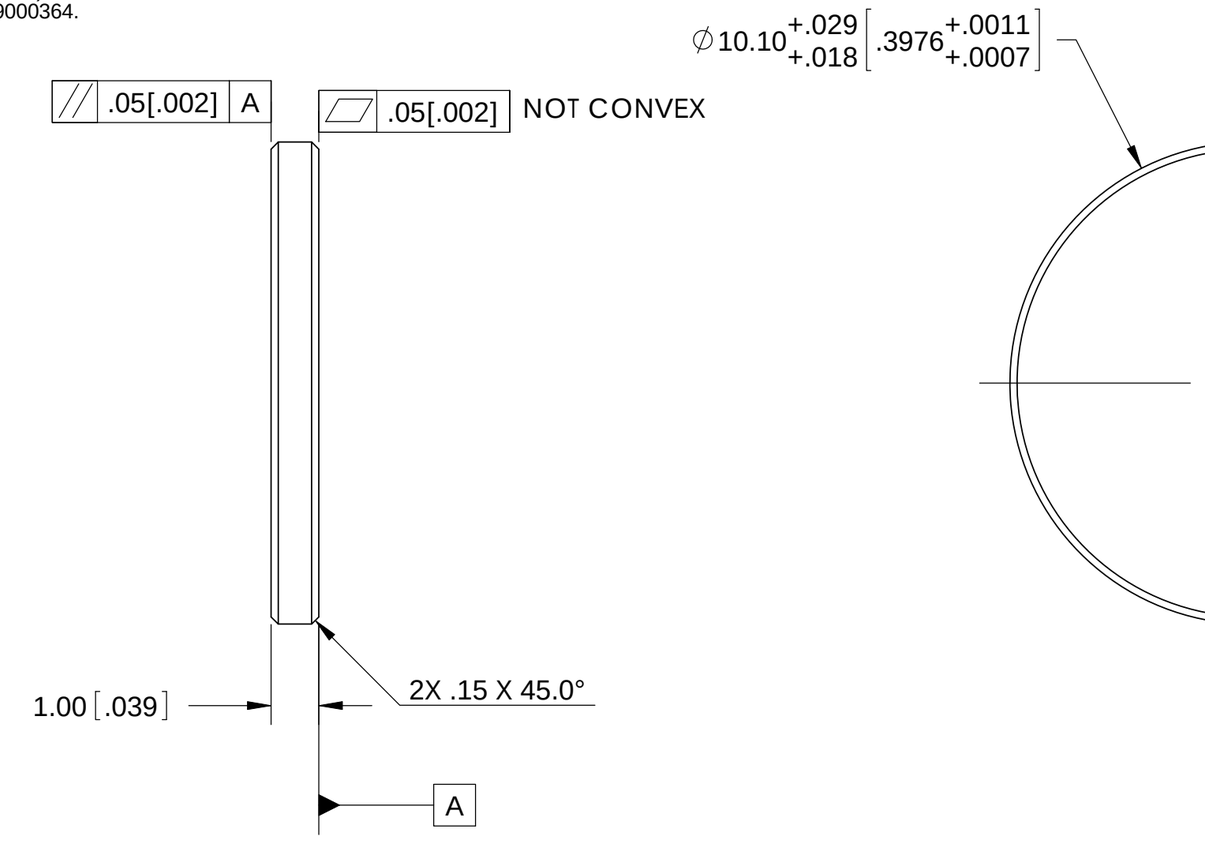
REV.	DATE	DCN #	DRAWING TREE #
v3	25 May 2011	E1100449	E1100450

NOTES CONTINUED:

4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
5. SCRIBE, ENGRAVE, 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. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIENT OR "TYPE" (IFF APPLICABLE), AND QUANTITY. IF PARTS ARE TO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
   EXAMPLE (PART) : 001-V1
   EXAMPLE (TAG) DXXXXXXX-VY, TYPE-XX, S/N XXX QTY:TBD.
6. APPROXIMATE WEIGHT = 0.643 grams.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES (INCLUDING SANDING OR SCOURING FOR MATTE FINISH) IS NOT ALLOWED. USE OF SCOTCH-BRITE OR SIMILAR PRODUCTS IS FORBIDDEN.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. ALL MATERIAL TO BE VIRGIN MATERIAL, (I.E. NOT WELD REPAIRS OR PLUGS) UNLESS APPROVED IN ADVANCE AND 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 MATERIAL USED MUST BE VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF AND WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH THE MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E09000364.



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)									
DIMENSIONS ARE IN MM [INCHES] TOLERANCES: .XX ± .1[.004] .XXX ± N/A ANGULAR ± .5°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .76[.03] x 45°. 3. DO NOT SCALE FROM DRAWING.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: MAGNET PLUG, aLIGO SUS				
MATERIAL: 416 SSTL	FINISH: 63 µinch		SYSTEM: ADVANCED LIGO	SUB-SYSTEM: SUS	DESIGNER: J.ODELL 15 Mar. 2010	SIZE: B	DWG. NO.: D060401	REV.: v3	
			NEXT ASSY: D1100937		DRAFTER: M.HILLARD 25 May 2011				
					CHECKER: J.LEWIS 17 Mar 2010				
					APPROVAL: J.ROMIE 25 May 2011	SCALE: 8:1	PROJECTION:	SHEET 1 OF 1	

d060401, PART PDM REV: X-012, DRAWING PDM REV: X-004