

NOTES CONTINUED:
 ④ 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

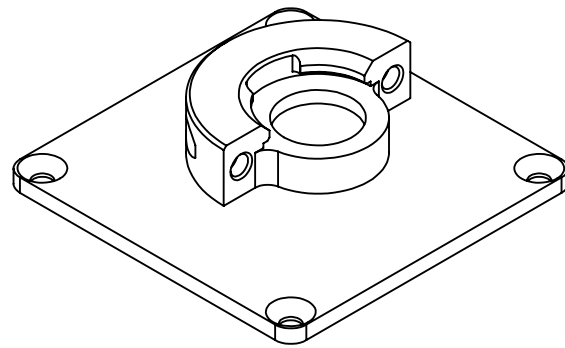
5. APPROXIMATE WEIGHT = 0.063 LB.

⑥ TUMBLE OF VIBRATORY DEBURR-FINISH 125 μINCH Ra MAX. FINAL ROUGHNESS, ALL SURFACES, BEFORE ANODIZING.

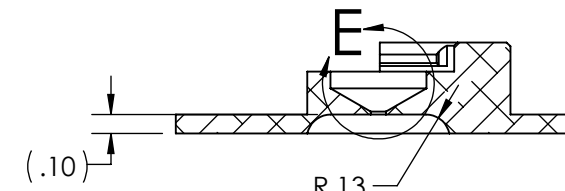
⑦ BLACK ANODIZE PER MIL-A8625F, TYPE II, CLASS 2.

8. UNLESS OTHERWISE SPECIFIED, MACHINED FILLET RADII .010 MAX.

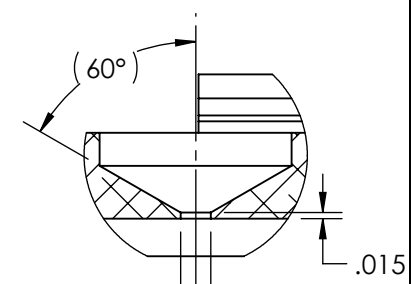
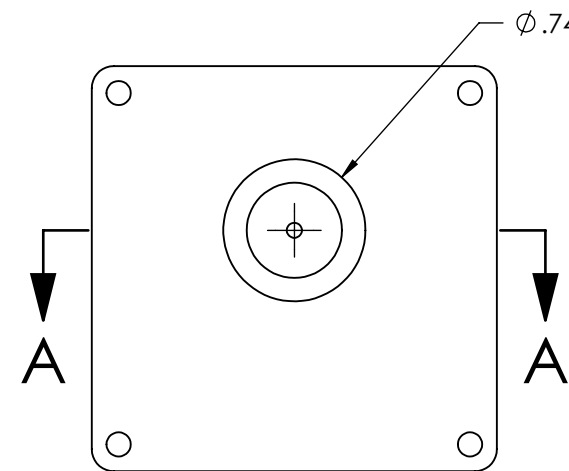
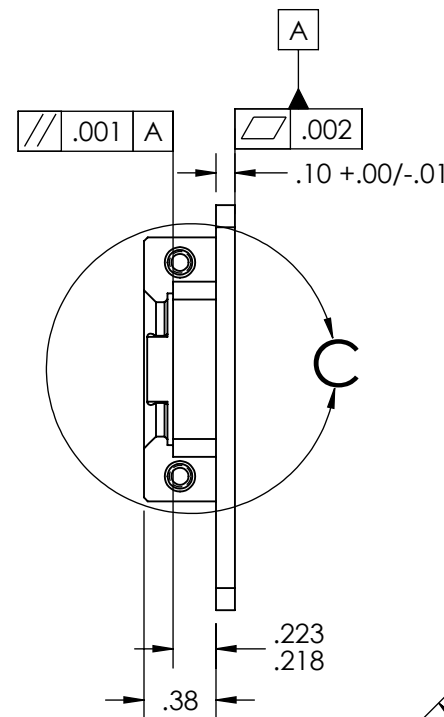
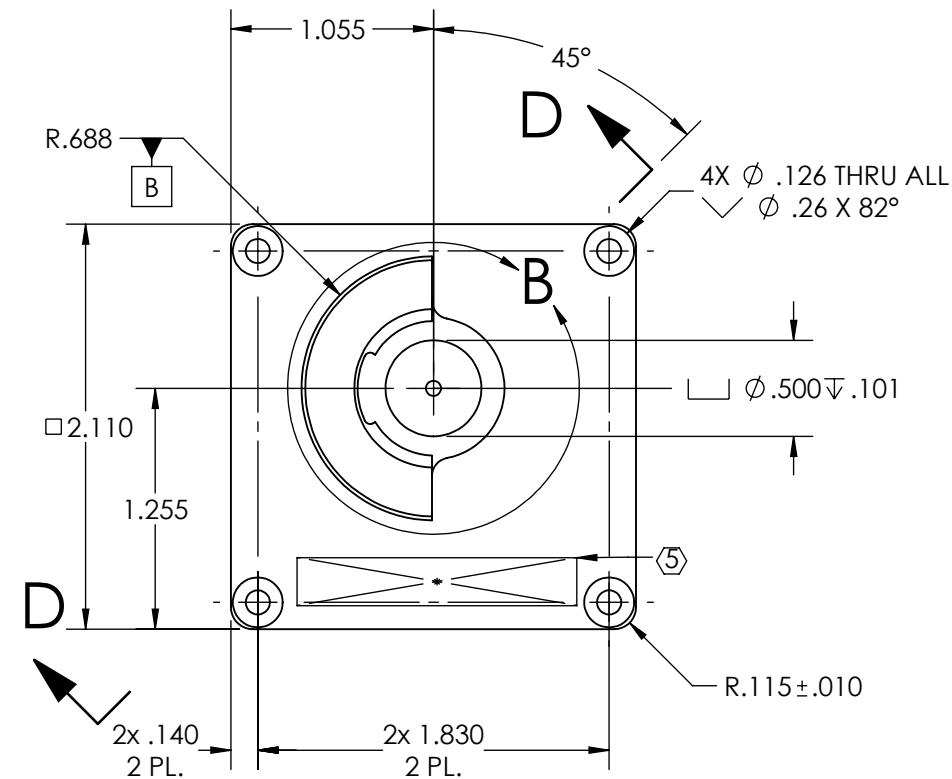
REV.	DATE	DCN #	DRAWING TREE #
v1	19 MAR 2013	-	-
v4	11 SEP 2018	E1800232-x0	-
-	-	-	-



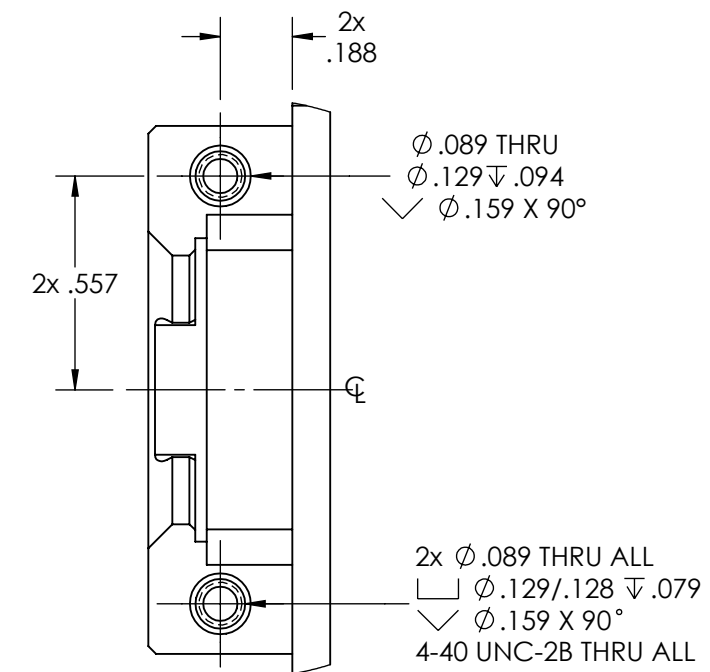
ISO VIEW



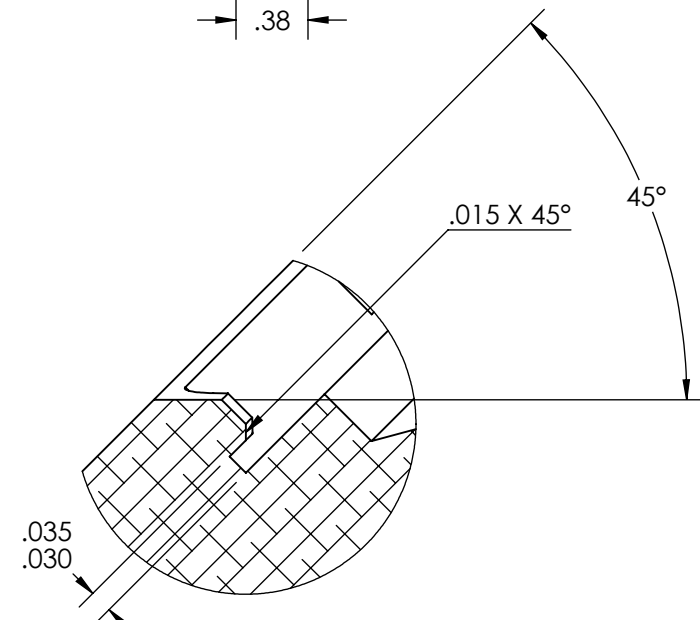
SECTION A-A



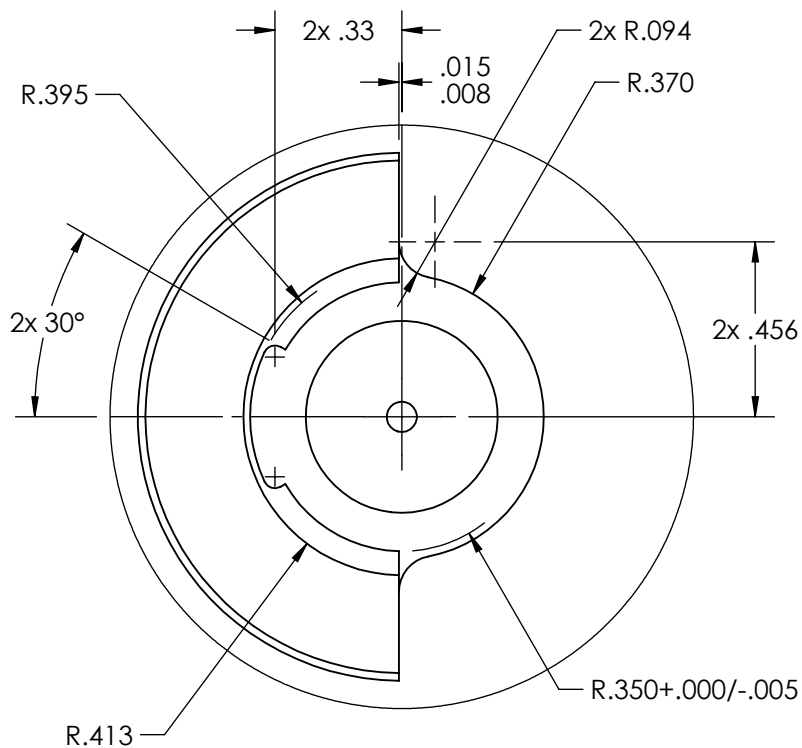
DETAIL E



DETAIL C



SECTION D-D TYP.



DETAIL B

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, .02 MAX. 3. DO NOT SCALE FROM DRAWING.	
MATERIAL	6061-T6 Al
FINISH	⑥ ⑦ μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
ADVANCED LIGO		qLIGO PCAL PHOTODETECTOR COVER, FRONT	
DESIGNER	R. SAVAGE	DATE	04 FEB 2013
DRAFTER	C. CONLEY	SIZE	DWG. NO.
CHECKER	SEE DCC	SCALE	1:1
APPROVAL	SEE DCC	PROJECTION	① ②
SUB-SYSTEM AOS		REV. v4	
NEXT ASSY D1300103		SHEET 1 OF 1	

D1300106 qLIGO Pcal Photodetector Cover, Front, PART PDM REV: X-023, DRAWING PDM REV: X-011