NOTES CONTINUED:

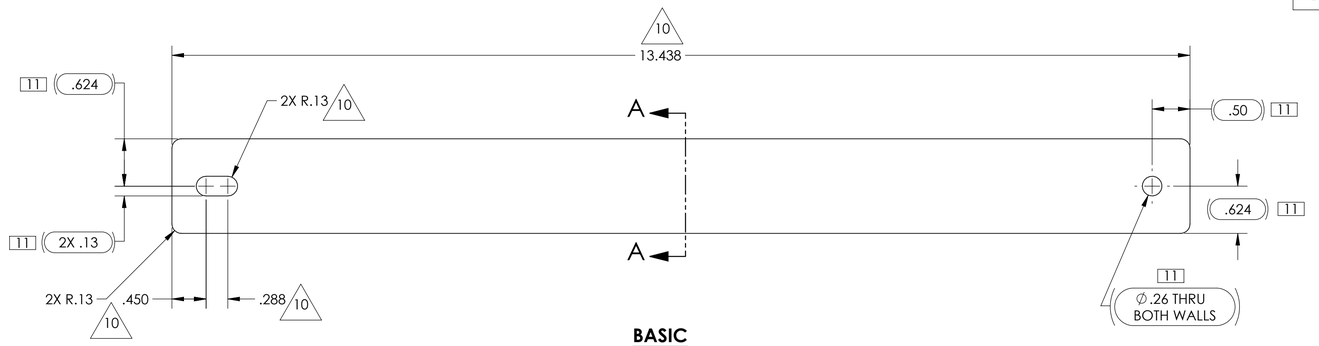
Ⓢ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE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

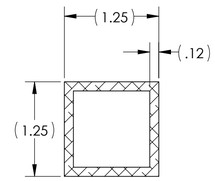
6. APPROXIMATE WEIGHT = .715 LB.
7. ELECTROPOLISH ALL SURFACES TO REMOVE .0005-.001 OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. MUST USE AN ELECTRODE INSIDE THE TUBE TO ALSO ELECTROPOLISH INTERIOR WALLS.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. 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.

△10 CHANGES ASSOCIATED WITH DCN E1200723-v1

[11] INSPECTION DIMENSION OF FINISHED -v1 PART

REV.	DATE	DCN #	DRAWING TREE #
v1	06-MAR-12	E1200002-v1	E1200003-v1
v2	06-AUG-12	E1200723-v1	E1200003-v2
-	-	-	-





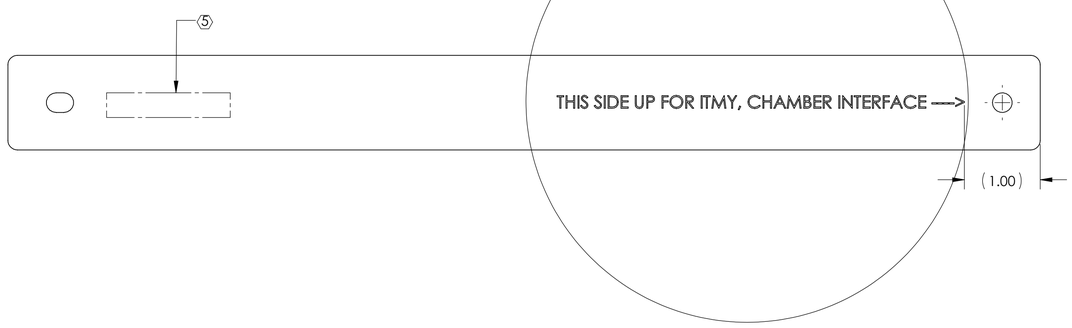
SECTION A-A

BASIC

MATERIAL: 1.25 SQ, .125 WALL
6063-T5 TUBING

(.17 APPROX.) THIS SIDE UP FOR ITMY, CHAMBER INTERFACE ----->

DETAIL C
SCALE 2 : 1

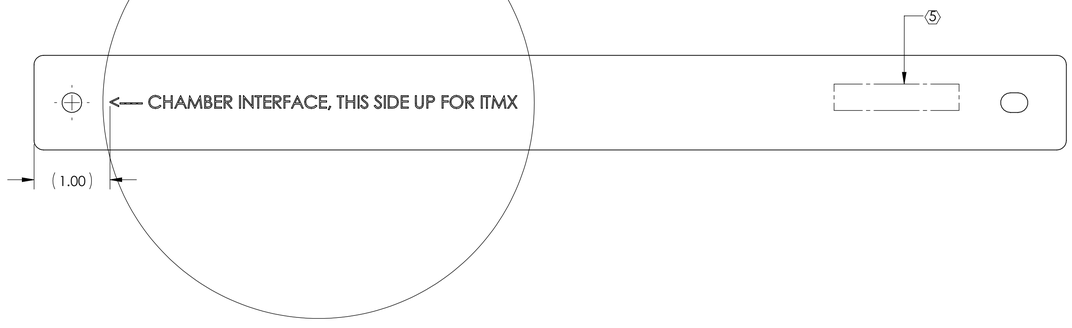


-02

MATERIAL: MAKE FROM BASIC

<----- CHAMBER INTERFACE, THIS SIDE UP FOR ITMX (.17 APPROX)

DETAIL B
SCALE 2 : 1



-01

MATERIAL: MAKE FROM BASIC

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, .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.			LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: aLIGO TCS CO2P SM2 ASSY SHORT SUPPORT				
	MATERIAL: 6063-T5	FINISH: 63 µinch	NEXT ASSY: D1101851-1, D1101851-2	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	DESIGNER: M.JACOBSON	19-DEC-2011	SIZE: D	DWG. NO.: D1102380	REV.: v2
						DRAFTER: E. SANCHEZ	27 JAN 2012			
						CHECKER: J. LEWIS	06 AUG 12			
						APPROVAL: M.JACOBSON	06 AUG 12	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1

D1102380_aLIGO TCS CO2P SM2 ASSY SHORT SUPPORT, PART PDM REV: X-030, DRAWING PDM REV: X-006