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NOTES CONTINUED:

5. SCRIBE, ENGRAVE, 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.
 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
 10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.

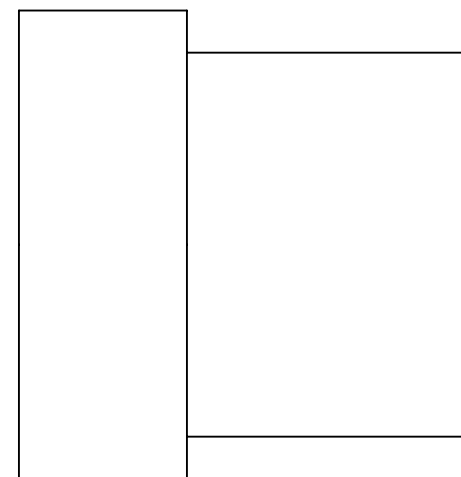
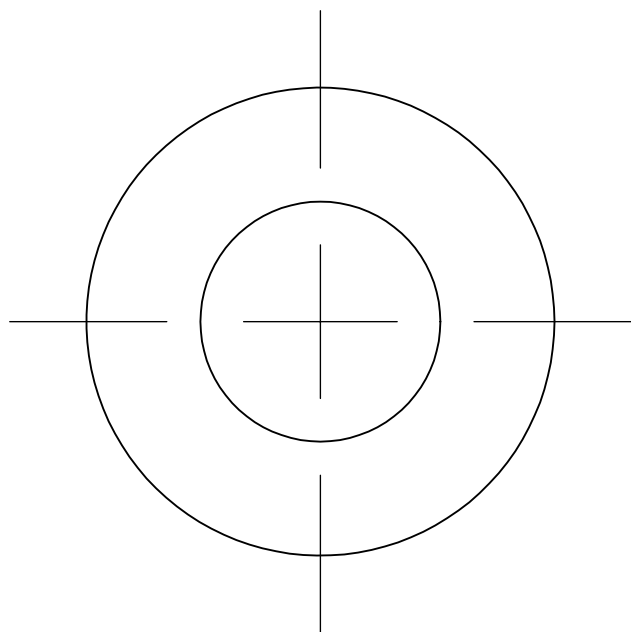
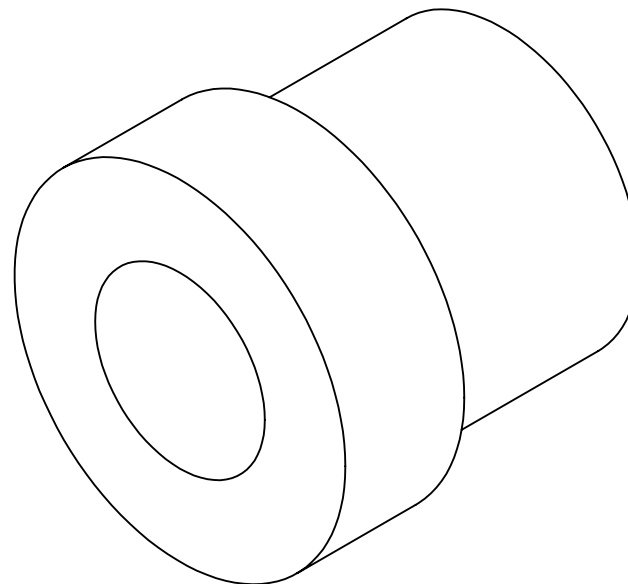
12. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE. THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING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

13 MAKE FROM 8492A167 (McM-Carr) PART

14 PLATE WITH ELECTROLESS NICKEL .0005" MAXIMUM THICKNESS

NOTE: NOT ALL NOTES APPLY TO THIS PART

REV.	DATE	DCN #	DRAWING TREE #
V1	11-2-12	TO FOLLOW	-
-	-	-	-
-	-	-	-



D1201364 aLIGO OPTICLA TABLE SHAFT GUIDE BUSHING, PART PDM REV: X-001, DRAWING PDM REV: X-001

D

C

B

A

D

C

B

A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ± .01
 .XXX ± .001
 ANGULAR ± 1.0°

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES, R.02 MIN.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL C1113 ALLOY FINISH SEE NOTE 14 32μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM AOS
 NEXT ASSY D1001163 / D1102291

PART NAME SHAFT GUIDE BUSHING

DESIGNER	KM	20 DEC 2010	SIZE	DWG. NO.	REV.
DRAFTER	K MAILAND	11-2-12	B	D1201364	v1
CHECKER	K MAILAND				
APPROVAL			SCALE: 4:1	PROJECTION:	SHEET 1 OF 1

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