

NOTES CONTINUED:

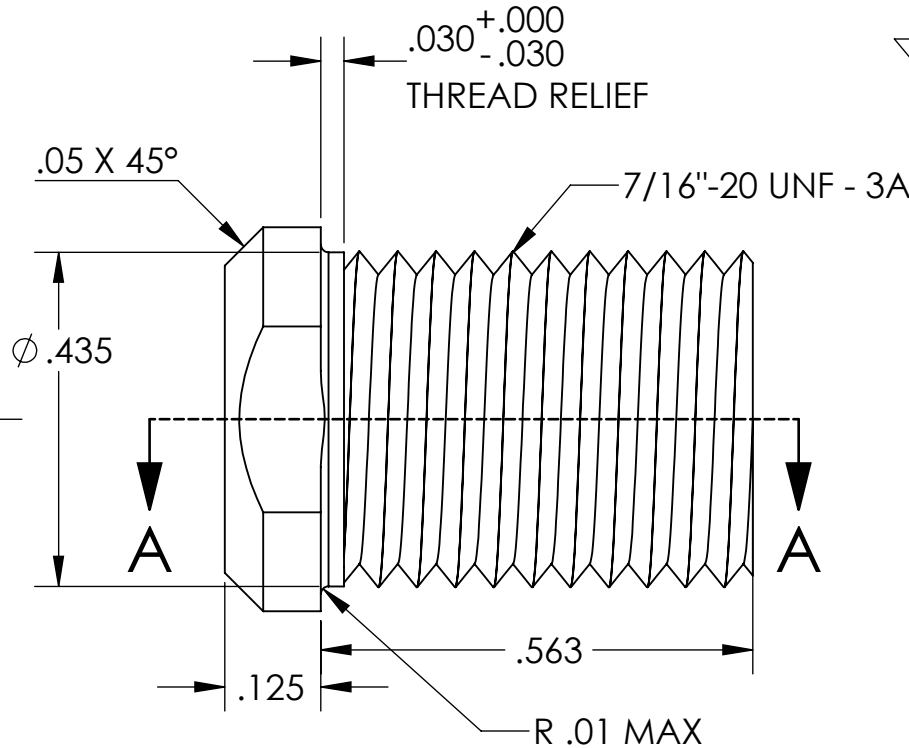
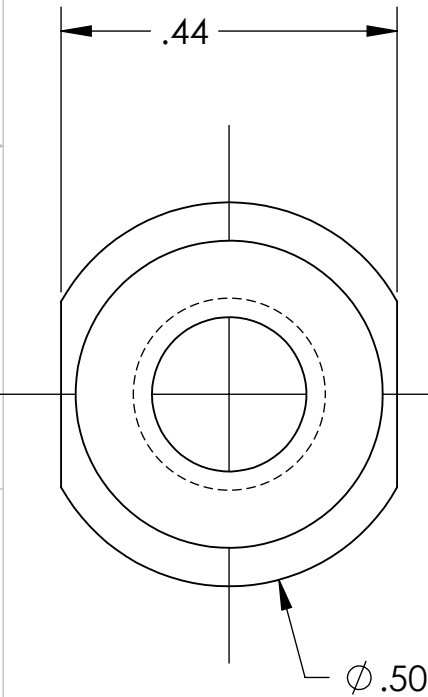
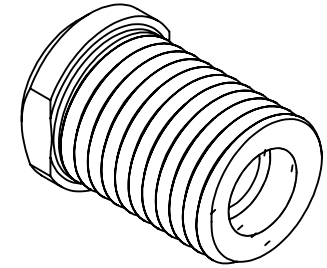
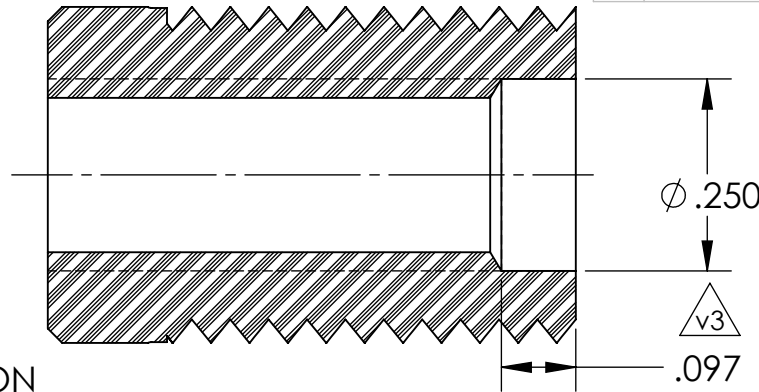
5. SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
 EXAMPLE (PART): 001-v1
 EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD

- 6. APPROXIMATE WEIGHT = X.XXX LB.
- 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
- 9. ALL PARTS MUST HAVE MATERIAL CERTIFICATIONS

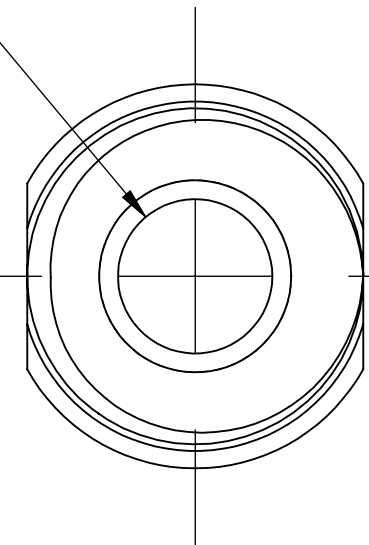
v3 IS A MINOR POST FAB MODIFICATION FOR BETTER INTERNAL THREAD RELIEF.

REV.	DATE	DCN #	DRAWING TREE #
V1	11/5/2012	-	-
V2	12/3/2012	E1201029	-
V3	1/3/2013	-	-

SECTION A-A



$\phi .2010$ THRU ALL
 1/4-20 UNC - 3B THRU ALL
 (USE L2 or L1 TAP IF AVAILABLE,
 OTHERWISE USE H1)



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:

.XX $\pm .01$
 .XXX $\pm .005$

ANGULAR $\pm 0.5^\circ$

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

SEMITRON ESd 480

FINISH

63 μinch



CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM

ADVANCED LIGO

NEXT ASSY

D1201441

SUB-SYSTEM

ISC

PART NAME

THREADED BUMPER, EQ-STOP, OMC, aLIGO

DESIGNER

SBARNUM 30 OCT 2012

DRAFTER

SBARNUM 31 OCT 2012

CHECKER

SBARNUM 3 DEC 2012

APPROVAL

PFRITSCH 3 DEC 2012

SIZE

A

DWG. NO.

D1201440

REV.

v3

SCALE: 4:1

PROJECTION:



SHEET 1 OF 1