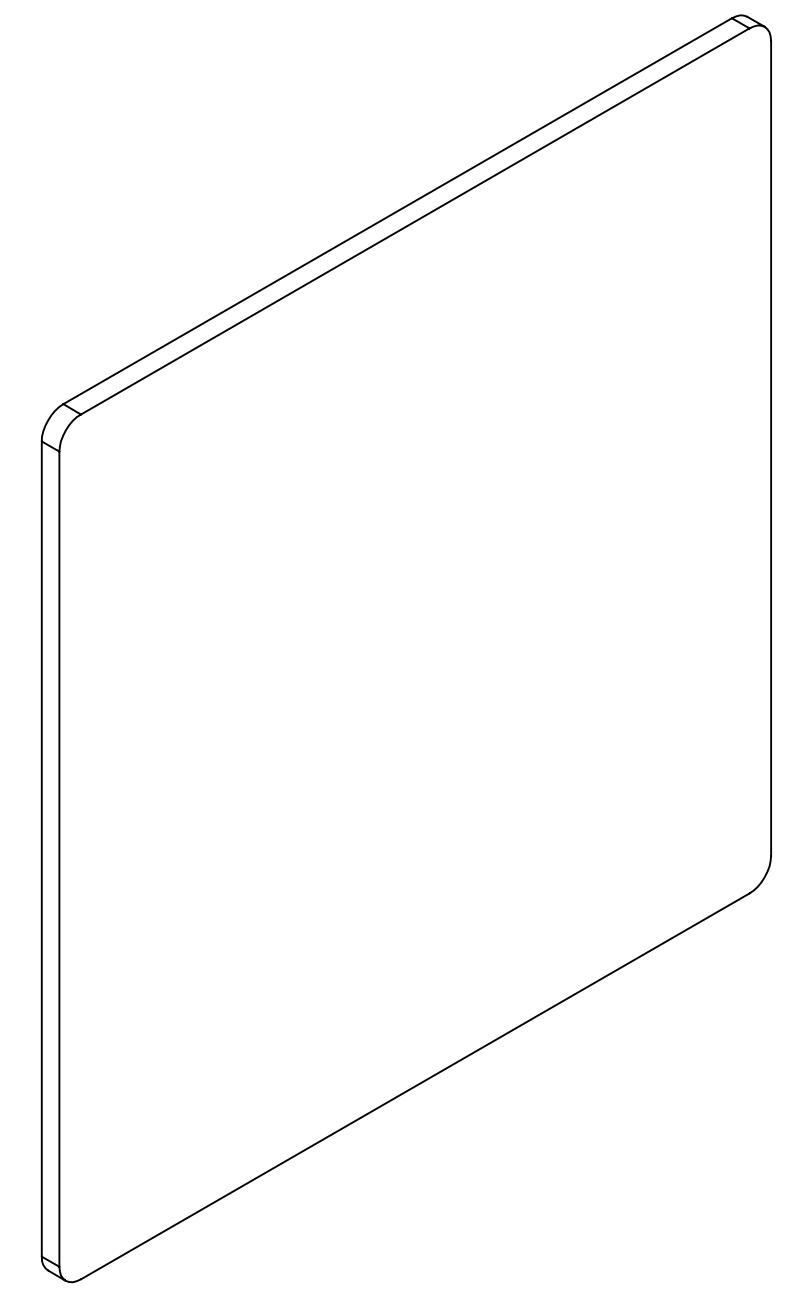
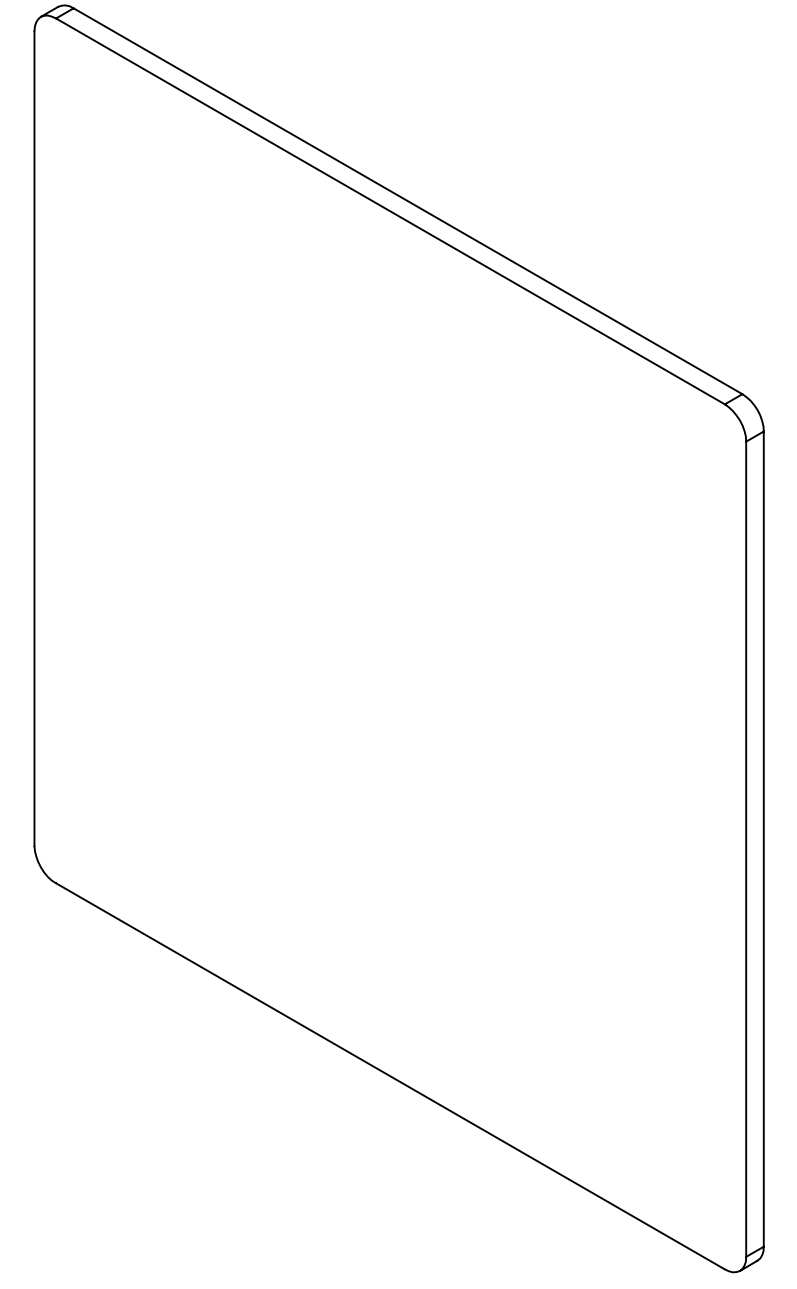
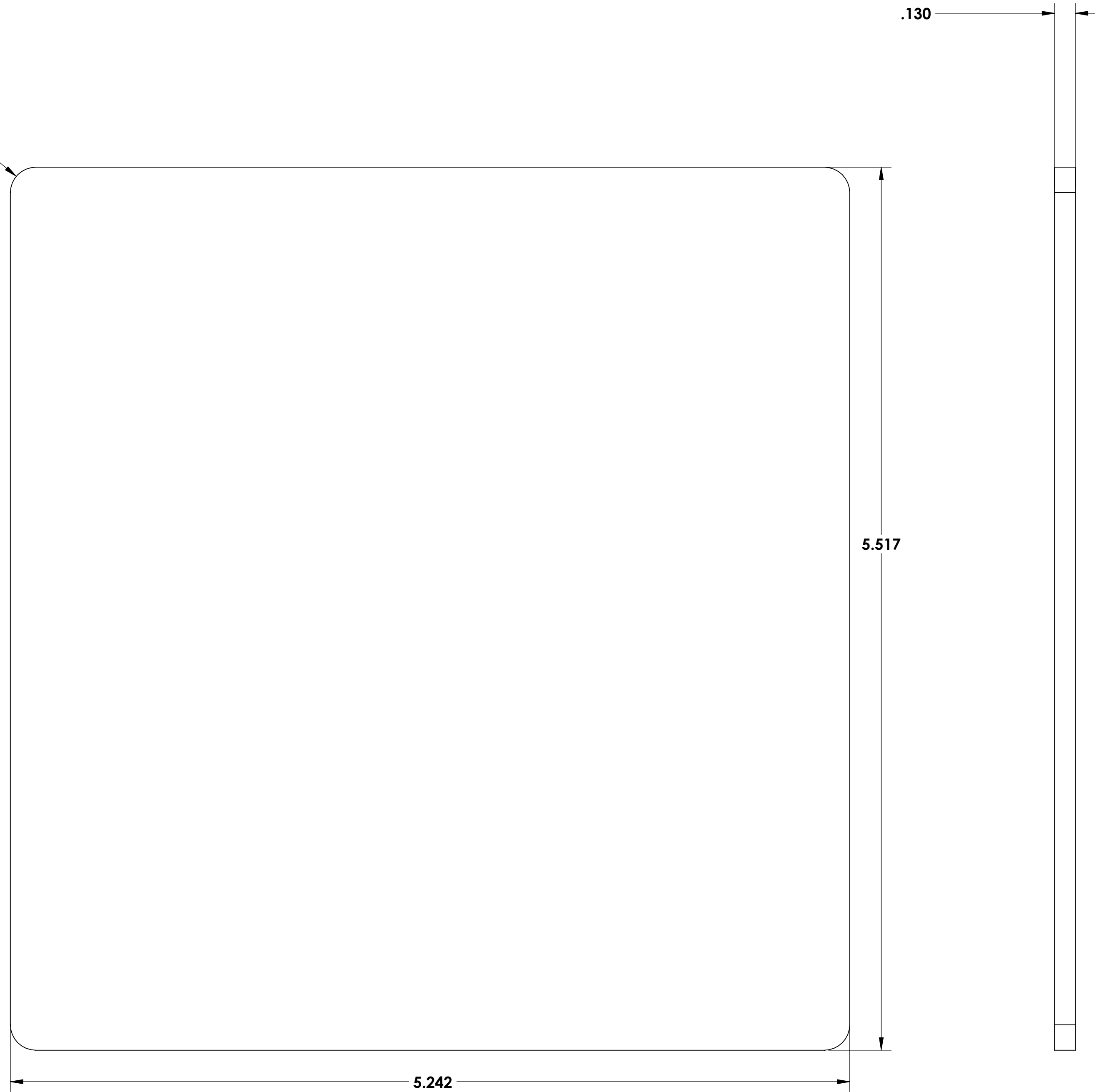


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR TYPE (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.  
EXAMPLE (PART): 001-v1  
EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD
  - 6. APPROXIMATE WEIGHT = X.XXX 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 MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, FLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
  - 10. SURFACE FINISH TO BE FREE FROM SCRATCHES OR GOUGES.

REV.	DATE	DCN #	DRAWING TREE #
V1	30 AUG 2012	E1200796	-
V2	11 SEP 2012	E1200819	-
-	-	-	-

4X R.159



<p><b>NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)</b></p> <p>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.</p>				<p><b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY          MASSACHUSETTS INSTITUTE OF TECHNOLOGY</p>				<p><b>PART NAME</b>          ASC VAC ENCLOSURE - LID αLIGO</p>											
<p>DIMENSIONS ARE IN INCHES</p> <p>TOLERANCES:          .XX ± .01          .XXX ± .005</p> <p>ANGULAR ± 0.5°</p>				<p><b>MATERIAL</b>          6061-T6 Al</p>		<p><b>FINISH</b>          63 μinch</p>		<p><b>SYSTEM</b>          ADVANCED LIGO</p>		<p><b>SUB-SYSTEM</b>          ISC</p>		<p><b>DESIGNER</b>          RABBOIT 13 FEB 2012</p>		<p><b>SIZE</b>          D</p>		<p><b>DWG. NO.</b>          D1102005</p>		<p><b>REV.</b>          v2</p>	
				<p><b>APPROVAL</b>          PFRITSCHEL</p>		<p><b>NEXT ASSY</b>          D1102002</p>		<p><b>SCALE:</b> 2:1</p>		<p><b>PROJECTION:</b></p>		<p><b>SHEET 1 OF 1</b></p>							

D1102005 ASC VAC Enclosure - LID αLIGO PART PDM REV: X-000 DRAWING PDM REV: X-001