NOTES CONTINUED:

⑤ LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE), FOLLOWED BY 'LABEL' FROM TABLE 1 ON NOTED SURFACE. USE MINIMUM 0.2" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXX-Y, 'LABEL'

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

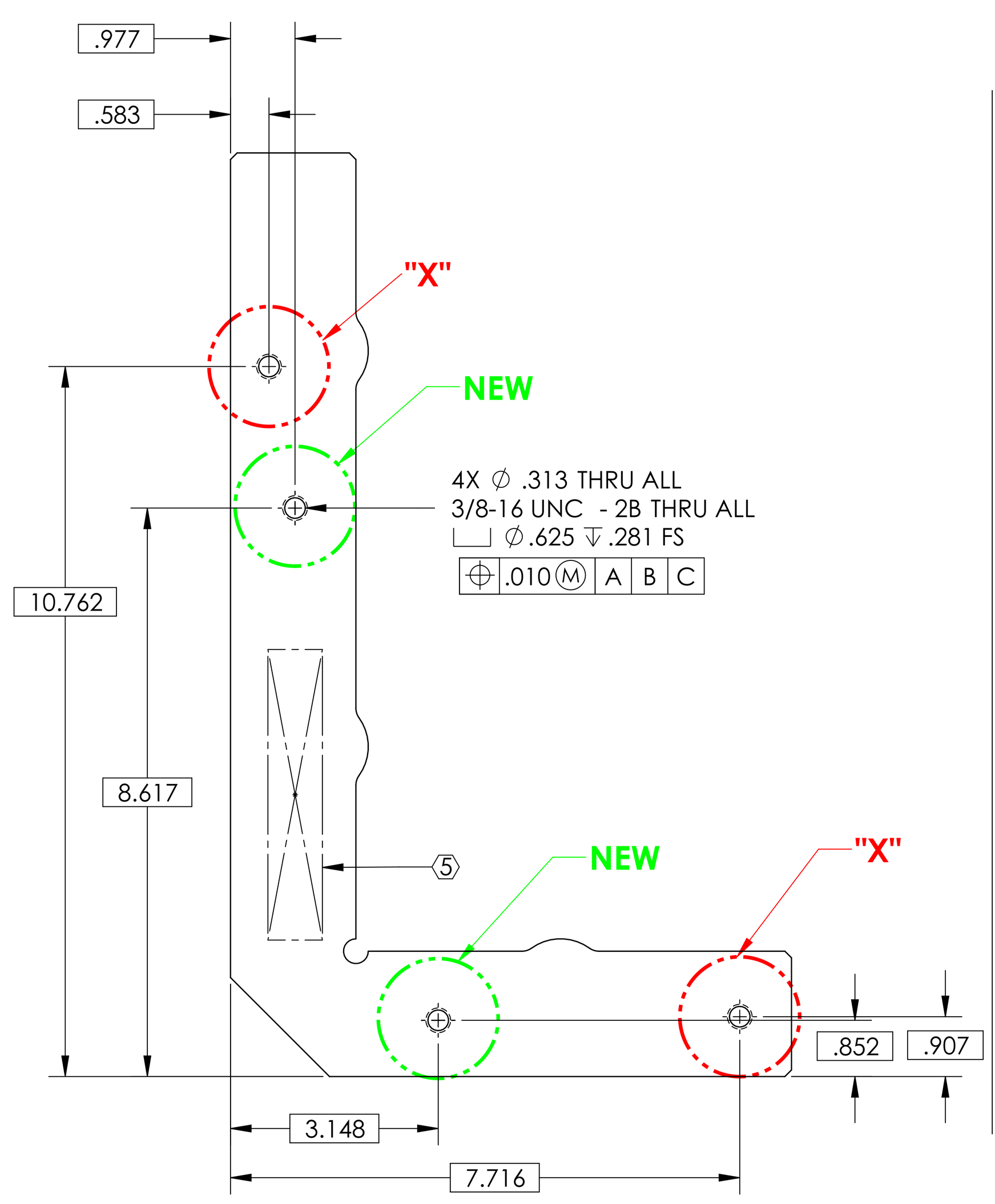
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

8. 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.

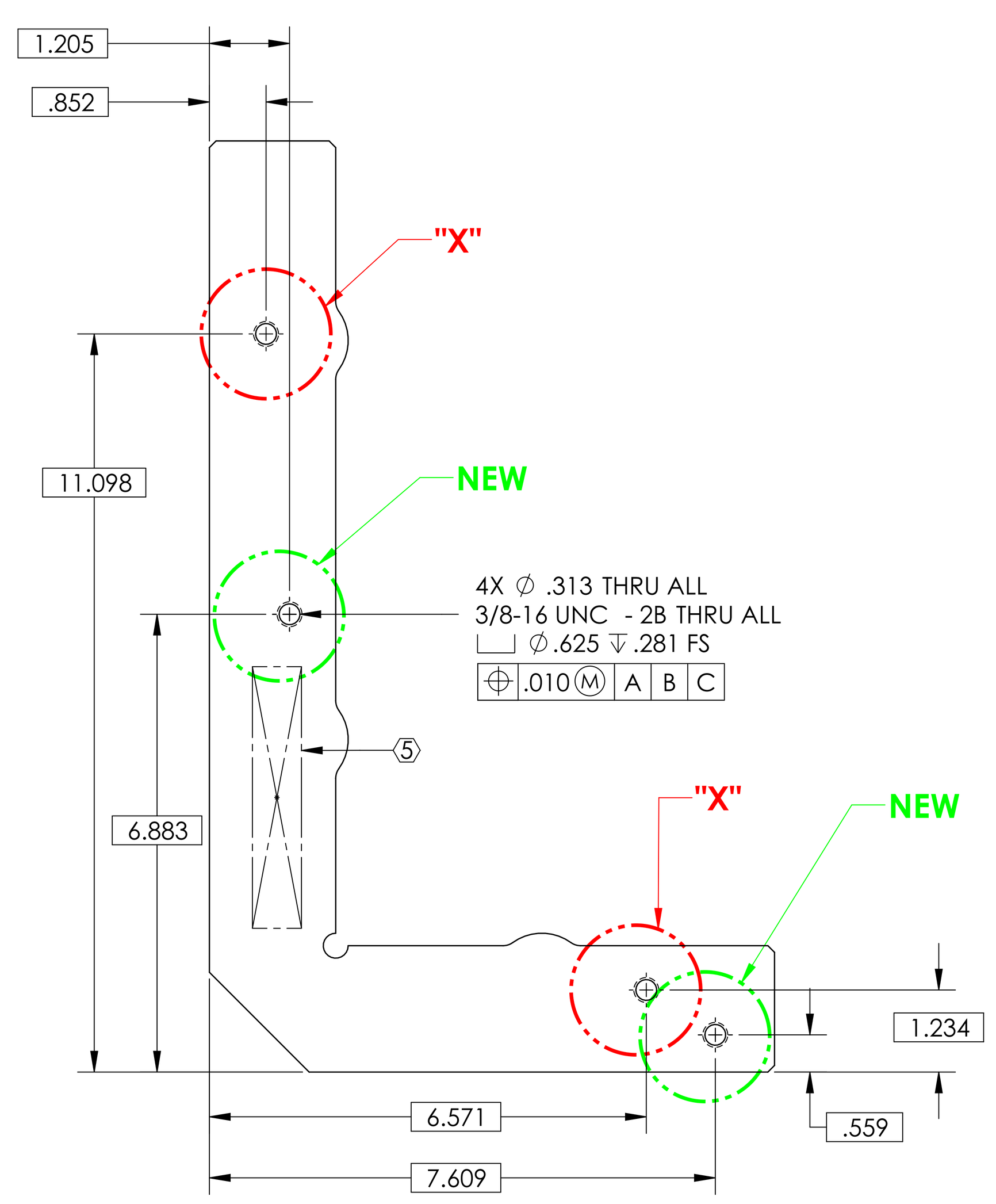
TABLE 1

'IDENTIFYING NO.'	'LABEL'
D1101048-1	BSC8-A
D1101048-2	BSC8-B
D1101048-3	BSC8-C
D1101048-4	BSC8-D
D1101048-5	BSC6-A
D1101048-6	BSC6-B
D1101048-7	BSC6-C
D1101048-8	BSC6-D

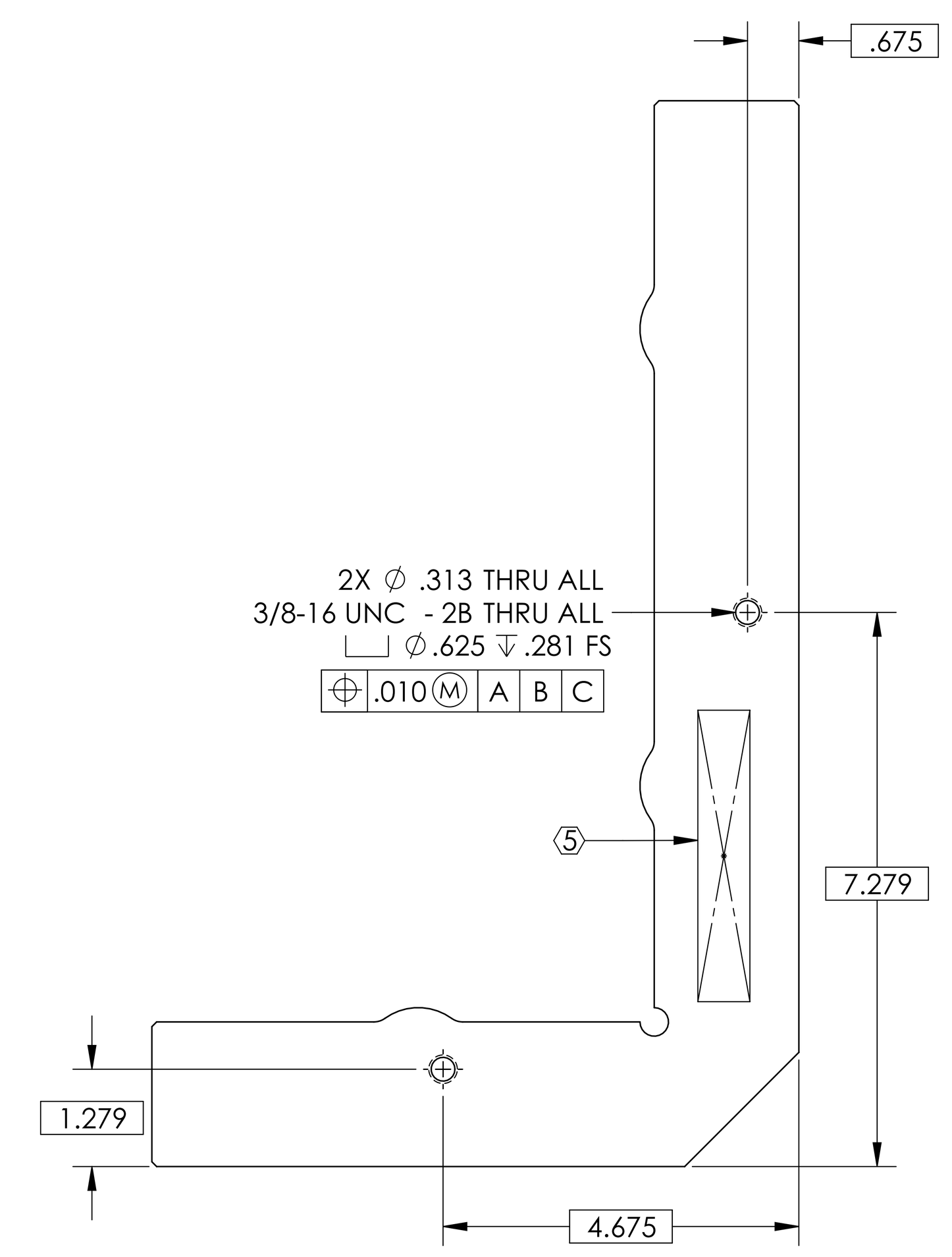
REV.	DATE	DCN #	DRAWING TREE #
v1	01 JUL 2011	E1100638-x0	-
v2	07 JUL 2011	E1100649-x0	-
v3	23 AUG 2011	E1100794-x0	-



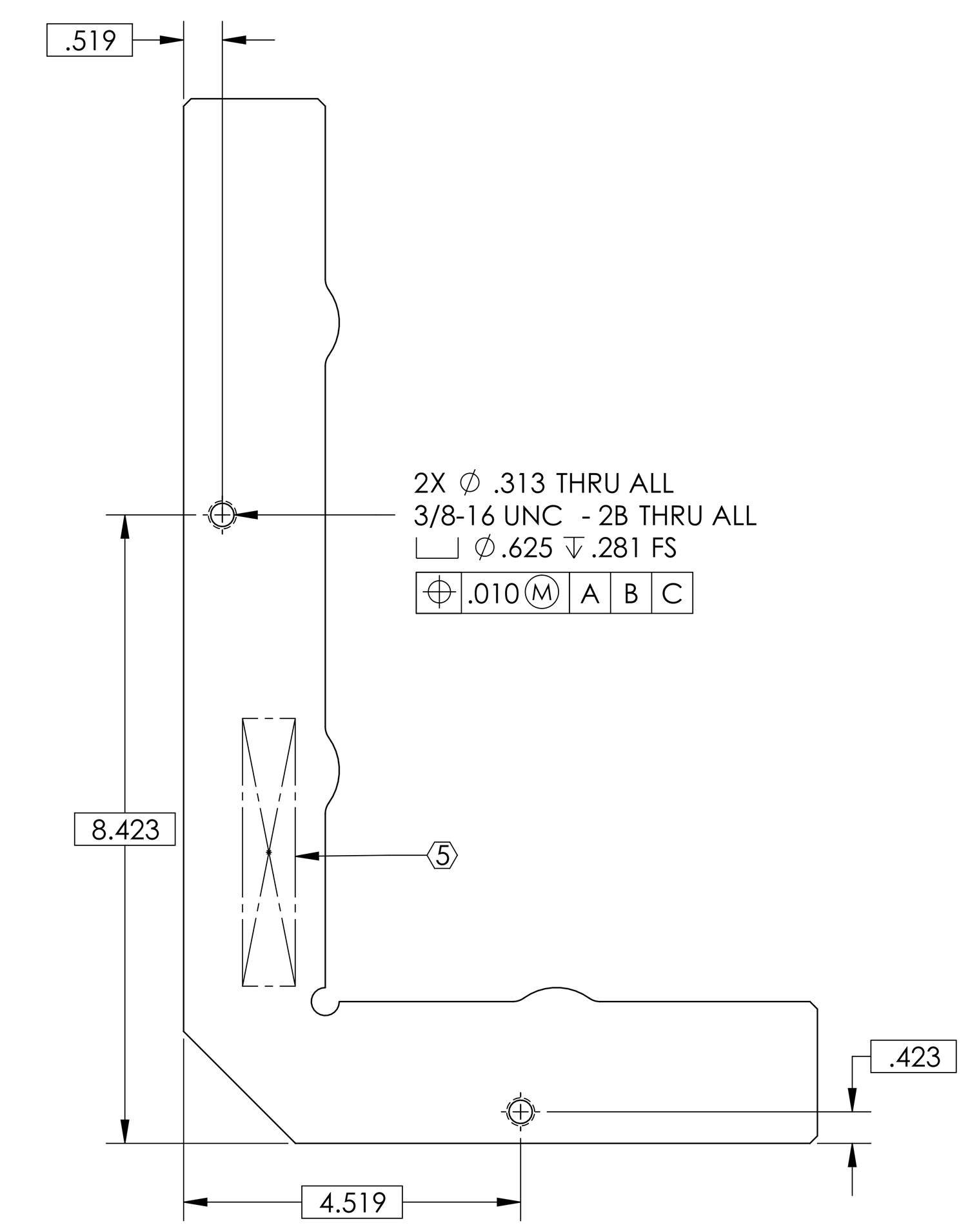
-1 DETAIL
MATERIAL: MAKE FROM BASIC
APPROXIMATE WEIGHT: 1.66 LB



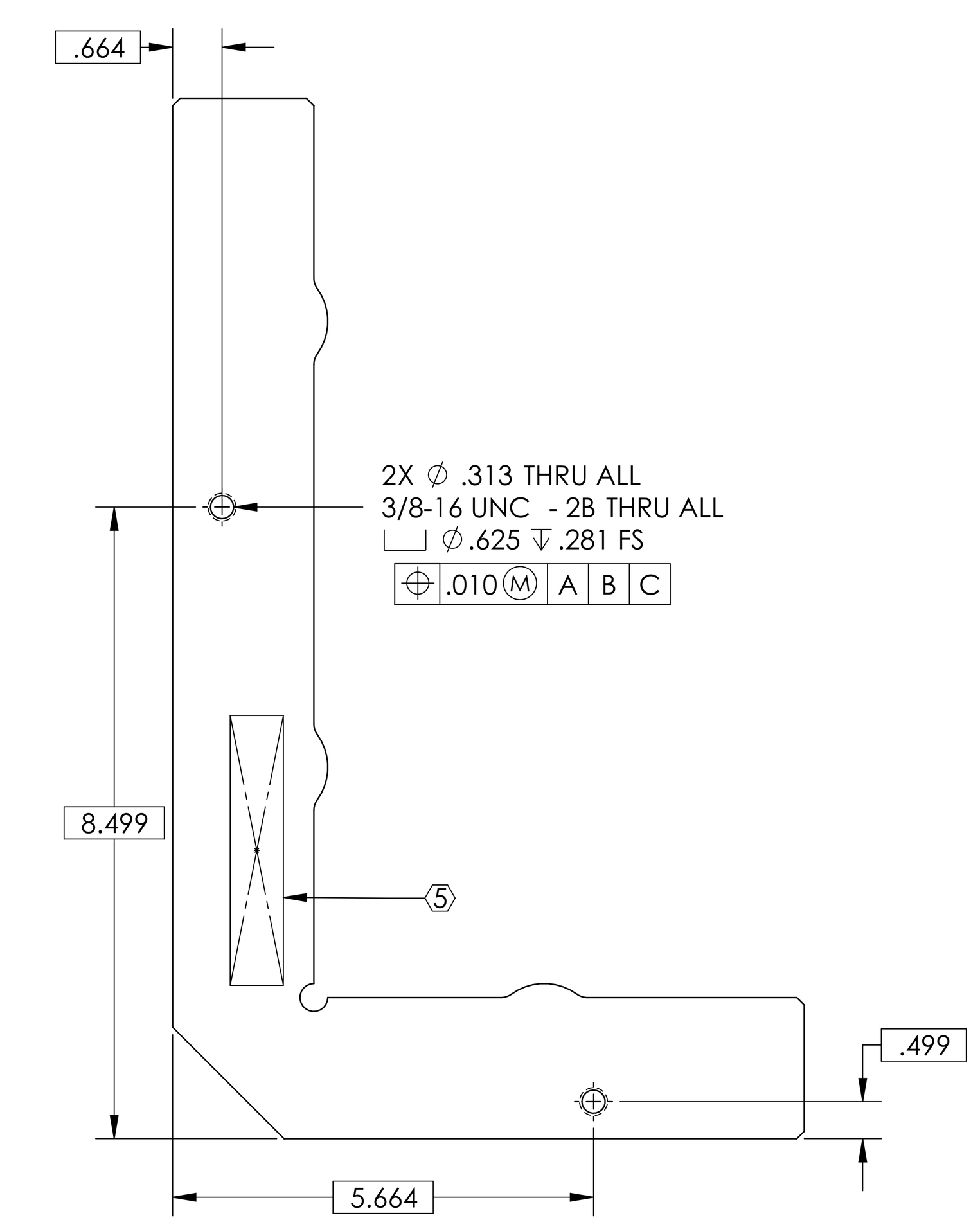
-2 DETAIL
MATERIAL: MAKE FROM BASIC.
APPROXIMATE WEIGHT: 1.66 LB



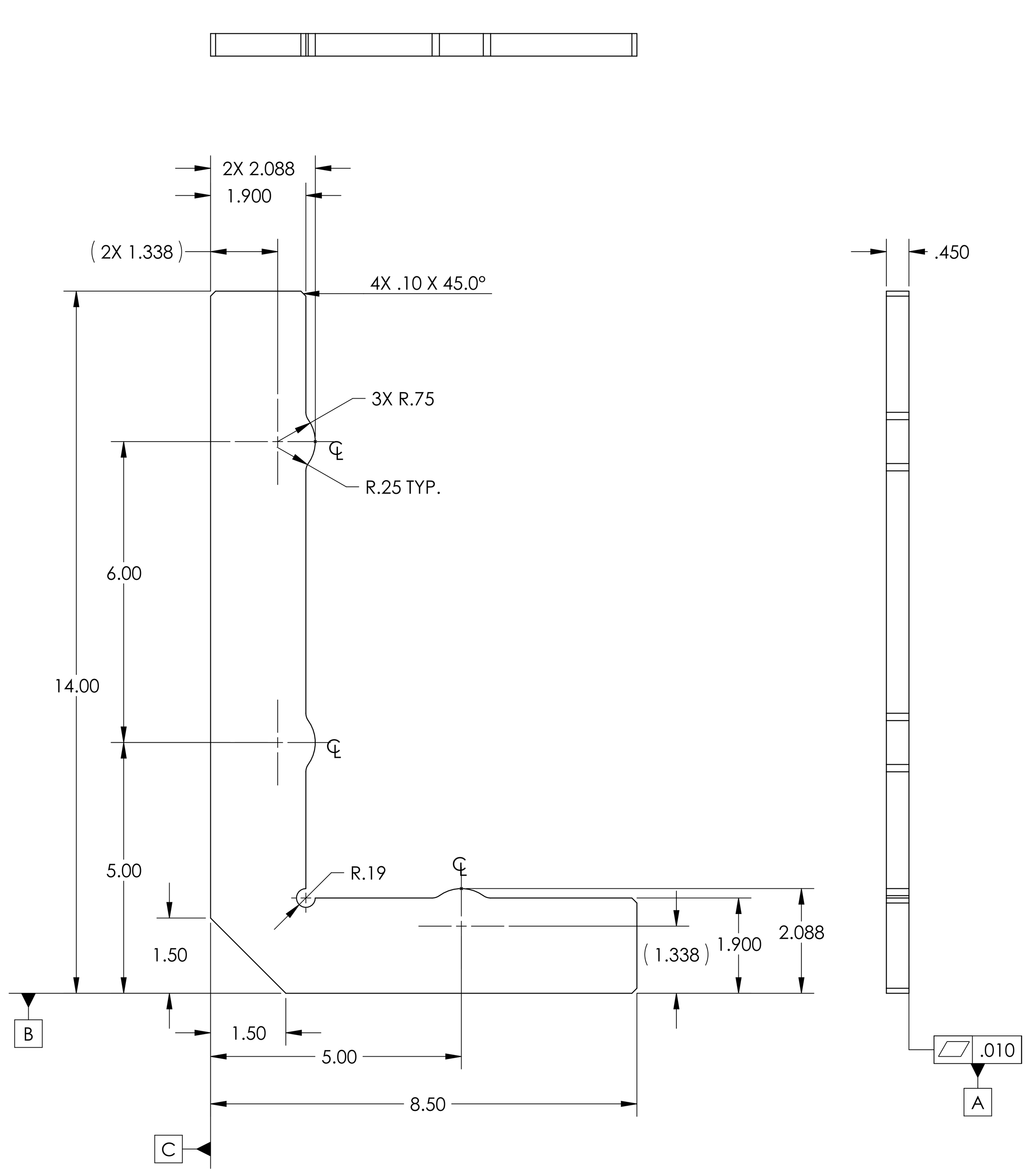
-3 DETAIL
MATERIAL: MAKE FROM BASIC
APPROXIMATE WEIGHT: 1.66 LB



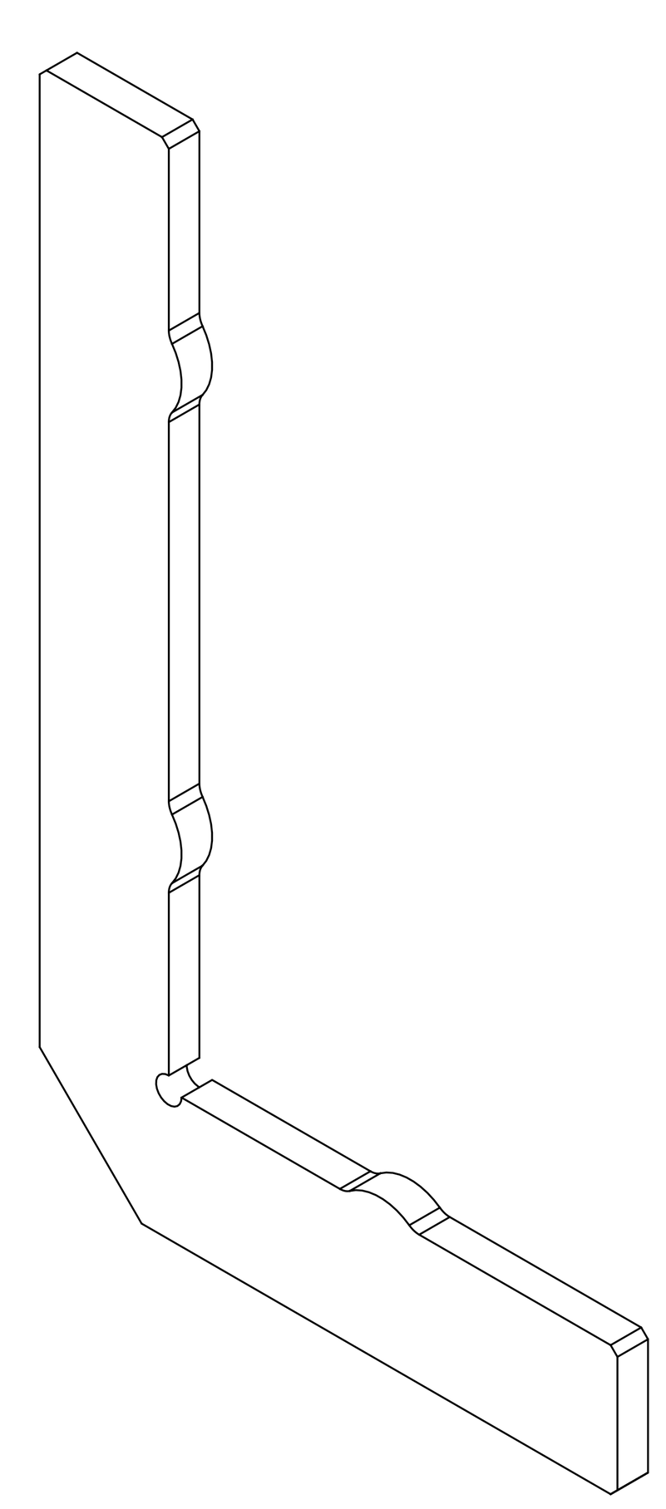
-4 DETAIL
MATERIAL: MAKE FROM BASIC
APPROXIMATE WEIGHT: 1.66 LB



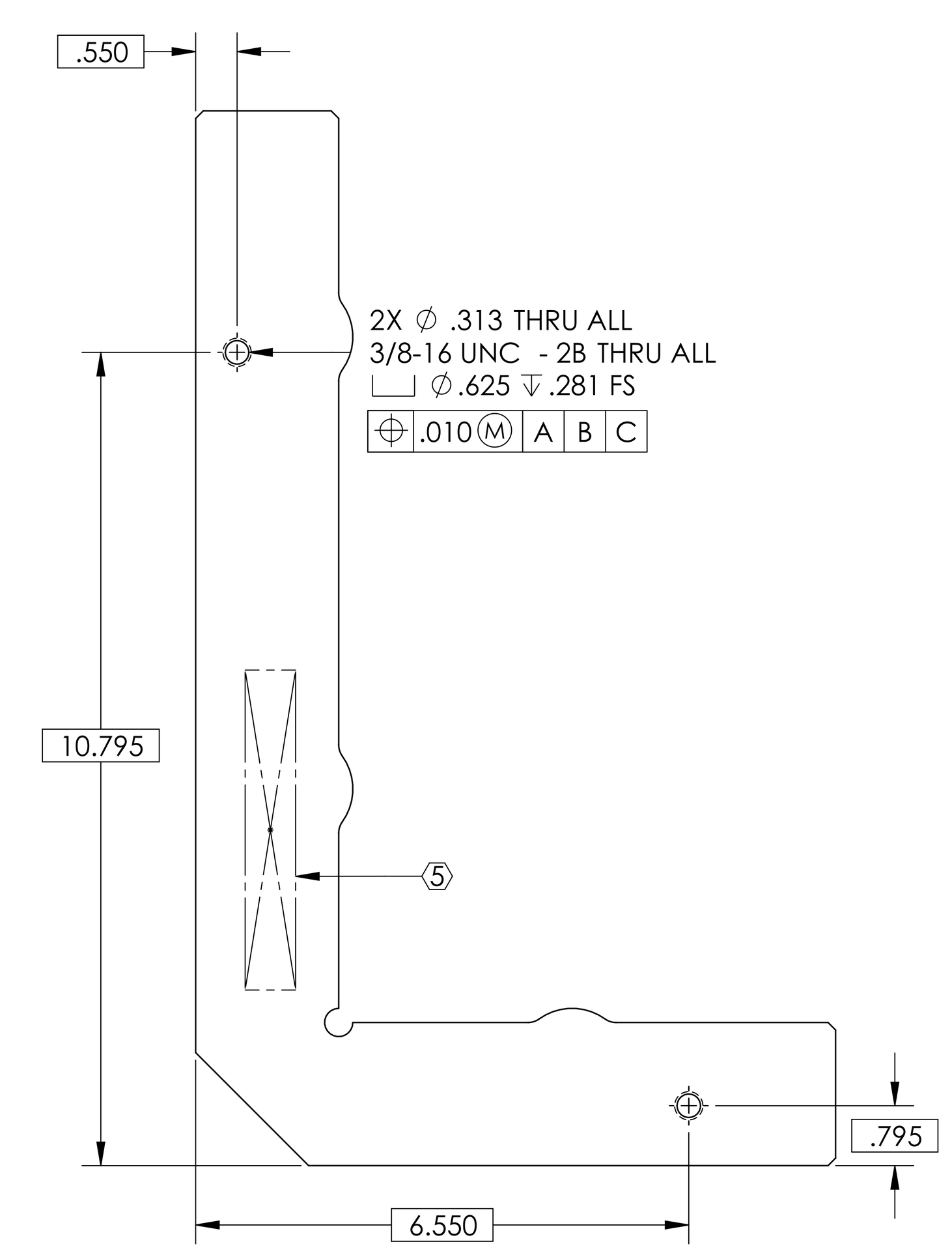
-5 DETAIL
MATERIAL: MAKE FROM BASIC
APPROXIMATE WEIGHT: 1.66 LB



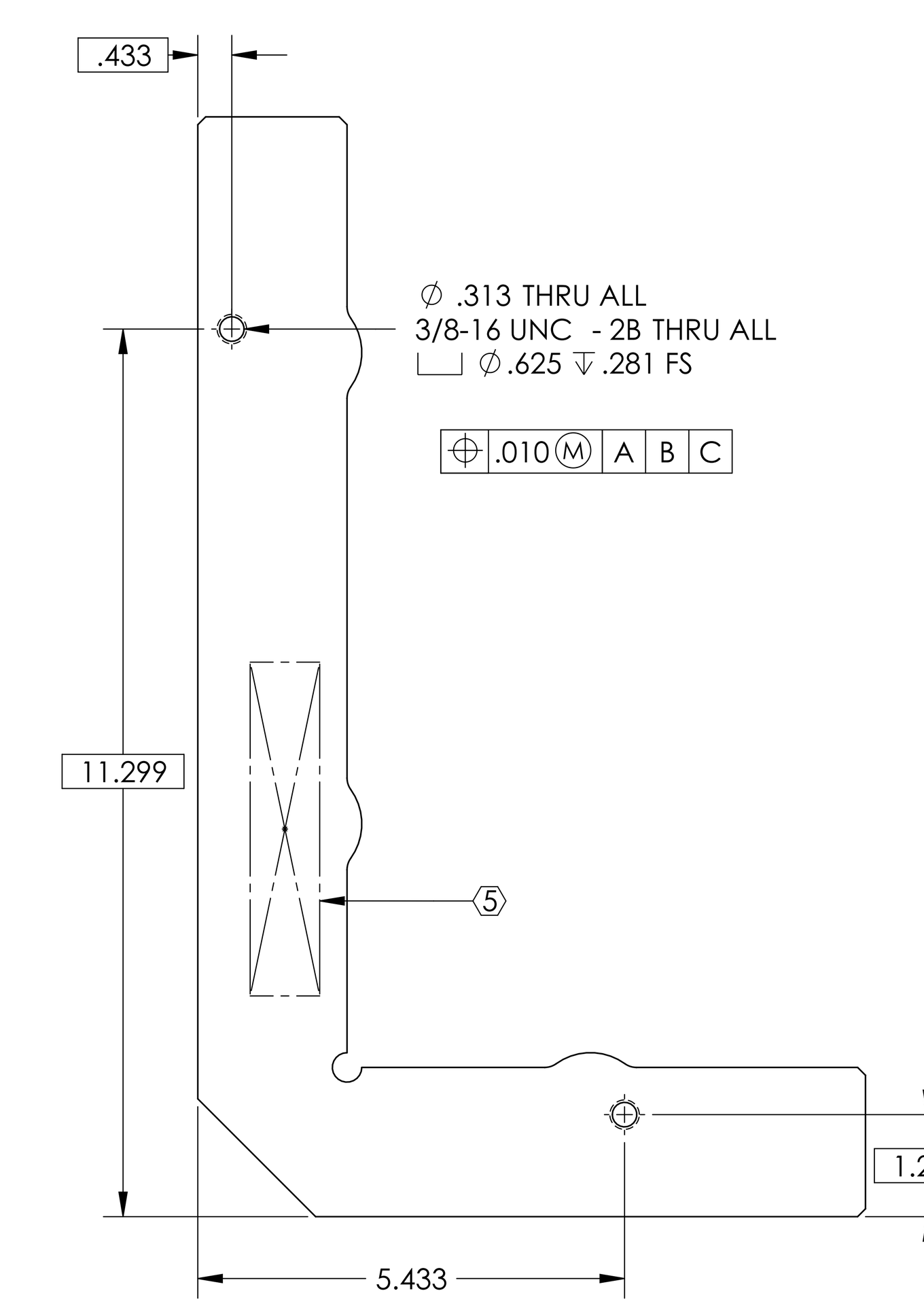
BASIC



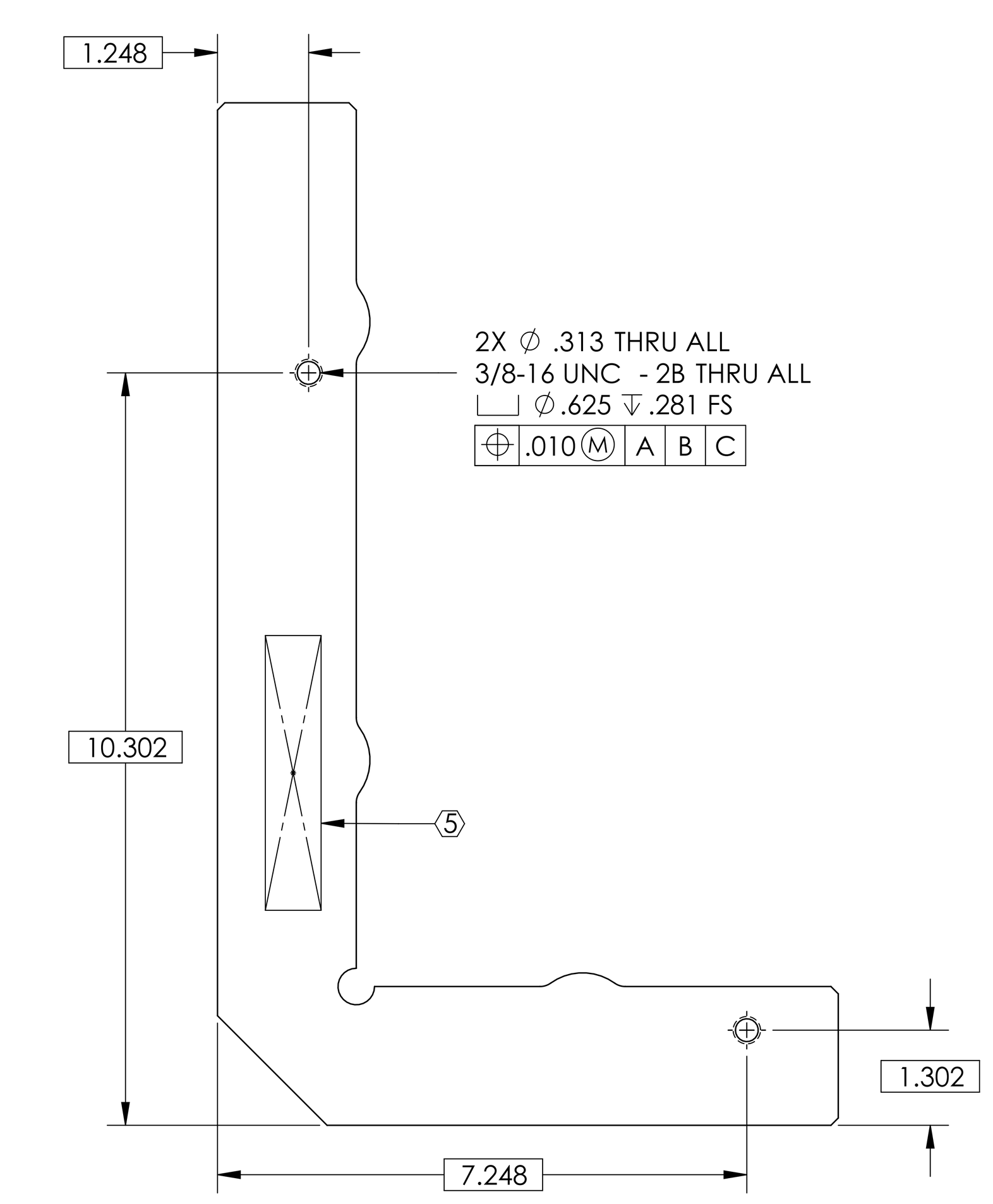
ISO VIEW
(BASIC SHOWN)
REFERENCE ONLY



-6 DETAIL
MATERIAL: MAKE FROM BASIC
APPROXIMATE WEIGHT: 1.66 LB



-7 DETAIL
MATERIAL: MAKE FROM BASIC
APPROXIMATE WEIGHT: 1.66 LB



-8 DETAIL
MATERIAL: MAKE FROM BASIC
APPROXIMATE WEIGHT: 1.66 LB

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± .5°

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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
6061-T6	63 µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM	SUB-SYSTEM
ADVANCED LIGO	SUS

NEXT ASSY: D1101050

PART NAME: ALIGO, SUS, ALIGNMENT TEMPLATE, BSC STRUCTURE

DESIGNER	S.SHANKLE	01 JUL 2011
DRAFTER	E.SANCHEZ	01 JUL 2011
CHECKER		
APPROVAL		

SIZE: E
DWG. NO.: D1101048
REV.: v3
SCALE: 1:2
PROJECTION:
SHEET 1 OF 1