NOTES CONTINUED:

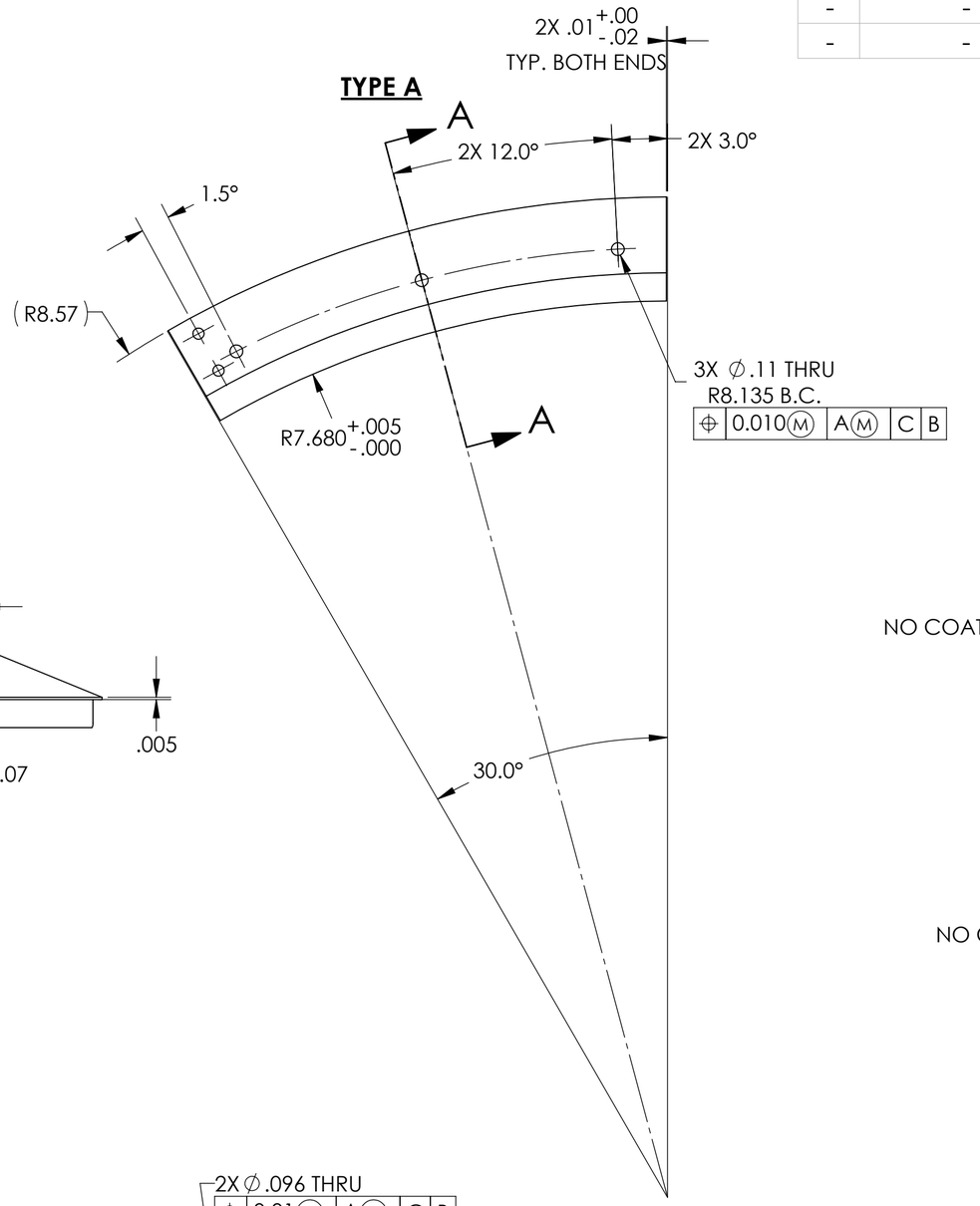
⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

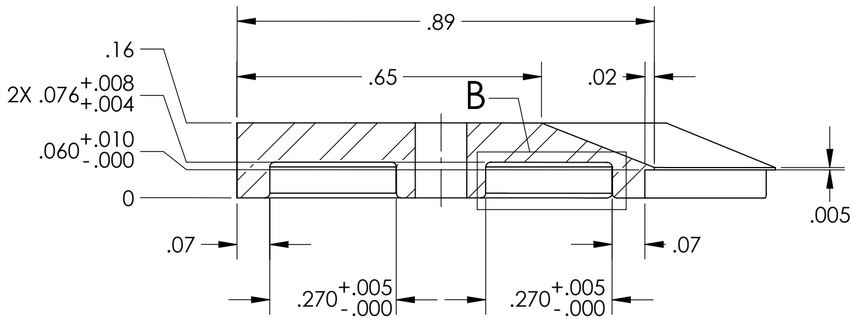
6. APPROXIMATE WEIGHT = 0.105 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO E0900364
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364
9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD 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. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

⑪ PLASMA SPRAY ALL SURFACE SURFACES PER E2100125 WITH ALUMINUM OXIDE .004-.008". NO COATING IN HOLES AND NOTED AREAS

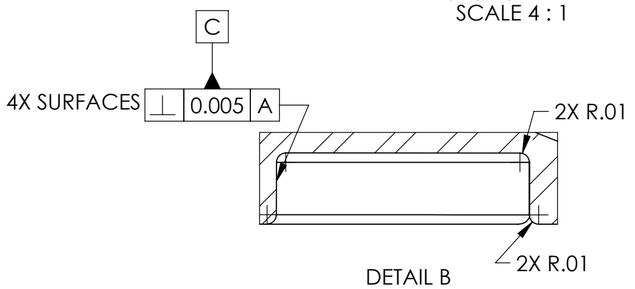
12. DIMENSIONS APPLY BEFORE ALUMINUM OXIDE COATING UNLESS SPECIFIED.

REV.	DATE	DCN #	DRAWING TREE #
-	-	-	-
-	-	-	-
-	-	-	-

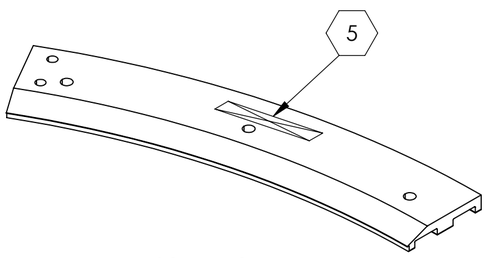




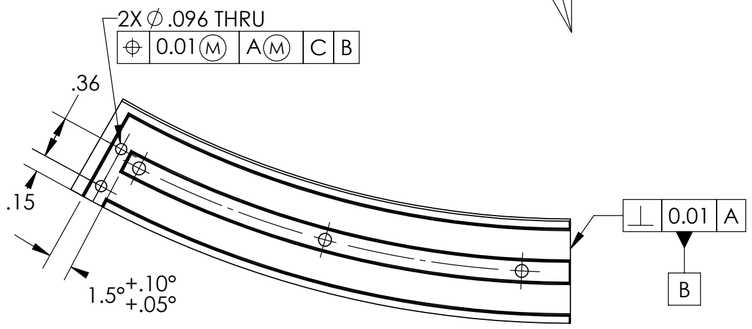
SECTION A-A
SCALE 4 : 1



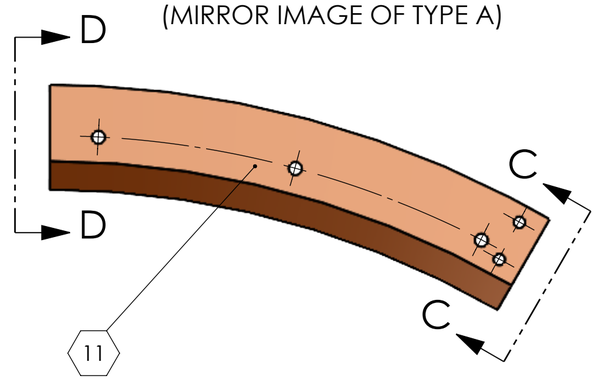
DETAIL B
SCALE 8 : 1



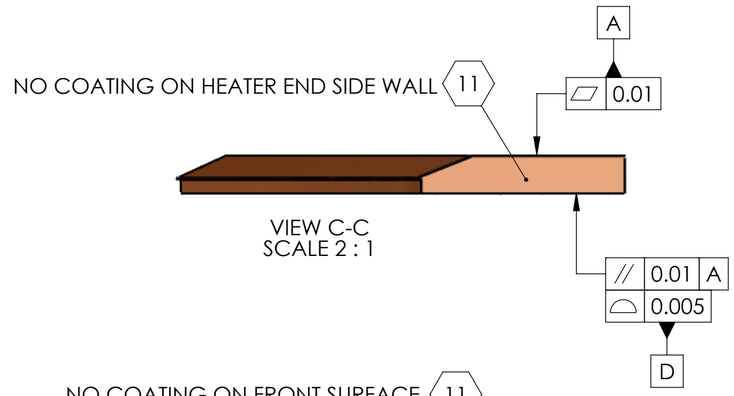
ISOMETRIC VIEW



TYPE B
(MIRROR IMAGE OF TYPE A)

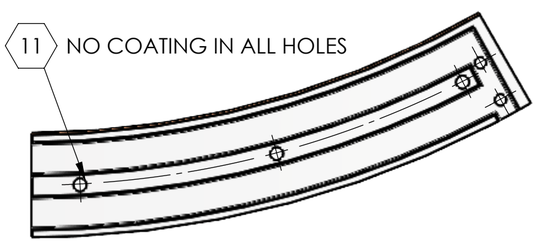


NO COATING ON TOP SURFACES



VIEW C-C
SCALE 2 : 1

VIEW D-D
SCALE 2 : 1



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± 0.5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATLEY 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.

MATERIAL SSTL 316

FINISH 32 µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM A+

SUB-SYSTEM AOS

NEXT ASSY D2500087

PART NAME
FROSTI Heater Upper Left Edge Segment

DESIGNER	Huy Tuong Cao	20 01 2025	
DRAFTER	Huy Tuong Cao	08 03 2024	
CHECKER			
APPROVAL			

SIZE c **DWG. NO.** D2400323 **REV.** v2

SCALE: 1:1 **PROJECTION:** SHEET 1 OF 1

PART PDM VERSION: $PRP:{VAULT VERSION}
DWG PDM VERSION:
D2400323-AOS-SSTL_FROSTI_Heater_Upper_Left_Edge_Segment