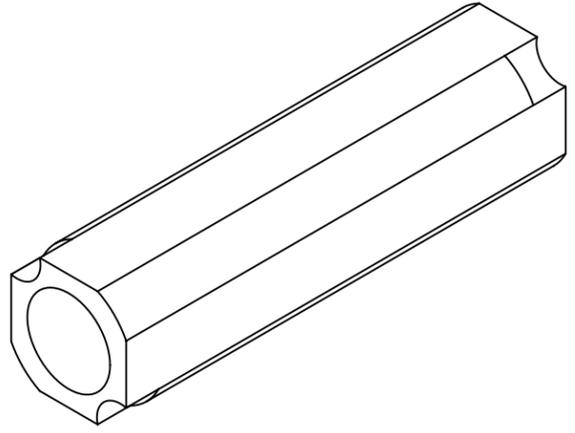


NOTES CONTINUED:

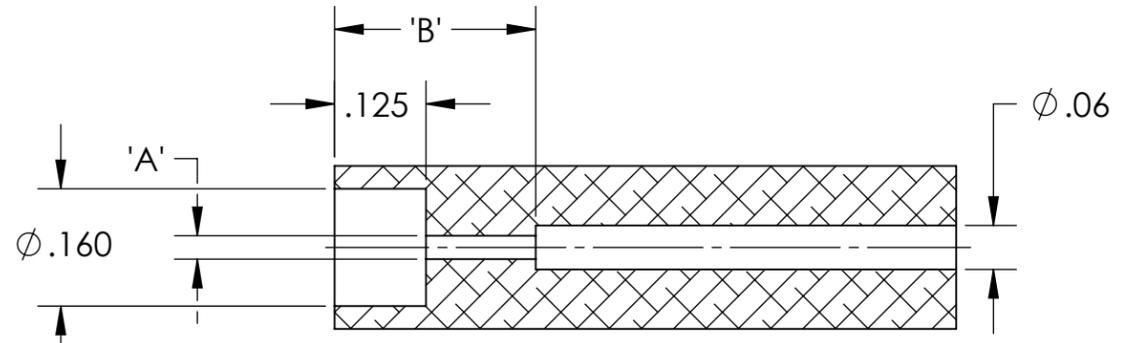
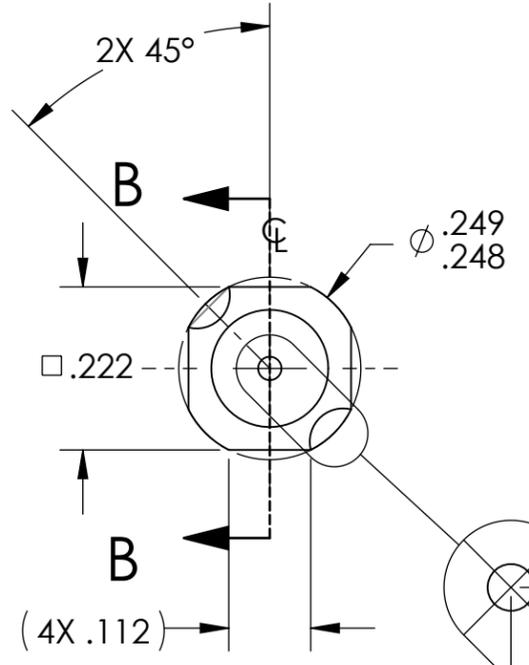
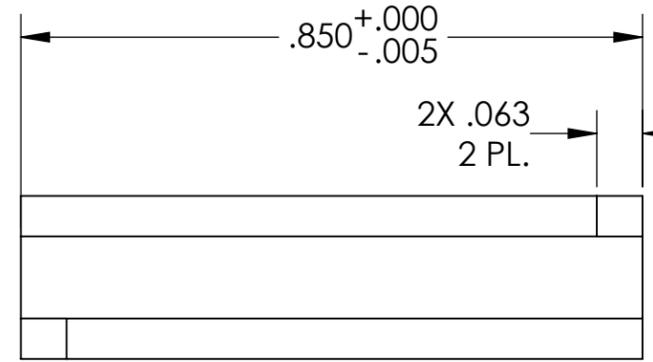
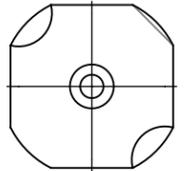
- 5. SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), 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.
- 9. ALTERNATE MATERIAL: MAY BE MADE FROM MACOR CERAMIC FOR MACHINABILITY PURPOSES AT MFR'S DISCRETION

REV.	DATE	DCN #	DRAWING TREE #
v1	13 OCT 2014	E1400397-x0	-
v4	30 JAN 2015	E1400397-x0	-
v5	02 FEB 2014	E1400397-x0	-

TYPE	Ø 'A' (INCHES)	'B'
-1	.032 /034	.253
-2	.035 /040	.265
-3	TBD	TBD



ISO VIEW



SECTION B-B

DETAIL A
SCALE 8 : 1
4 PL.

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 ± 0.5°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED 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.		aLIGO, SURFACE CHARGE CONTROL IONIZER, NEEDLE HOLDER	
MATERIAL Alumina		FINISH 63 µinch		NEXT ASSY D1400331		DESIGNER E.SANCHEZ 09 OCT 2014 DRAFTER E.SANCHEZ 13 OCT 2014 CHECKER SEE DCC SEE DCC APPROVAL SEE DCC SEE DCC	
SYSTEM ADVANCED LIGO SUB-SYSTEM SYS				SIZE DWG. NO. B D1400349		REV. v5	
SCALE: 4:1				PROJECTION:		SHEET 1 OF 1	

D1400349 aLIGO, SURFACE CHARGE CONTROL IONIZER, NEEDLE HOLDER, PART PDM REV: X-008, DRAWING PDM REV: X-007