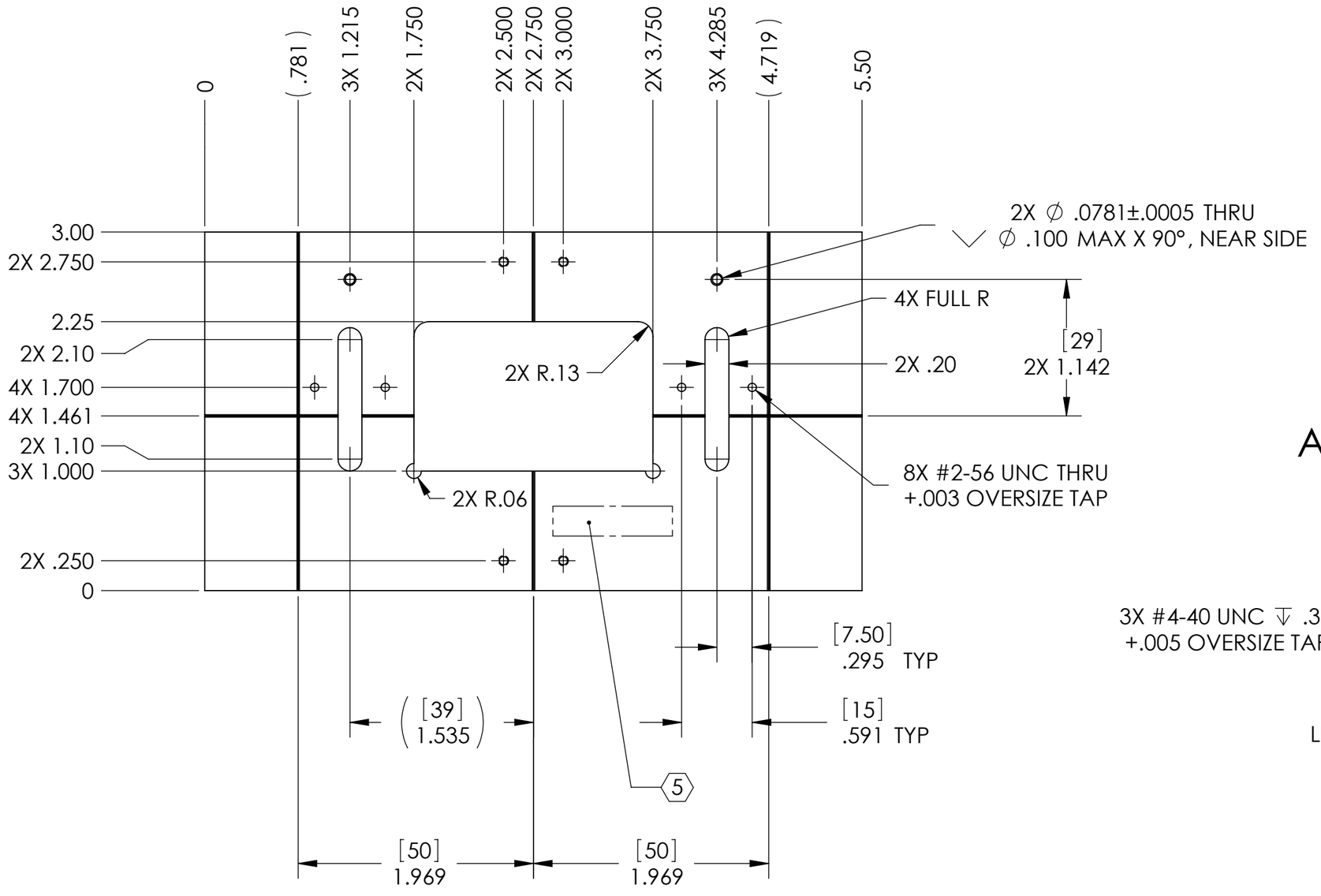
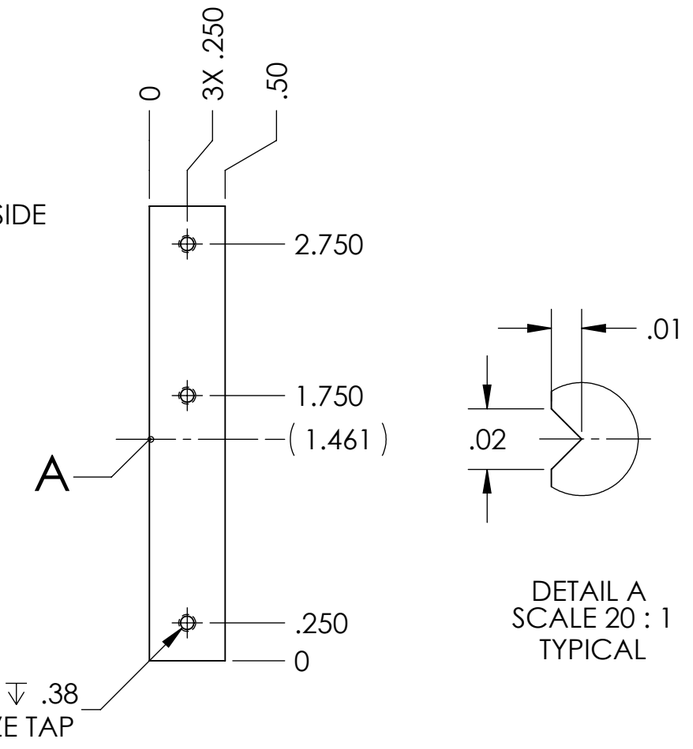
NOTES CONTINUED:

5. 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 001 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. 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	02 SEP 2011	E1100826	E080191
-	-	-	-





DETAIL A
SCALE 20 : 1
TYPICAL

LEFT AND RIGHT SIDES

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 BONDING FIXTURE

PART NAME BONDING TEMPLATE FRONT, HLTS

DESIGNER	D. BRIDGES	02 SEP 2011
DRAFTER	D. BRIDGES	02 SEP 2011
CHECKER	B. MOORE	06 SEP 2011
APPROVAL		

SIZE B **DWG. NO.** D0902665 **REV.** v2

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

D0902665_Advanced_LIGO_SUS_HLTS_Bonding_Template_Front,_Sapphire_Prism, PART PDM REV: V1-001, DRAWING PDM REV: V1-002