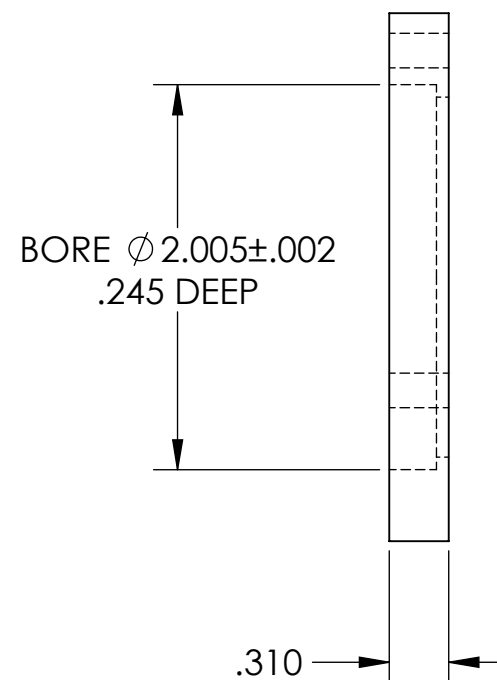
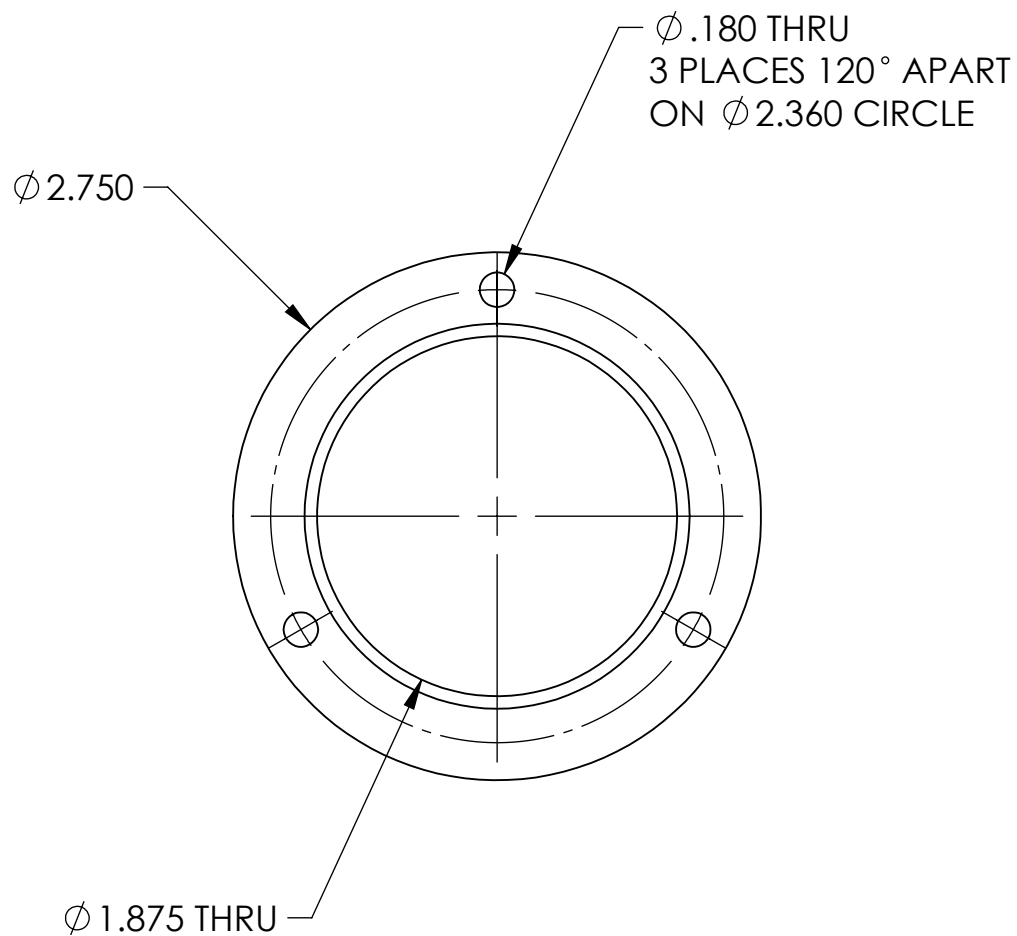
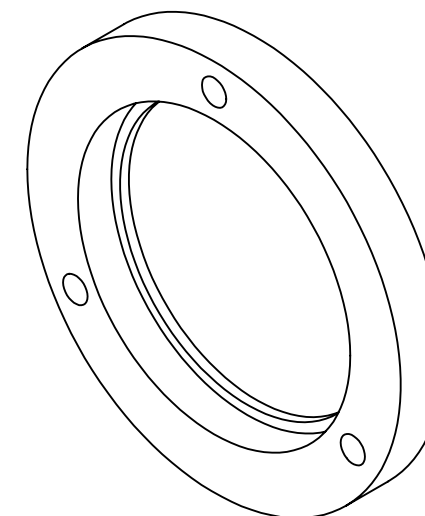


NOTES CONTINUED:

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

- D 6. APPROXIMATE WEIGHT = X.XXX LB.
- 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 HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
- 10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
- 11. 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 #
-	-	-	-
-	-	-	-
-	-	-	-



D1101665\_ALIGO\_IO\_FL\_FR\_SLEEVE\_LOCK, PART PDM REV: X-002, DRAWING PDM REV:

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME											
DIMENSIONS ARE IN INCHES TOLERANCES: .XX $\pm .01$ .XXX $\pm .005$ ANGULAR $\pm 0.1^\circ$				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY 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.				SYSTEM <b>ADVANCED LIGO</b>		SUB-SYSTEM <b>100</b>		DESIGNER L.WILLIAMS 13 AUG 2013 DRAFTER L.WILLIAMS 13 AUG 2013 CHECKER APPROVAL		PART NAME <b>FI FR SLEEVE LOCK</b>		SIZE DWG. NO. <b>B D1101665</b>		REV. <b>v1</b>	
MATERIAL <b>6061 Alloy</b>				FINISH <b>32 <math>\mu</math>inch</b>				NEXT ASSY		SCALE: 1:1		PROJECTION:		SHEET 1 OF 1					