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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

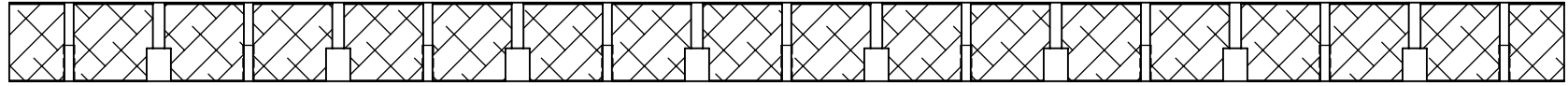
6. APPROXIMATE WEIGHT = X.XXX LB.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

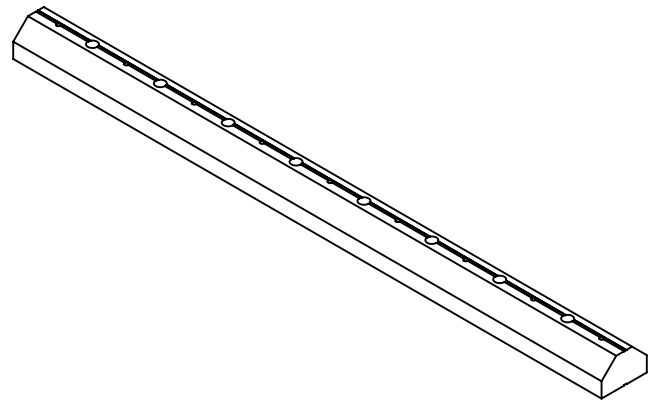
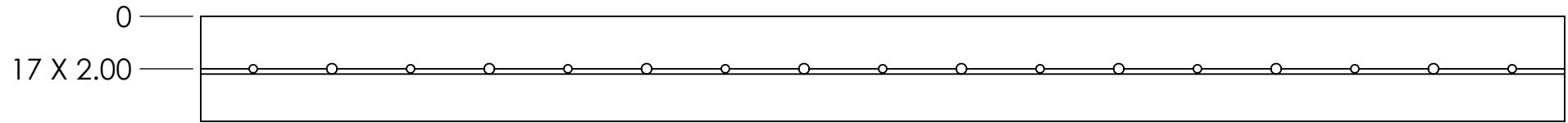
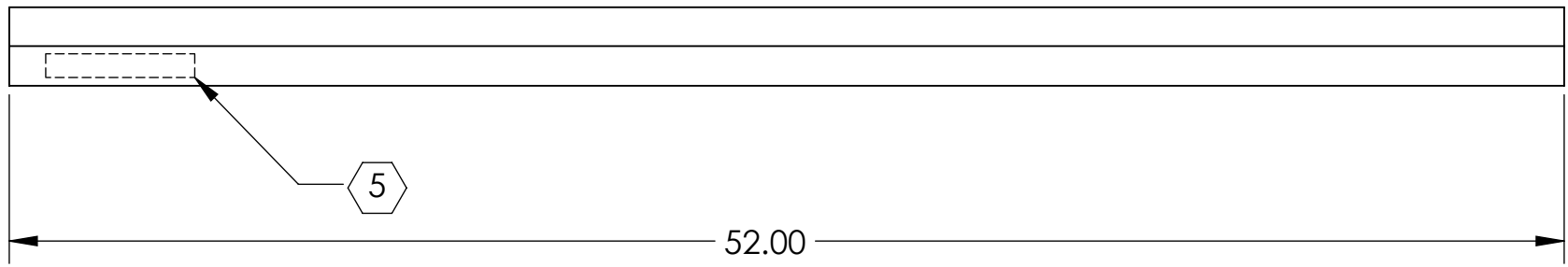
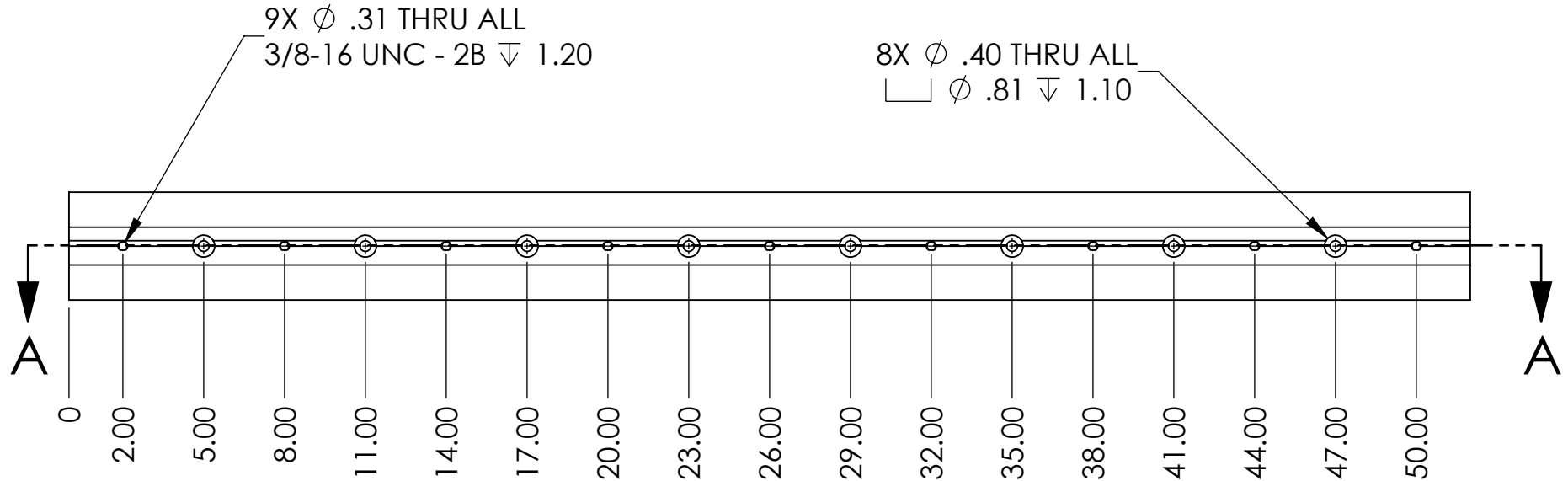
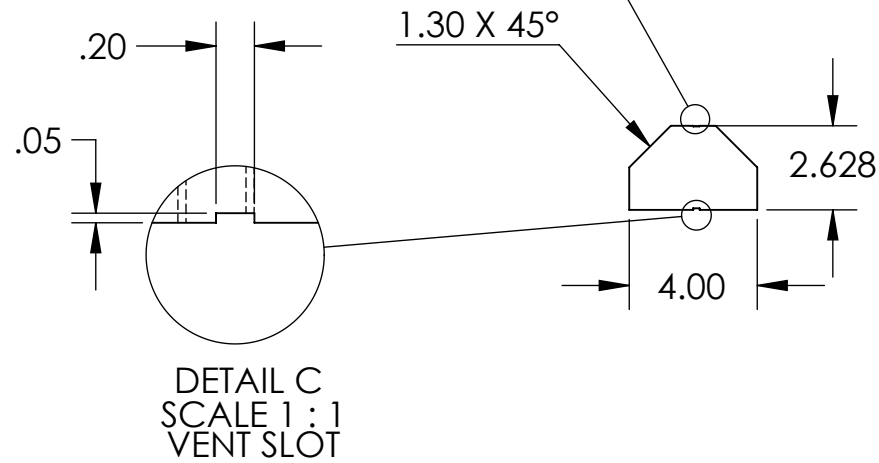
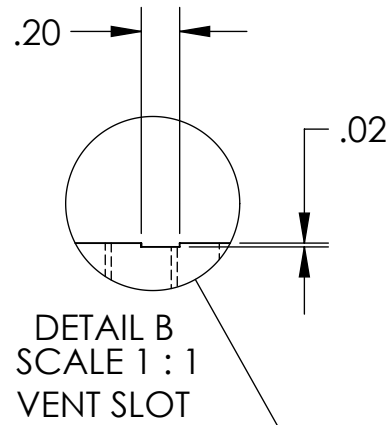
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

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



D1200353 Upper Riser for WHAM-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 |

| | | | |
|---|---------------|------------|-----|
| CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY | | PART NAME | |
| SYSTEM | ADVANCED LIGO | SUB-SYSTEM | SEI |
| NEXT ASSY | D070300 | | |

| | | | | | |
|----------------------------------|---------|-------------|-------------|----------|--------------|
| Upper Riser for WHAM-6 ISI aLIGO | | | | REV. | |
| DESIGNER | SBARNUM | 28 FEB 2012 | SIZE | DWG. NO. | v1 |
| DRAFTER | SBARNUM | 9 MAR 2012 | B | D1200353 | |
| CHECKER | KMASON | 12 MAR 2012 | SCALE: | 1:6 | |
| APPROVAL | KAMASON | 12 MAR 2012 | PROJECTION: | | SHEET 1 OF 1 |

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