

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. APPROXIMATE WEIGHT = 1.508 LB.

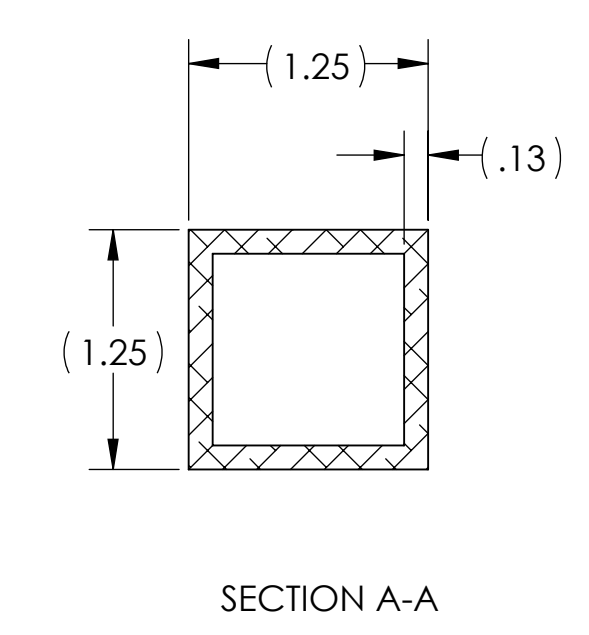
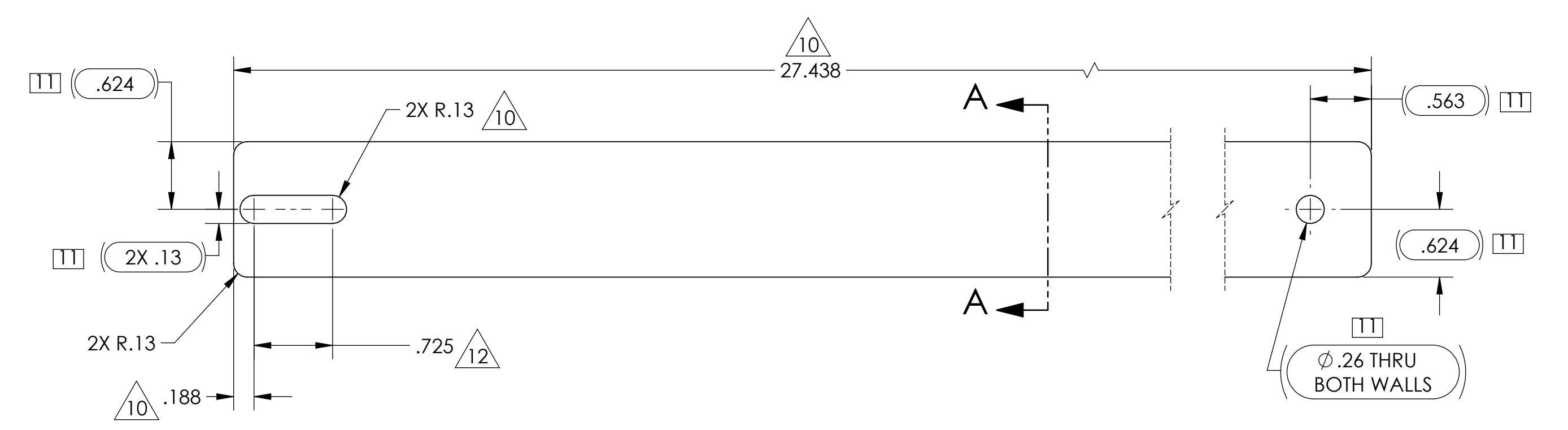
7. ELECTROPOLISH ALL SURFACES TO REMOVE .0005-.001 OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. MUST USE AN ELECTRODE INSIDE THE TUBE TO ALSO ELECTROPOLISH INTERIOR WALLS.

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
 △12 CHANGES ASSOCIATED WITH DCN E1300141-x0

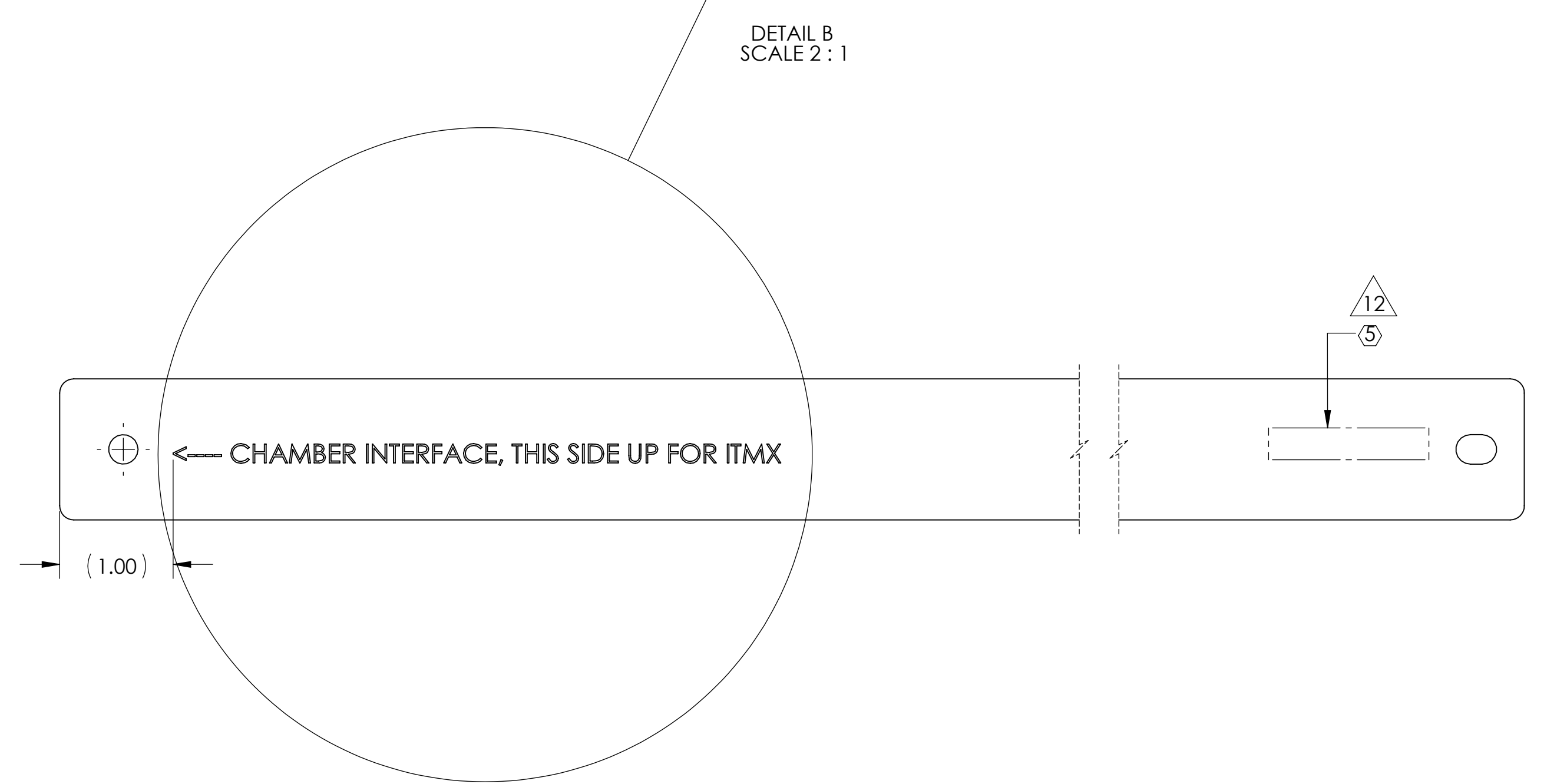
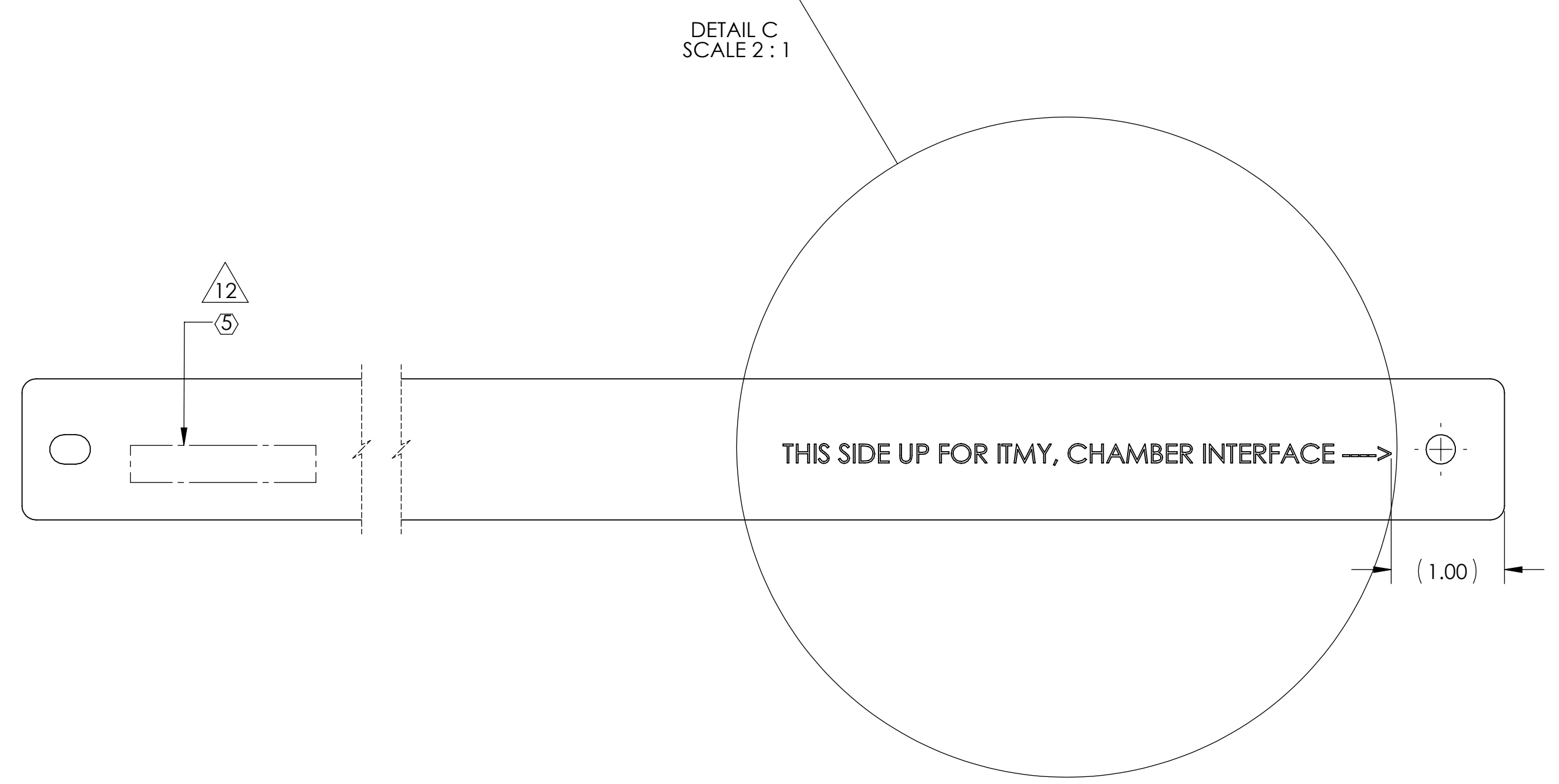
REV.	DATE	DCN #	DRAWING TREE #
v1	06-MAR-12	E1200002-v1	E1200003-v1
v2	06-AUG-12	E1200723-v1	E1200003-v2
v3	22-FEB-13	E1300141-x0	-



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

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

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



-02
 MATERIAL: MAKE FROM BASIC

-01
 MATERIAL: MAKE FROM BASIC

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME						
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.				ADVANCED LIGO		AO S		aLIGO TCS CO2P SM2 ASSY LONG SUPPORT				
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°				MATERIAL 6063-T5 FINISH 63 μinch		NEXT ASSY D1101851-1, D1101851-2		DESIGNER M. JACOBSON DRAFTER E. SANCHEZ CHECKER C. GUIDO APPROVAL M. JACOBSON	19-DEC-2011 27 JAN 2012 22-FEB-13 22-FEB-13	SIZE DWG. NO. D	D1102384	REV. v3
SCALE: 1:1 PROJECTION:								SHEET 1 OF 1				

D1102384-LIGO TCS CO2P SM2 ASSY LONG SUPPORT, PART PDM REV. X.006, DRAWING PDM REV. X.006