

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. MASS: 31.2 G [0.069 LB].

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

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

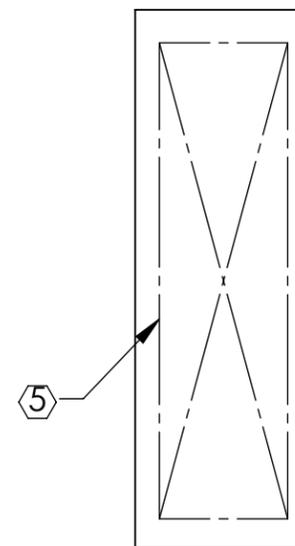
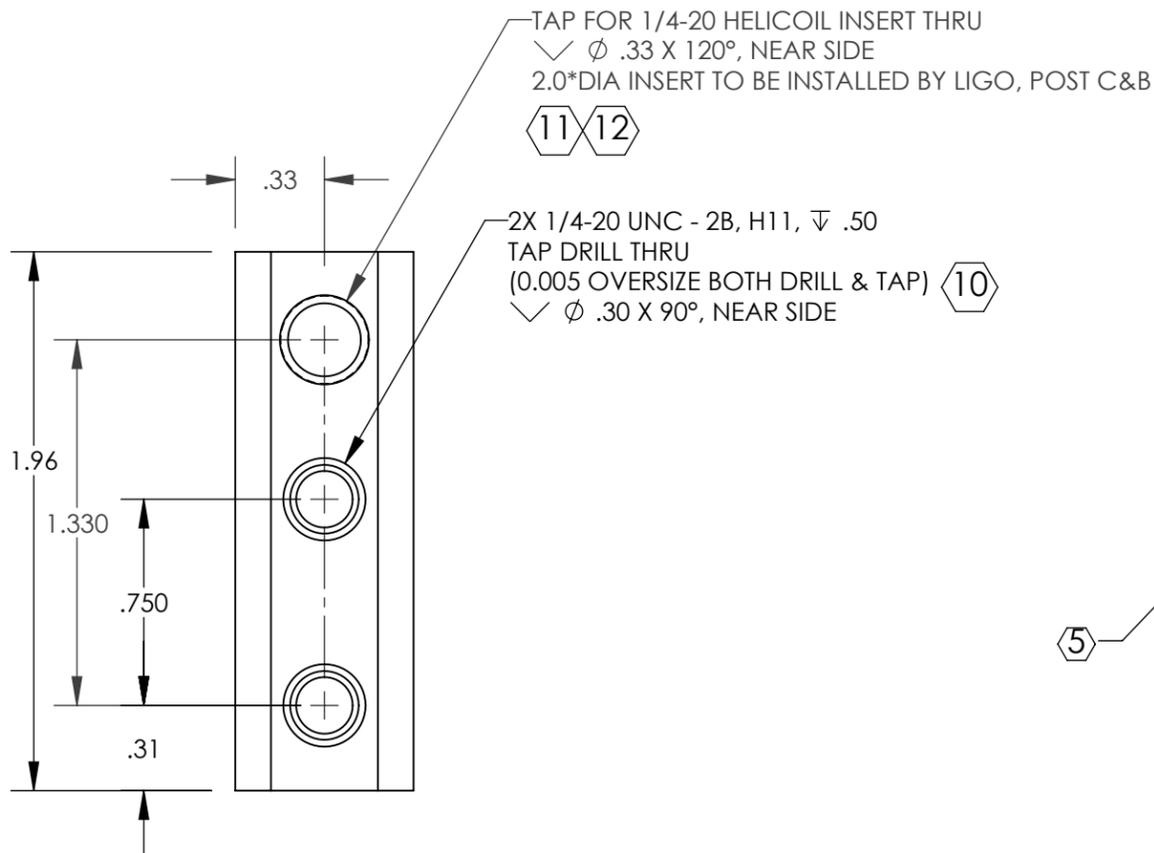
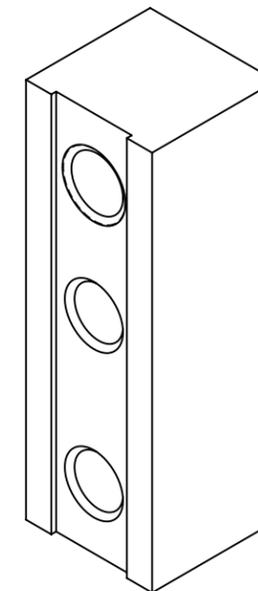
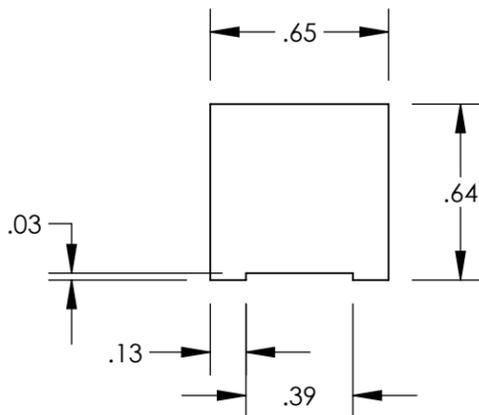
9. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL, WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE PART SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

10 TAPPED HOLES (HELICOIL EXCLUDED): 0.005 OVERSIZE BOTH DRILL AND TAP.

11 PREPARE HELICOIL TAPPED HOLE ACCORDING TO EMHART HELICOIL PRODUCT CATALOG HC2000. DO NOT INSTALL HELICOIL.

12 INTERNAL NOTE: HELICOILS TO BE INSTALLED BY LIGO, POST C&B. USE ONLY NITRONIC 60 HELICOILS.

REV.	DATE	DCN #	DRAWING TREE #
v1	25 MAR 2012	E1101214	-
-	-	-	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1.0°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		ADVANCED LIGO AOS	
MATERIAL: 6061-T6 Al FINISH: 63 μinch Ra				SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS NEXT ASSY: D1101526		DESIGNER: C. CONLEY DRAFTER: C. CONLEY CHECKER: SEE DCN APPROVAL: SEE DCN	
				DATE: 08 MAR 2012 DATE: 25 MAR 2012		SIZE DWG. NO.: B D1200427 SCALE: NONE PROJECTION:	
						REV. v1 SHEET 1 OF 1	