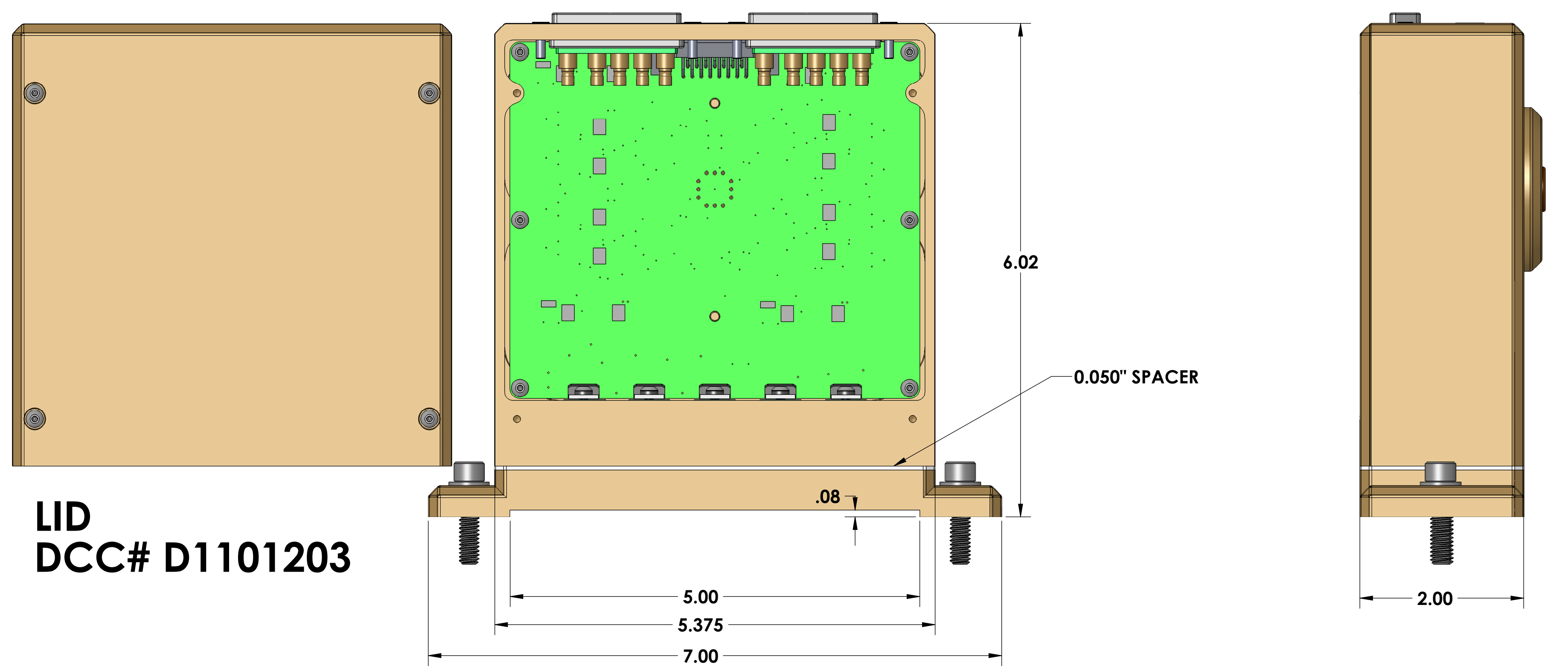
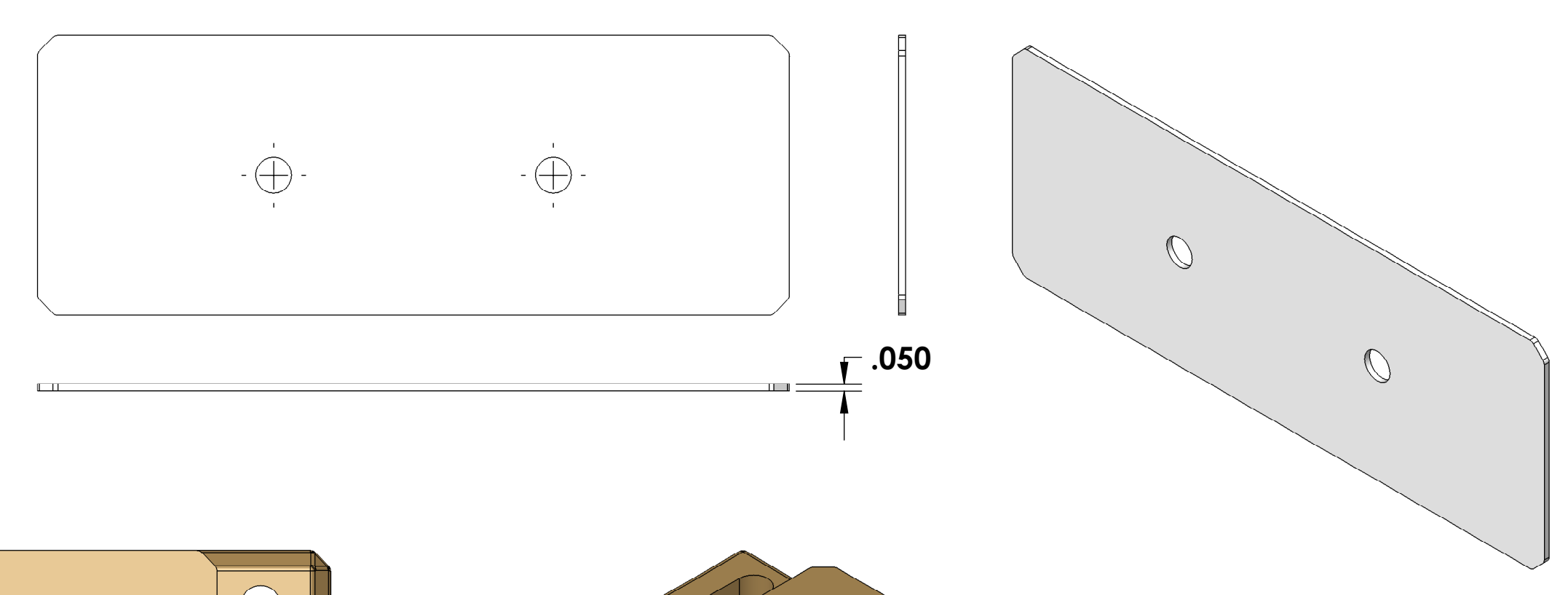
PHOTO HOOD
DCC# D1101204



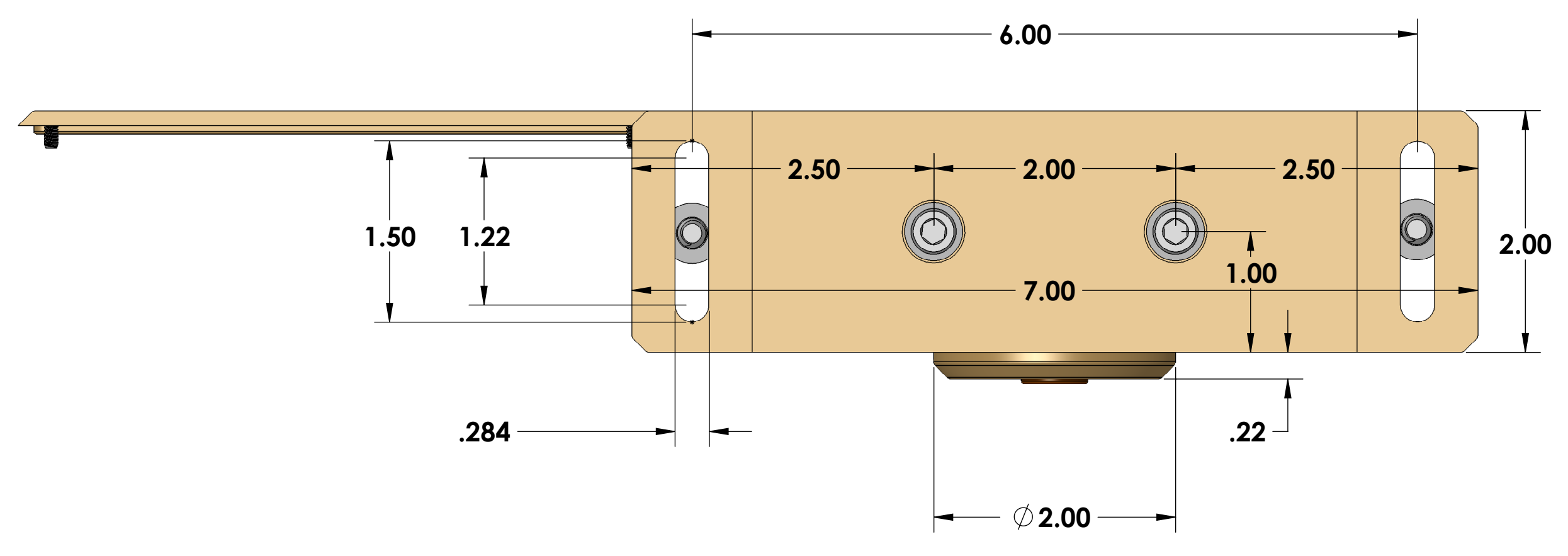
REV.	DATE	DCN #	DRAWING TREE #



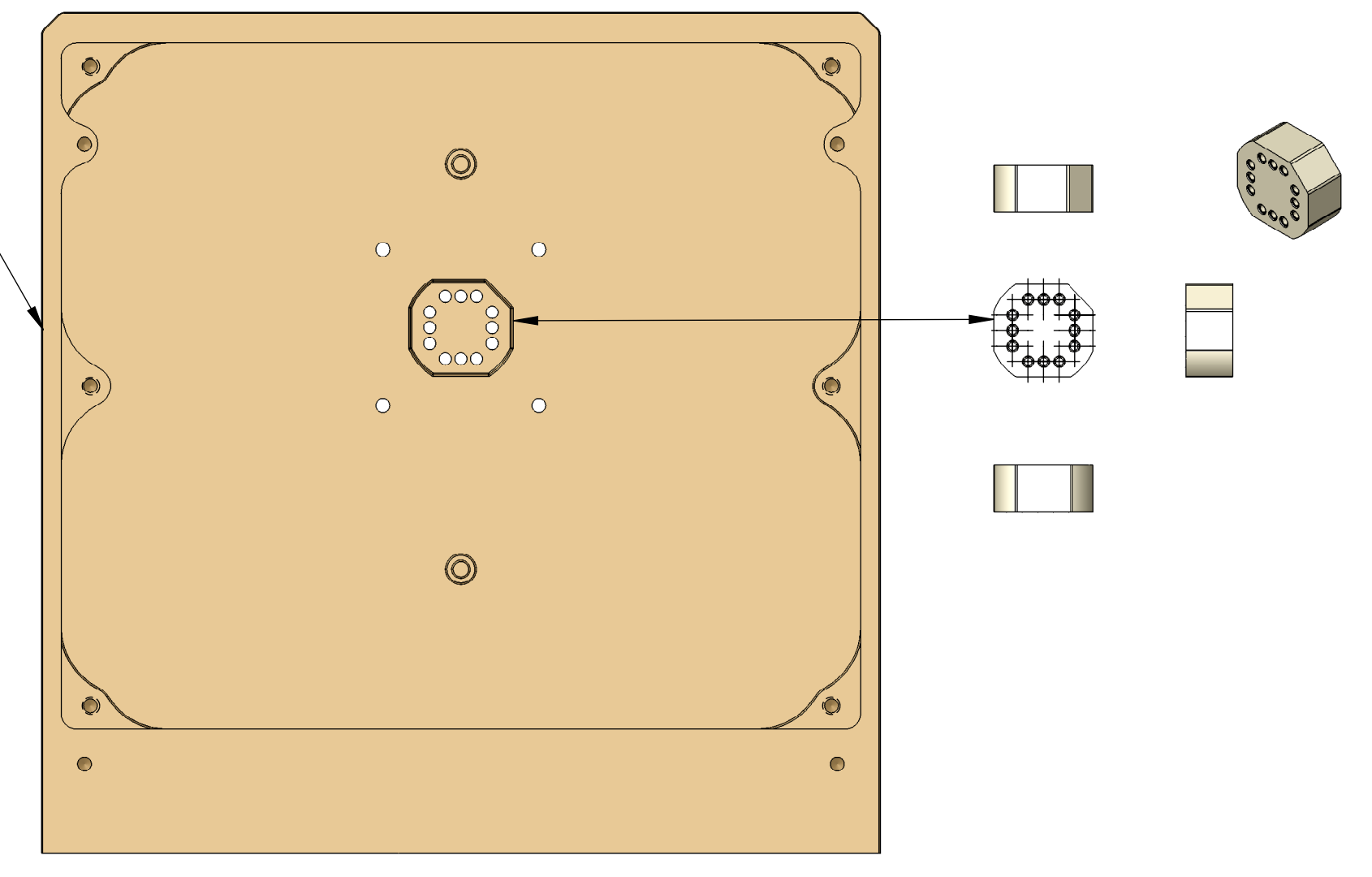
SPACER FOR BASE
DCC# D1101205



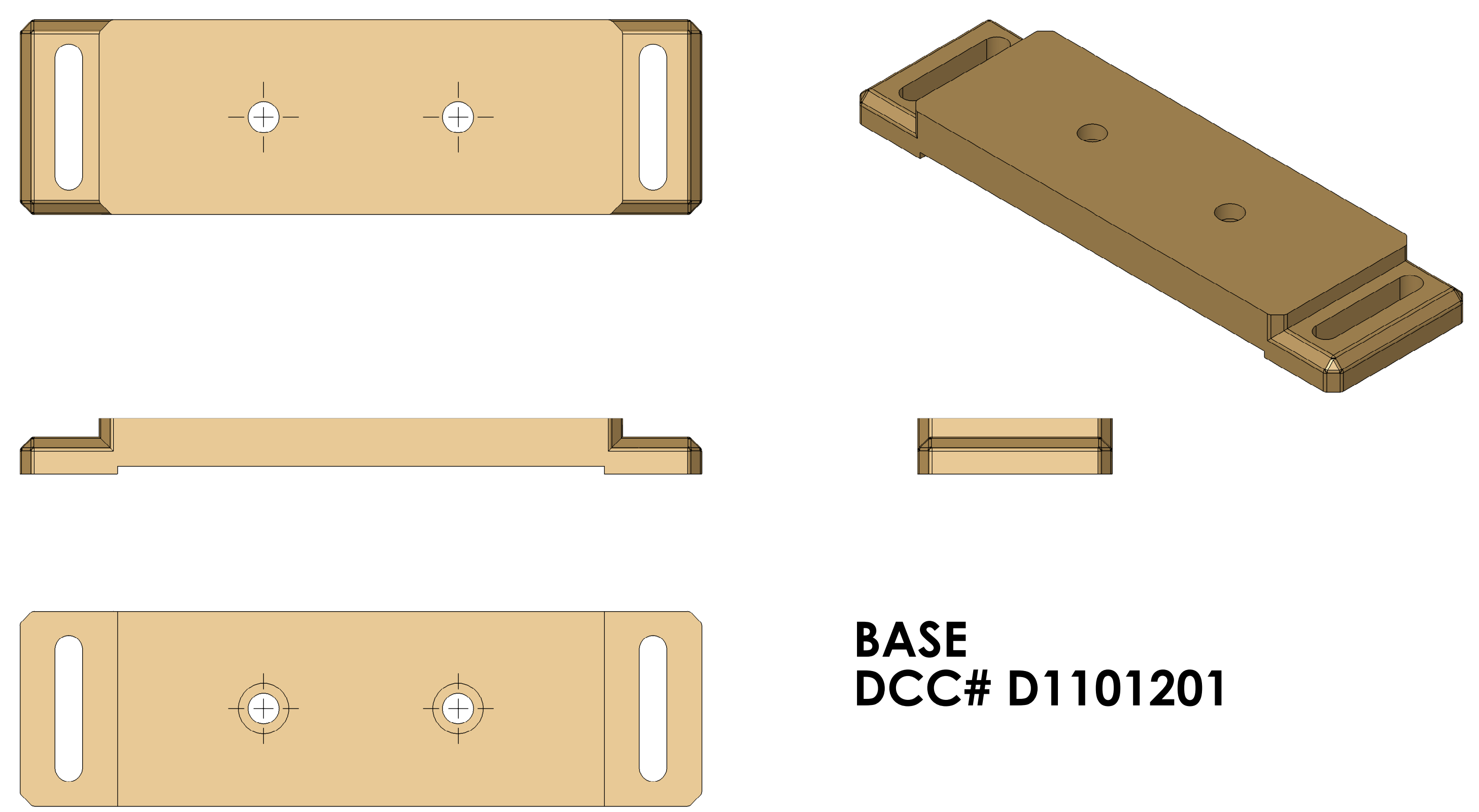
LID
DCC# D1101203



MAIN BODY
DCC# D1101202



PHOTODIODE
ALIGNMENT SPACER
DCC# D1101206



BASE
DCC# D1101201

DIMENSIONS ARE IN		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES:		1. INTERPRET DRAWING PER ASME Y14.5-1994		SYSTEM		ASC ENCLOSURE - TOP ASSEMBLY	
.XX ±		2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.		SUB-SYSTEM		DESIGNER R. ABBOTT	
.XXX ±		3. DO NOT SCALE FROM DRAWING.		ISC		DRAFTER E. BROWN	
ANGULAR ± °		4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		NEXT ASSY		CHECKER	
		MATERIAL				APPROVAL	
		N/A		N/A μinch		SCALE: 1:2	
						DWG. NO. D1101200	
						REV. v2	
						SHEET 1 OF 1	