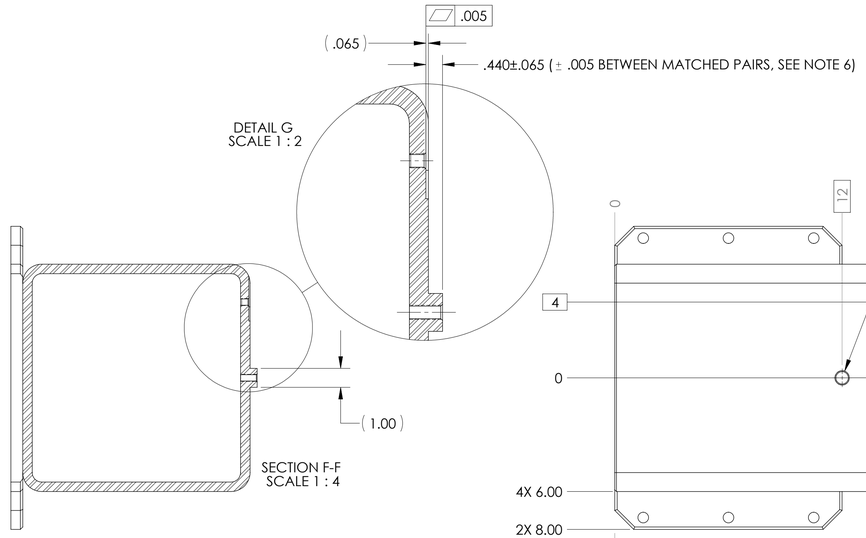
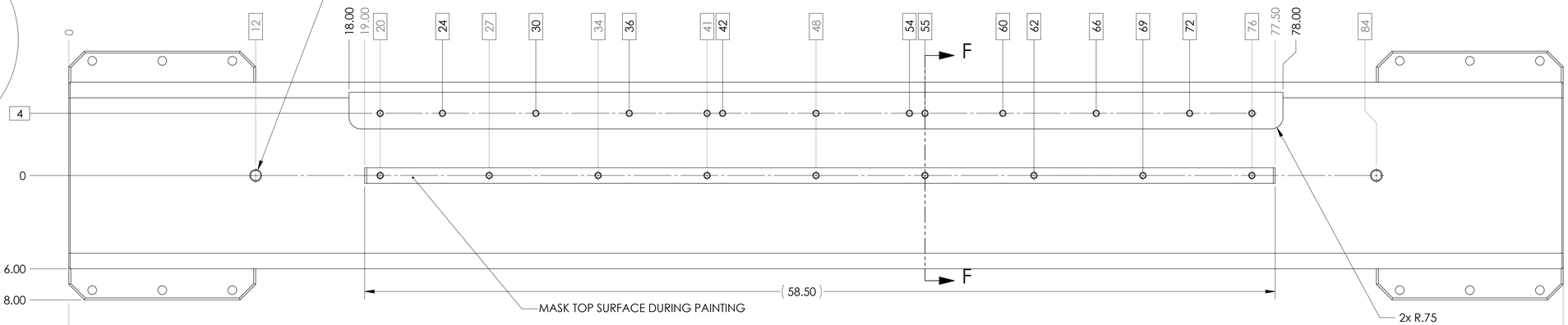
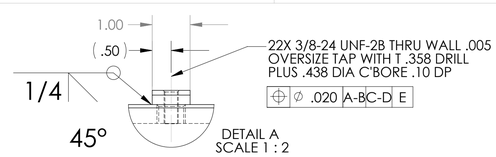
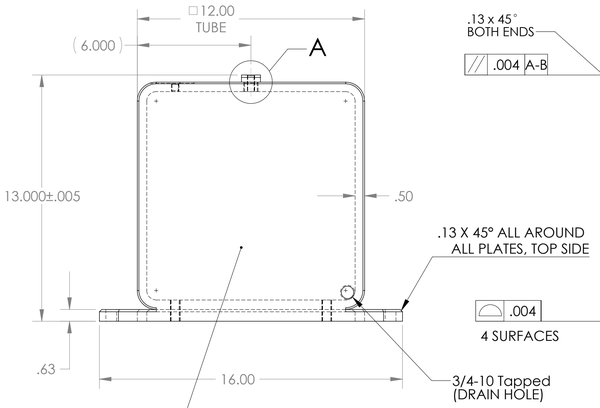
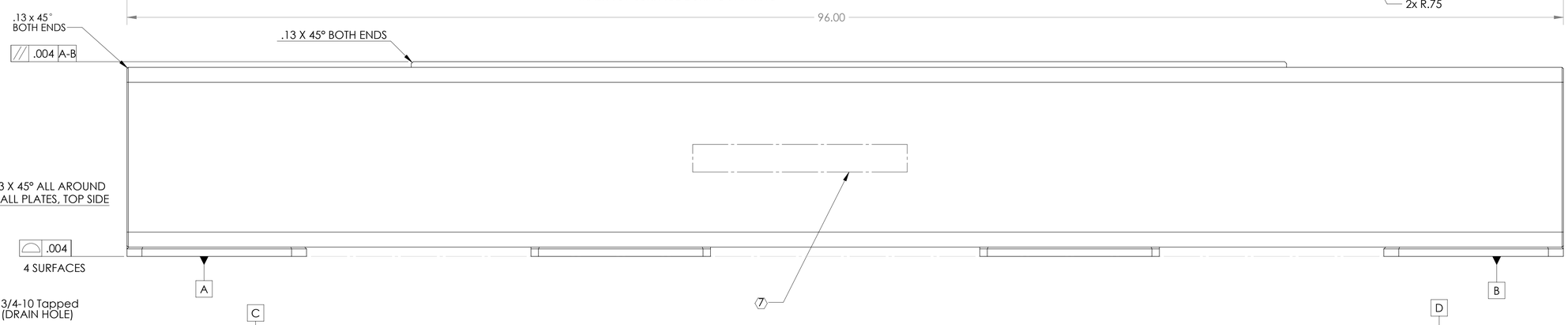
REV.	DATE	DCN #	DRAWING TREE #
V1	20 Aug2010	E1000340	
V2	20 OCT 2010	E1000340	

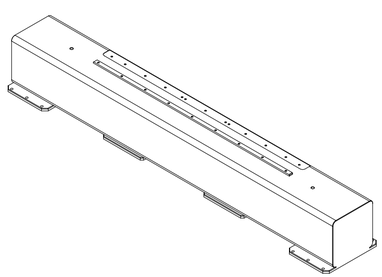


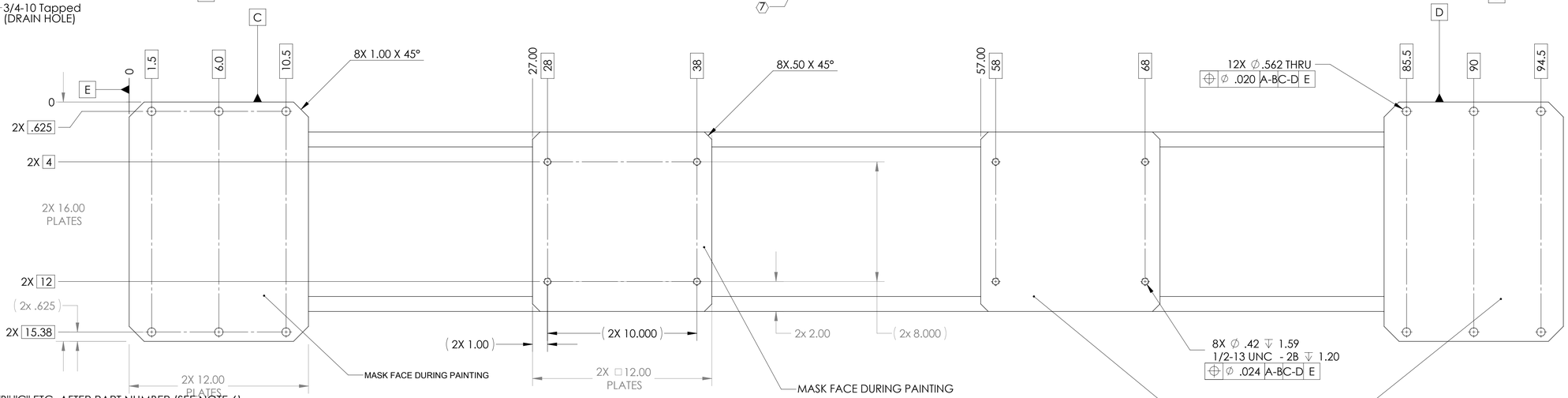












NOTES CONTINUED:

5. FULL WELDED CONSTRUCTION.
6. MANUFACTURE IN MATCHED PAIRS, AND MARK AS "PAIR: A" "B" "C" ETC. AFTER PART NUMBER (SEE NOTE 6).
7. PART NUMBER (DRAWING NO. PLUS REVISION) TO BE CLEARLY MARKED ON THE PART NEAR LOCATION SHOWN EXAMPLE : **D1002127-V1 PAIR: A** (~ 1" CHARACTERS)
8. BEFORE FINISHING REMOVE ALL: MILL SCALE, OXYDATION, GREASE, OIL, DIRT, FINGERPRINTS, CONTAMINANTS, ETC.
9. PRIME WITH SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER "**P60G2**" PER SPECIFICATON.
10. PAINT SMOOTH WHITE, SHERWIN WILLIAMS "**POLANE HS-PLUS**" POLYURETHANE ENAMEL P/N F63W66.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .025
.XXX ± .010

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 ASTM a500 Grade-B

FINISH 125 µinch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO

SUB-SYSTEM SEI

NEXT ASSY D1002124

PART NAME Support Tube, Stand, Test, BSC-ISI+Quad + HAM-ISI, aLIGO

DESIGNER	SBARNUM	10 Aug 2010	SIZE	DWG. NO.	REV.
DRAFTER	SBARNUM	17 Aug 2010	D	D1002127	v2
CHECKER	MHILLARD	19 OCT 2010			
APPROVAL	KMASON	20 OCT 2010	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1

D1002127 Support Tube, Stand, Test, BSC-ISI+Quad + HAM-ISI, aLIGO, PART PDM REV: X-000, DRAWING PDM REV: X-000