

8

7

6

5

4

3

2

1

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.

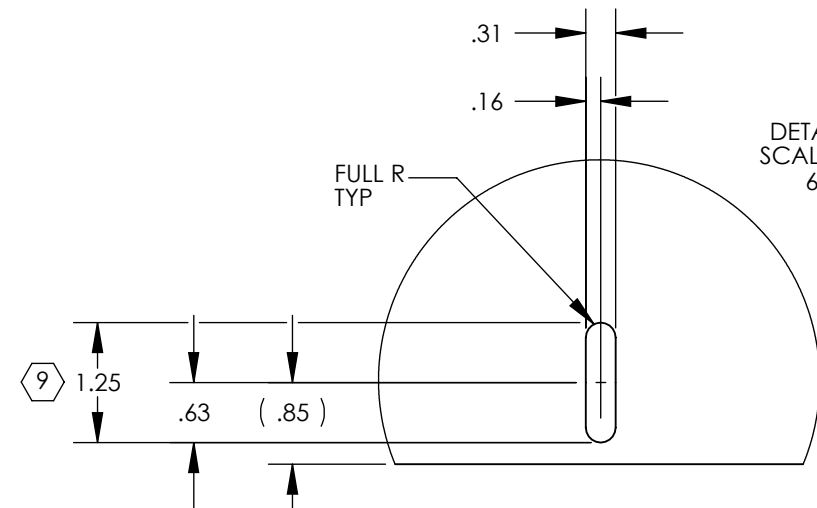
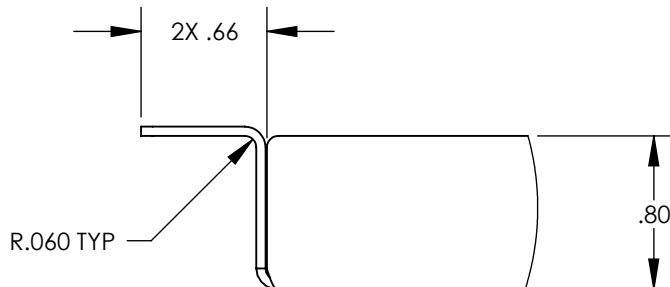
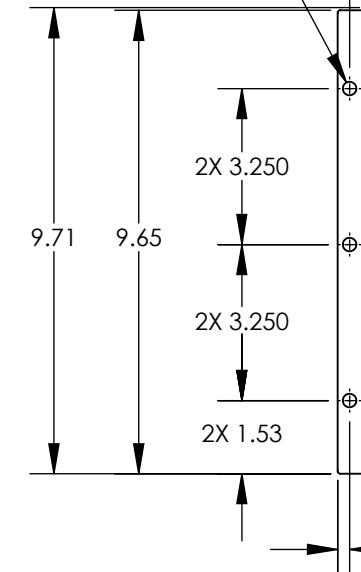
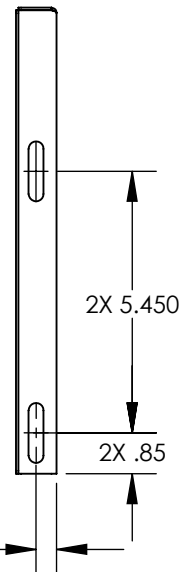
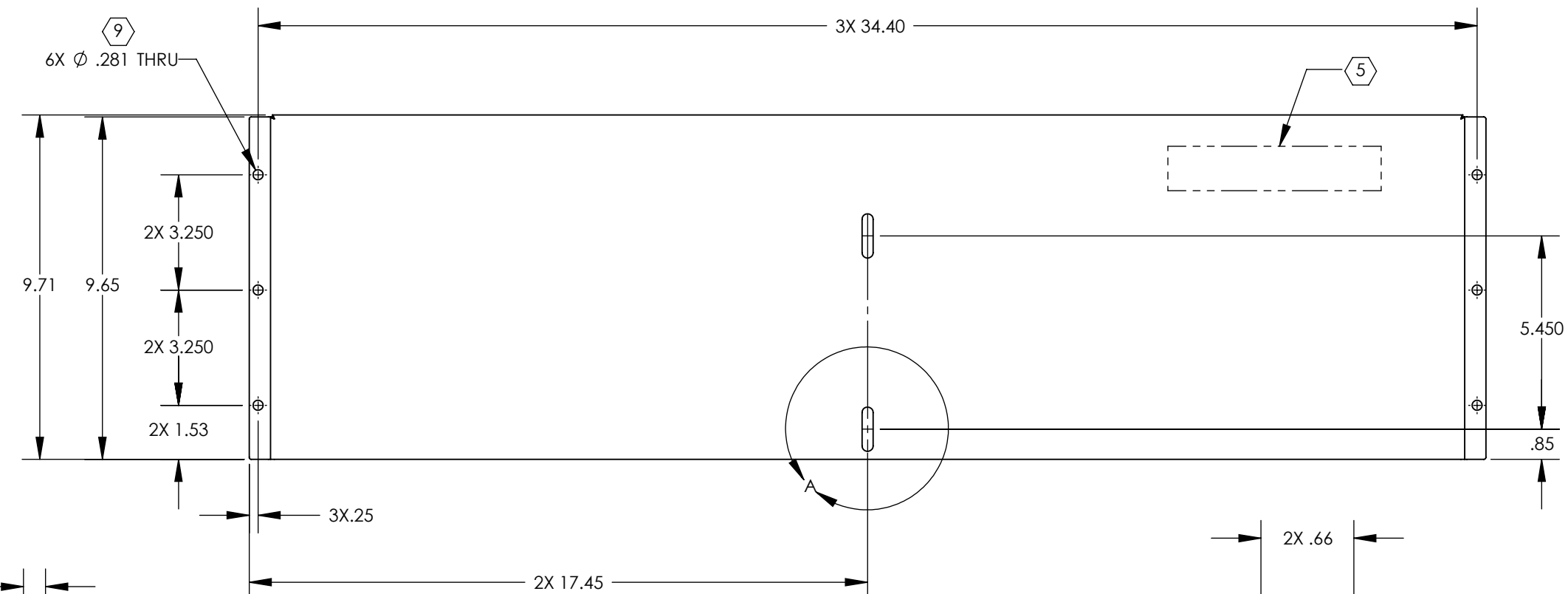
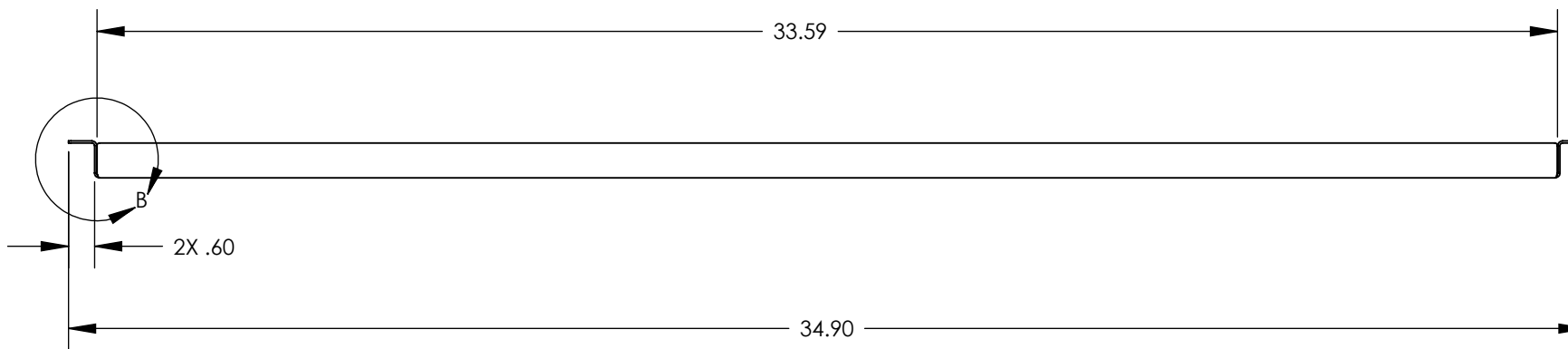
7. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

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 AND SLOTS WILL BE MASKED PRIOR TO PORCELAIN COATING TO APPROXIMATELY 2.5-3X HOLE AND SLOT CENTERED ON BOTH SIDES OF THE HOLE AND SLOT.

10. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.

REV.	DATE	DCN #	DRAWING TREE #
v1	13 MAR 2011	E1100216	-
-	-	-	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .02
 .XXX ± .005

ANGULAR ± 1.0°

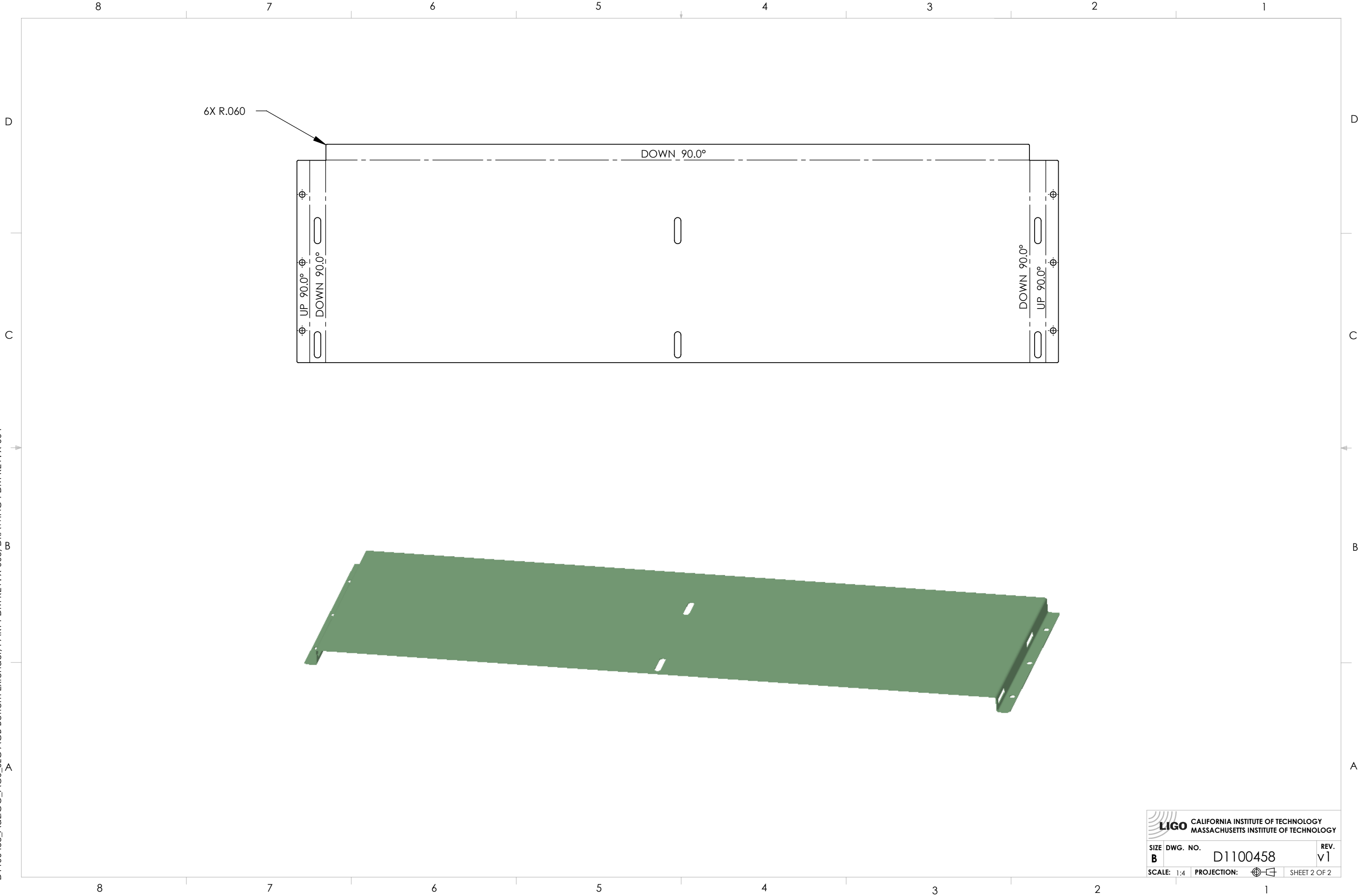
1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
 3. DO NOT SCALE FROM DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.


CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
DESIGNER	N.Nguyen	17 Feb 2011	SIZE DWG. NO.
DRAFTER	N. KILPATRICK	13 MAR 2011	B
CHECKER			D1100458
APPROVAL			REV. v1
MATERIAL		NEXT ASSY	
18 GA ENAMEL STEEL A424		D1100359	
FINISH		SCALE: 1:4	
		PROJECTION:	
		SHEET 1 OF 2	

D1100458_AdlIGO_AOS_SLC_ACB Bottom Extender, PART PDM REV: X-003, DRAWING PDM REV: X-004

8 7 6 5 4 3 2 1

D1100458_AcLIGO_AOS_SLC_ACB Bottom Extender, PART PDM REV: X-003, DRAWING PDM REV: X-004



 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
B	D1100458	v1
SCALE: 1:4	PROJECTION:	SHEET 2 OF 2