

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

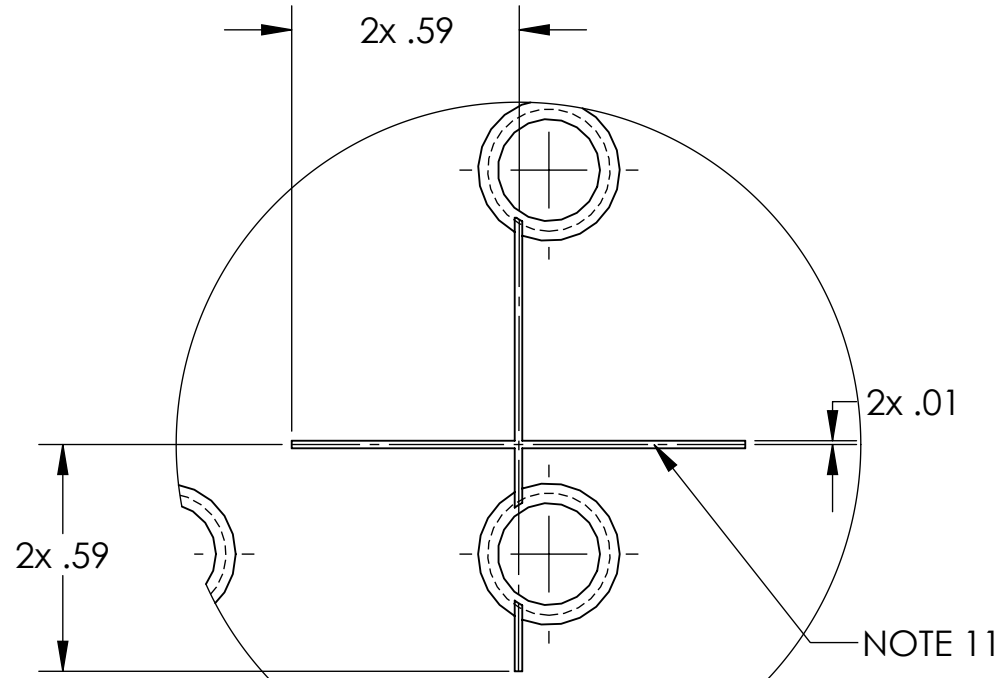
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH
LIGO SPECIFICATION E0900364

8. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

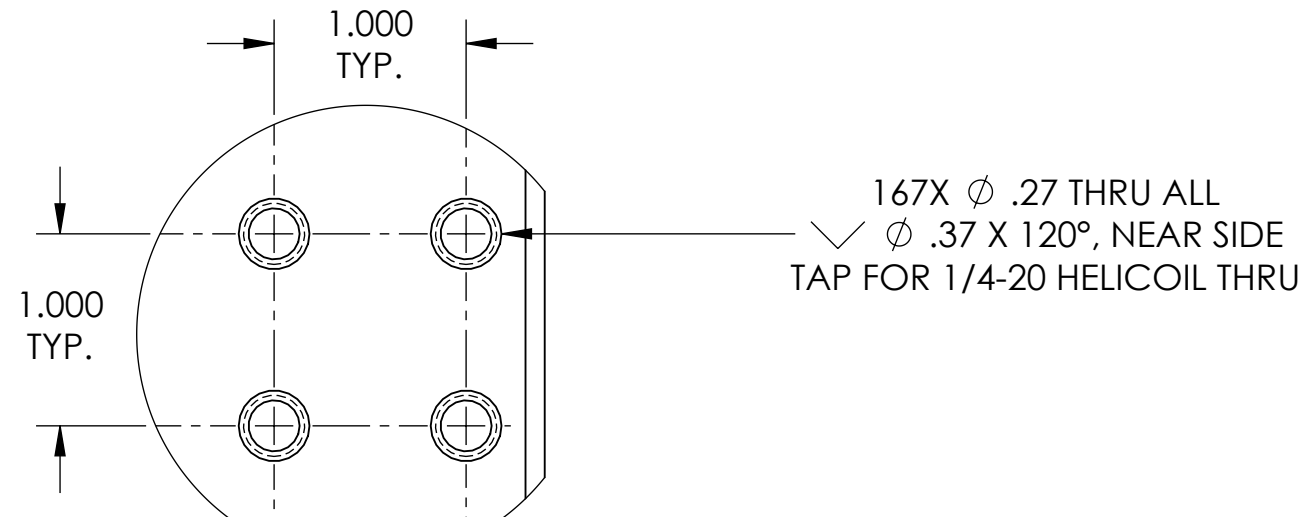
9. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL,
AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

10. 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](#)

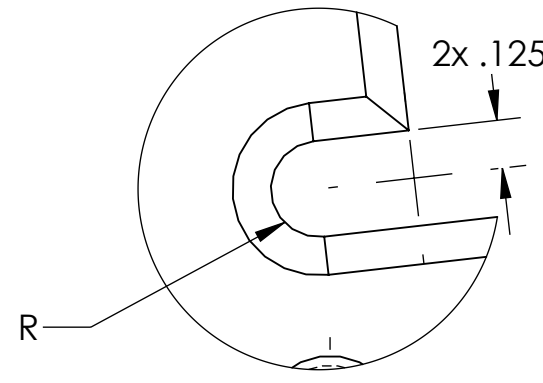
11. YAG LASER ETCH PART WITH ALIGNMENT TARGETS AS SHOWN.
MARKING SHALL BE ENGRAVED TO MINIMAL DEPTH, AND WIDTH SHALL NOT EXCEED .010" MAX.
MARKING SHALL BE LEGIBLE UNDER CONDITIONS OF NORMAL VISION IN DAYLIGHT.



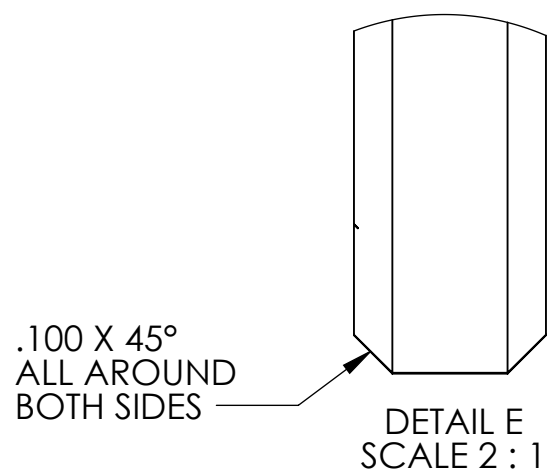
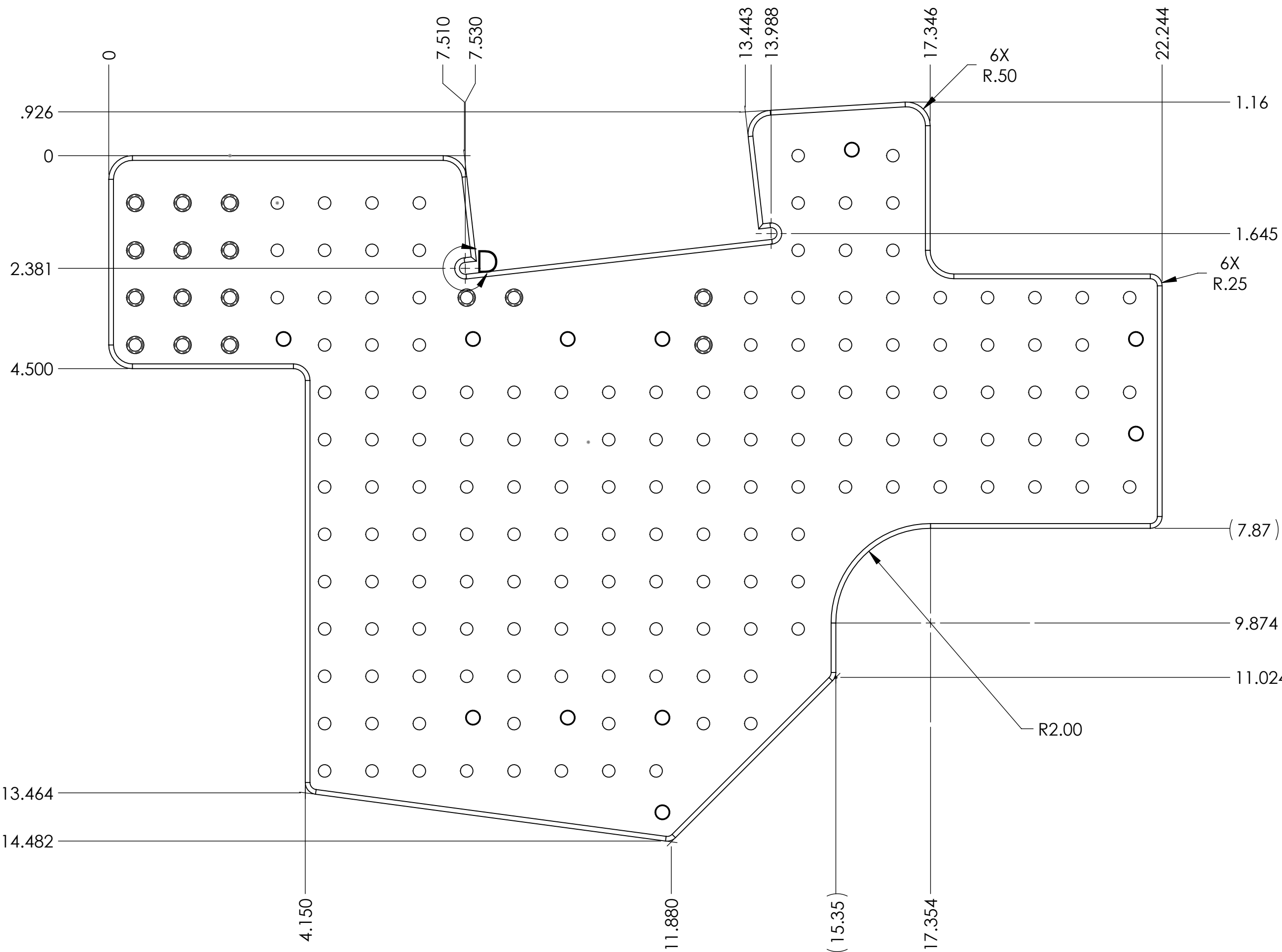
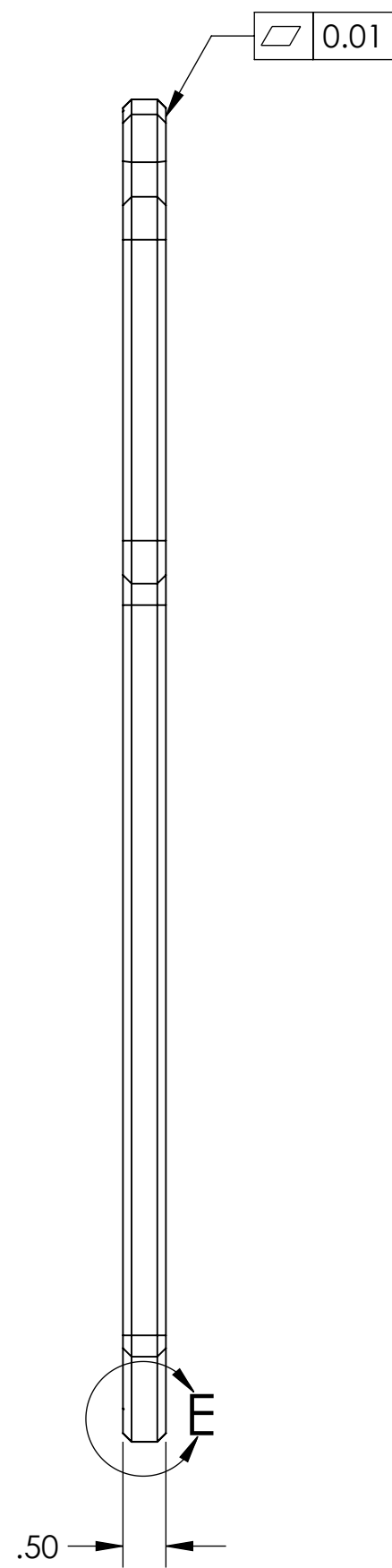
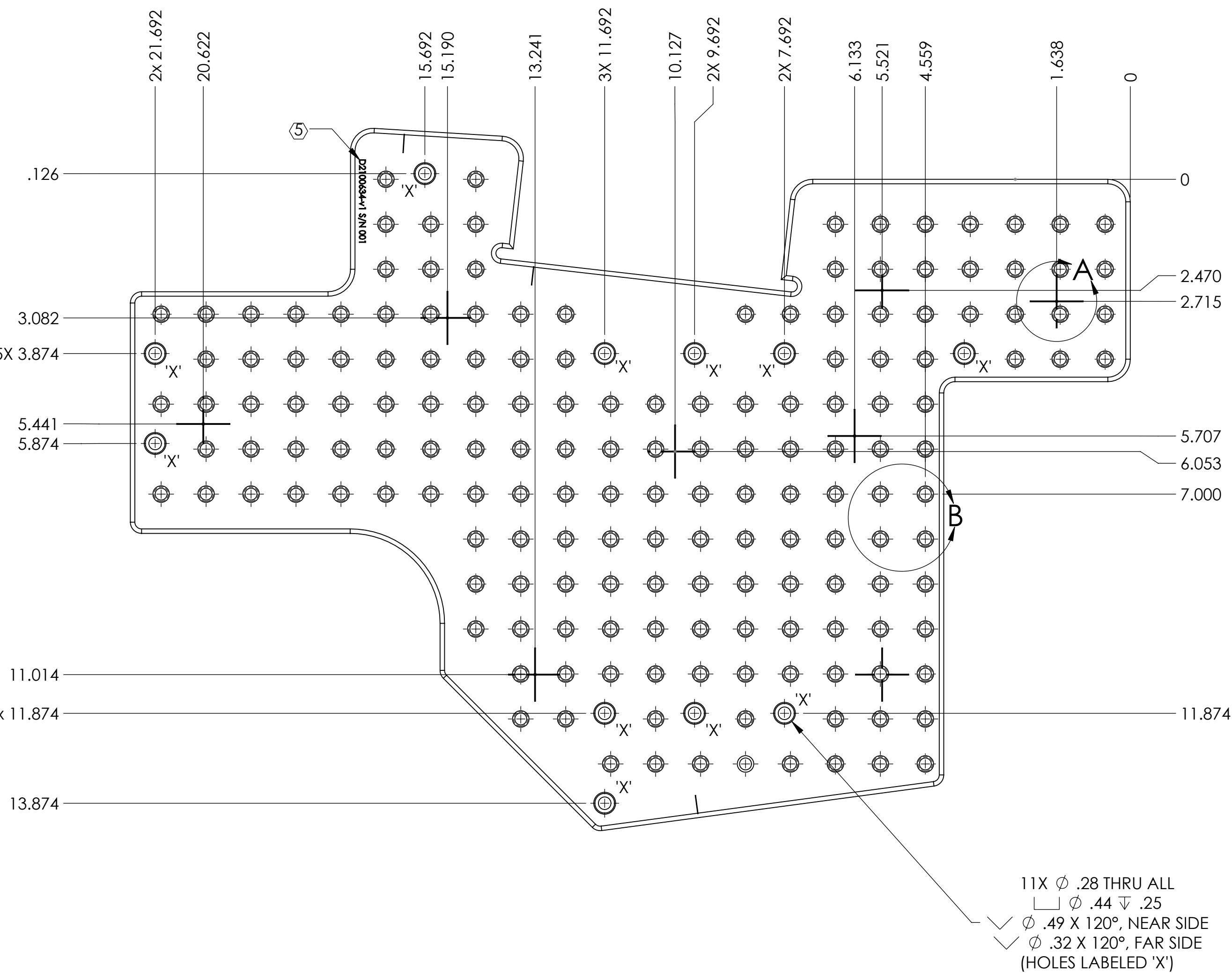
DETAIL A
SCALE 2 : 1





DETAIL B
SCALE 1 : 1



DETAIL D
SCALE 2 : 1



	2	1	1
REV.	DATE	DCN #	DRAWING TREE #
v1	JAN 13 2025	E2500006-x0	-
-	-	-	-
-	-	-	-

		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		<div> CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY</div>		PART NAME A+ SUS HAM6-H1 WFS36 SLED Baseplate					
DIMENSIONS ARE IN INCHES [MM]		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.		SYSTEM A+		SUB-SYSTEM SUS		DESIGNER R. JONES		SIZE DWG. NO.	REV.
TOLERANCES: .XX ± .01 .XXX ± .005						DRAFTER A.LOPEZ	12 JAN 2025	D	D2100634	v1	
ANGULAR ± 0.5°						CHECKER SEE DCC	SEE DCC	APPROVAL SEE DCC	SEE DCC	SCALE: 1:2	PROJECTION: <div></div>
MATERIAL 6061-T6 Al		FINISH 63 μinch		NEXT ASSY D2100568							