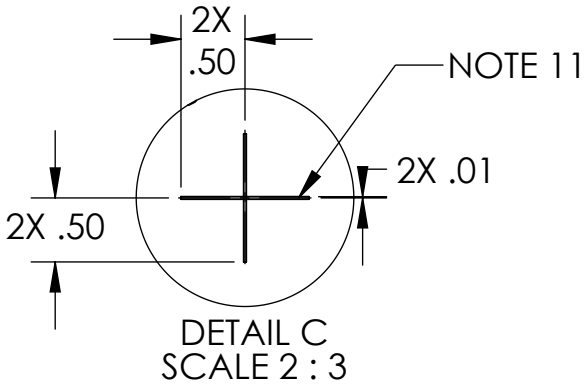
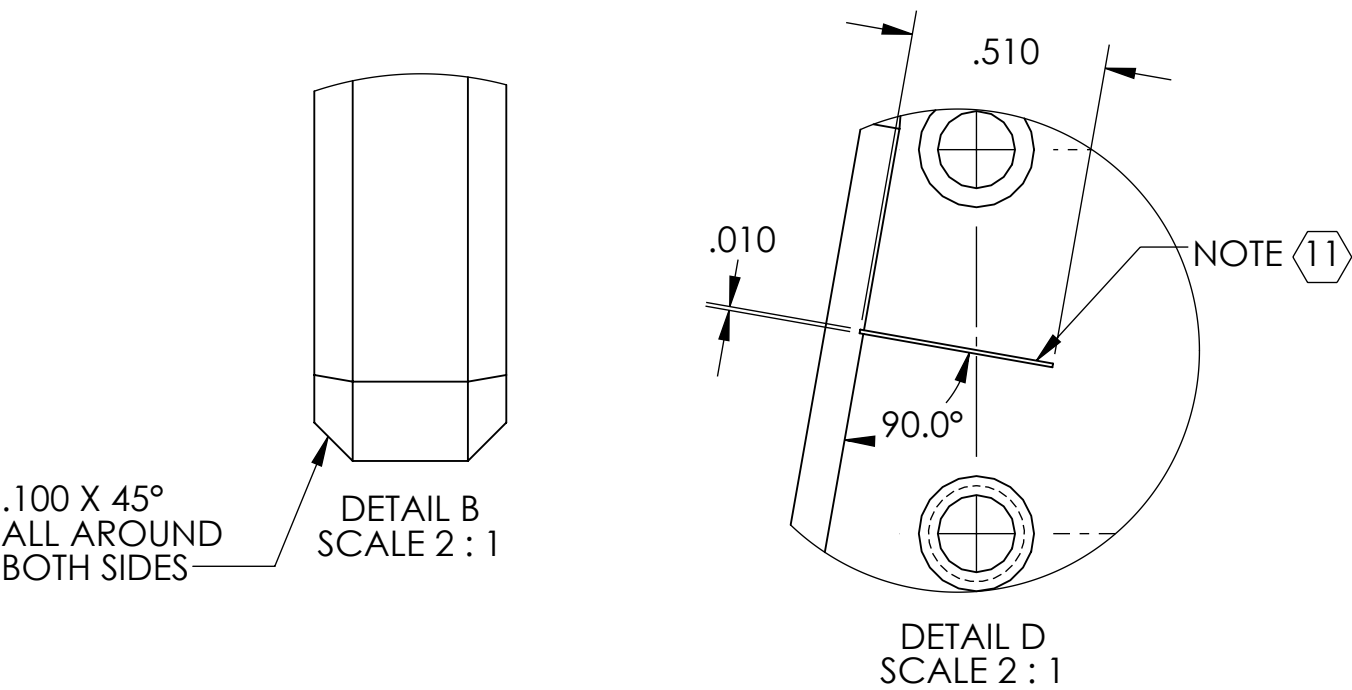
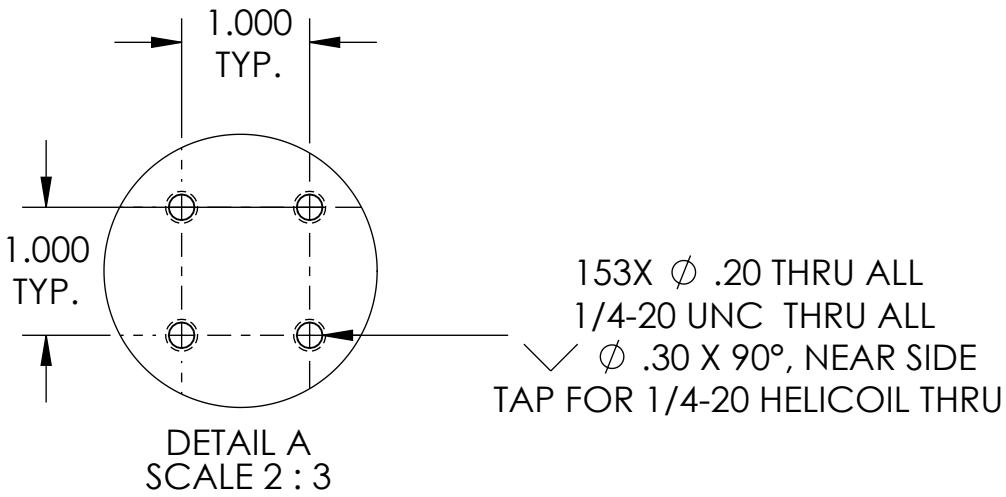


NOTES CONTINUED:

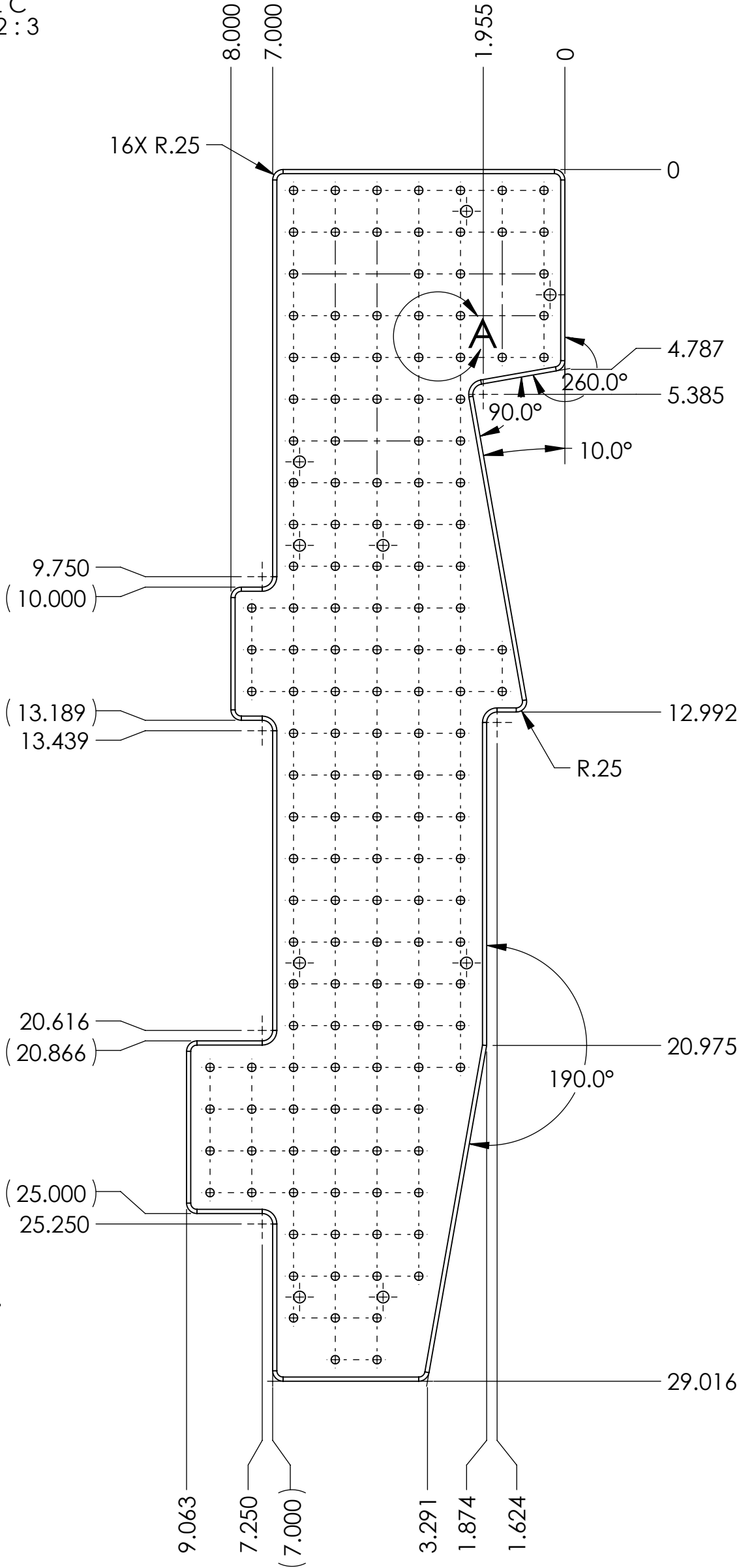
⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE 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



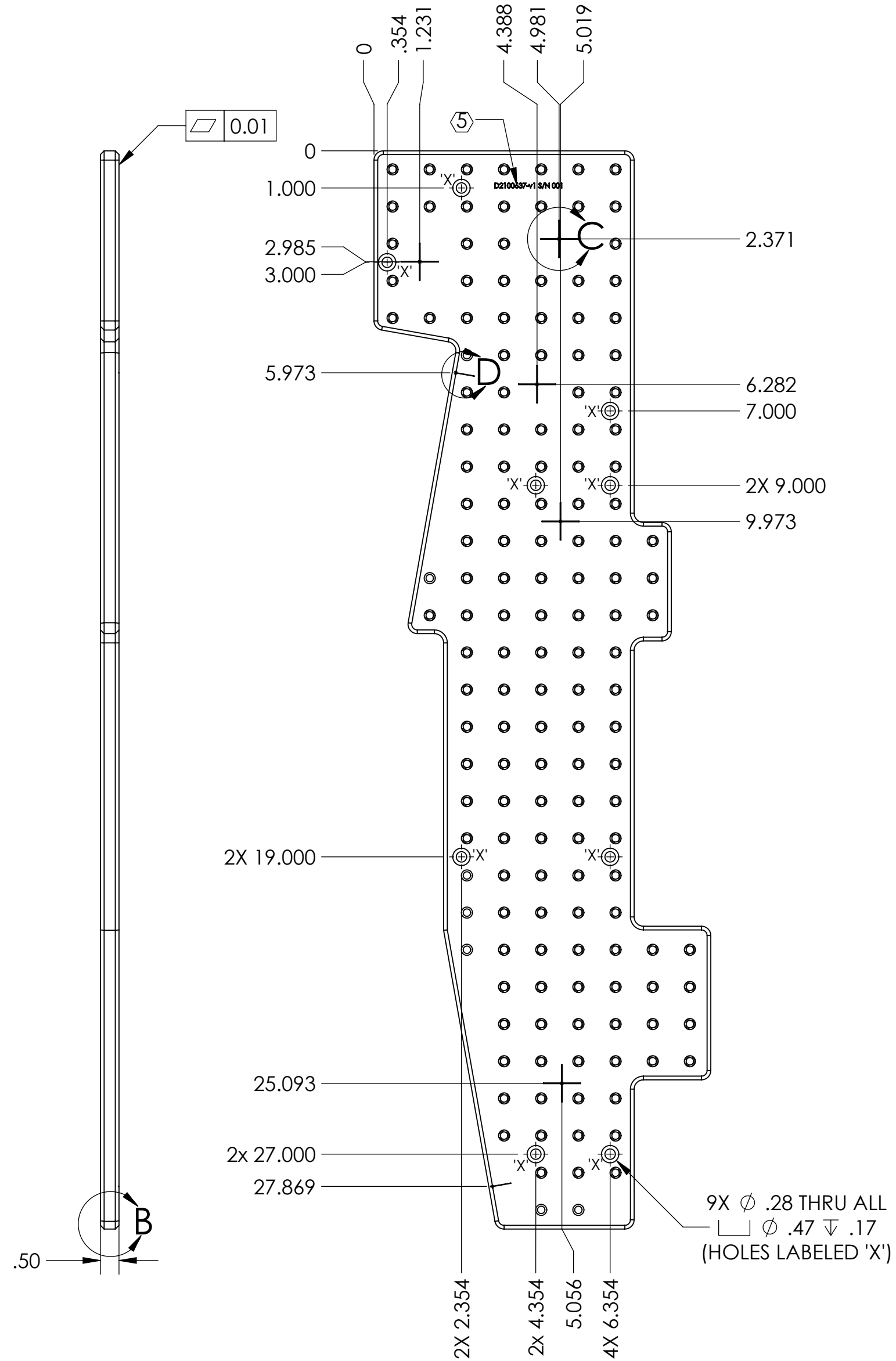
6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO E0900364
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364
8. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, 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 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.



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		
DIMENSIONS ARE IN INCHES [MM]	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.	
TOLERANCES:	MATERIAL	FINISH
.XX ± .01	6061-T6 Al	32 μinch
.XXX ± .005		
ANGULAR ± 0.5°		



REV.	DATE	DCN #	DRAWING TREE #
v1	6 MAR 2025	E2500006-x0	-
-	-	-	-
-	-	-	-



PART NAME			DRAWING TREE #		
HAM6-L1 AS WFS (WFS45) SLED Baseplate			-		
DESIGNER	R.JONES	JUNE 2023	SIZE	DWG. NO.	REV.
DRAFTER	A.LOPEZ	6 MAR 2025	c	D2100637	v1
CHECKER	SEE DCC	SEE DCC	SCALE: 1:4	PROJECTION:	SHEET 1 OF 1
APPROVAL					