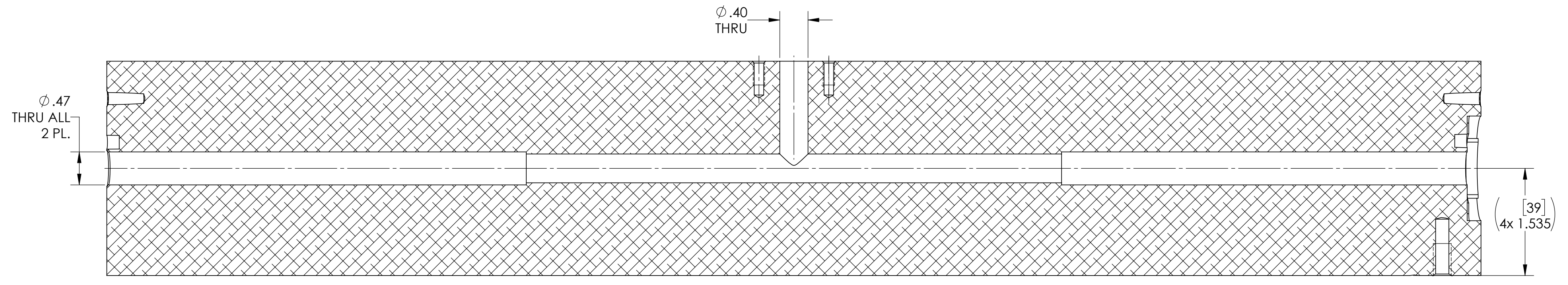
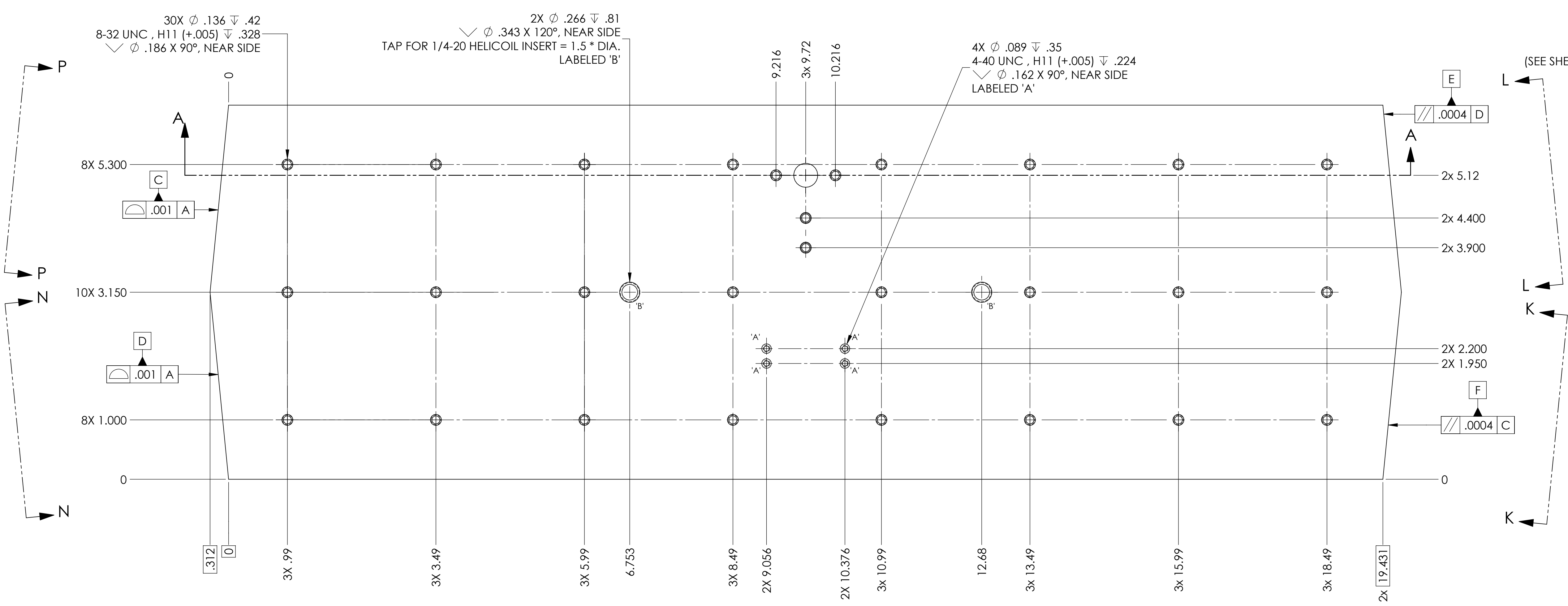
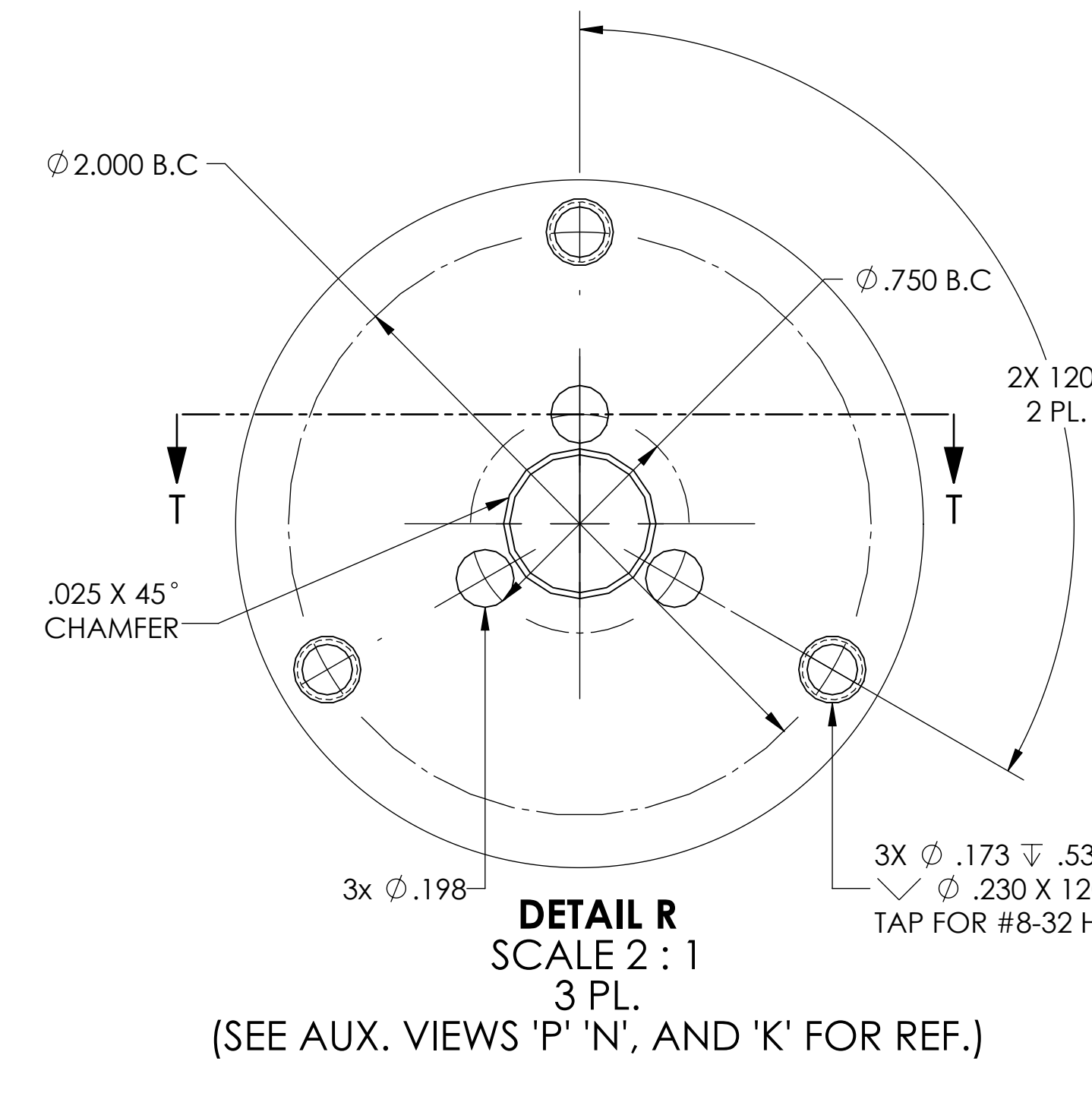
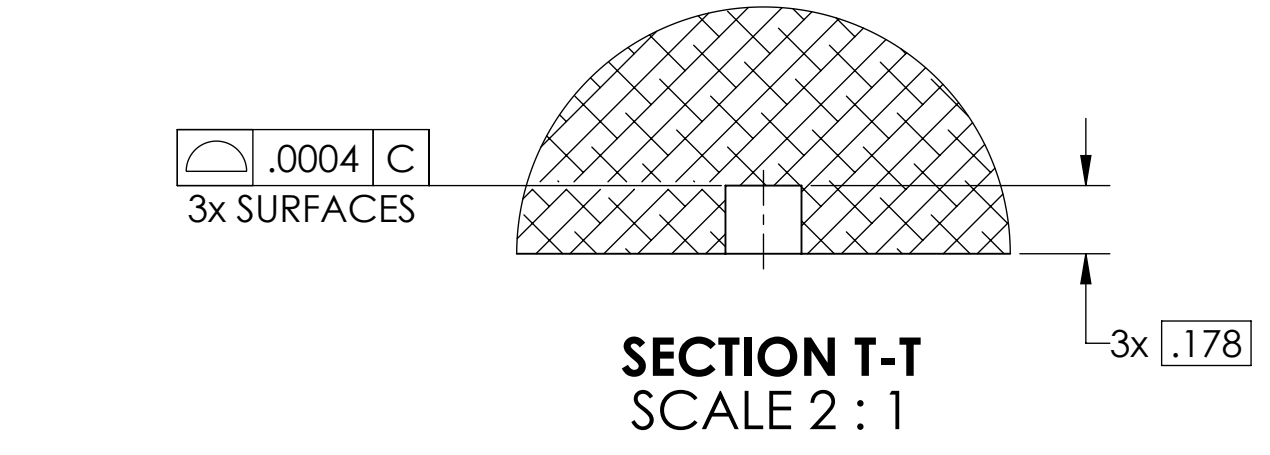
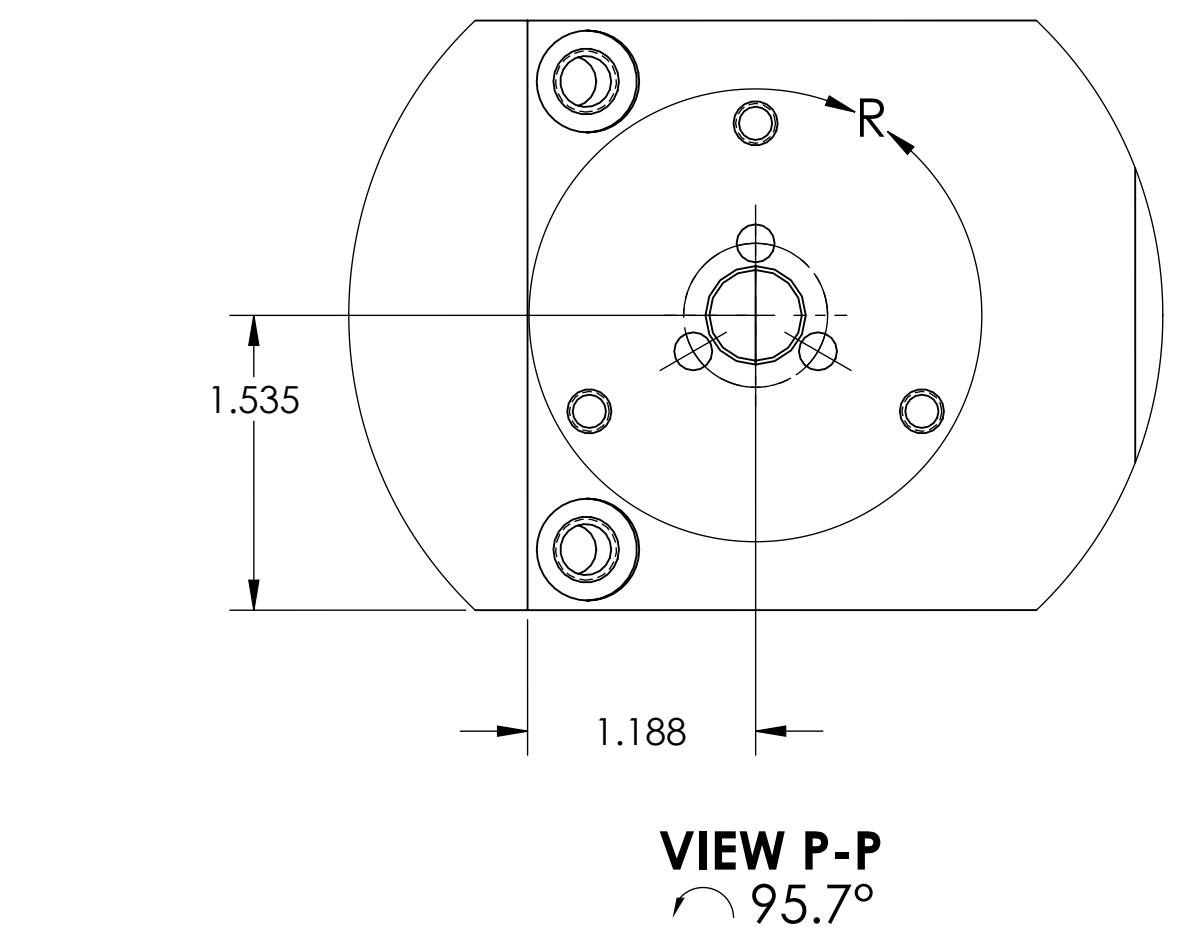
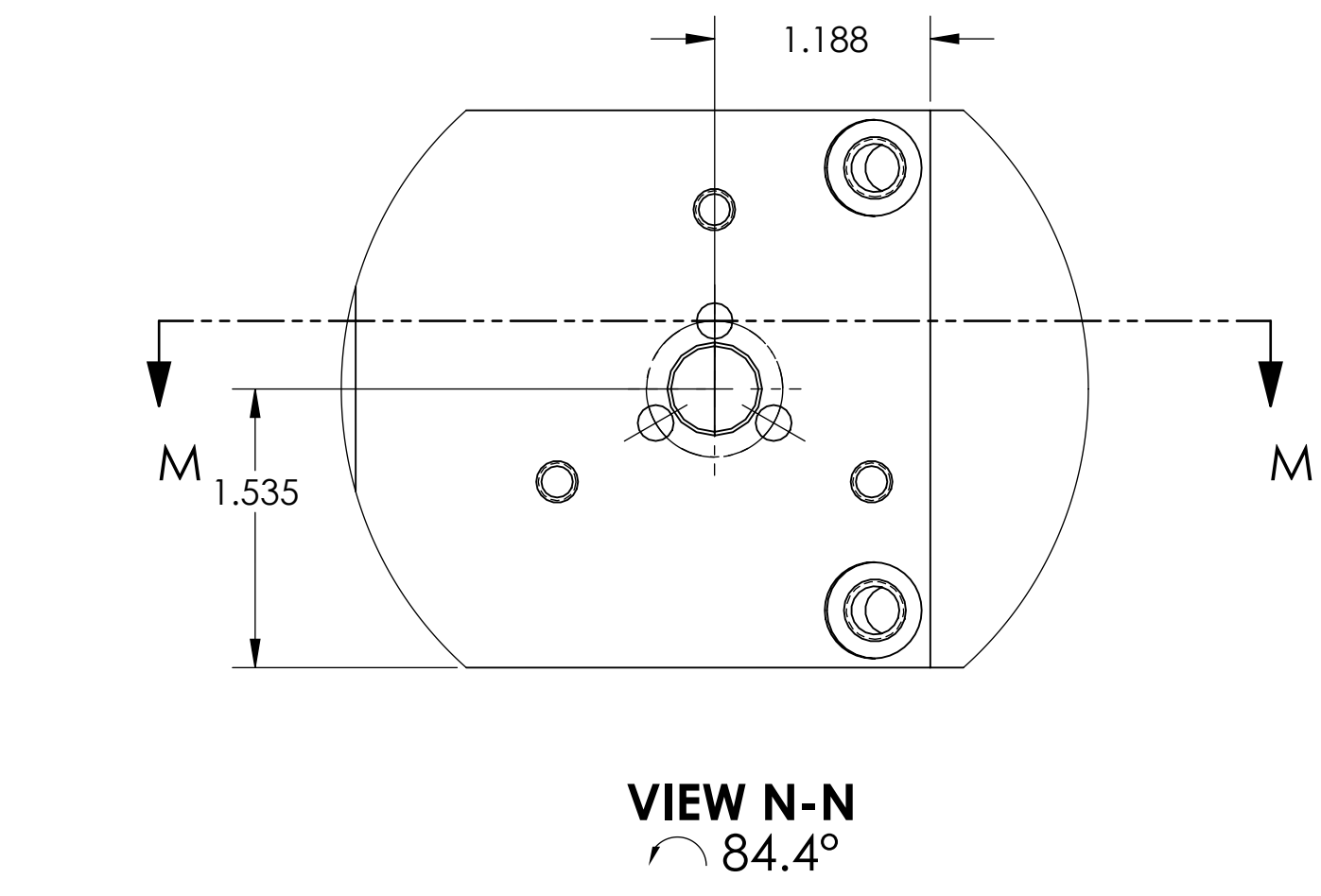
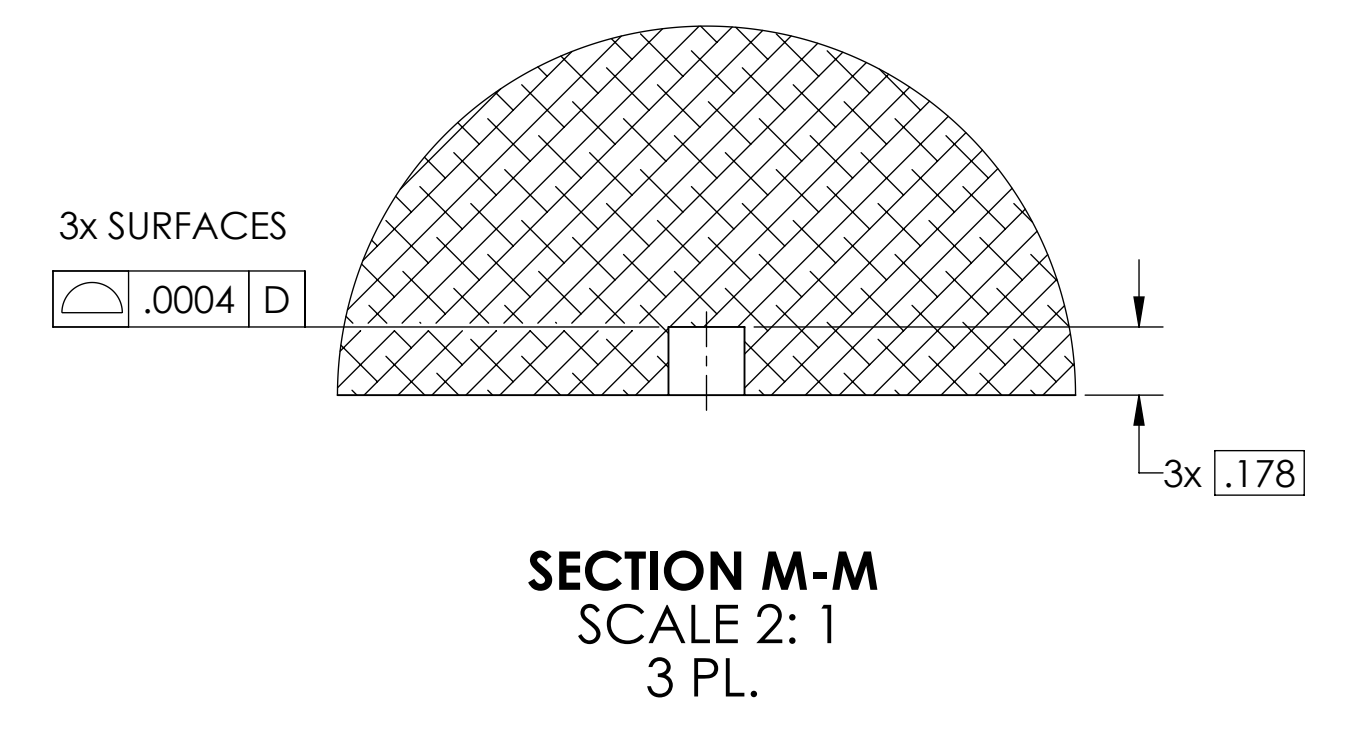
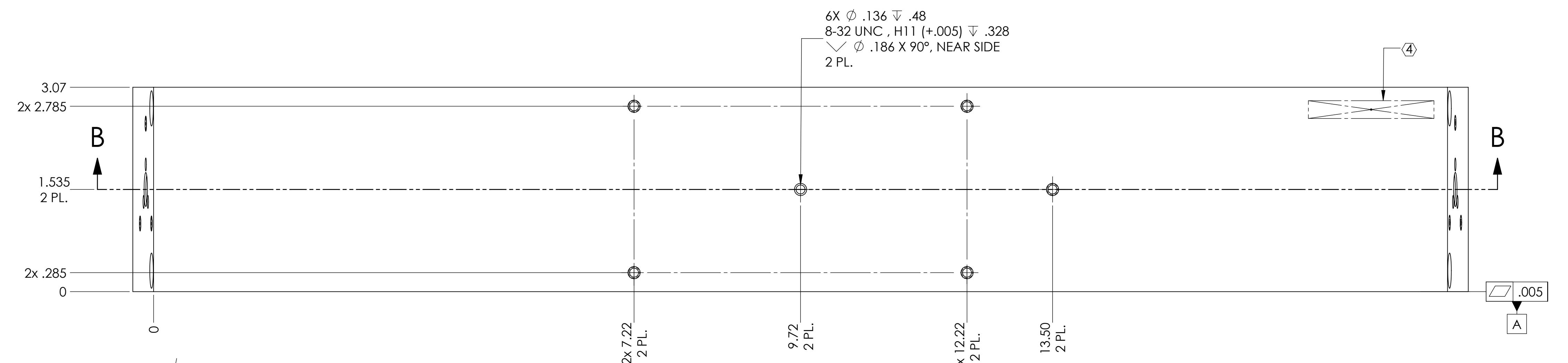


NOTES CONTINUED:  
 3. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED BY THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.17" HIGH CHARACTERS. UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N-XXX  
 4. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.  
 5. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO ENHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4  
 6. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.  
 7. 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.

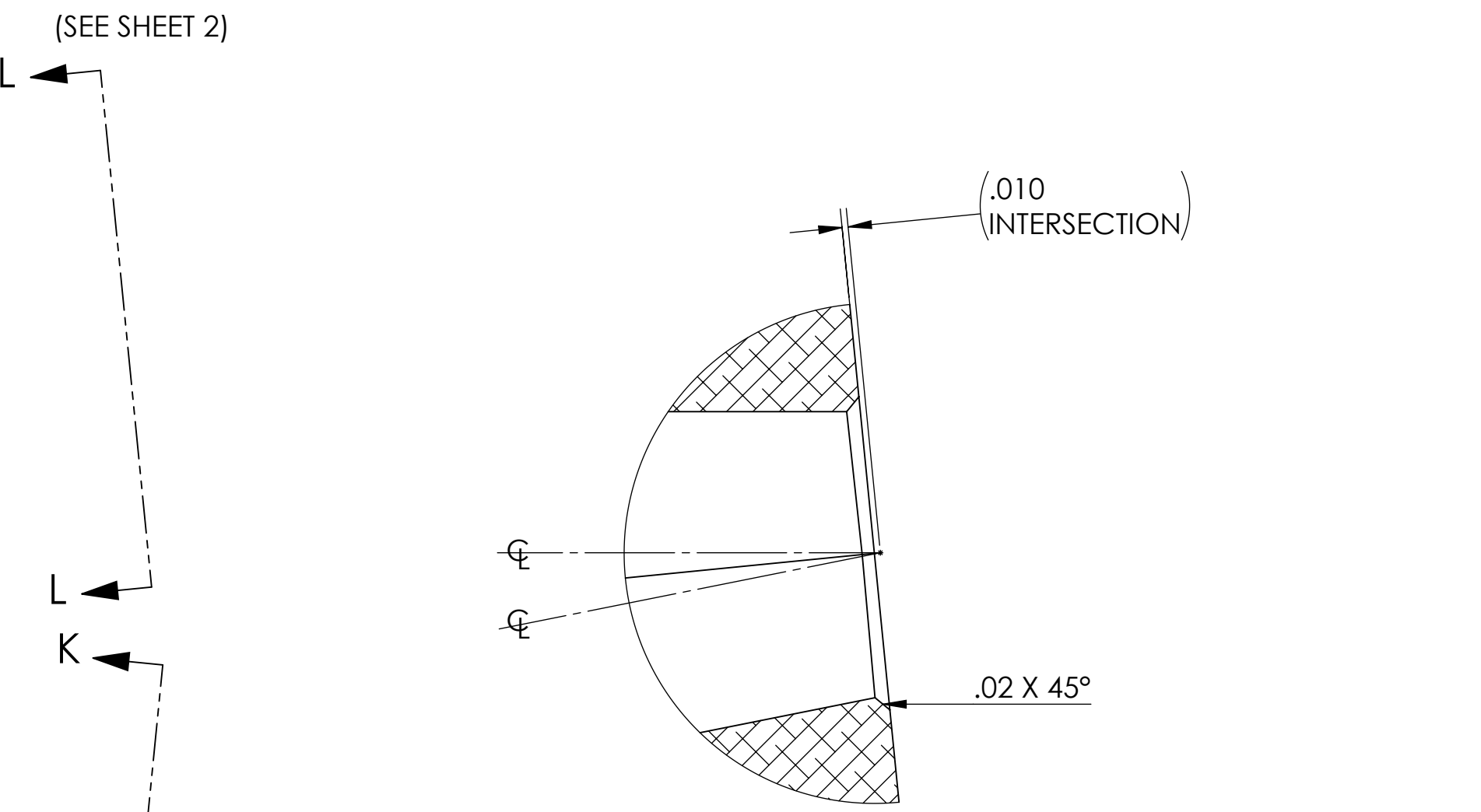
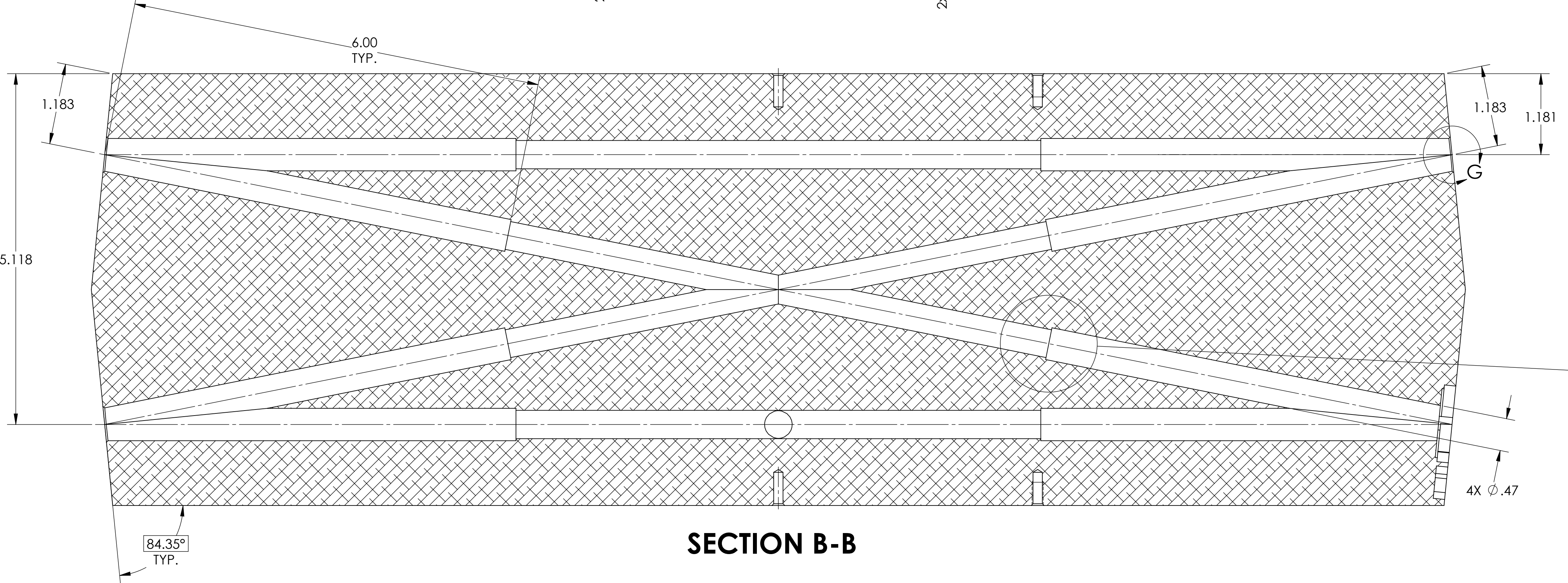
REV.	DATE	DCN #	DRAWING TREE #
v1	13 JUN 2016		-
v10	27 MAR 2017	E1700061-x0	-
v11	23 MAY 2017	E1700172-x0	-



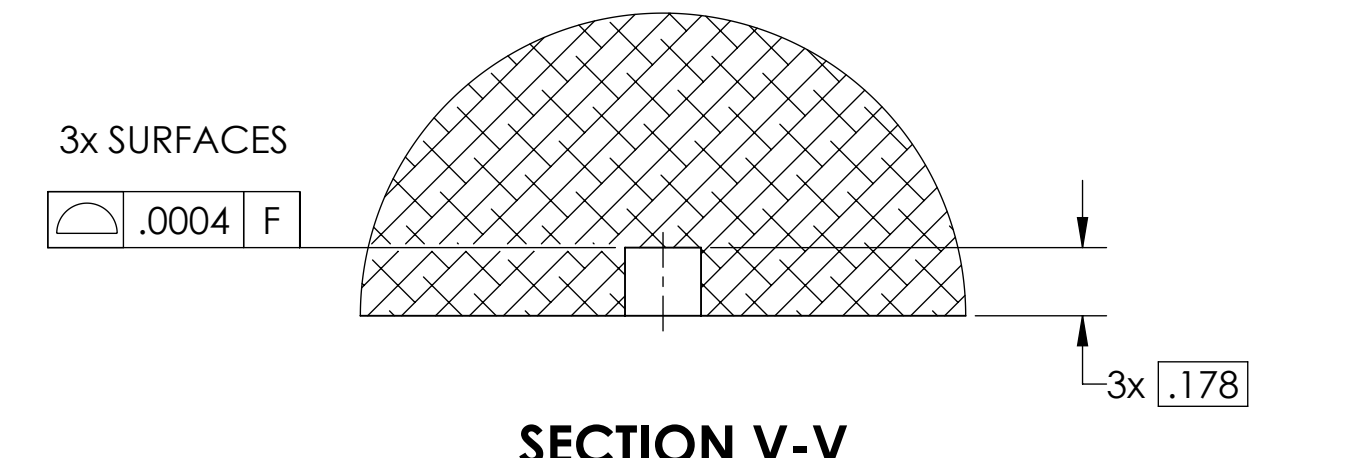
SECTION A-A



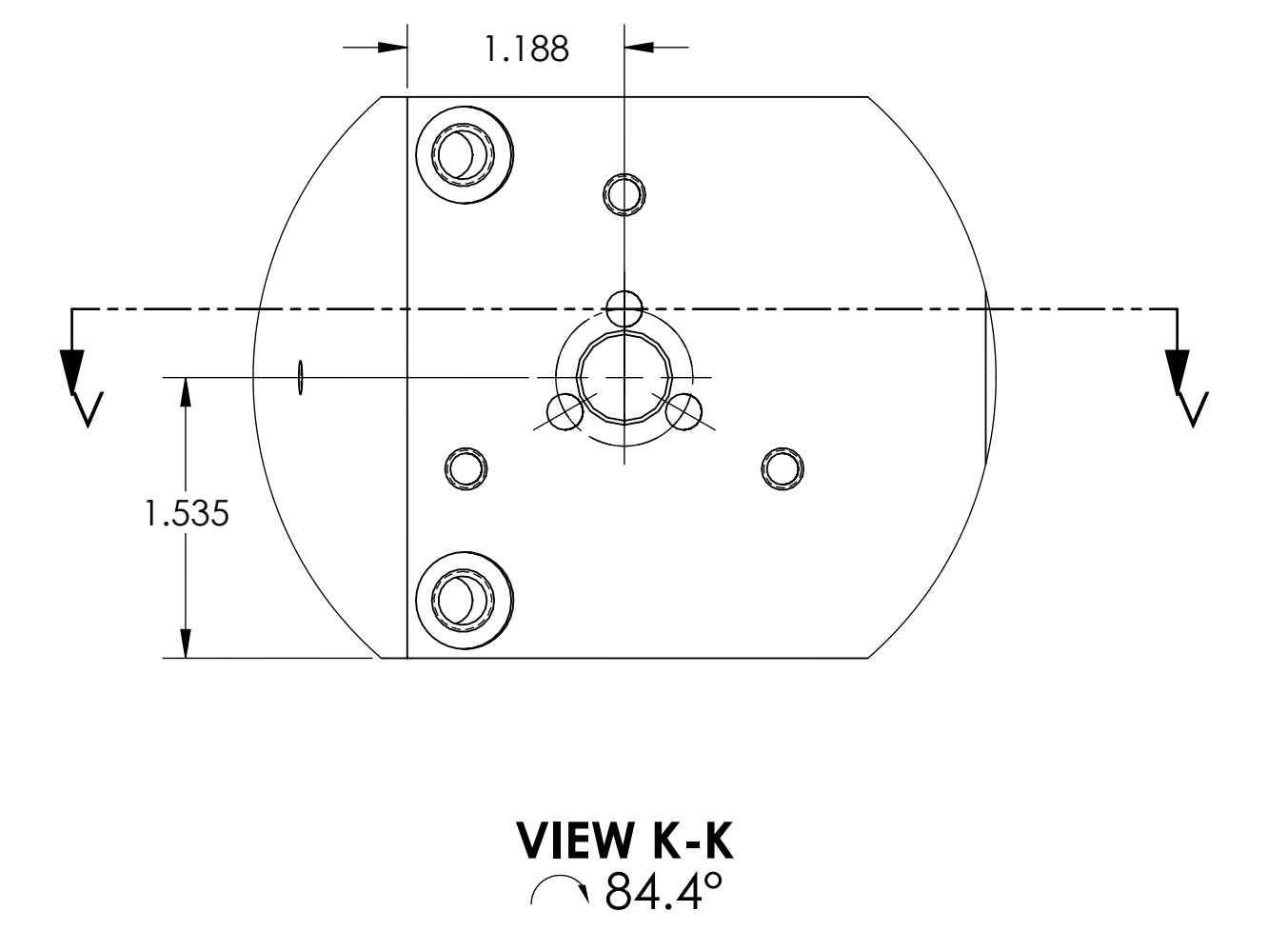
SECTION B-B



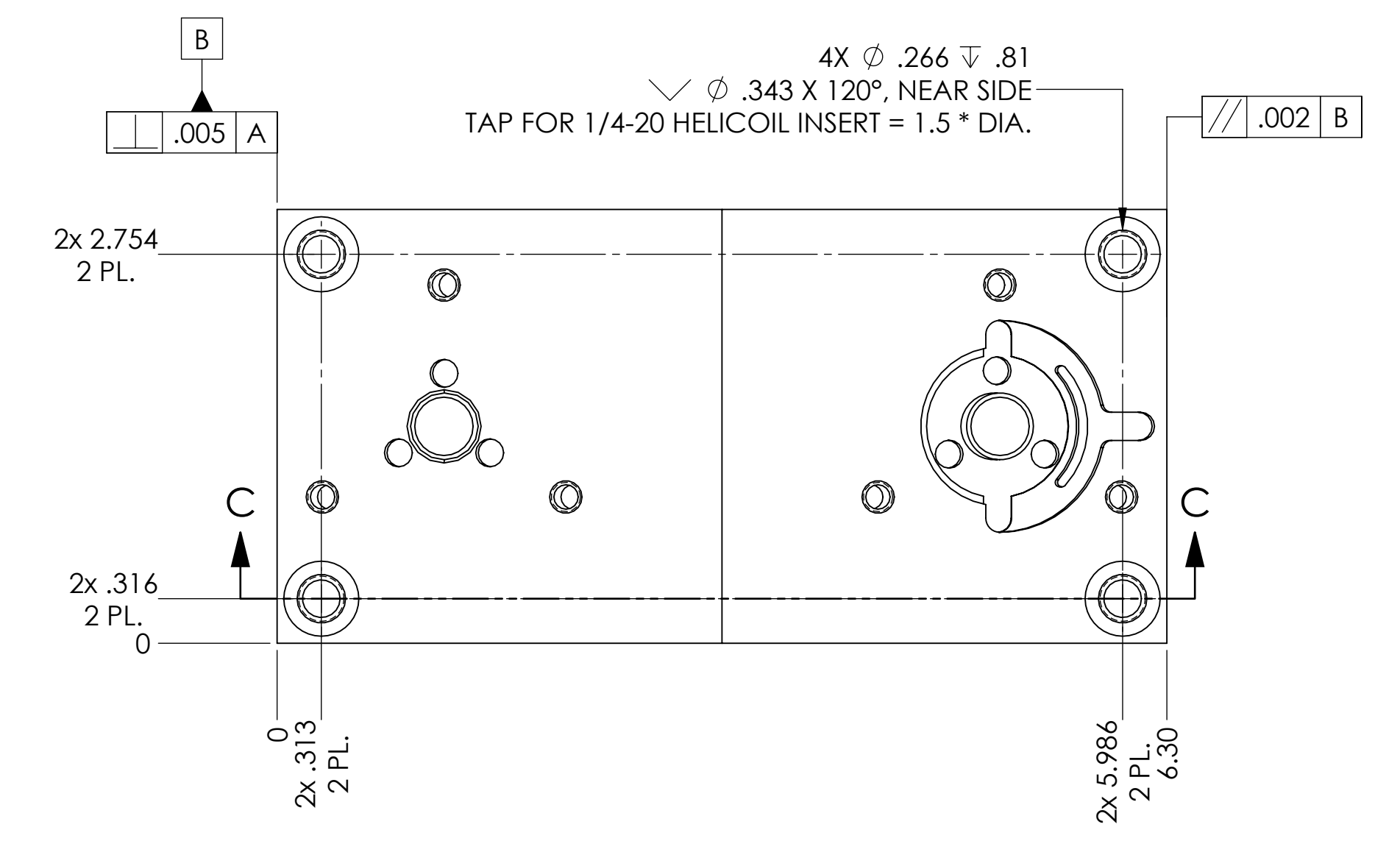
DETAIL G SCALE 2:1 TYP. REF. ONLY



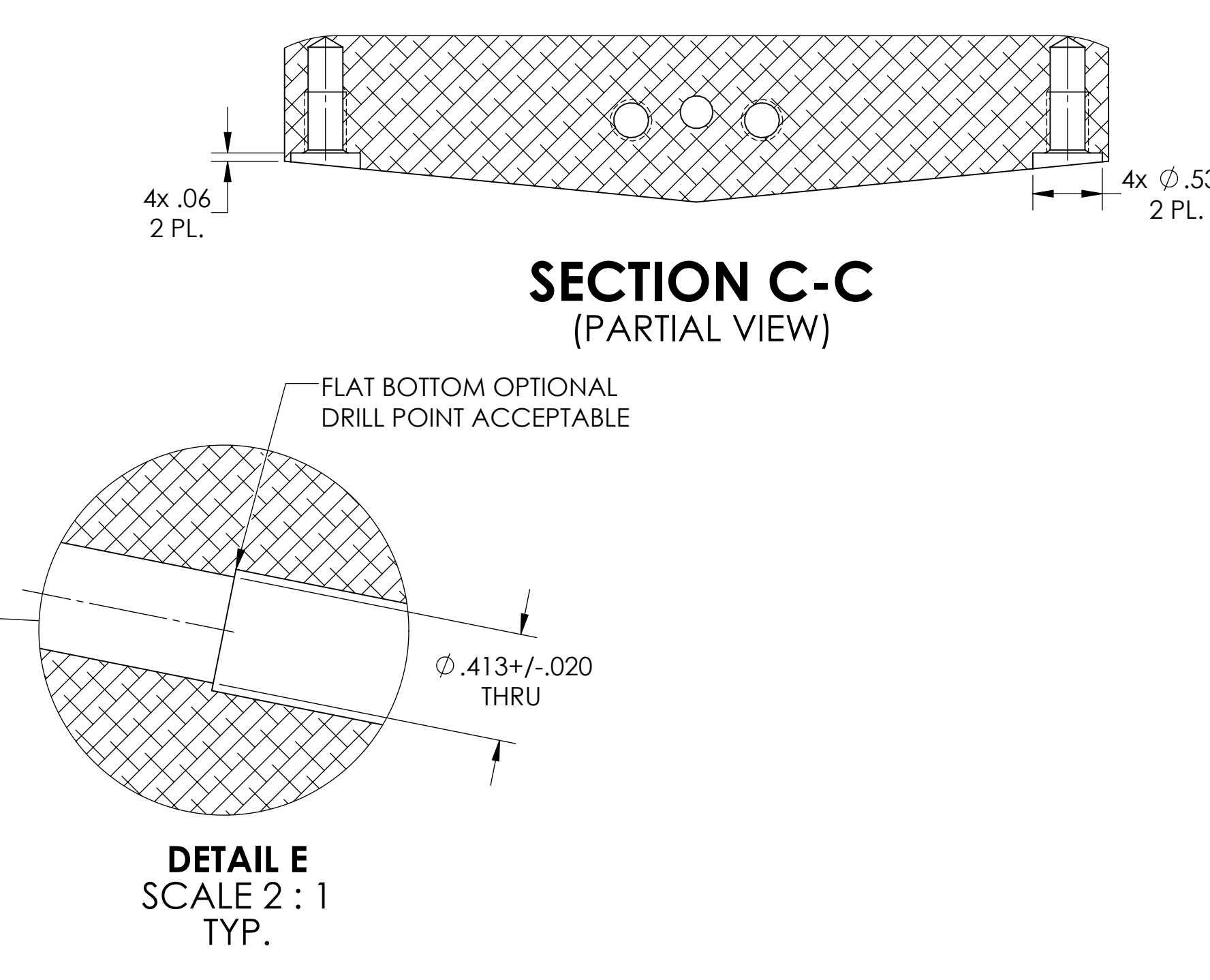
SECTION V-V SCALE 2:1



VIEW K-K 84.4°



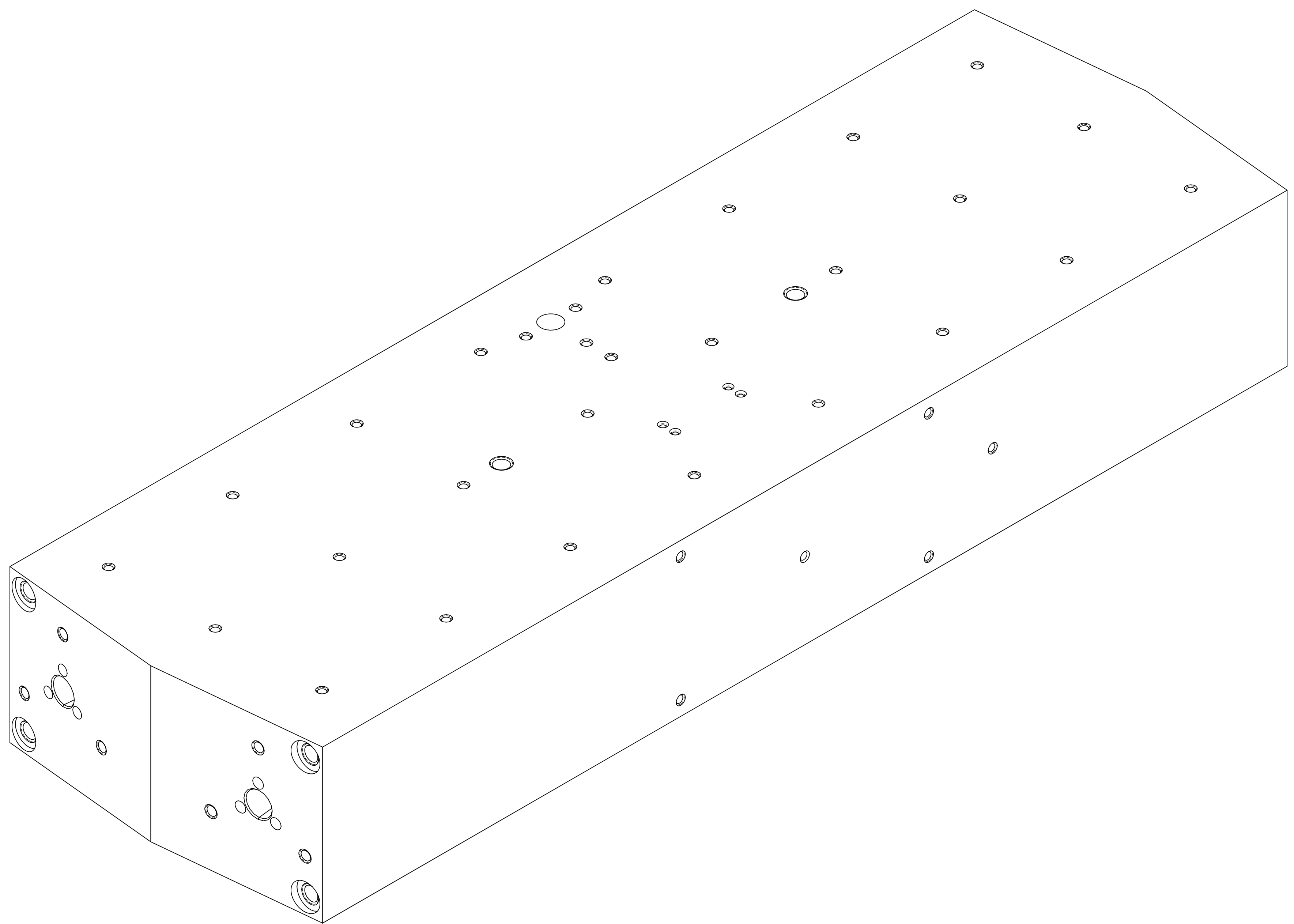
SECTION C-C (PARTIAL VIEW)



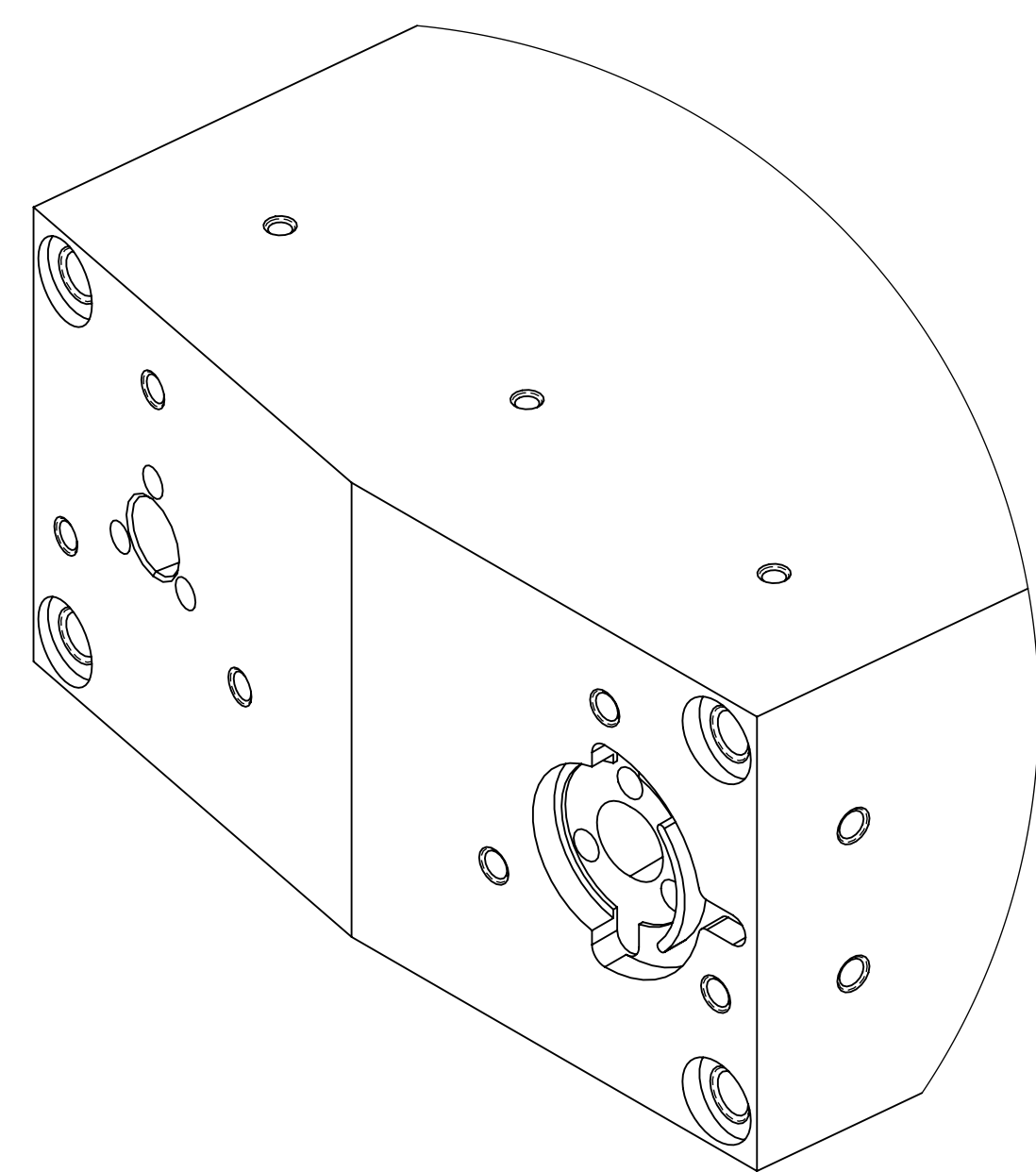
DETAIL E SCALE 2:1 TYP.

DIMENSIONS ARE IN INCHES [MM]		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± .01 .XXX ± .005		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 FLUID MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO SYSTEM		aLIGO, PSL, PREMODO CLEANER, BODY	
ANGULAR ± 0.5°		MATERIAL 6061 Alloy		FINISH 63 μinch		NEXT ASSY D1600270	
				DESIGNER 08 MAR 2010		SIZE DWG. NO. E	
				DRAFTER 13 JUN 2014		D1600227	
				CHECKER		v11	
				APPROVAL		SCALE: 1:1 PROJECTION: SHEET 1 OF 2	

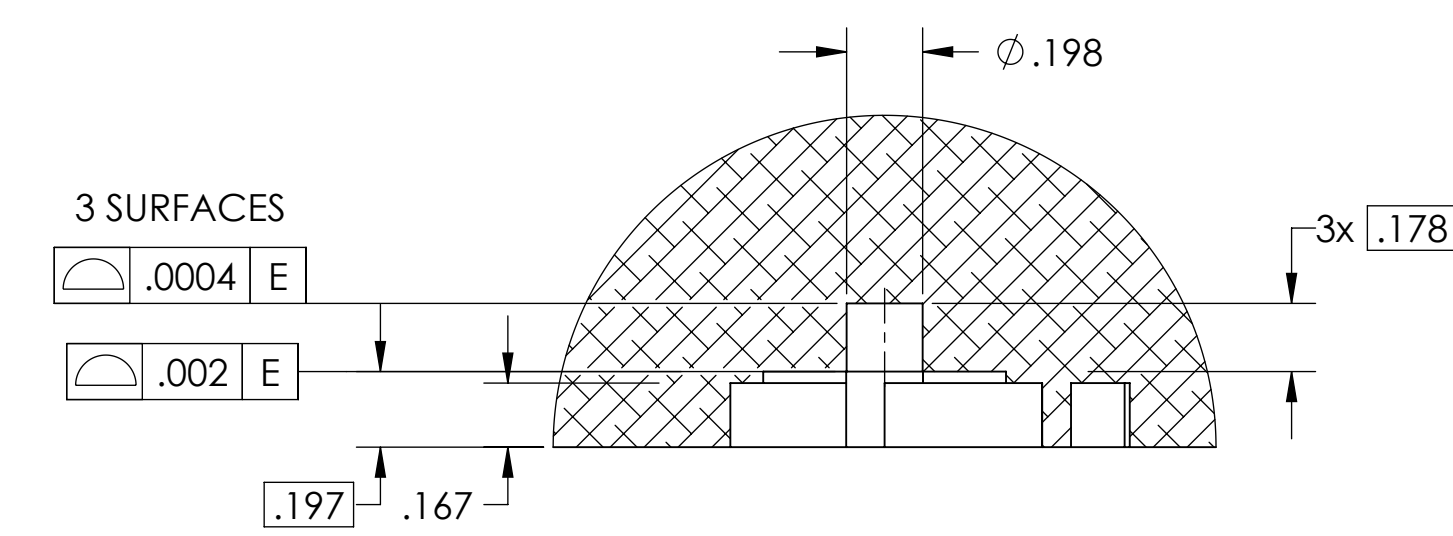
(NOTE: DRAWING UPDATED TO CURRENT CAD FORMAT BY E.SANCHEZ, 06/13/2016)



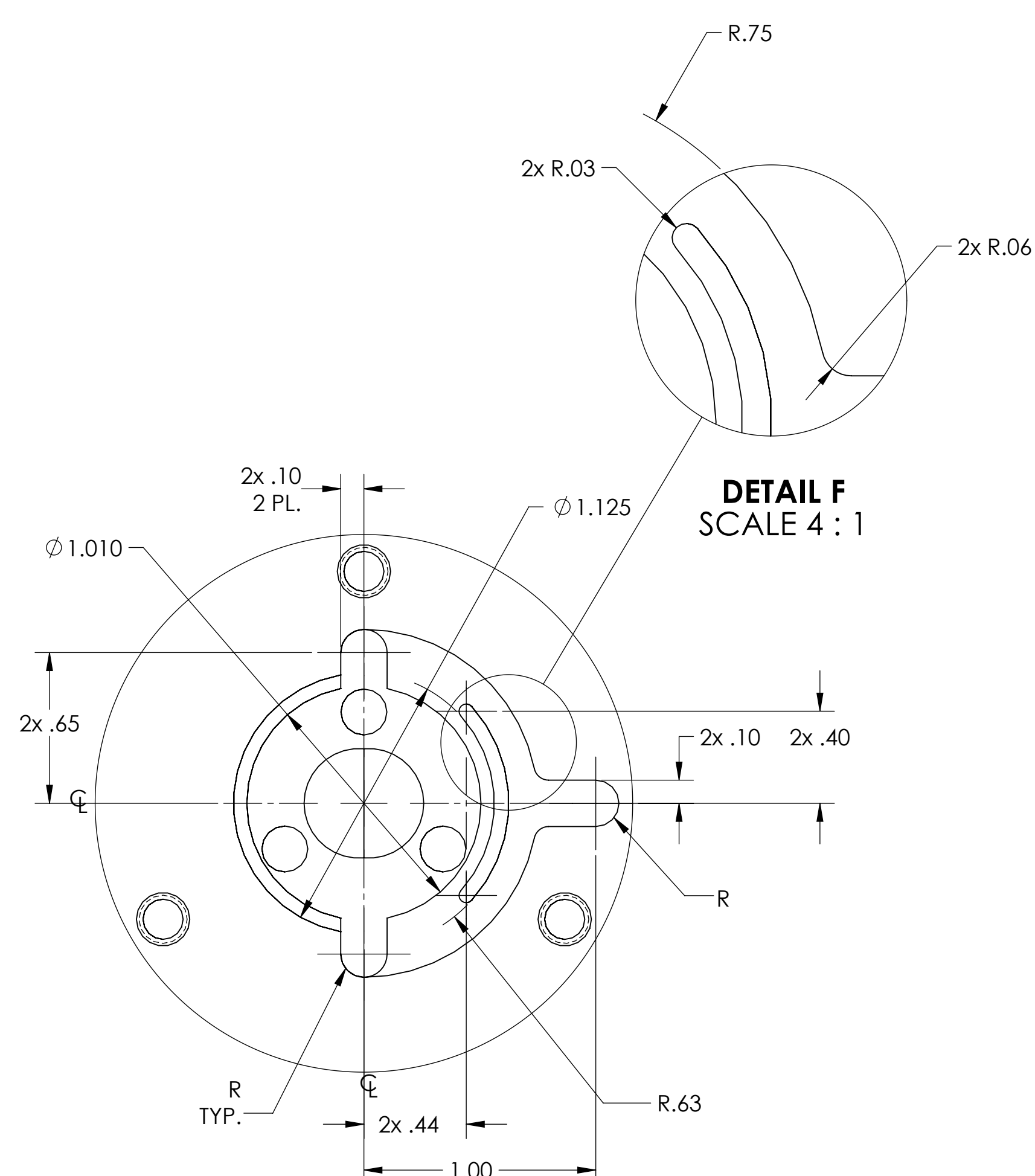
ISO VIEW



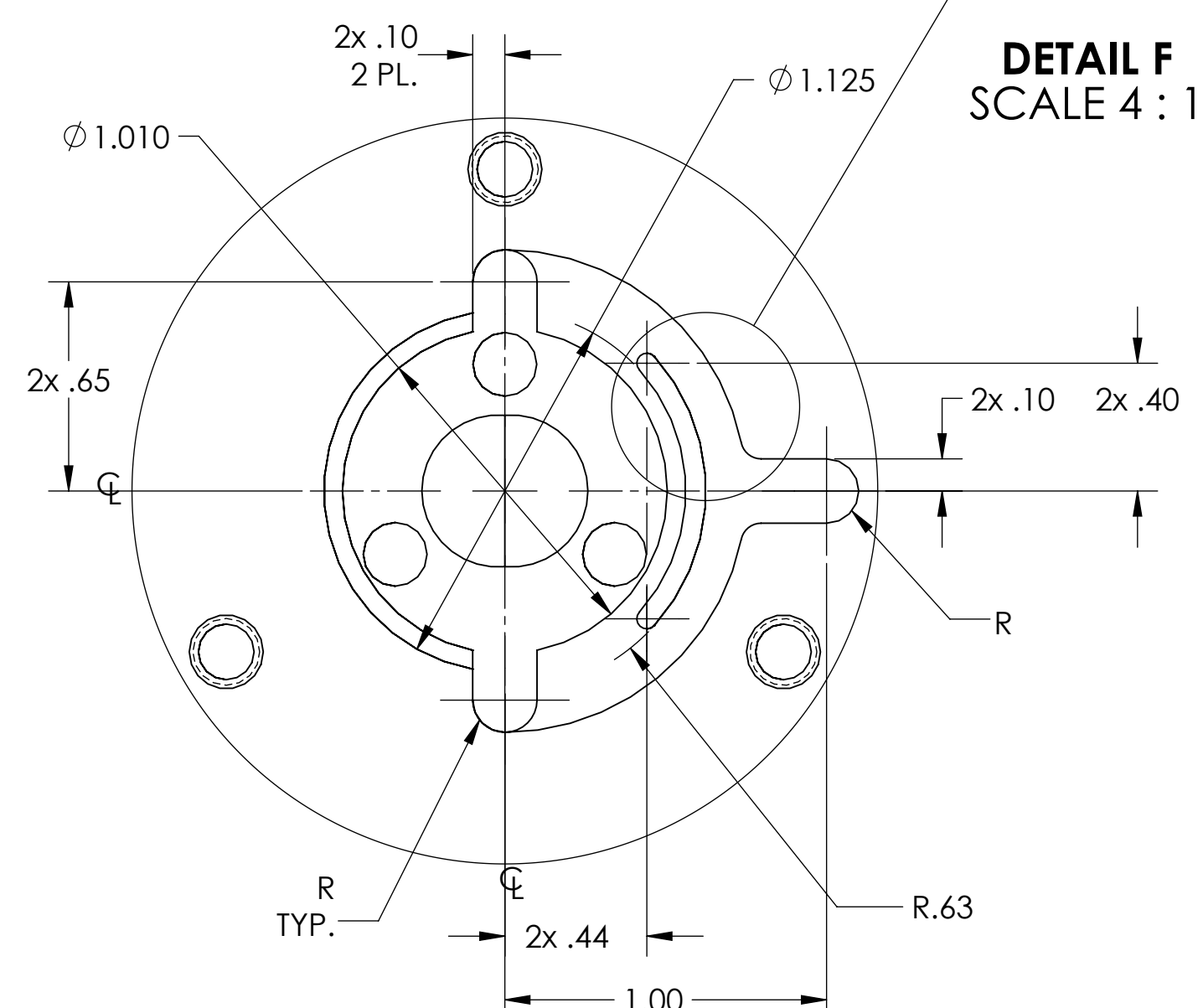
ISO VIEW- OUTPUT SIDE



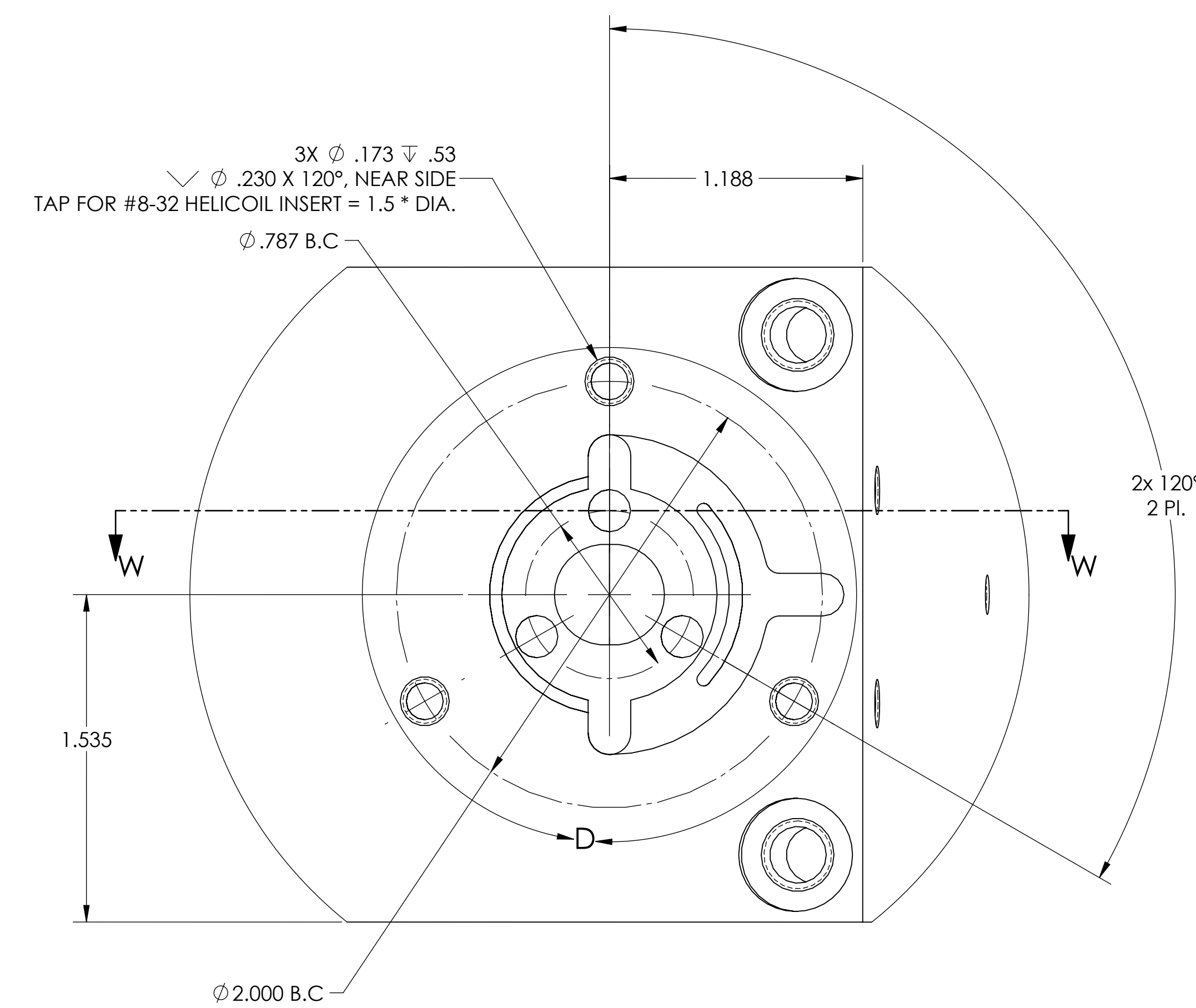
SECTION W-W  
SCALE 2 : 1



DETAIL F  
SCALE 4 : 1



DETAIL D  
SCALE 2 : 1



VIEW L-L  
95.7°  
SCALE 2 : 1

