NOTES CONTINUED:

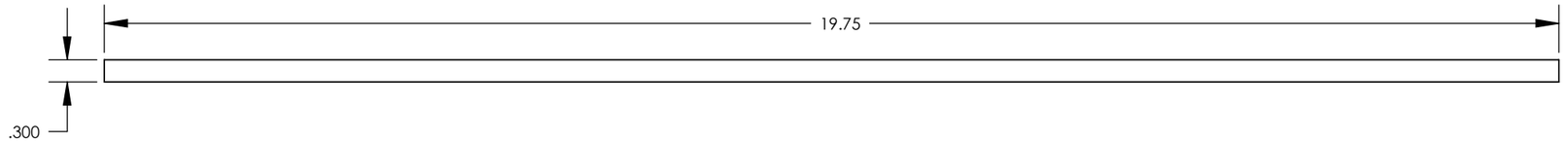
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

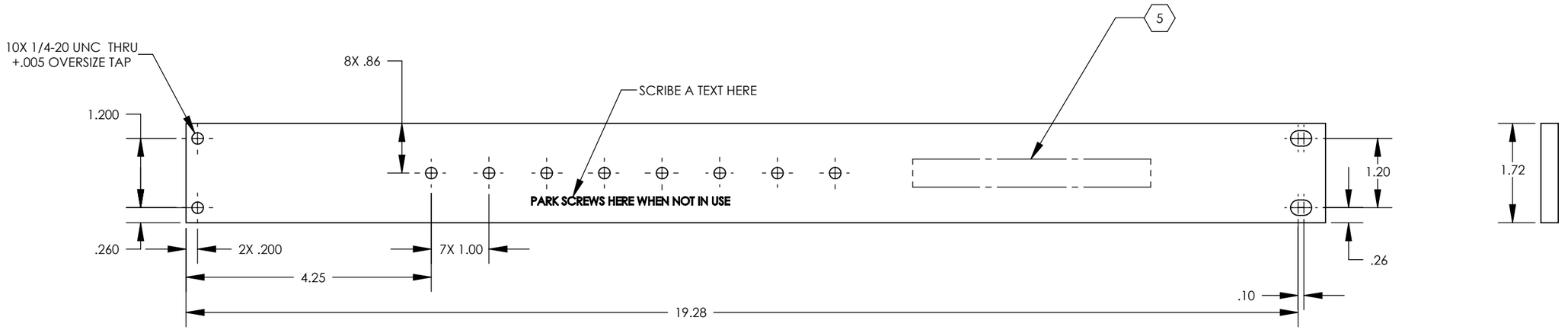
6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

7. 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.

8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

REV.	DATE	DCN #	DRAWING TREE #
v1	15 JUL 2011	E1100335	-
v2	18 APR 2012	E1100335	-
v3	25 SEP 2012	E1100312	-





NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)							
DIMENSIONS ARE IN TOLERANCES: .XX ± .03 .XXX ± .010 ANGULAR ± .5°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATLEY 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.			LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: STIFFENER, TUBE UP	
	MATERIAL: 6061-T6 Al	FINISH: 63 µinch	NEXT ASSY: D1101288	SYSTEM: ADVANCE LIGO	SUB-SYSTEM: AOS	DESIGNER / DRAFTER / CHECKER / APPROVAL	SIZE: B; DWG. NO.: D1101404; REV.: v3; SCALE: 1:1; PROJECTION: ; SHEET 1 OF 1

D1101404, STIFFENER, TUBE UP, PART PDM REV: X-018, DRAWING PDM REV: X-018