



NOTES: (UNLESS OTHERWISE SPECIFIED)

- Clean up and remove sharp edges.
- Liquid Contaminants/Machining Lubricants
Liquids containing hydrocarbons or other contaminants, other than the machining fluids specified herein, shall not be allowed to come into contact with suspension material at any time. All machining fluids shall be water soluble and free of sulfur, chlorine and silicone; such as Cincinnati Milacron's Citreth 410 (stainless steel).
- Identification - Serial Number
A serial number shall be etched, or scribed on the part see note drawing note.
- Serial Number Format
The Serial number shall be of the format: D99xxx-x (2)
- Example: D990021-A-001
The drawing number, The revision number, The sequential part number
- BAG AND TAG PARTS**

4	1	-	-	-
3	2	-	-	-
2	1	-	-	-
1	1	-	-	-
REF.	QTY.	PART or DRWG No.	NOMENCLATURE or DESCRIPTION	MATERIAL

Qty: Make 8 Total Per Assembly

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TOLERANCES: FRACTIONAL ± / ANGULAR ± 2 deg ANGULARWASH ± BEND ± / TWO PLACE DECIMAL ± .02		THREE PLACE DECIMAL ± .005 FINISHED SURFACE RMS / BREAK CORNERS IN (D1) / REMOVE ALL BURRS /		HEAT TREAT /		FINISH /	
MATERIAL: .008 Stainless Steel Shim Stock Full hard		USED IN XXX		NEXT ASSY: XXX		REV		DESCRIPTION	
DRAWG. NO.		DESCRIPTION		REFERENCE DRAWINGS		ISSUE DESCRIPTION		SCALE	

PARTS and MATERIAL LIST									
B	Title and Material change		LIGO-E000233-00-D	kern	4-26-00				
A	For Fabrication		LIGO-E000219-00-D	kern	4-19-00				
00	PRE-RELEASE		-	kern	4/19/00	JOB FILE			
REV	DESCRIPTION		ISSN NUMBER	APPR'D	CHECK	DRWN	DATE	SCALE	D000175-B
								4X	D000175-B
								B	D000175-B
								4X	SHEET#

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
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HAM BEAM DUMP CLAMP