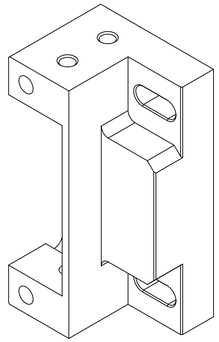
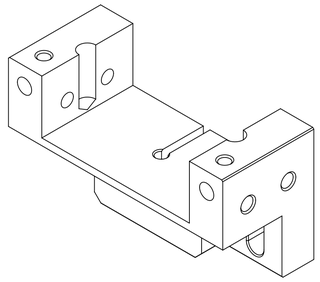
**NOTES CONTINUED:**

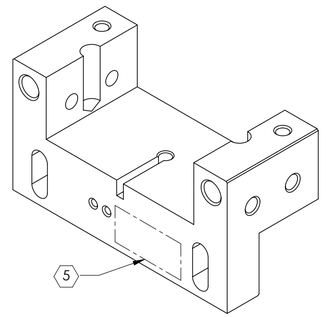
Ⓢ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

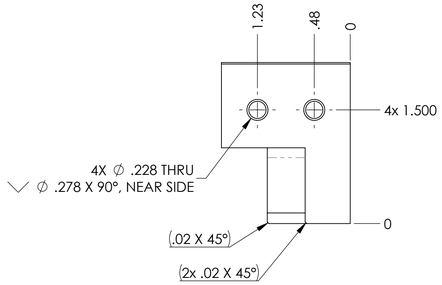
6. APPROXIMATE WEIGHT = .58 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART 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.

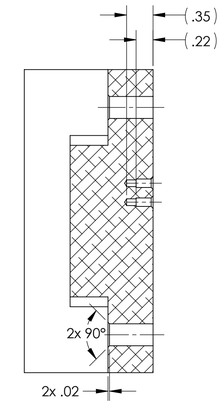
| REV. | DATE | DCN # | DRAWING TREE # |
|---|---|---|---|
| V1 | - | - | - |
| v2 | 13 NOV 2013 | E1300835-x0 | - |
| - | - | - | - |



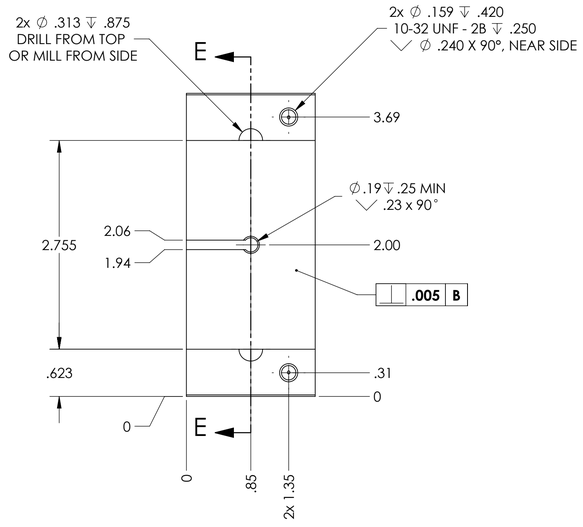


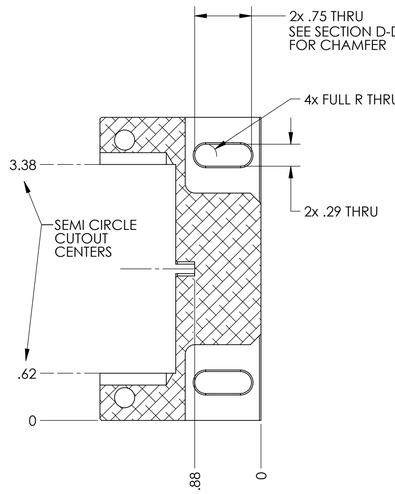


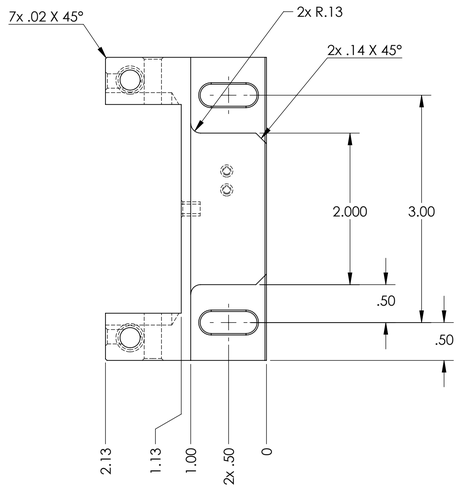



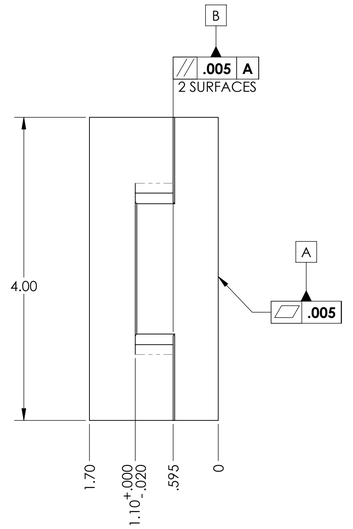

**SECTION D-D**

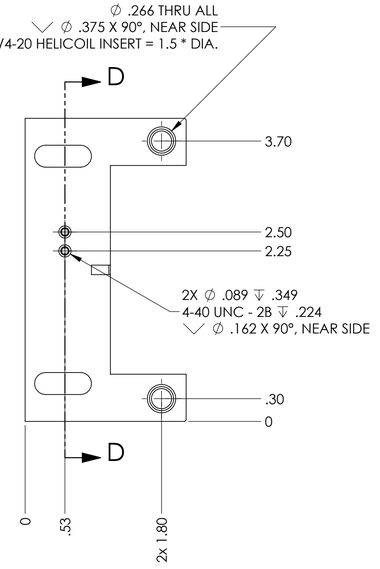


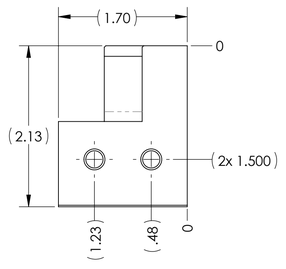




**SECTION E-E**




| NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>.XX ± .01<br>.XXX ± .005<br>ANGULAR ± .5° | 1. INTERPRET DRAWING PER ASME Y14.5-1994.<br>2. REMOVE ALL SHARP EDGES .005-.015.<br>3. DO NOT SCALE FROM DRAWING.<br>4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. | | LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY | | PART NAME: ISC Fast Shutter Bracket aLIGO | | | | |
| | | | SYSTEM: ADVANCED LIGO | SUB-SYSTEM: ISC | DESIGNER: SBARNUM | MAY 2013 | SIZE: D | DWG. NO.: D1003324 | REV.: v2 |
| | MATERIAL: 6061-T6 Al | FINISH: 63 µinch | NEXT ASSY: D1003318 | | DRAFTER: SBARNUM | MAY 2013 | | | |
| | | | | | CHECKER: JLEWIS | | | | |
| | | | | | APPROVAL: PFRITSCHEL | | SCALE: 1:1 | PROJECTION: | SHEET 1 OF 1 |

D1003324 ISC Fast Shutter Bracket aLIGO, PART PDM REV= X.X02, DRAWING PDM REV= X.X01