

**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: DXXXXXX-VY, TYPE-XX, S/N XXX

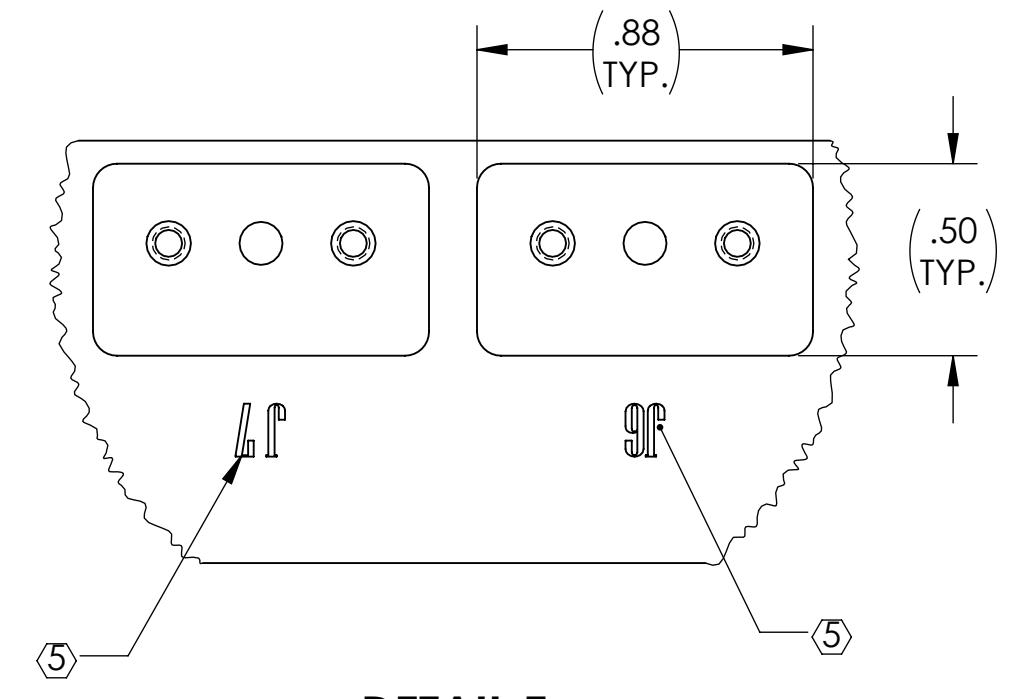
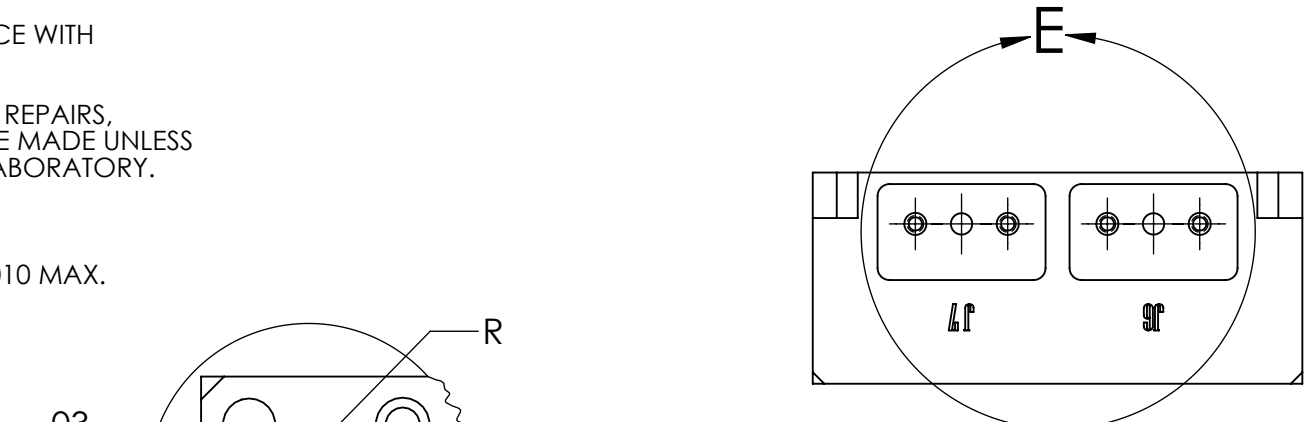
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO SPECIFICATION E0900364

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

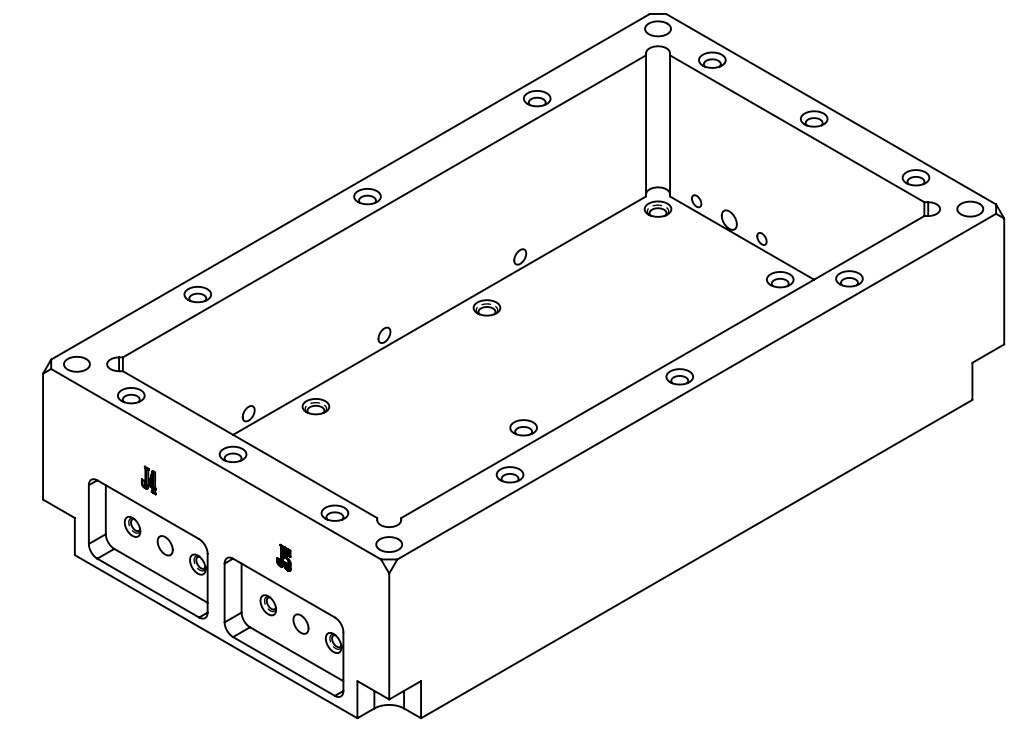
9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO SPECIFICATION E0900364

10. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .010 MAX.

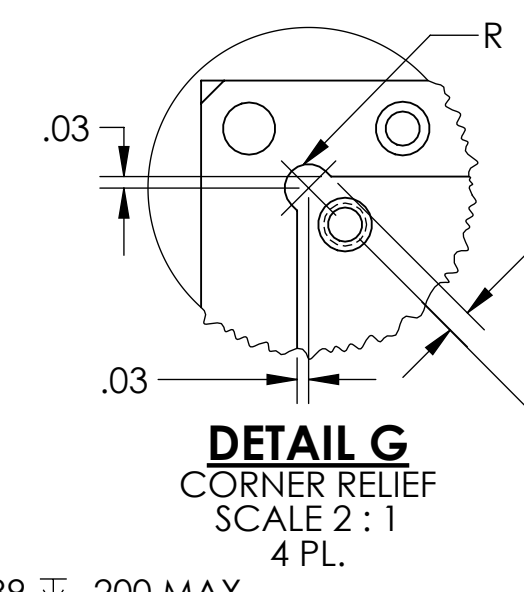
REV.	DATE	DCN #	DRAWING TREE #
v5	30 AUG 2019	-	-
v6	05 SEP 2019	E1900251-x0	-
-	-	-	-



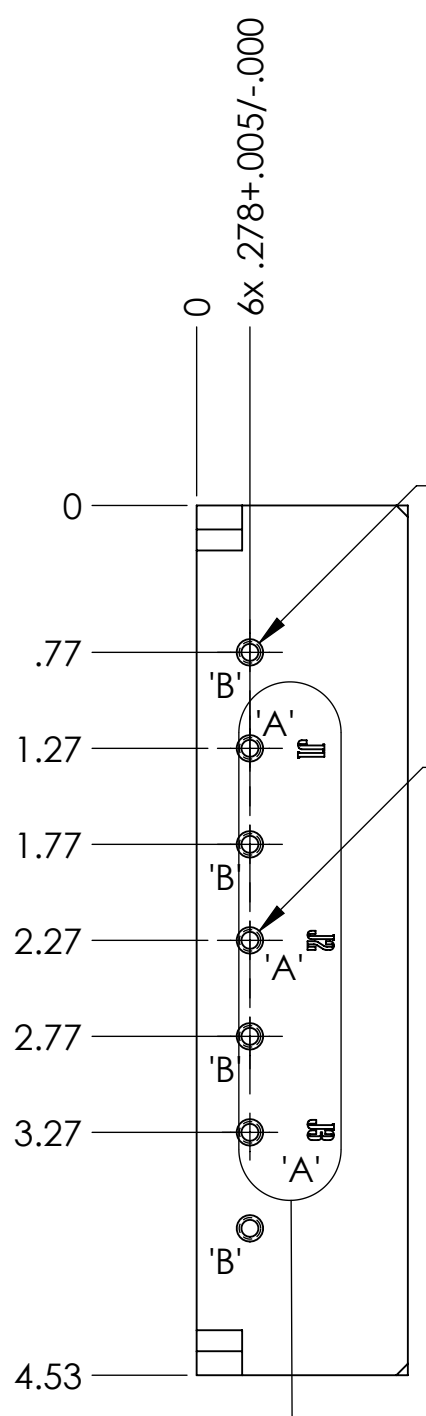
**DETAIL E**  
SCALE 2 : 1  
(SEE DETAIL 'D' FOR DIMENSIONAL DATA)



**ISO VIEW**



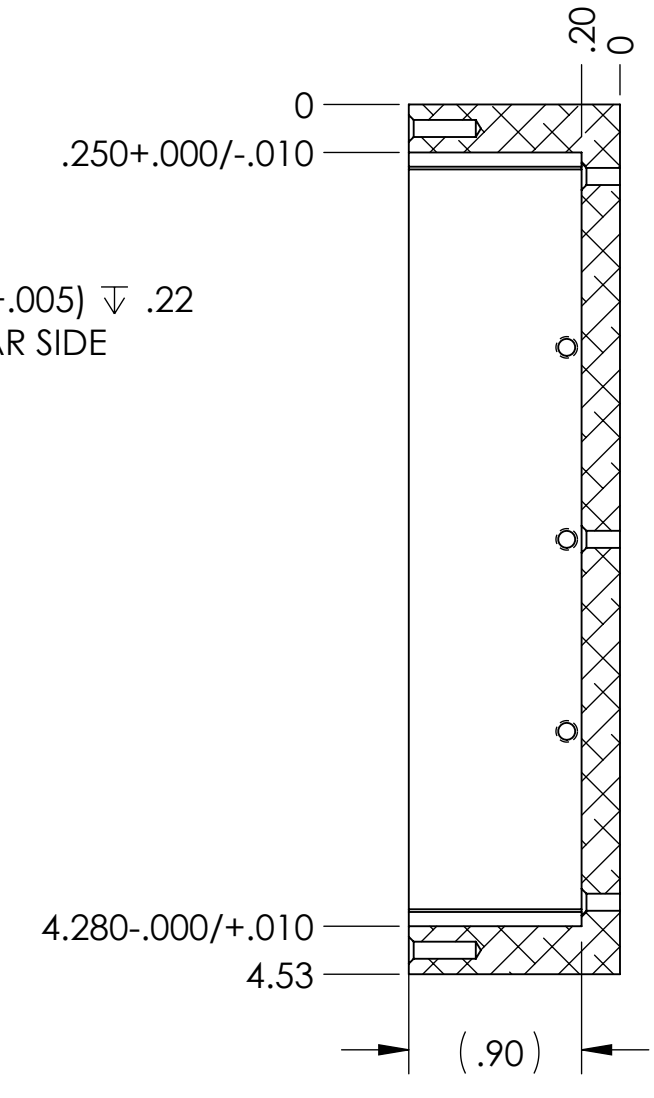
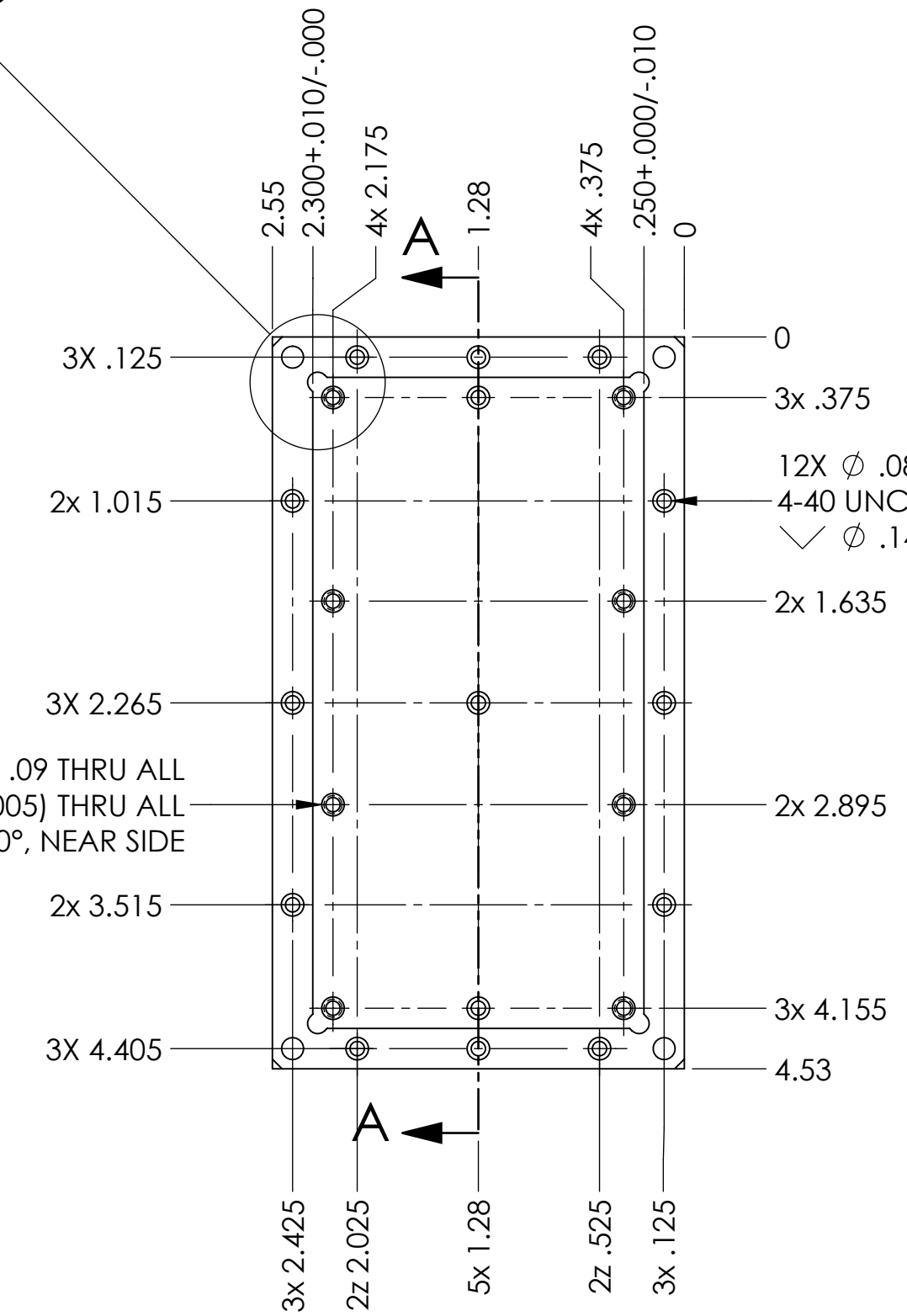
**DETAIL G**  
CORNER RELIEF  
SCALE 2 : 1  
4 PL.



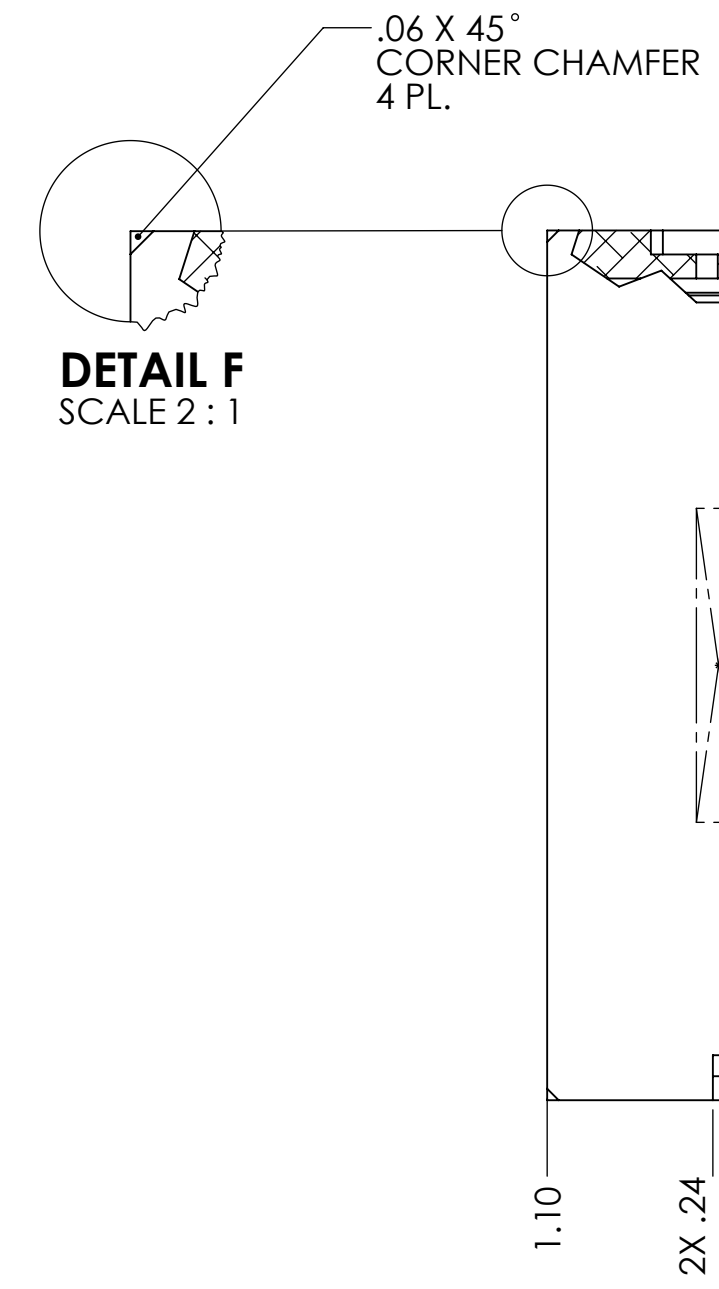
4X  $\phi$  .089  $\nabla$  .200 MAX.  
 4-40 UNC - 2B, H11 (+.005)  $\nabla$  .17  
 $\nabla$   $\phi$  .14 X 90°, NEAR SIDE  
 DO NOT BREAK THRU LABELED 'B'

3X  $\phi$  .089 THRU  
 4-40 UNC - 2B, H11 (+.005) THRU  
 $\nabla$   $\phi$  .14 X 90°, NEAR SIDE  
 LABELED 'A'

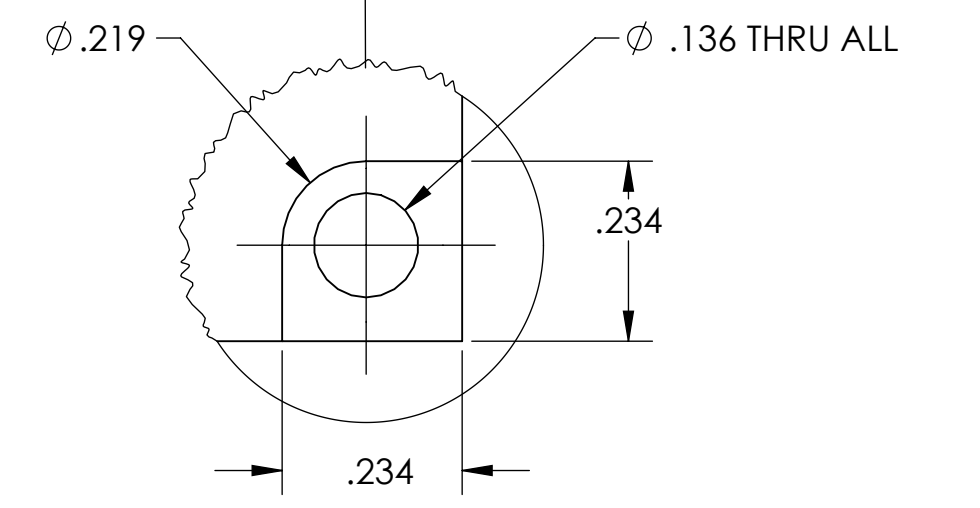
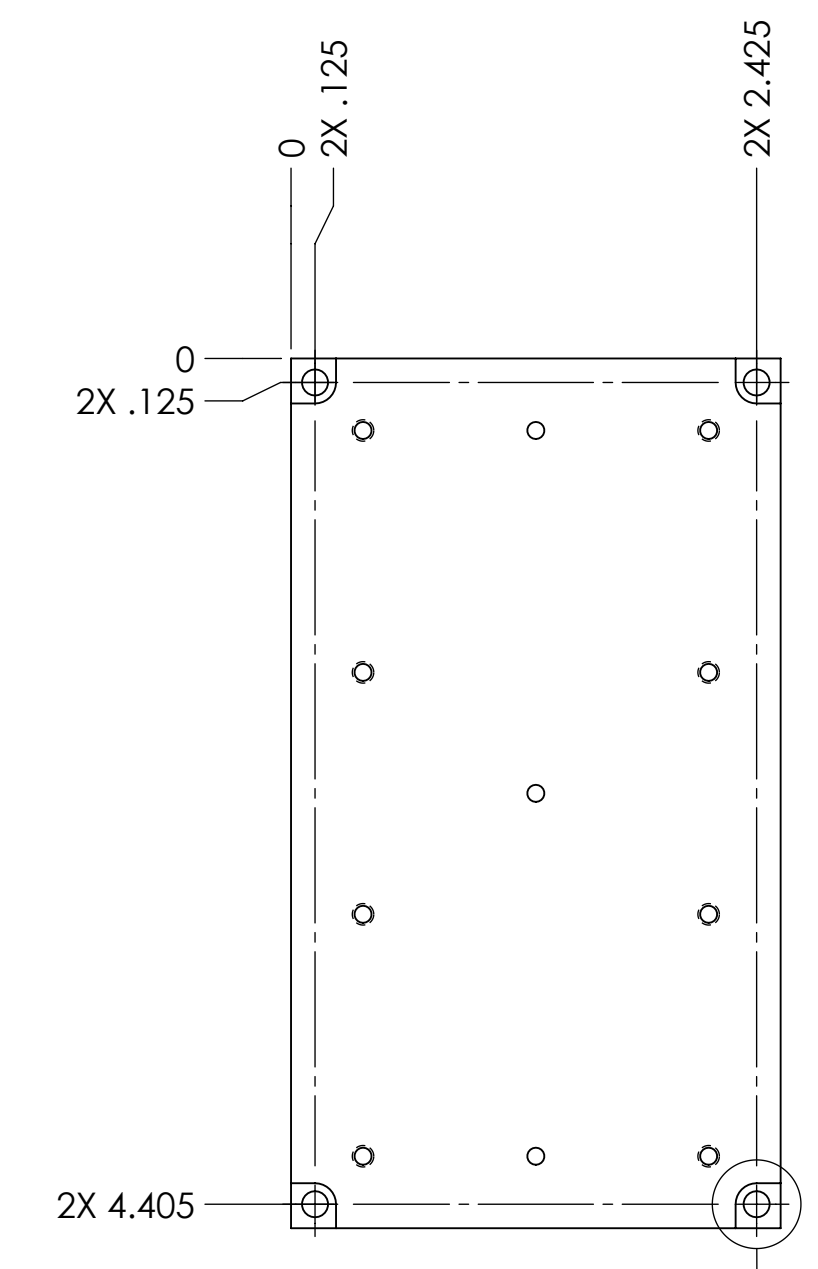
11X  $\phi$  .09 THRU ALL  
 4-40 UNC - 2B, H11 (+.005) THRU ALL  
 $\nabla$   $\phi$  .14 X 90°, NEAR SIDE



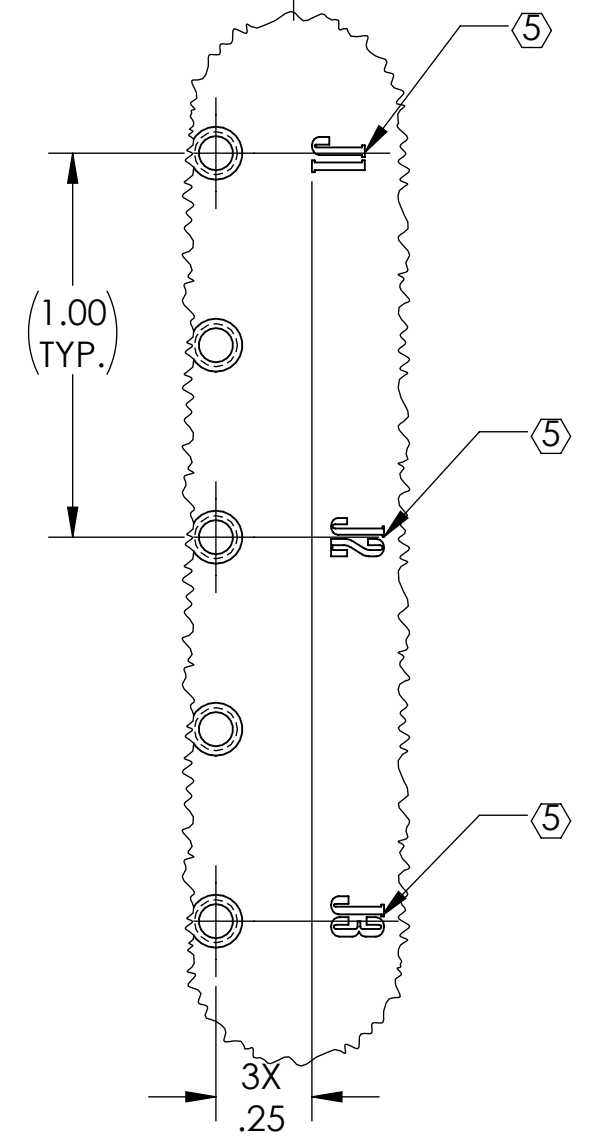
**SECTION A-A**



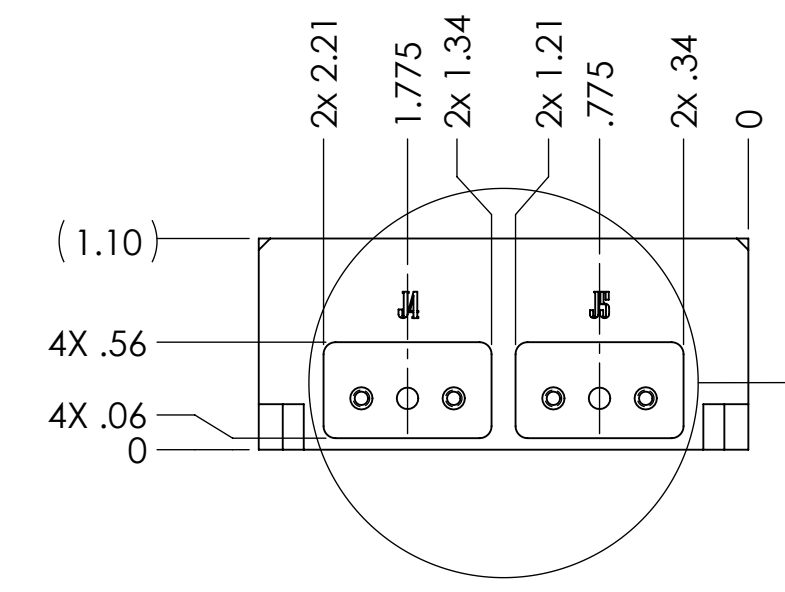
**DETAIL F**  
SCALE 2 : 1



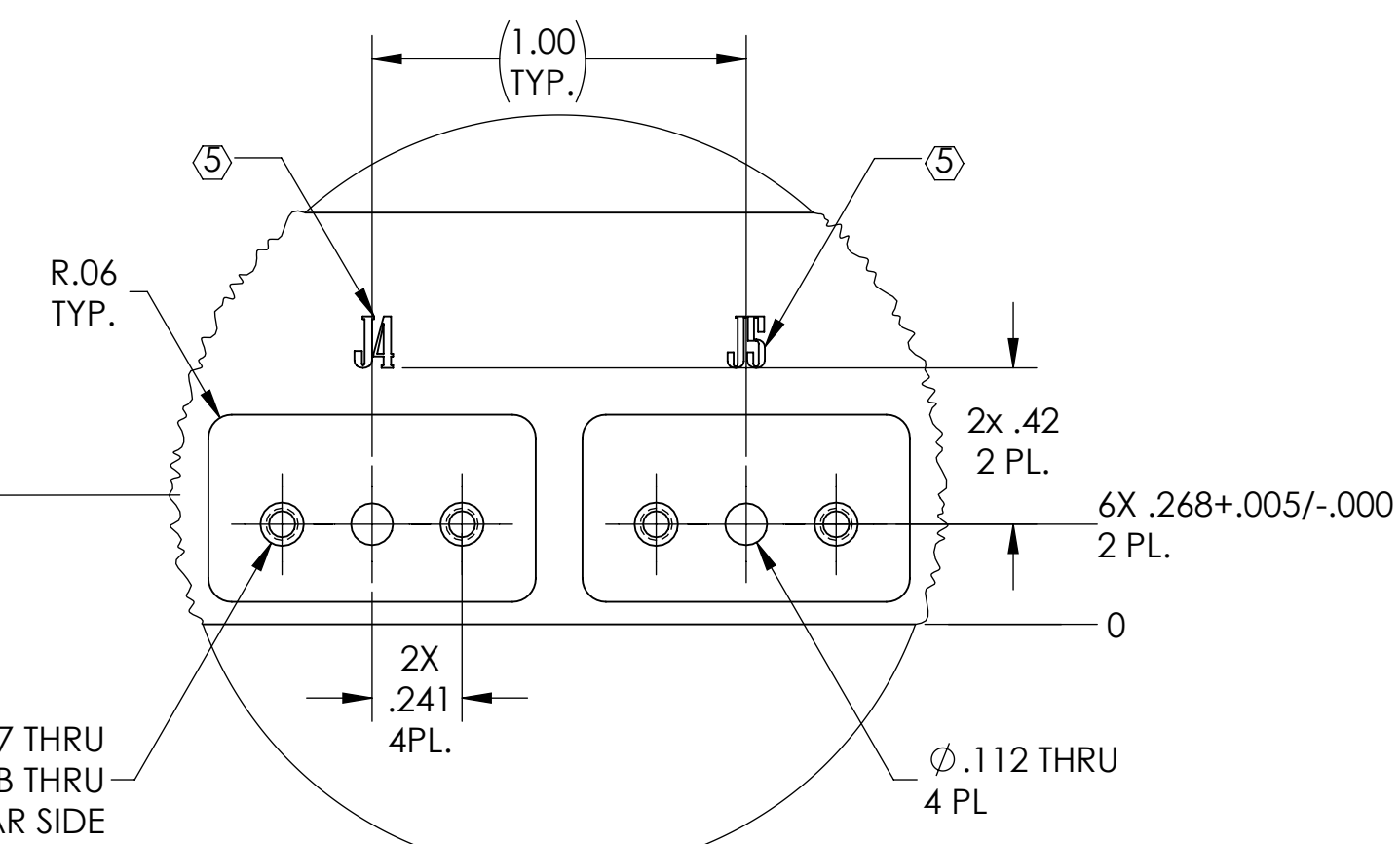
**DETAIL B**  
SCALE 4 : 1  
(SEE SIDE VIEW FOR C'BORE DEPTH)  
4 PL.



**DETAIL C**  
SCALE 2 : 1



**DETAIL D**  
SCALE 2 : 1



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL 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.		<b>SYSTEM</b> ADVANCED LIGO		<b>SUB-SYSTEM</b> SYS	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX $\pm$ .01 .XXX $\pm$ .005 ANGULAR $\pm$ 0.5°		<b>MATERIAL</b> 6061-T6 Al		<b>FINISH</b> 63 $\mu$ inch	
		<b>NEXT ASSY</b> N/A		<b>DESIGNER</b> E.SANCHEZ 22 AUG 2019 <b>DRAFTER</b> E.SANCHEZ 29 AUG 2019 <b>CHECKER</b> SEE DCC SEE DCC <b>APPROVAL</b> SEE DCC SEE DCC	
		<b>SIZE</b> DWG. NO. D <b>DWG. NO.</b> D1900377		<b>REV.</b> v6	
		<b>SCALE:</b> 1:1 <b>PROJECTION:</b>		<b>SHEET 1 OF 1</b>	