

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

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO
EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL.
AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

12. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

13. PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION. THE INDICATED HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING TO APPROXIMATELY 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF THE HOLE.

14. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.

15. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.

FLANGE	SUBFLANGE	FLANGE TYPE	CONNECTOR	SUBSYSTEM	DESCRIPTION
F2-1C1	-1	C	25D-1	ISC	ISC - PICOMOTORS
F2-1C2	-1	C	25D-2	ISC	ISC - ETM TRANSMON 1064nm
F2-2C1	-2	C	25D-1	ISC	ISC - ETM TRANSMON 532nm
F2-2C2	-2	C	25D-2	ISC	ISC - TRANSMON BEAM DIVERTER
F2-3E1A	-3	E	5 WAY COAX-1A	SUS	SUS - ESD FOR QUAD 1
F2-3E1B	-3	E	5 WAY COAX-1B	SUS	SUS - ESD FOR QUAD 1
F2-3E1C	-3	E	5 WAY COAX-1C	SUS	SUS - ESD FOR QUAD 1
F2-3E1D	-3	E	5 WAY COAX-1D	SUS	SUS - ESD FOR QUAD 1
F2-3E1E	-3	E	5 WAY COAX-1E	SUS	SUS - ESD FOR QUAD 1

FLANGE	SUBFLANGE	FLANGE TYPE	CONNECTOR	SUBSYSTEM	DESCRIPTION
E2		BLANK			-- BLANK (FULL FLANGE) --