

NOTES CONTINUED:

5 SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
 EXAMPLE (PART): 001-v1
 EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD

6 DIMENSION SPECIFICATIONS:
 NOMINAL I.D.: 2.30
 NOMINAL O.D.: 2.99
 THICKNESS: .060

7 MATERIAL:
 PEEK, VICTREX GRADE 450G OR SIMILAR
 OR
 TEFLON PFA TYPE 450

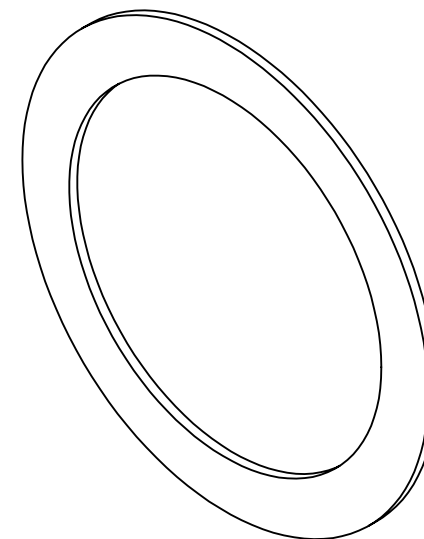
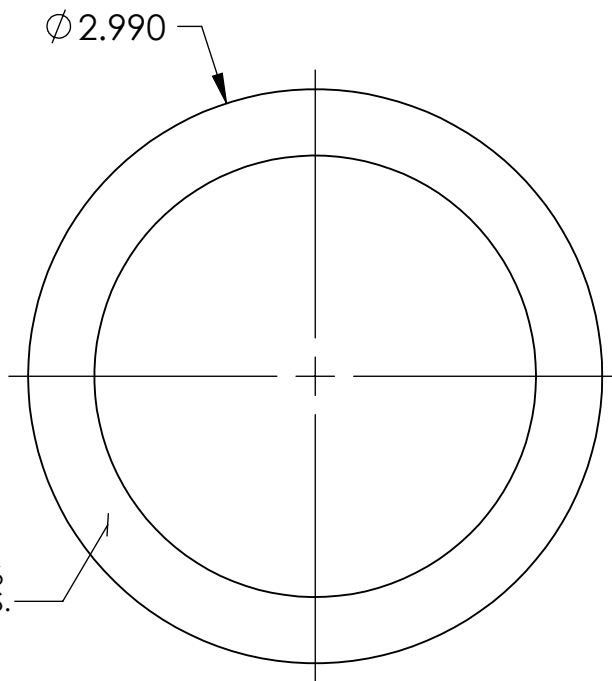
8 FINISHED PART TO BE CLEANED IN ACCORDANCE WITH LIGO-E960022.

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

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

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

REV.	DATE	DCN #	DRAWING TREE #
v2	22 AUG 2011	E1100655-v1	E1100656-v1
-	-	-	-
-	-	-	-



SEE NOTE 6 FOR SPECS.

.060^{+0.005}
 -.000

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:

.XX ± .01
 .XXX ± .005

ANGULAR ± 1.0°

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

MATERIAL

SEE NOTE 7

FINISH

N/A μinch D1003194, D1100493, D1100494



CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM

ADVANCED LIGO

SUB-SYSTEM

AOS

PART NAME

WASHER, CLAMP RING

DESIGNER

A. LANGLEY 15 MAR 2011

DRAFTER

E. SANCHEZ 19 APR 2011

CHECKER

M. JACOBSON 22 AUG 2011

APPROVAL

D. COYNE 23 AUG 2011

SIZE

A

DWG. NO.

D1100495

REV.

v2

SCALE: 1:2

PROJECTION:



SHEET 1 OF 1