

NOTES CONTINUED:

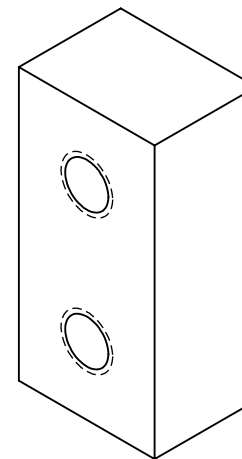
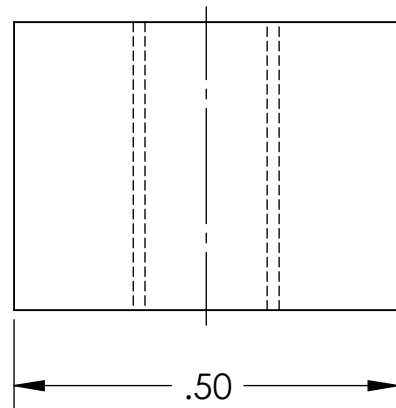
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

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

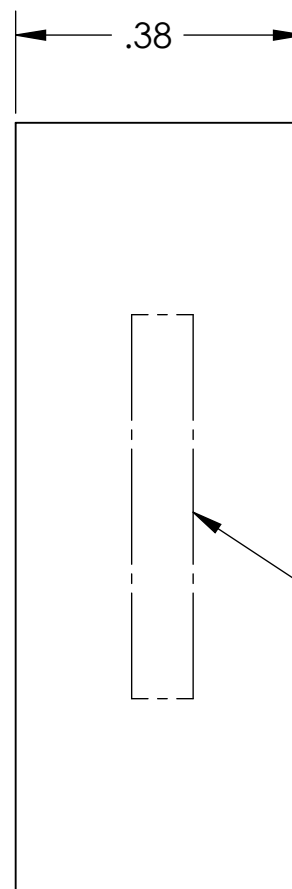
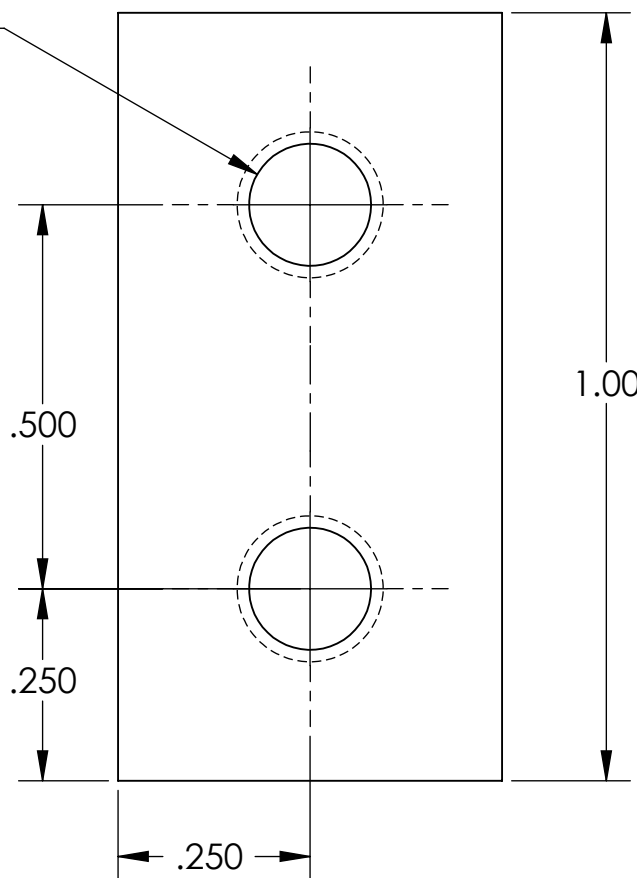
7. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

8. SURFACE FINISH TO BE MACHINED FREE FROM SCRATCHES.

REV.	DATE	DCN #	DRAWING TREE #
v1	24 MAY 2011	E1000822-v1	-
v2	18 JULY 2011	-	-
-	-	-	-



2X 10-32 UNF - 2B THRU
+.005 OVERSIZE TAP



GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES	1. INTERPRET DRAWING PER ASME Y14.5-1994.
TOLERANCES: .XX ± .03 .XXX ± .010	2. REMOVE ALL SHARP EDGES. .030 RADIUS ON ALL EDGES AND HOLES.
ANGULAR ± 0.5°	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	63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

NEXT ASSY: D1002864

PART NAME		AL APERTURE CLIP	
DESIGNER	TQ. NGUYEN	24 MAY 2011	SIZE DWG. NO.
DRAFTER	TQ. NGUYEN	24 MAY 2011	B
CHECKER	M. SMITH		D1100987
APPROVAL	D. COYNE		REV. v2
SCALE: 4:1		PROJECTION:	SHEET 1 OF 1