

NOTES: (UNLESS OTHERWISE SPECIFIED)

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 Cimtech 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: D99xxxx-x-001

Example: D990021-A-001

The drawing number, The revision number, The sequential part number

Make From
 Opto Sigma
 PN: 148-3410

*Dis-Assemble and Strip Anodizing

*Replace existing Thumb Screw as shown

*Remove Clamp

Replace Thumb Scr and Washer w/5mm SHCS x ~.75" or 18/19mm lg. Mat'l S Stl

Existing Part (see note)

Remove Clamp - Do Not RE-Use

Remove Existing Screw and Washer

REF	QTY	PART or DRWG No.	DESCRIPTION	MATERIAL
PARTS and MATERIAL LIST				

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN FEET (cm)			
TOLERANCES: FRACTIONAL ±1/16 ANGULAR ±.25° ANGULAR/HATCH/BEND ±.01 TWO PLACE DECIMAL ±.01		THREE PLACE DECIMAL ±.005 FINISHED SURFACE RMS 63 BREAK CORNERS IN: .015 OUT: .015 REMOVE ALL BURRS	
XXX	XXX	MATERIAL: See Note	HEAT TREAT: -
DWG. NO.	DESCRIPTION	USED ON: XXX	NEXT ASS'Y: XXX

REV	DESCRIPTION	DCN NUMBER	APPR'D	CHECK	DRWN	DATE
A	For Fabrication				KENM	12-1-99
00	PRE-RELEASE	-	-	-	KENM	1-31-99

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY			
ETM BEAM DUMP POST BRACKET			
CAD FILE D990465-A	SIZE C	DWG. NO. D990465-A	
SCALE FULL	SHEET	SHEET#	