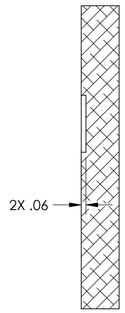
NOTES CONTINUED:

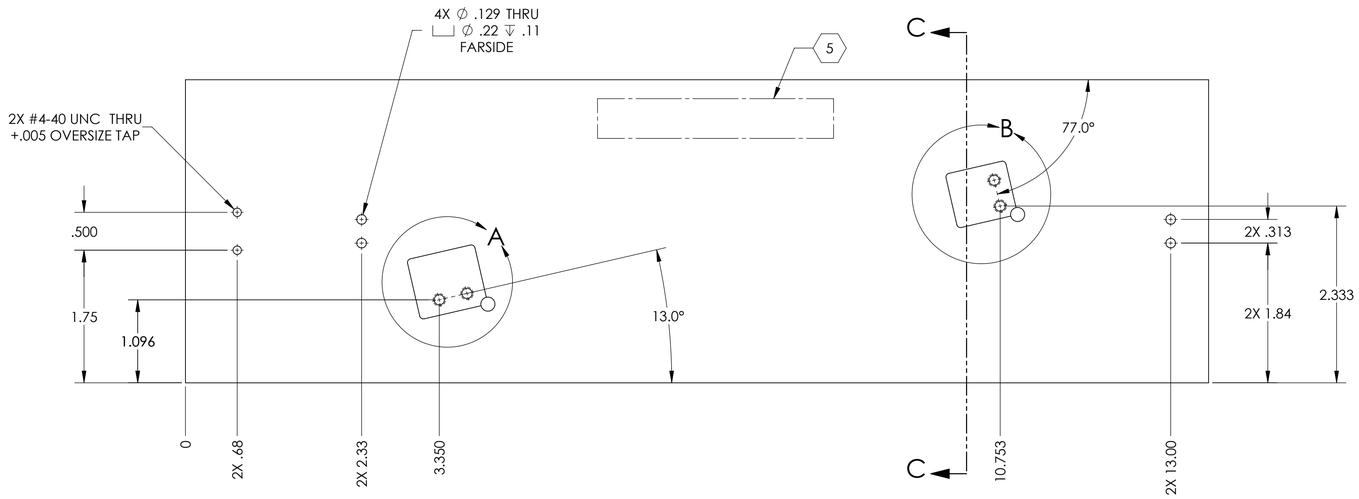
Ⓢ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 101 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

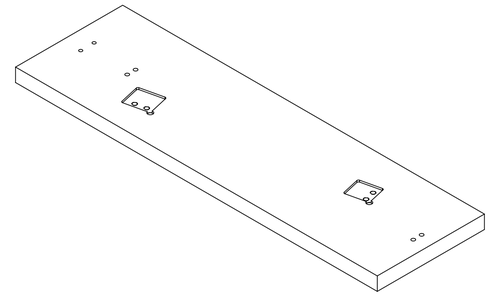
6. APPROXIMATE WEIGHT = 2.618 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	09 APR 2010	E0900502	E0900353
v2	02 SEP 2010	E1000347	E0900353
-	-	-	-

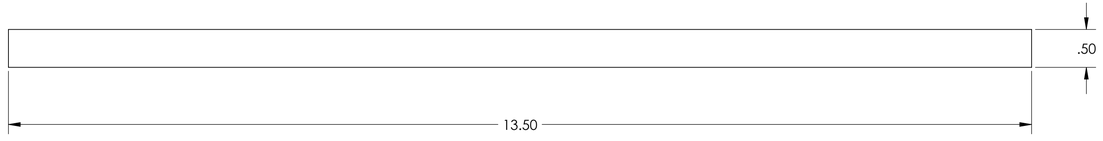


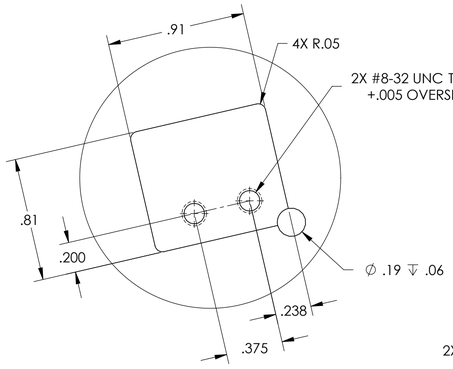
SECTION C-C



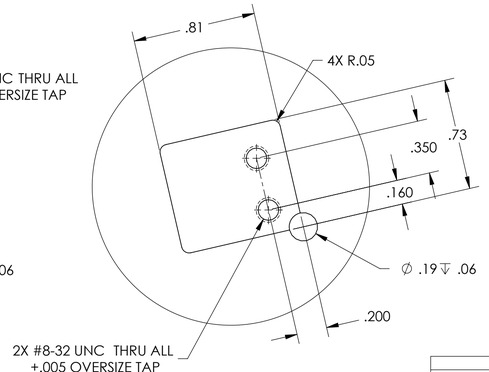


ISOMETRIC VIEW





DETAIL A
SCALE 2 : 1



DETAIL B
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, R.02 MIN. 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: 6061-T6 Al	FINISH: 63 µinch	NEXT ASSY: D0902526	

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO | SUB-SYSTEM: SUS

PART NAME: BASE PLATE, HSTS INTERMEDIATE WIRE JIG

DESIGNER	W. RASCH	20 OCT 2009
DRAFTER	B. MOORE	17 FEB 2010
CHECKER	M. MEYER	18 FEB 2010
APPROVAL		

SIZE: D | DWG. NO.: D0902535 | REV.: v2

SCALE: 1:1 | PROJECTION: | SHEET 1 OF 1

D0902535-v2_aLIGO_SUS_HSTS_Base Plate, Intermediate Wire Jig, PART FDM REV- X-006, DRAWING FDM REV- X-008