

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

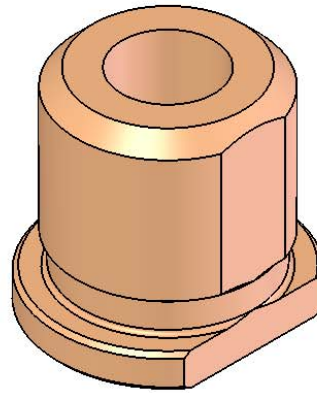
6. APPROXIMATE WEIGHT = 0.005 LB.

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

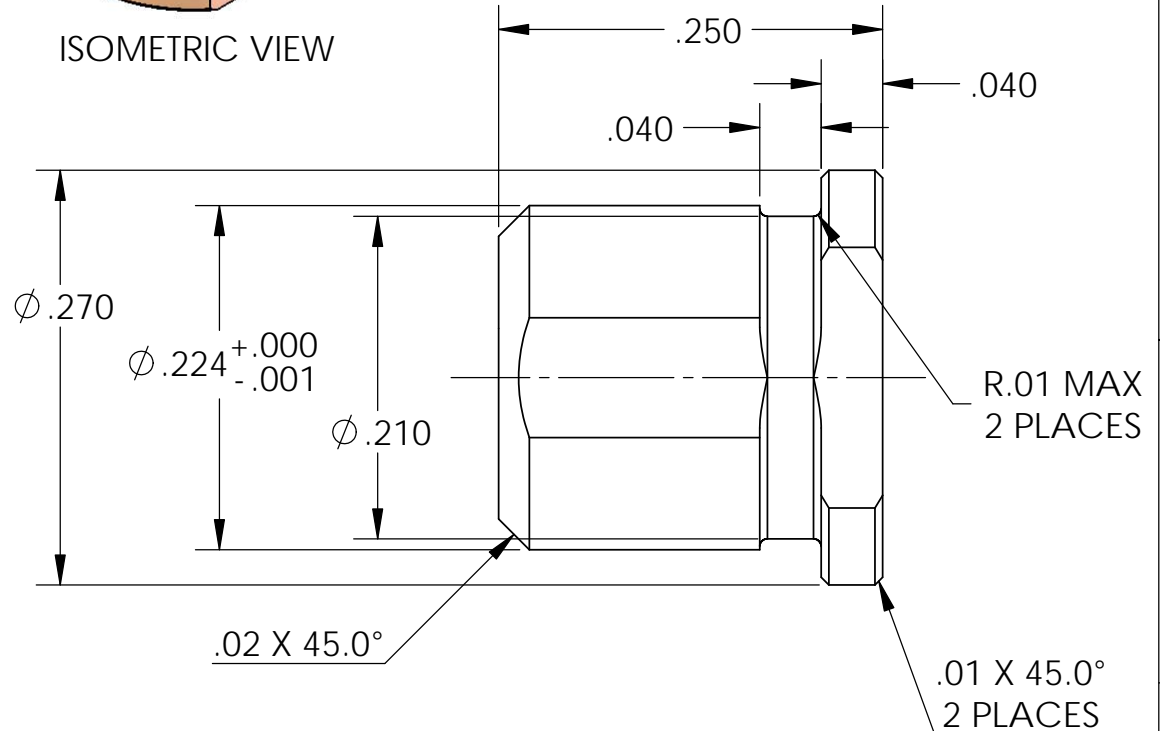
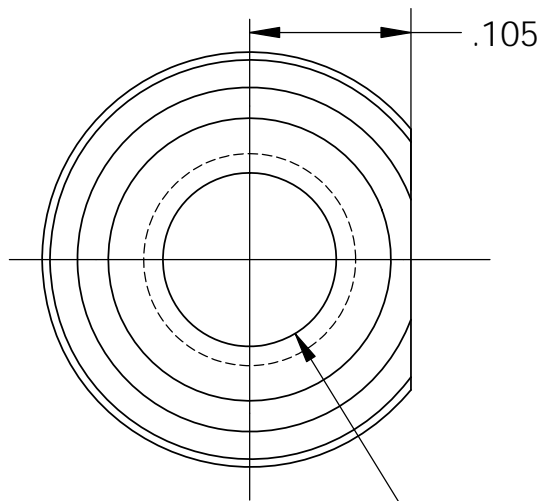
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. 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.

10. THE ALLOW MUST COMPLY WITH THE LIMITS IN ZINC (Zn), PHOSPHORUS (P) AND LEAD (Pb) ESTABLISHED IN L080072-00



ISOMETRIC VIEW



SEE TABLE for Ø AND THREAD THRU ALL

CONFIGURATION	Ø	THREAD
D1700139-101	0.126 +/-0.002	#6-80
D1700139-102	0.11	#6-40 UNF H11(+.005)

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
XX ± .015
XXX ± .005

ANGULAR ± 0.5°

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES: .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL Aluminum Bronze 10 FINISH 32 µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM SQZ NEXT ASSY D1500300

PART NAME VOPO Oven Threaded Bushing

DESIGNER	A. Fernandez	20 MAR 2017	SIZE	DWG. NO.	REV.
DRAFTER	A. Fernandez	20 MAR 2017	A	D1700139	v1
CHECKER	F. Matchard	20 MAR 2017	SCALE: 4:1	PROJECTION:	SHEET 1 OF 1
APPROVAL	C. torrie	20 MAR 2017			