NOTES CONTINUED:

(5) MECHANICALLY STAMP (NO INKS OR DYES) PART NUMBER, REVISION AND SERIAL NUMBER .20 DEEP WITH MINIMUM CHARACTER HEIGHT .156 APPROXIMATELY WHERE SHOWN. SERIAL NUMBER WILL START AT 001 AND PROCEED CONSECUTIVELY.
EXAMPLE: D100XXX-V1
S/N 001

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

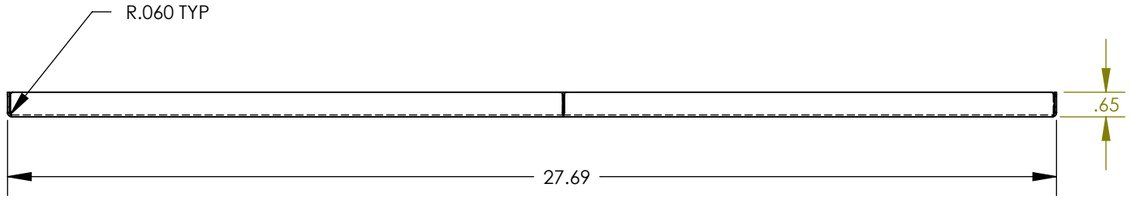
7. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

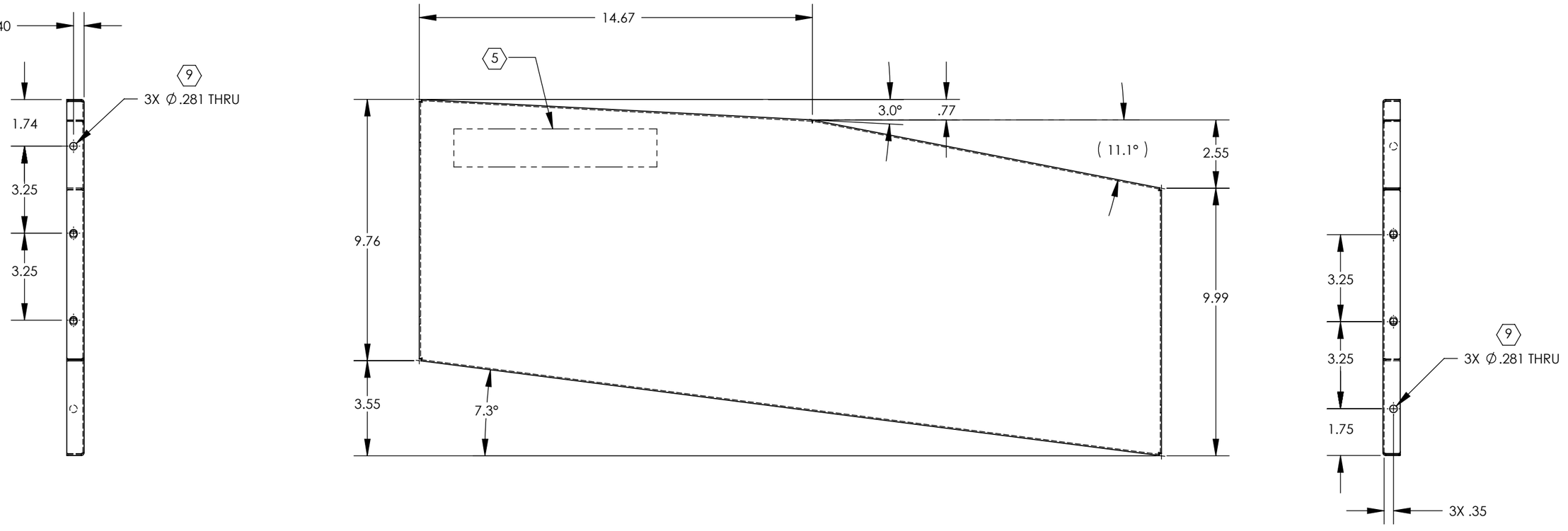
(8) SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

(9) 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.

10. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.

REV.	DATE	DCN #	DRAWING TREE #
v1	14 MAR 2011	E1000216	-
-	-	-	-
-	-	-	-





NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)							
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .02 .XXX ± .005 ANGULAR ± 1.0°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELEY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 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: ACB RIGHT SIDE EXTENDER		
	MATERIAL: 18 GA ENAMEL STEEL A424	FINISH: (8) (9)	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	DESIGNER: N.Nguyen 24 Feb 2011 DRAFTER: N. KILPATRICK 13 MAR 2011 CHECKER: APPROVAL:	SIZE: B	DWG. NO.: D1100354 REV.: v1 SCALE: 1:4 PROJECTION: SHEET 1 OF 1
			NEXT ASSY: D1100359				

D1100354_AdLIGO_AOS_SLC ACB Right Side Extender, PART PDM REV: X-005, DRAWING PDM REV: