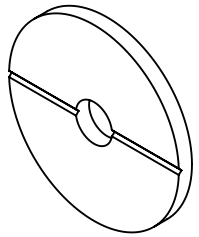
NOTES CONTINUED:

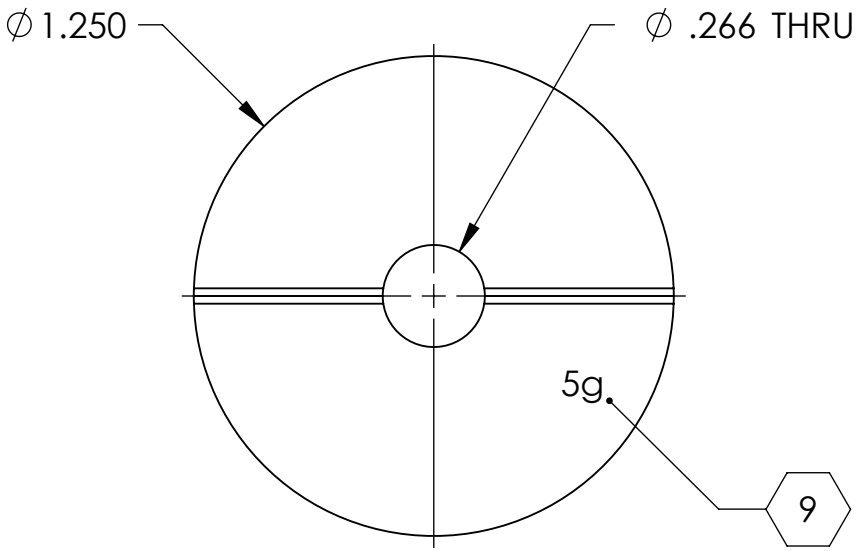
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND 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 = 5g
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

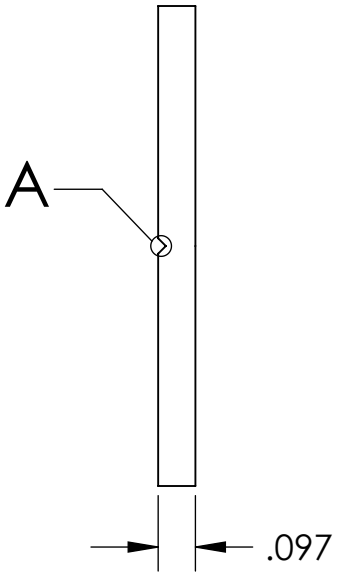
⑨ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) AS MARKED ON NOTED SURFACE. USE .12" HIGH CHARACTERS.

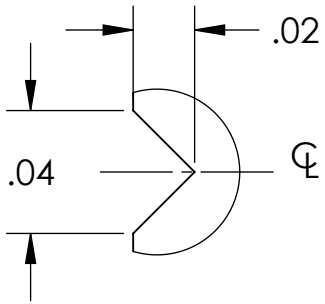
REV.	DATE	DCN #	DRAWING TREE #
v1	13 MAY 2011	E1100419	E0900353
-	-	-	-
-	-	-	-



ISOMETRIC VIEW







DETAIL A
SCALE 16 : 1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± 0.5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, R.02 MIN.
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 6061-T6 Al

FINISH 32 µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO

SUB-SYSTEM SUS

NEXT ASSY MULTIPLE

PART NAME ADD-ON MASS, 5g

DESIGNER	B. MOORE	09 MAY 2011
DRAFTER	B. MOORE	10 MAY 2011
CHECKER	M. MEYER	10 MAY 2011
APPROVAL		

SIZE A **DWG. NO.** D1100863 **REV.** v1

SCALE: 2:1 **PROJECTION:** SHEET 1 OF 1

D1100863_aLIGO_SUS_HSTS_ADD-ON MASS 5g, PART PDM REV: , DRAWING PDM REV: