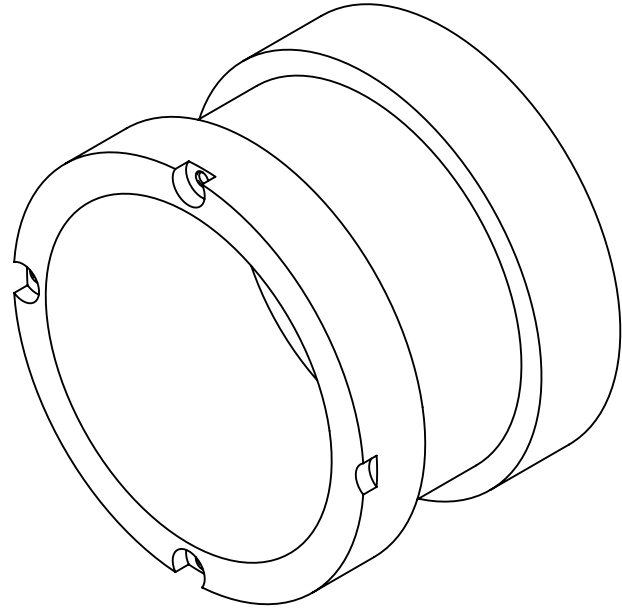


D1500428 aLIGO, SUS, PENRE ETM QUAD, 6.2 Kg CAN BODY, PART PDM REV: X-001, DRAWING PDM REV: X-001

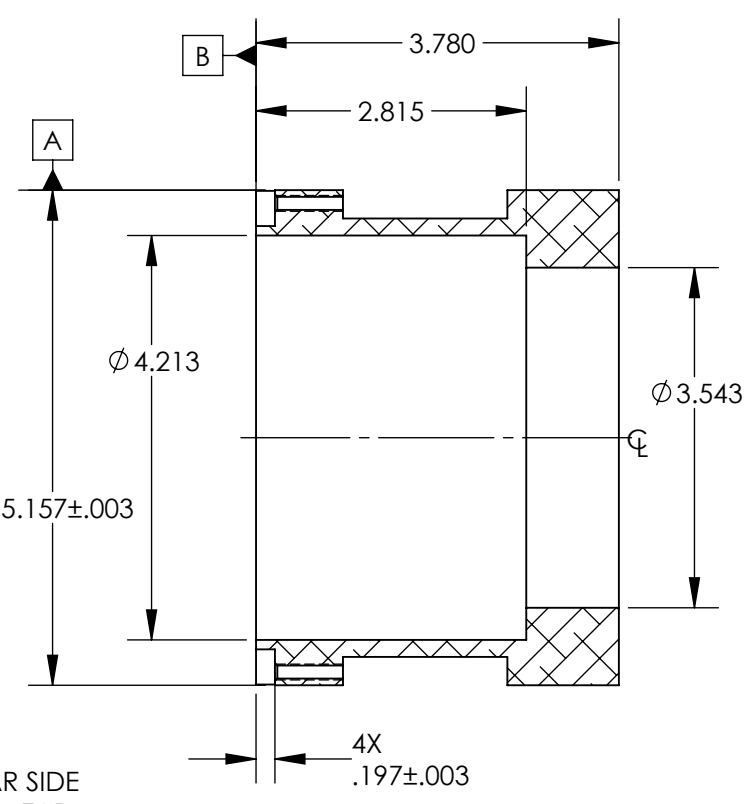
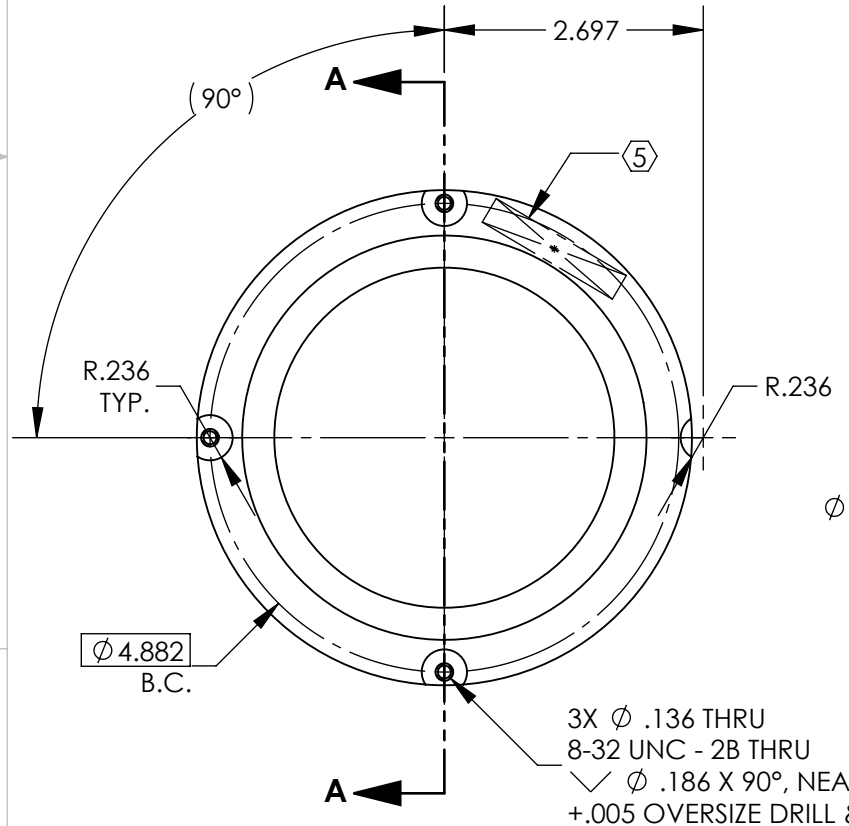
NOTES CONTINUED:

- 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: DXXXXXXX-VY, TYPE-XX, S/N XXX
- 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 8. 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.
- 9. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .015 MAX.

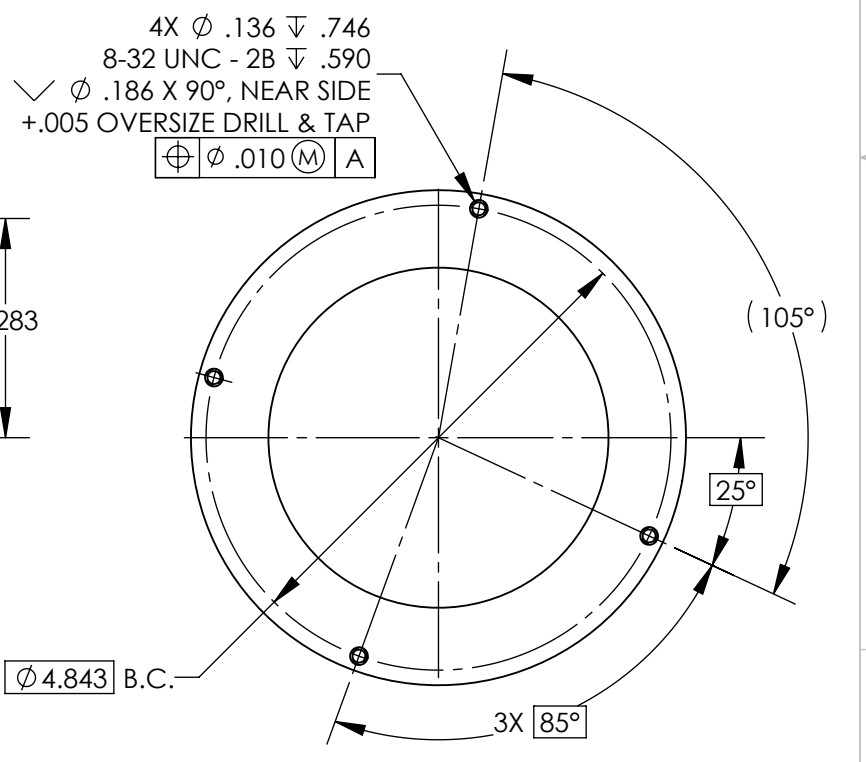
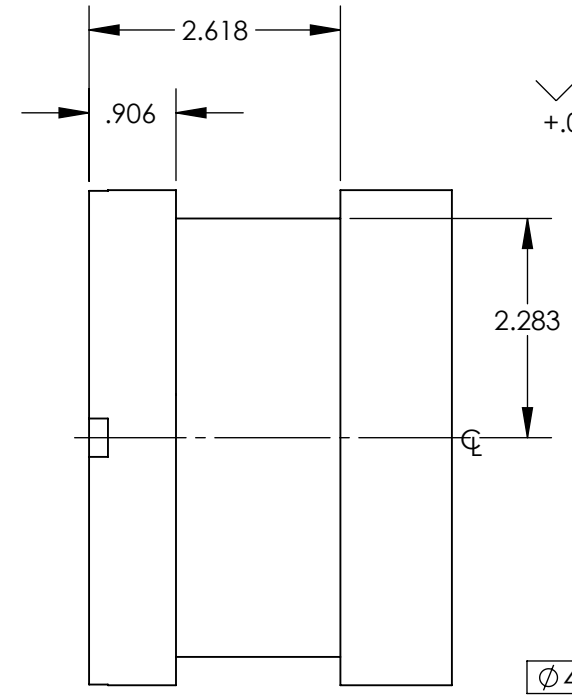
REV.	DATE	DCN #	DRAWING TREE #
v1	09 NOV 2015	E1500433-x0	-
v2	16 DEC 2015	E1500468-x0	-
-	-	-	-



ISO VIEW



SECTION 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. 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	FINISH
TUNGSTEN MT-17C	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME aLIGO, SUS, PENRE ETM QUAD, 6.2 Kg. CAN BODY	
SYSTEM	SUB-SYSTEM	DESIGNER	DATE
ADVANCED LIGO	SUS	E.SANCHEZ	13 OCT 2015
CHECKER	APPROVAL	DRAFTER	DATE
SEE DCC	SEE DCC	E.SANCHEZ	09 NOV 2015
SEE DCC	SEE DCC	CHECKER	DATE
SEE DCC	SEE DCC	APPROVAL	DATE
SEE DCC	SEE DCC	SCALE	PROJECTION
SEE DCC	SEE DCC	1:2	ASME Y14.5
NEXT ASSY		SIZE DWG. NO.	
D080166		B D1500428	
		REV.	
		v2	
		SHEET 1 OF 1	