

D0902060_Advanced_LIGO_SUS_HLTS_Base_Plate_Magnet_Placement_Fixture_Intermediate_Mass_PART PDM REV: V1-000, DRAWING PDM REV: V1-001

NOTES CONTINUED:

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. USE MINIMUM 0.12" HIGH CHARACTERS. UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

6. SCRIBE OR ETCH LINES AS SHOWN .02 DEEP X .02 WIDE.

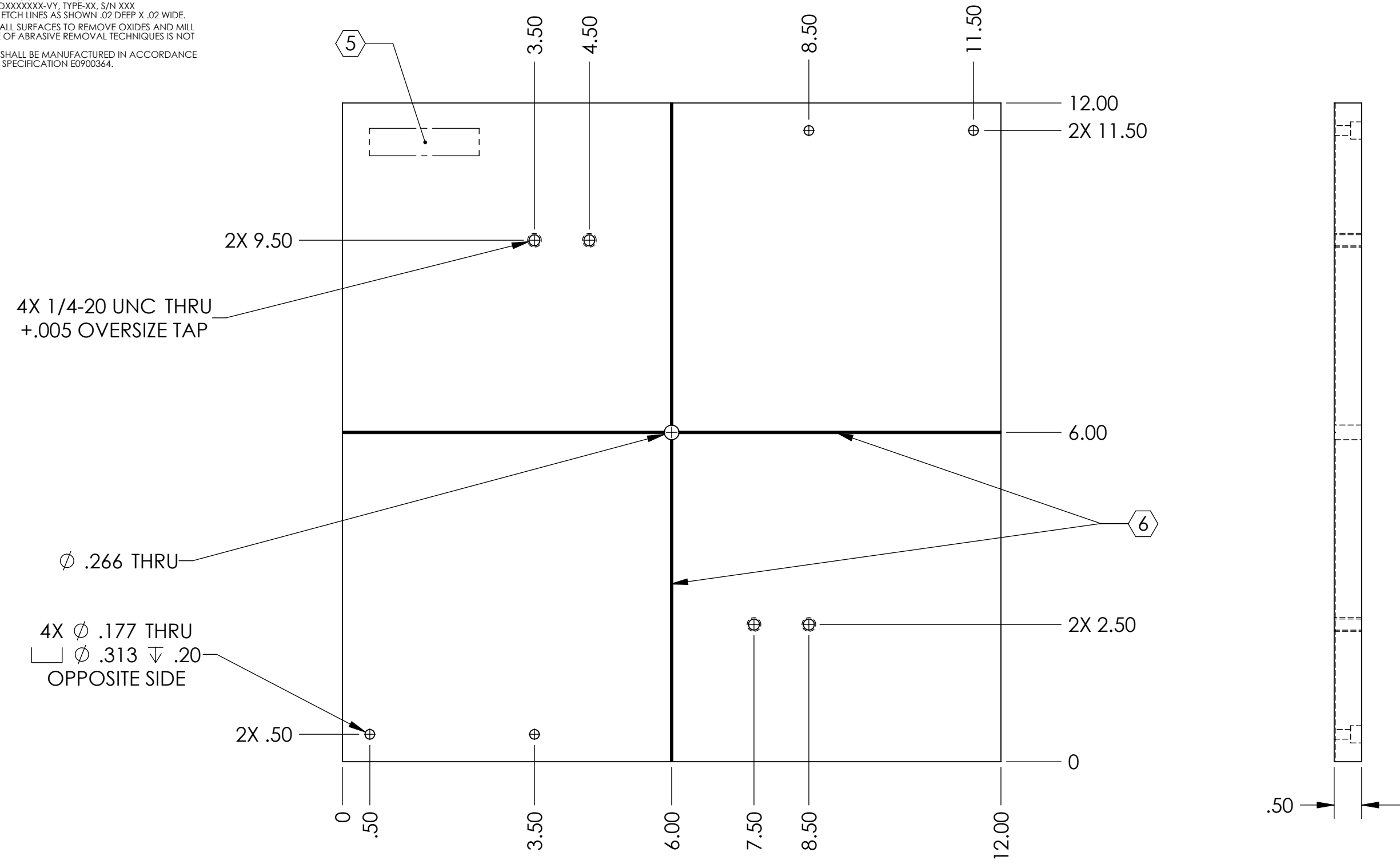
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	15 SEP 2009	E0900302	E080191
v2	23 FEB 2011	E1100132	E080191
-	-	-	-

D
C
B
A

D
C
B
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, R.02 MIN. 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
6061-T6 Al	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		BASE PLATE	
SYSTEM	SUB-SYSTEM	DESIGNER	DATE	SIZE	DWG. NO.
ADVANCED LIGO	SUS	D. BRIDGES	15 SEP 2009	B	D0902060
NEXT ASSY	CHECKER	R. BIEDENHARN	11 DEC 2010	REV.	v2
MAGNET PLACEMENT FIXTURE, INT. MASS	D. BRIDGES	14 APR 2011	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1