

8 7 6 5 4 3 2 1

NOTES CONTINUED:

5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

6. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

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.

REV.	DATE	DCN #	DRAWING TREE #
v1	13 OCT 2011	E1100335	-
-	-	-	-
-	-	-	-

D

D

C

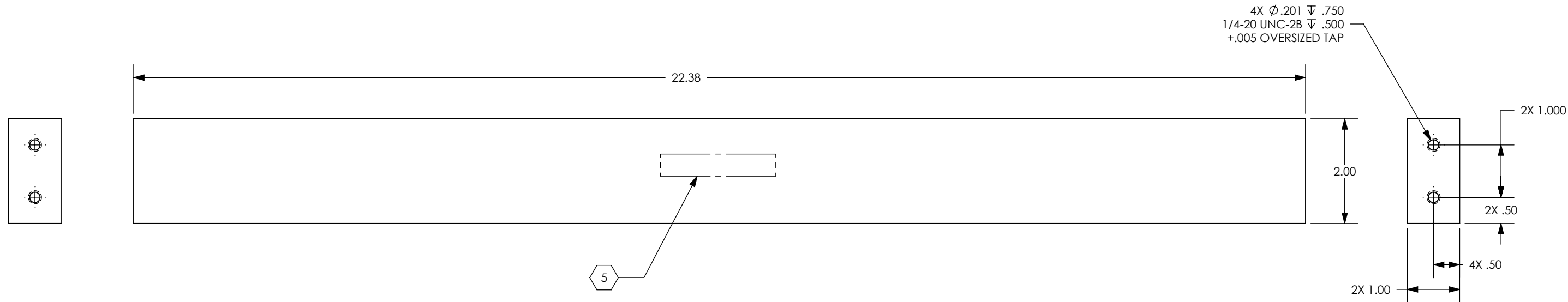
C

B

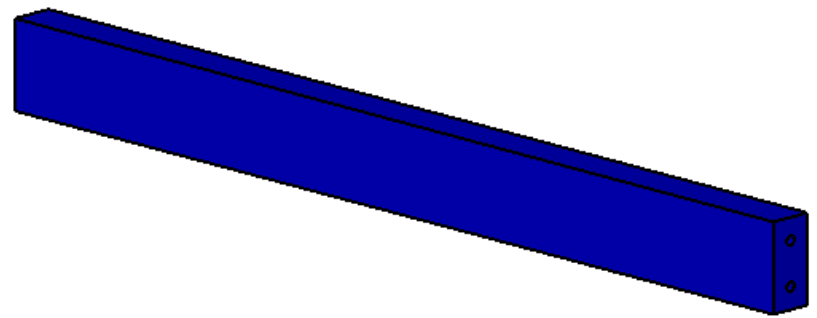
B

A

A



4X ϕ .201 ∇ .750
 1/4-20 UNC-2B ∇ .500
 +.005 OVERSIZED TAP



D1101723, SUPPORT, RAIL, ACB, PART PDM REV: X-002, DRAWING PDM REV: X-005

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN TOLERANCES: .XX \pm .010 .XXX \pm .005 ANGULAR \pm .5°				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.		SUPPORT, RAIL, ACB	
MATERIAL		FINISH		SYSTEM		SUB-SYSTEM	
6061-T6 Al		63 μ inch		ADVANCED LIGO		AOS	
NEXT ASSY				DESIGNER		SIZE DWG. NO.	
D1101724				DRAFTER		B D1101723	
				CHECKER		REV.	
				APPROVAL		v1	
				SCALE: 1:2		PROJECTION:	
						SHEET 1 OF 1	

8 7 6 5 4 3 2 1