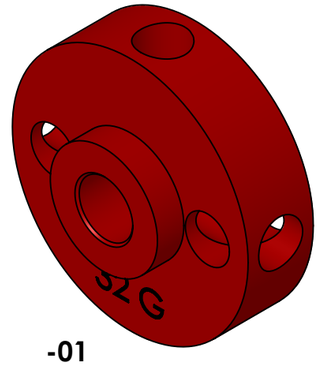
NOTES CONTINUED:

5. LASER MARK A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART IN THE NOTED AREA. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEDE CONSECTUVELY. BAG AND TAG ITEMS WITH THEIR PART NUMBER, REVISION, VARIANT OR "TYPE", AND QUANTITY.
   EXAMPLE (PART): 001-v1
   EXAMPLE (TAG): DXXXXXXX-v1, TYPE-01, QTY: TBD
6. MASS:
   -01; 32 G [0.07 LB]
   -02; 63 G [0.14 LB].
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.
10. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL, WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE PART SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTITIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

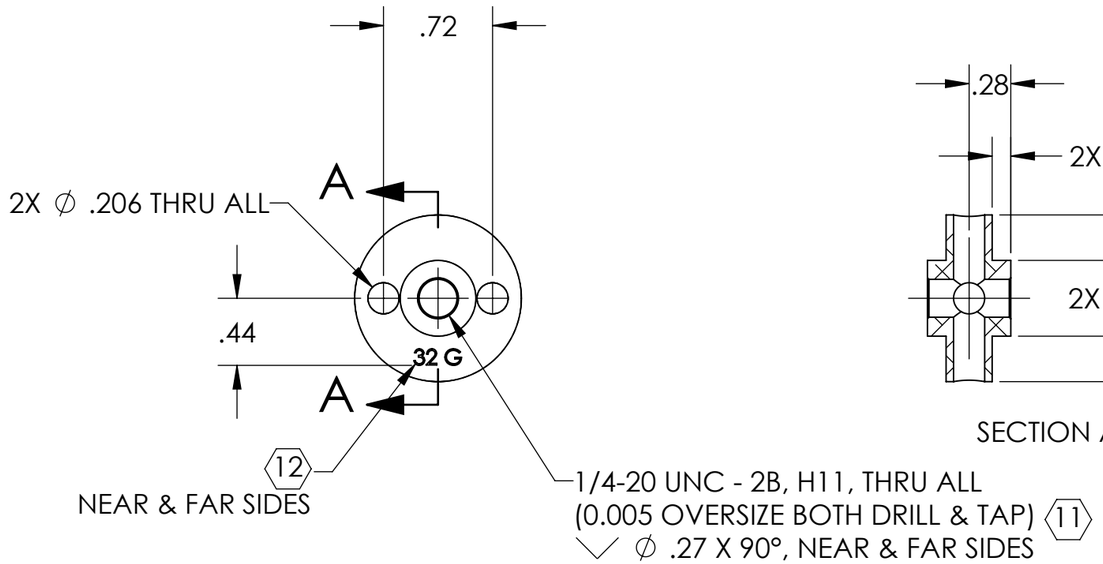
⟨11⟩ TAPPED HOLES: .005 OVERSIZE BOTH DRILL AND TAP.

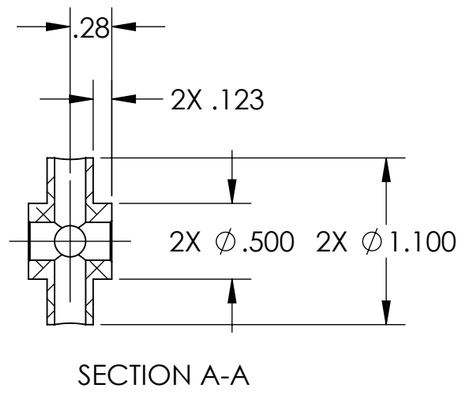
⟨12⟩ SCRIBE, ENGRAVE, LASER MARK, OR MECHANICALLY STAMP (NO INKS OR DYES), "32 G" FOR -01, "63 G" FOR -02, APPROXIMATELY CENTER JUSTIFIED AS SHOWN. CHARACTER HEIGHT 0.10-0.18. NEAR & FAR SIDES.

REV.	DATE	DCN #	DRAWING TREE #
v1	19 MAR 2012	E1101214	-
-	-	-	-
-	-	-	-

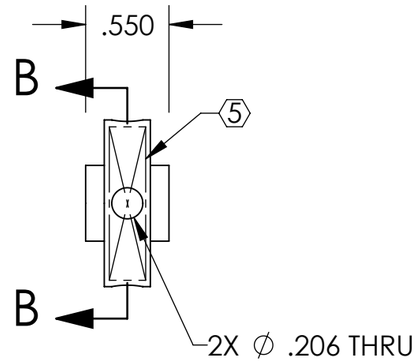


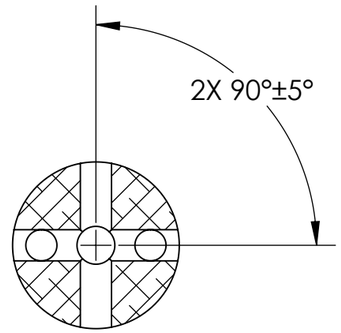
-01





SECTION A-A



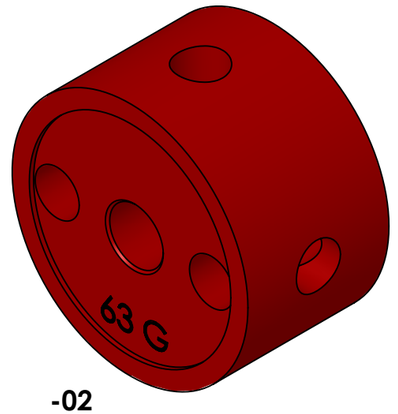


SECTION B-B

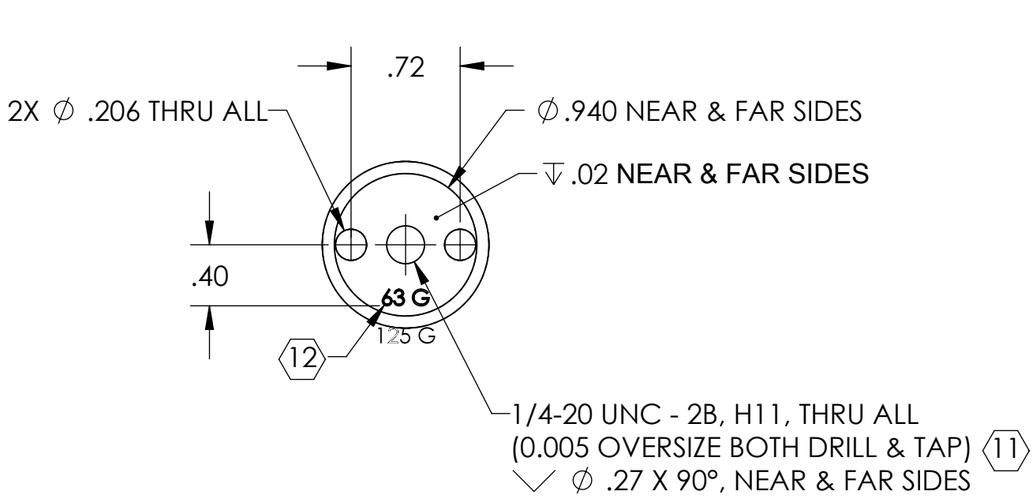
D1200432 aLIGO TMS Small Balance Weight, PART PDM REV: X-011, DRAWING PDM REV: X-006

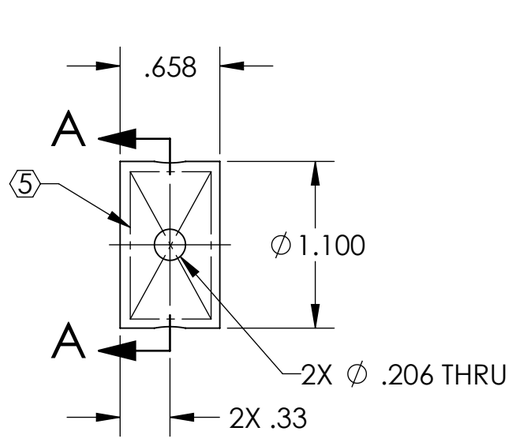
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)							
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1.0°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	MATERIAL: 304 SSTL	FINISH: 63 µinch Ra	LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	NEXT ASSY: VARIOUS

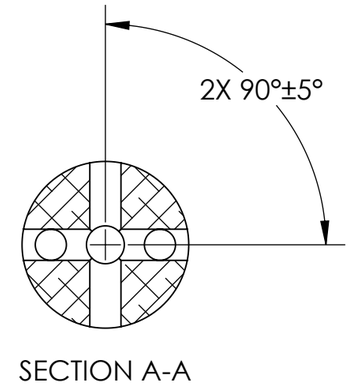
PART NAME: aLIGO TMS SMALL BALANCE WEIGHT					
DESIGNER	C. CONLEY	12 MAR 2012	SIZE: B	DWG. NO.: D1200432	REV.: v1
DRAFTER	C. CONLEY	19 MAR 2012			
CHECKER	SEE DCN				
APPROVAL	SEE DCN		SCALE: NONE	PROJECTION:	SHEET 1 OF 2



-02







SECTION A-A

D1200432 aLIGO TMS Small Balance Weight, PART PDM REV: X-011, DRAWING PDM REV: X-006

LIGO	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE B	DWG. NO. D1200432	REV. v1	
SCALE: NONE	PROJECTION:	SHEET 2 OF 2	