

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

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

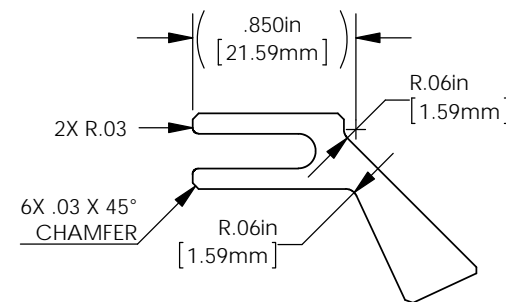
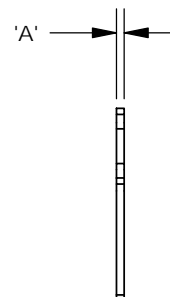
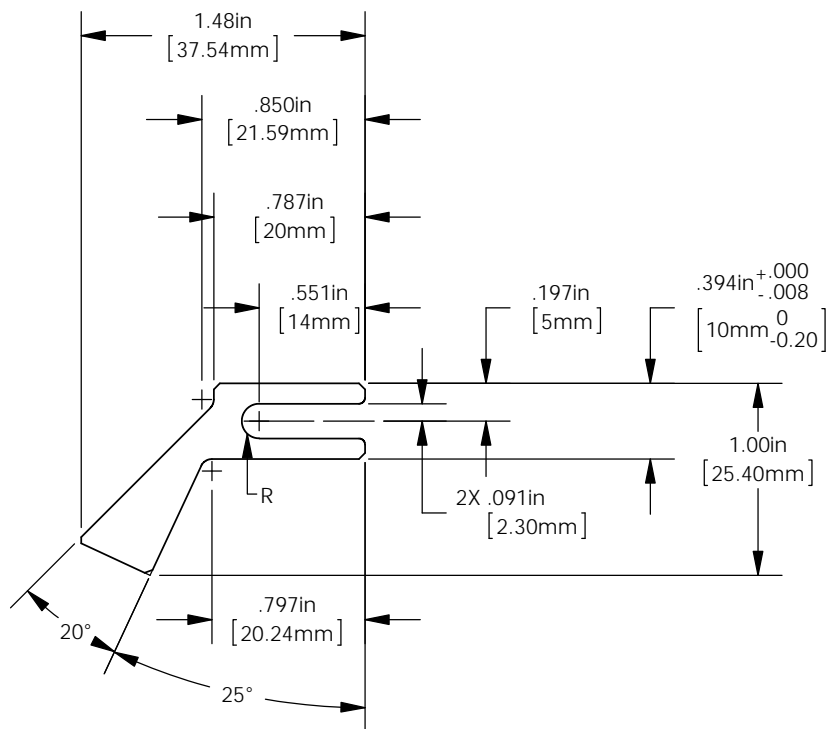
8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

PART NO.	'A' (mm)	APPROX. WEIGHT (LB.)
D1102163-1	1	.001
D1102163-2	2	.003
D1102163-3	3	.004
D1102163-4	4	.006
D1102163-5	5	.007
D1102163-6	6	.009

REV.	DATE	DCN #	DRAWING TREE #
v1	07 NOV 2011	-	-
v2	09 NOV 2011	E1101092-x0	-
-	-	-	-



ISO VIEW



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES [MM]
 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. 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 6061-T6 Al
FINISH 63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM **ADVANCED LIGO** SUB-SYSTEM **SUS**
 NEXT ASSY **D060324**

PART NAME **ALIGO, SUS, QUAD TOP STAGE BLADE, WIRE CLAMP SHIM (REDESIGNED)**

DESIGNER	E.SANCHEZ	07 NOV 2011	SIZE	DWG. NO.	REV.
DRAFTER	E.SANCHEZ	07 NOV 2011	A	D1102163	v2
CHECKER	SEE DCC	SEE DCC	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1
APPROVAL	SEE DCC	SEE DCC			