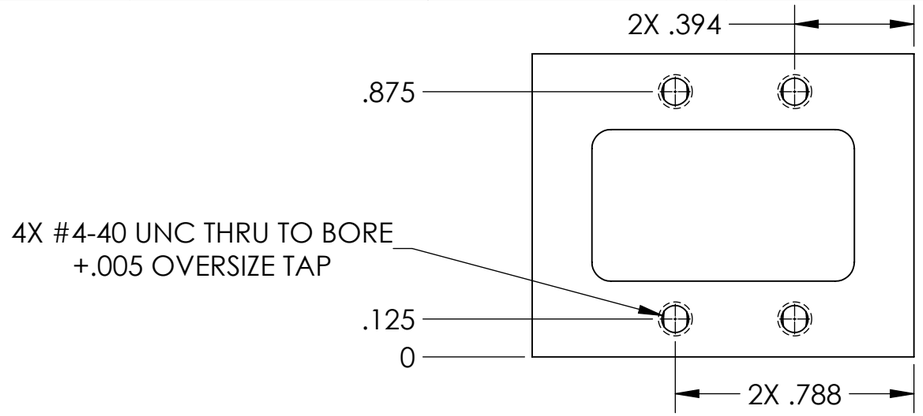
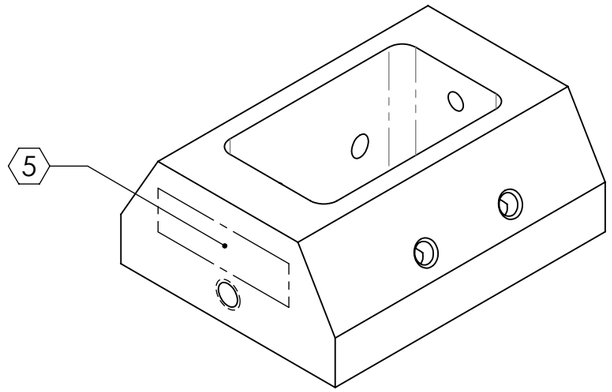
NOTES CONTINUED:

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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

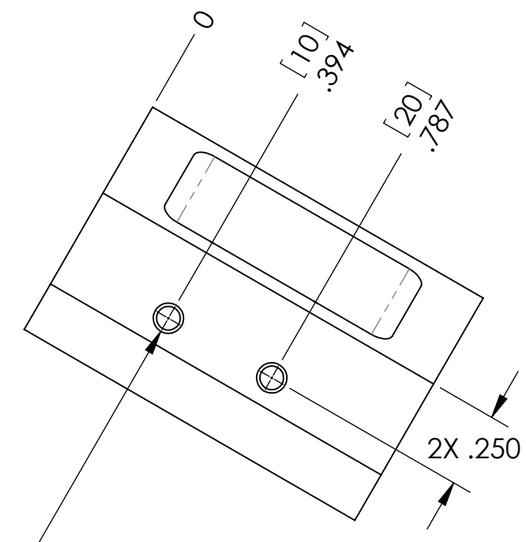
REV.	DATE	DCN #	DRAWING TREE #
v1	22 OCT 2009	E0900369	E080191
v2	10 NOV 2010	E1000693	E080191
v3	07 FEB 2012	E1200183	E080191



VIEW B-B

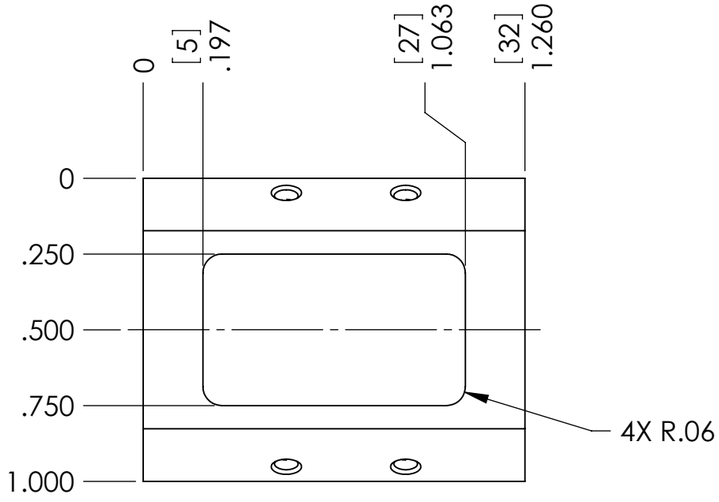


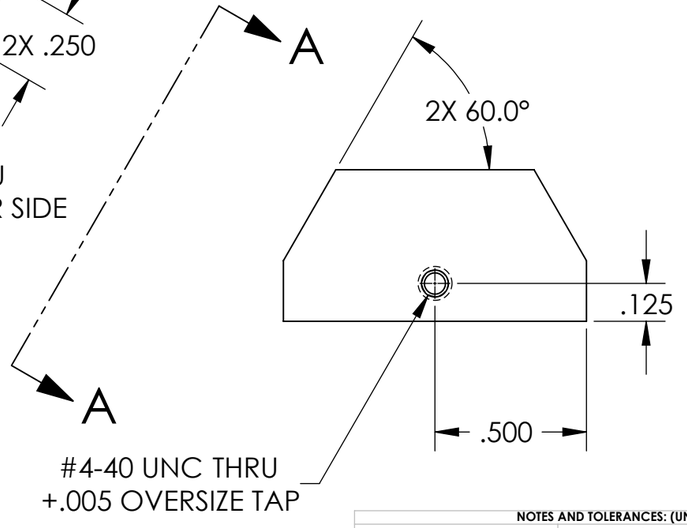
ISOMETRIC VIEW

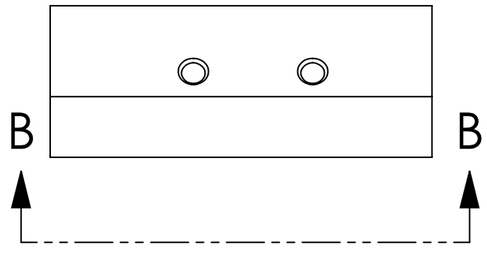


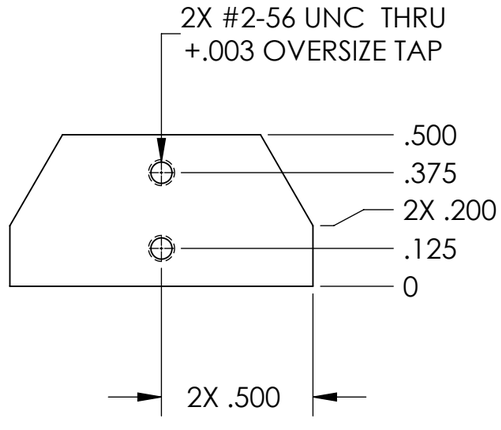
2X ⌀ .0781±.0005 THRU
⌵ ⌀ .100 MAX X 90°, NEAR SIDE

VIEW A-A









NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES [MM]

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

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: SAPPHIRE PRISM HOLDER

PART NAME: SAPPHIRE PRISM HOLDER

DESIGNER	D. BRIDGES	06 SEP 2011
DRAFTER	B. MOORE	07 FEB 2012
CHECKER	J. ROMIE	07 FEB 2012
APPROVAL		

SIZE: B | DWG. NO.: D0902664 | REV.: v3
SCALE: 2:1 | PROJECTION: | SHEET 1 OF 1

D0902664_Advanced_LIGO_SUS_HLTS_Sapphire_Prism_Holder, PART PDM REV: V2-000, DRAWING PDM REV: V1-000