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
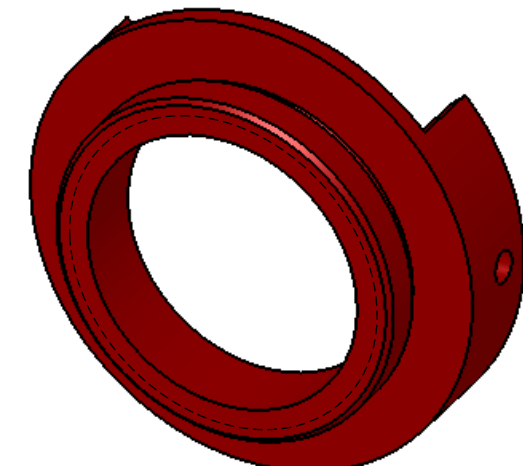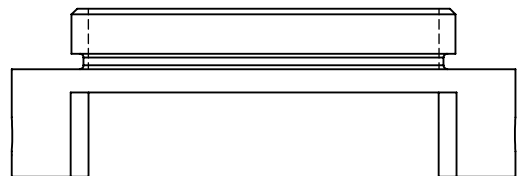EXAMPLE (TAG): DXXXXXXX-VY, TYPE-XX, QTY: TBD

6. APPROXIMATE WEIGHT= .033 BL.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
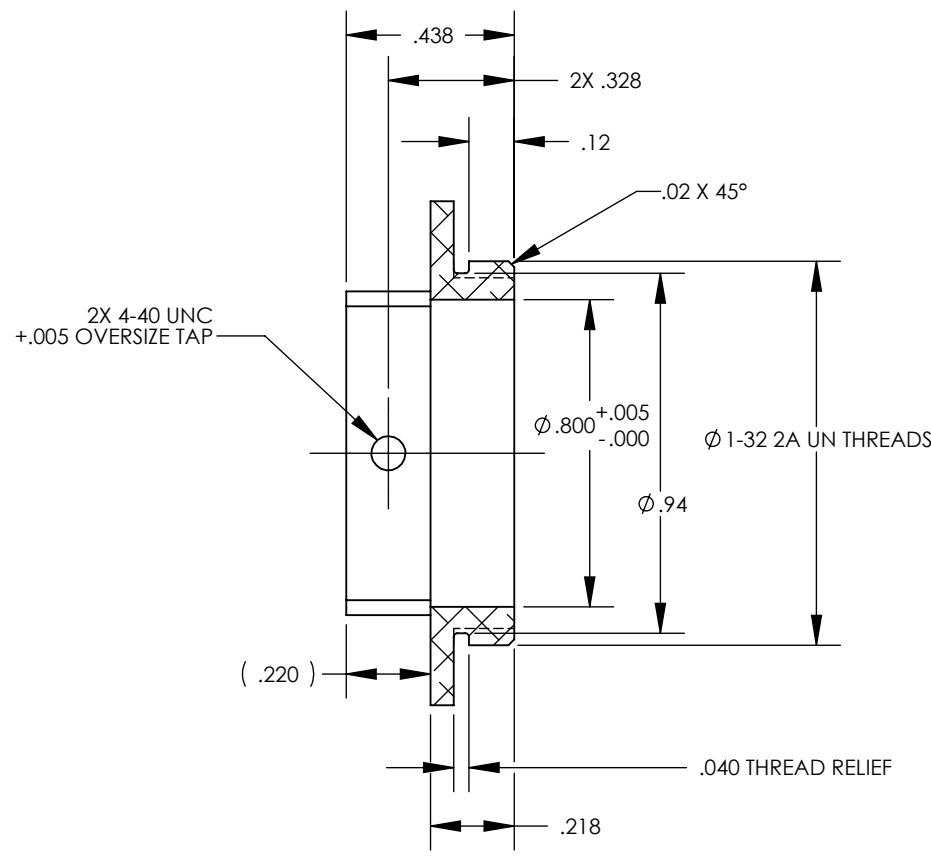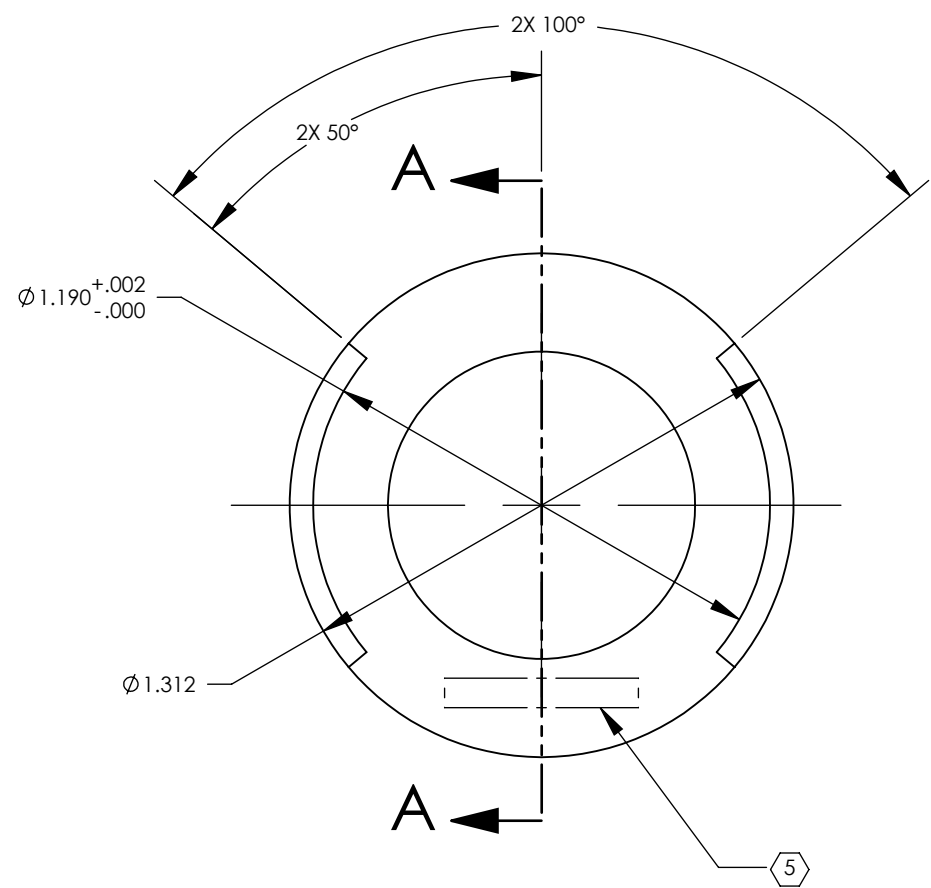
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL 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	30 MAR 2011	-	-
v2	4 JUN 2012	E1000563	-
-	-	-	-

2X 100°
2X 50°

A

Ø 1.190 +.002 / -.000
Ø 1.312

A

⑤

.438
2X .328
.12
.02 X 45°

2X 4-40 UNC +.005 OVERSIZE TAP

Ø .800 +.005 / -.000
Ø .94
Ø 1-32 2A UN THREADS

(.220)
.040 THREAD RELIEF
.218

SECTION A-A

GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN

TOLERANCES:
.XX ±
.XXX ±

ANGULAR ± °

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATLEY 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.

MATERIAL	FINISH
304, 316 OR 302 SSTL	N/A μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS

NEXT ASSY
D1001918 & D1001963

PART NAME
IRIS DIAPHRAGM MOUNT

			SIZE	DWG. NO.	REV.
DESIGNER	M. RUIZ	30 MAR 2011	B	D1100556	v2
DRAFTER	M.RUI	30 MAR 2011			
CHECKER					
APPROVAL			SCALE: 2:1	PROJECTION:	SHEET 1 OF 1