NOTES CONTINUED:

⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REV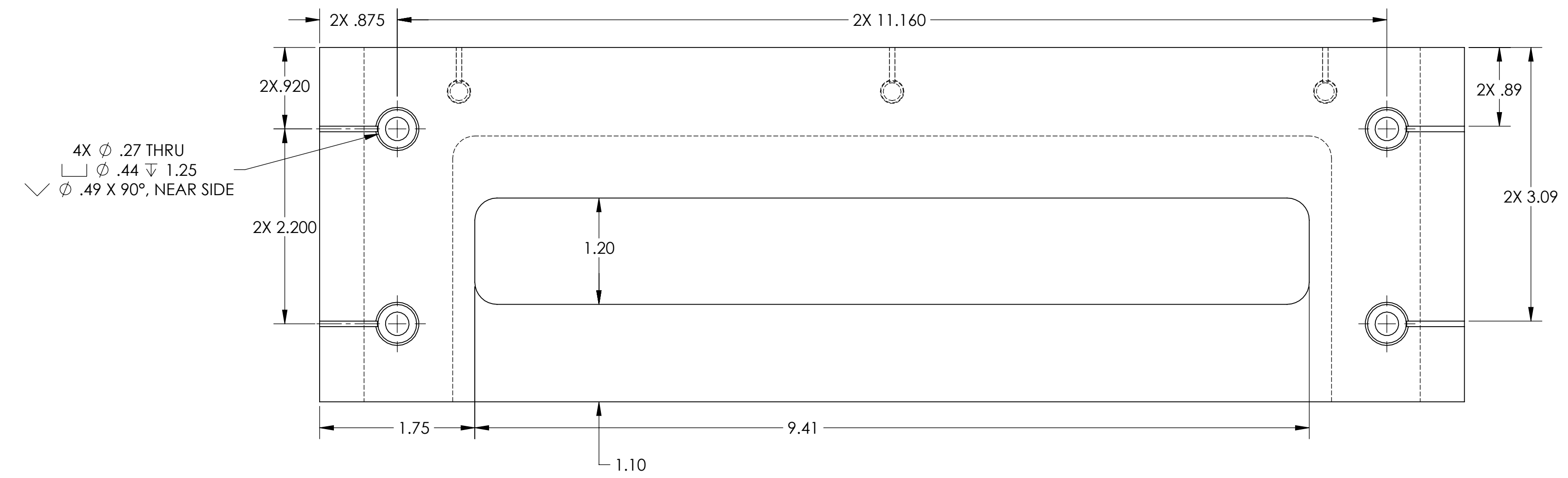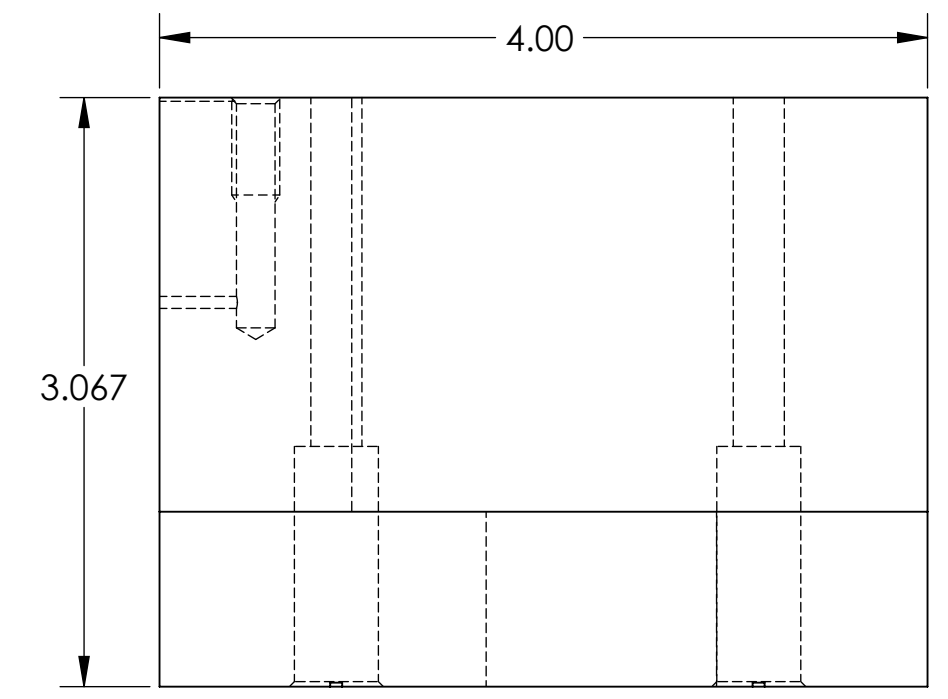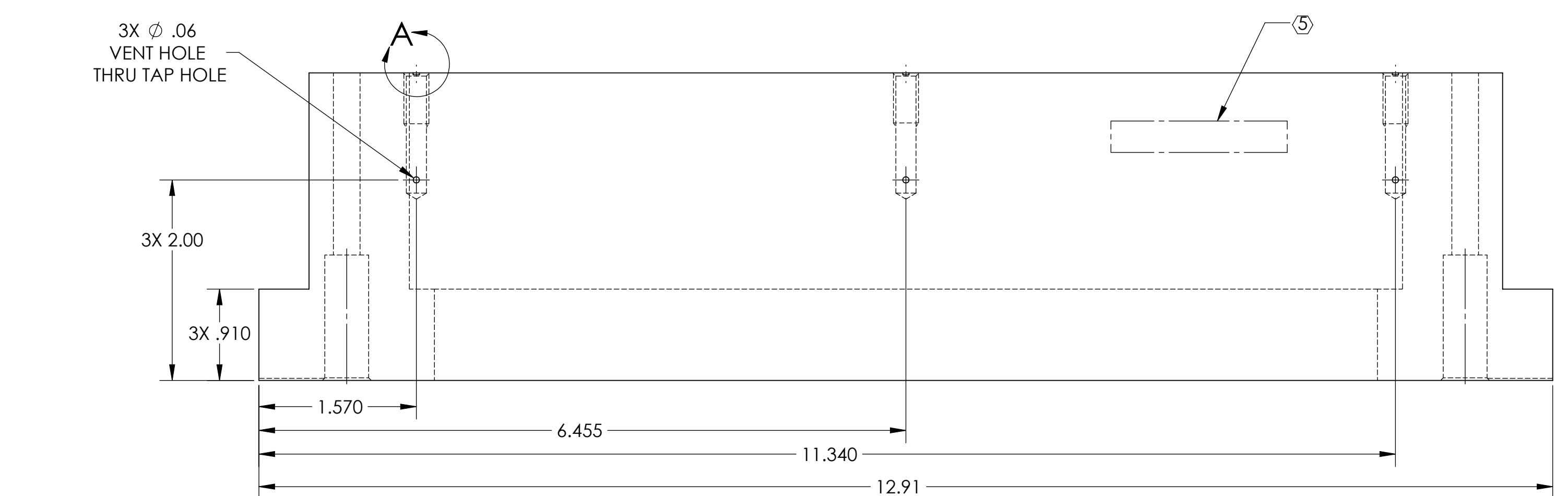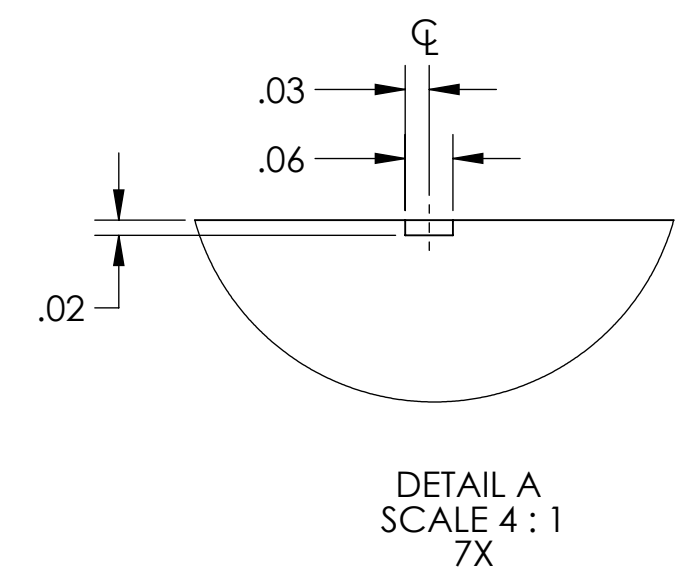ISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

6. APPROXIMATE WEIGHT = 7.599 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 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	30 JAN 2012	E1100289-v1	-
v2	11 APR 2012	-	-
-	-	-	-

3X DRILL ⍱ 1.20
1/4-20 UNC ⍱ .50
+.005 OVERSIZE TAP

6X R.25

.50
1.50
9.91

3X .500
1.00

1.570
6.455
11.340
12.41
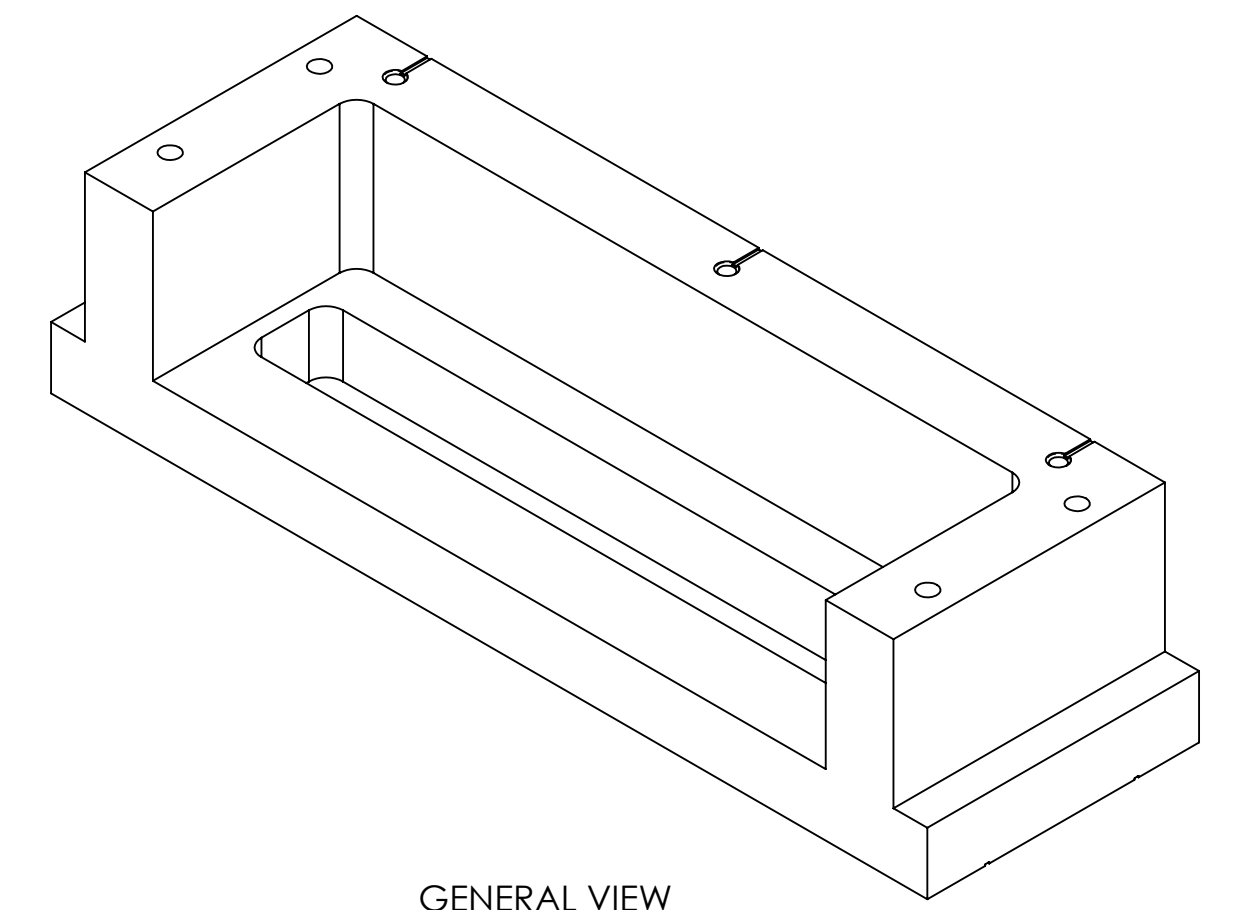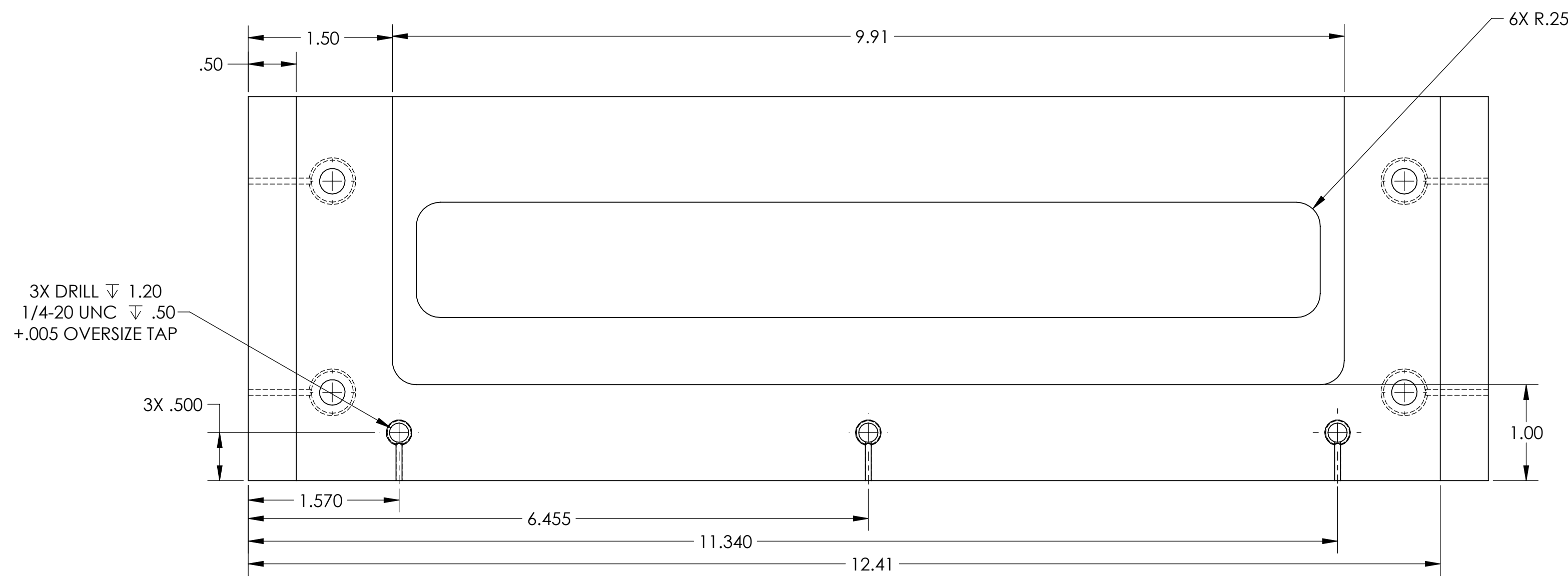
GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE

.03
.06
.02
Ȼ

DETAIL A
SCALE 4 : 1
7X

3X ⌀ .06
VENT HOLE
THRU TAP HOLE

A

⑤

3X 2.00
3X .910

1.570
6.455
11.340
12.91

4.00
3.067

2X .875
2X 11.160

2X.920
2X .89

4X ⌀ .27 THRU
⌴ ⌀ .44 ⍱ 1.25
⌵ ⌀ .49 X 90°, NEAR SIDE

2X 2.200
2X 3.09

1.20

1.75
9.41
1.10

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.

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005
ANGULAR ± 1.0°

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME
SRM AR_L1 SPACER

SYSTEM
ADVANCED LIGO

SUB-SYSTEM
AOS

MATERIAL
6061-T6 Al

FINISH
63 μinch

NEXT ASSY
D1200141

DESIGNER	TQ. NGUYEN	30 JAN 2012
DRAFTER	TQ. NGUYEN	30 JAN 2012
CHECKER	L. AUSTIN	
APPROVAL	C. TORRIE	

SIZE
D

DWG. NO.
D1200144

REV.
v2

SCALE: 1:1   PROJECTION: SHEET 1 OF 1

D1200144 4LIGO SRM AR_L1 SPACER, PART PDM REV. X-015, DRAWING PDM REV. X-010