

**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 = 1.480 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	14 SEP 2012	E1100312	-
-	-	-	-
-	-	-	-

D

C

B

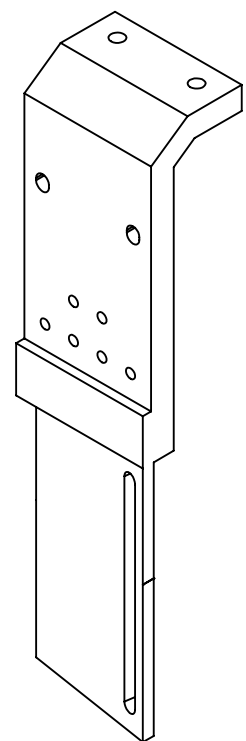
A

D

C

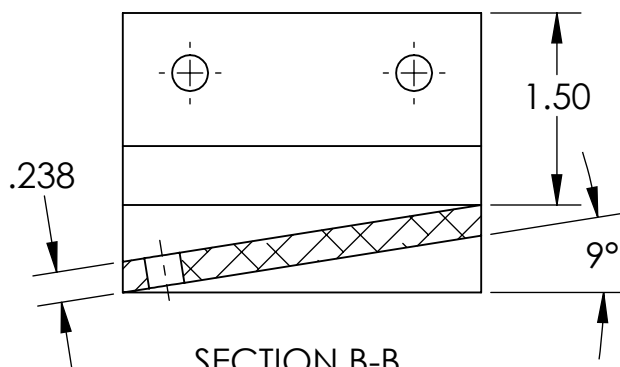
B

A

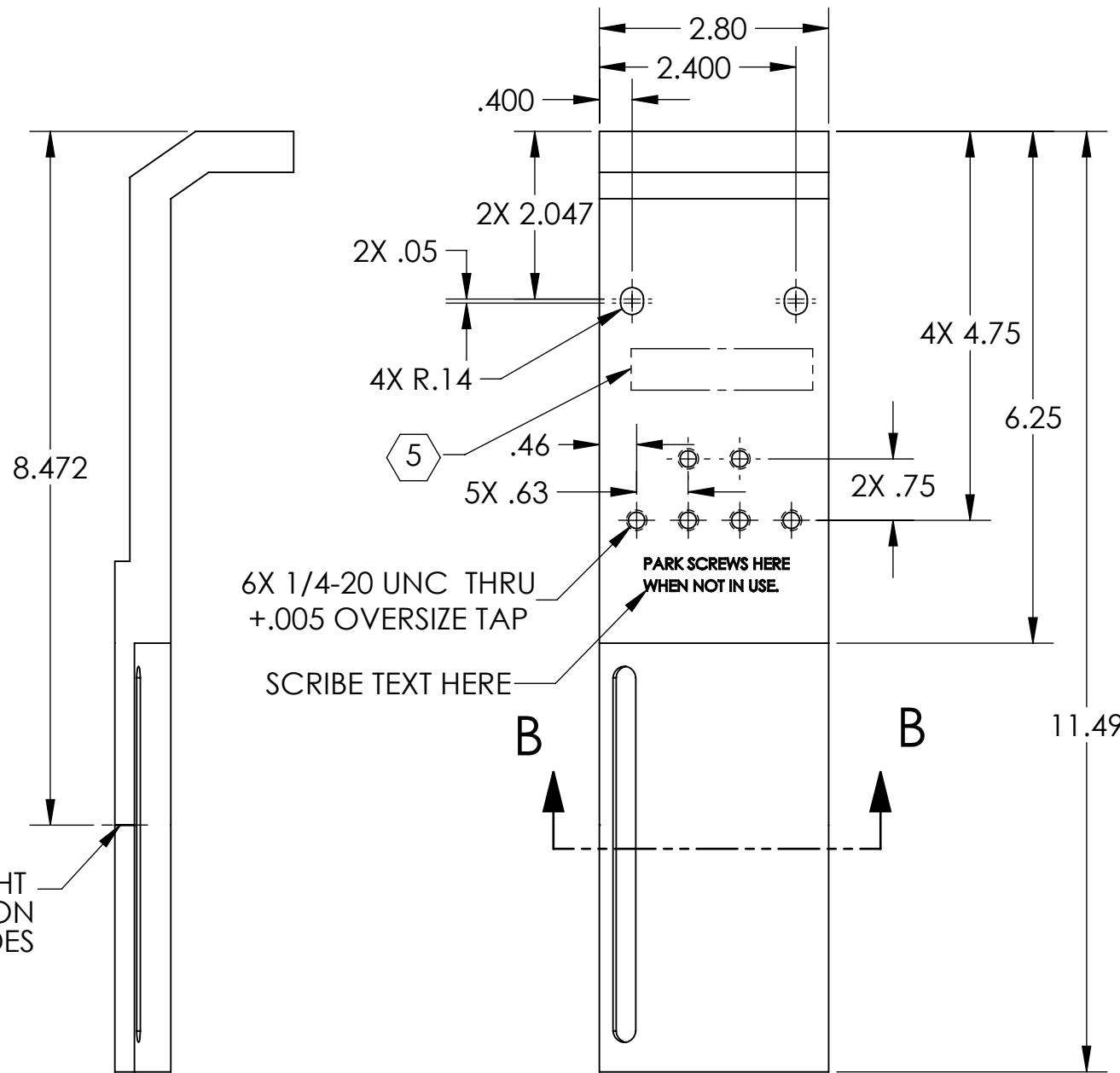


GENERAL VIEW FOR REFERENCE ONLY NO SCALE

MARK THIN STRAIGHT LINE AT THIS LOCATION BOTH SIDES



SECTION B-B SCALE 1 : 1.5

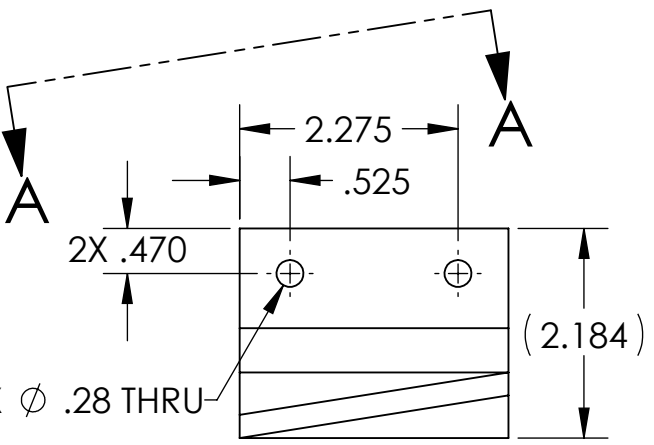


6X 1/4-20 UNC THRU +.005 OVERSIZE TAP  
 SCRIBE TEXT HERE

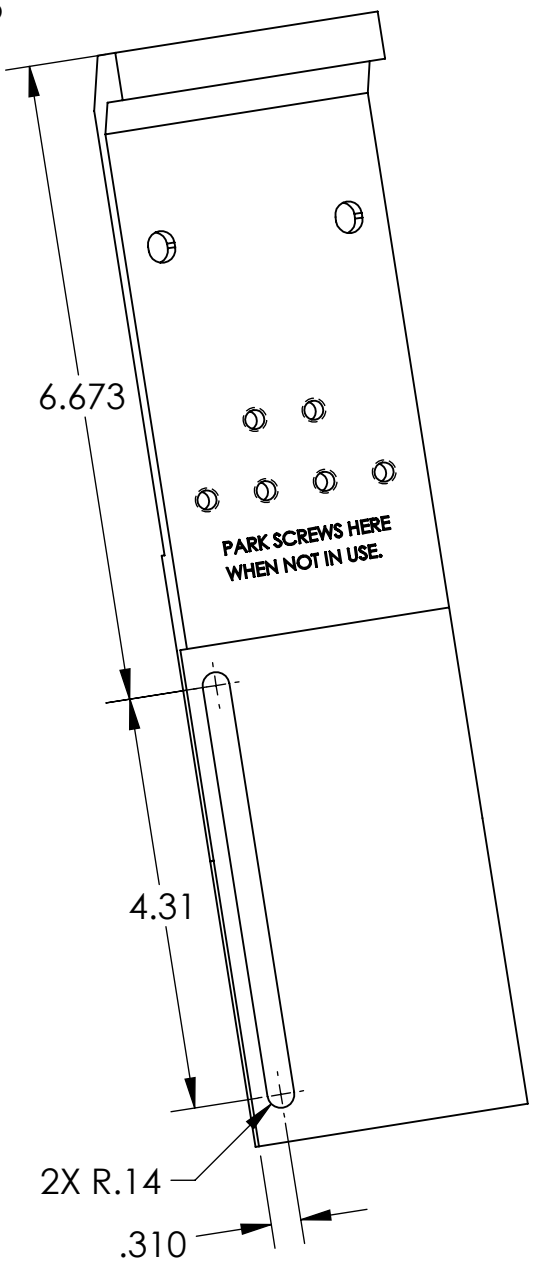
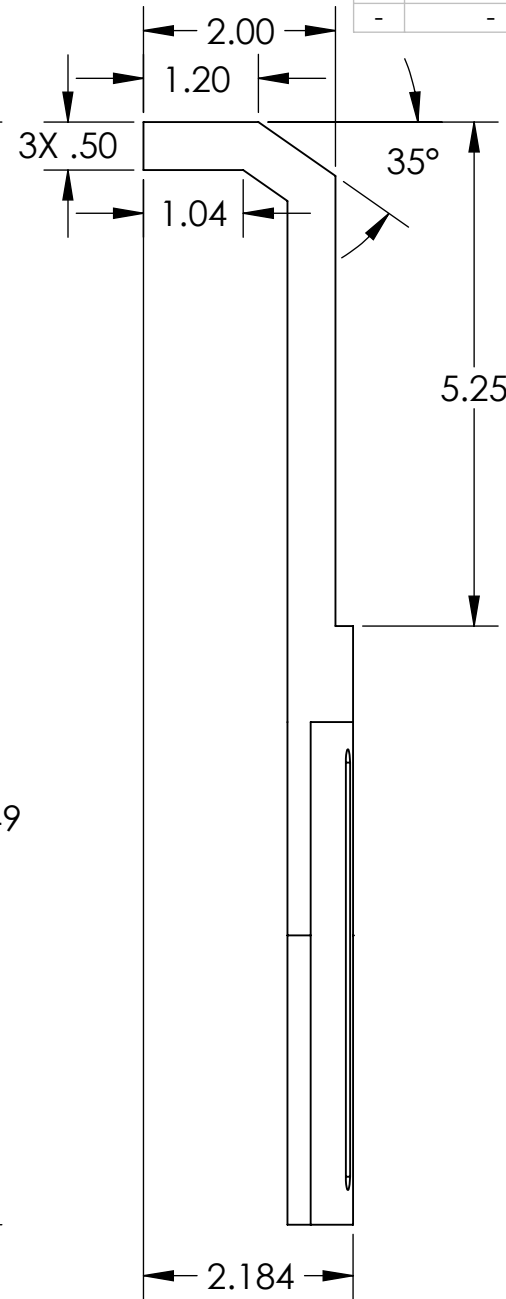
PARK SCREWS HERE WHEN NOT IN USE

B

B



2X Ø .28 THRU



VIEW A-A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES  
 TOLERANCES:  
 .XX ± .01  
 .XXX ± .005  
 ANGULAR ± 0.5°

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

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM AOS NEXT ASSY D1200275

PART NAME ACB, VARIABLE HEIGHT BRACKET, 9 DEGREE

DESIGNER	J. LEWIS	12 SEP 2012	SIZE	DWG. NO.	REV.
DRAFTER	TQ. NGUYEN	14 SEP 2012	B	D1201251	v1
CHECKER	L. AUSTIN		SCALE:	1:2	PROJECTION:
APPROVAL	M. SMITH				SHEET 1 OF 1

D1201251\_d1lgo\_slc\_acb\_bsc1-bsc3 Variable Height Gauge, PART PDM REV: X-011, DRAWING PDM REV: X-009