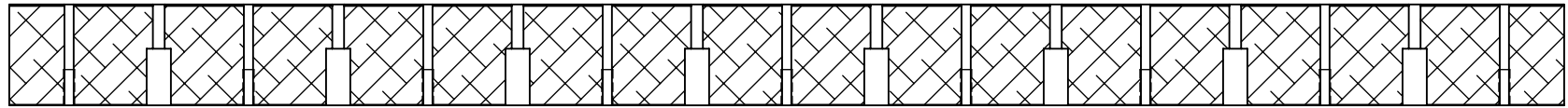


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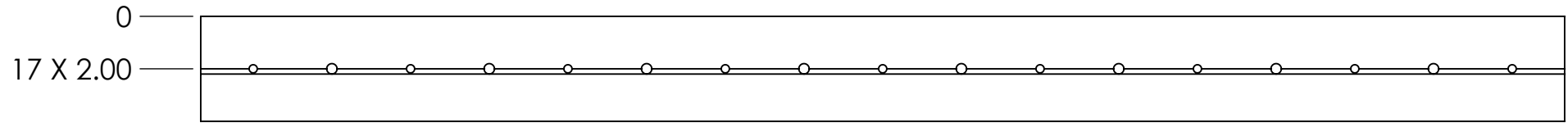
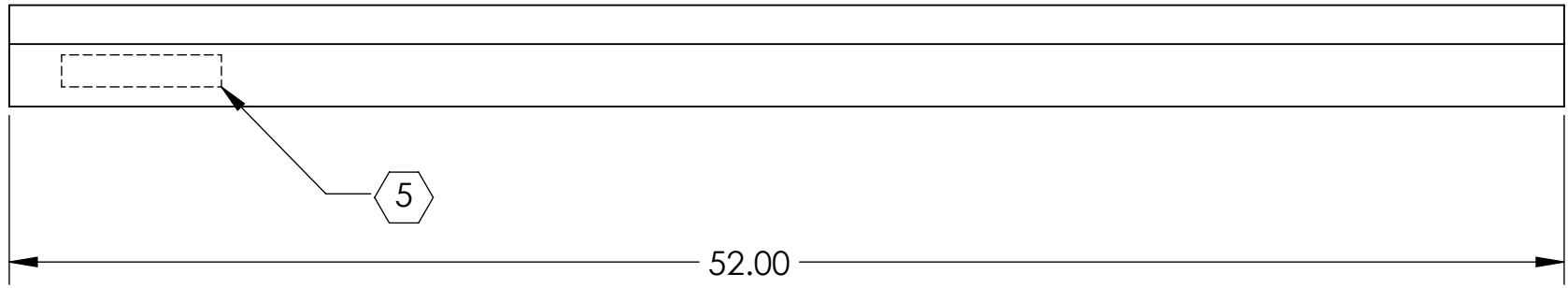
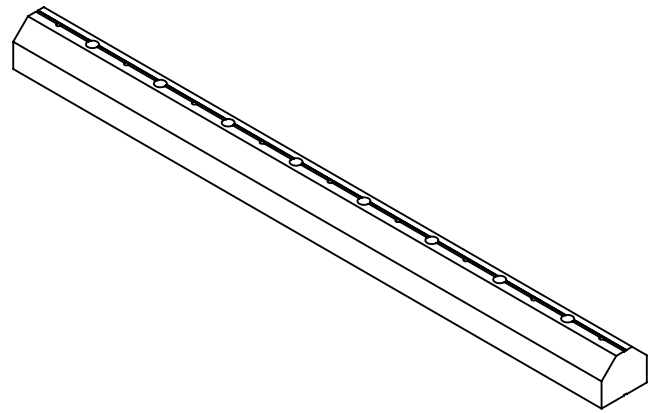
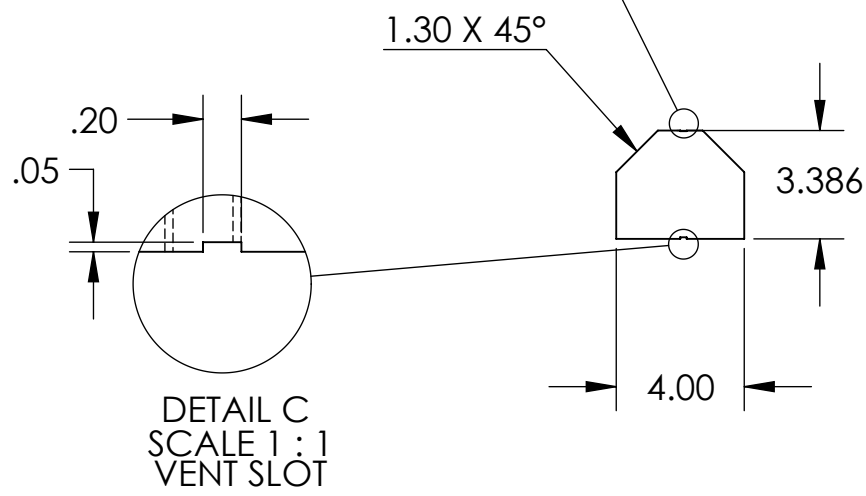
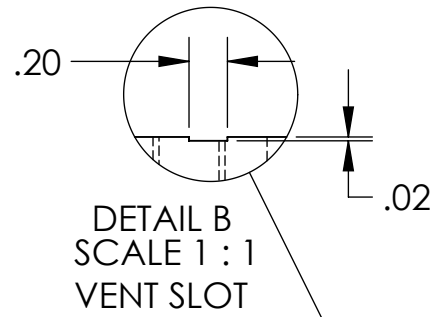
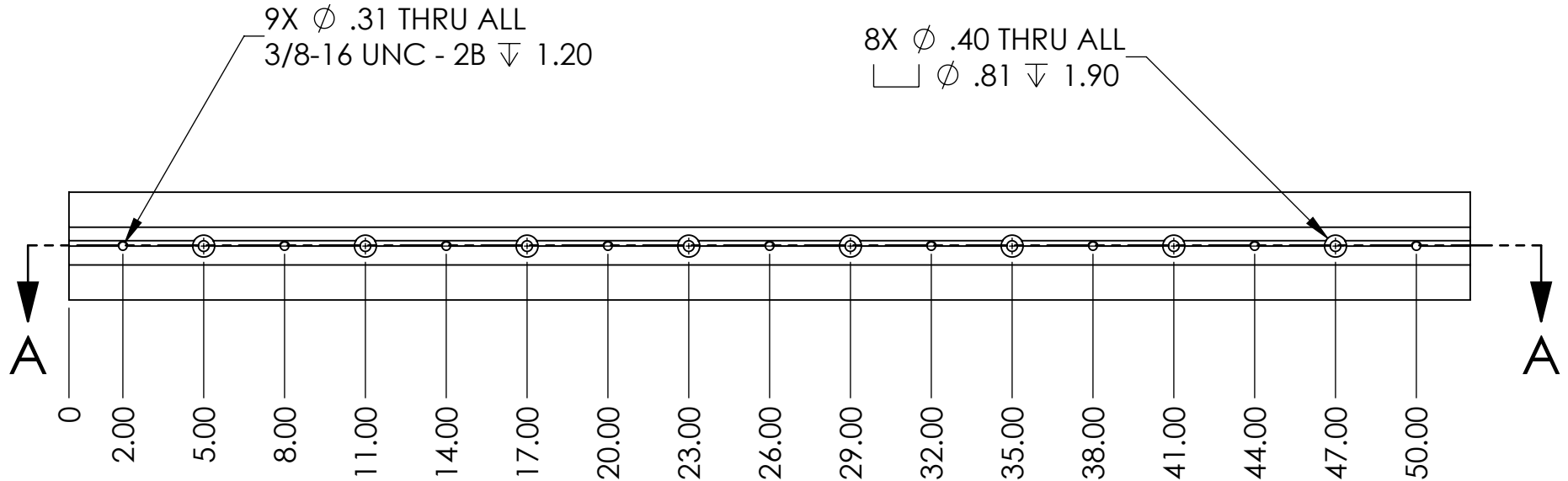
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE 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 = 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 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 Mar 2012	E1200283	-
-	-	-	-
-	-	-	-



SECTION A-A



D1200349 Upper Riser for LHAM-6 ISI aLIGO, PART PDM REV: X-000, DRAWING PDM REV: X-000

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 0.6°

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.

MATERIAL	6061-T6 Al	FINISH	63 μinch
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		Upper Riser for LHAM-6 ISI aLIGO	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	SEI	DESIGNER	SBARNUM 28 FEB 2012
NEXT ASSY	D070300	CHECKER	KMASON 12 MAR 2012	APPROVAL	KAMASON 12 MAR 2012
				SIZE	DWG. NO.
				B	D1200349
				SCALE:	1:6
				PROJECTION:	
				SHEET	1 OF 1