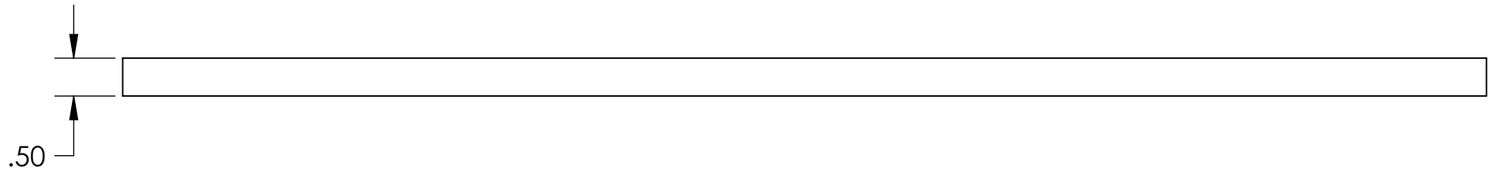
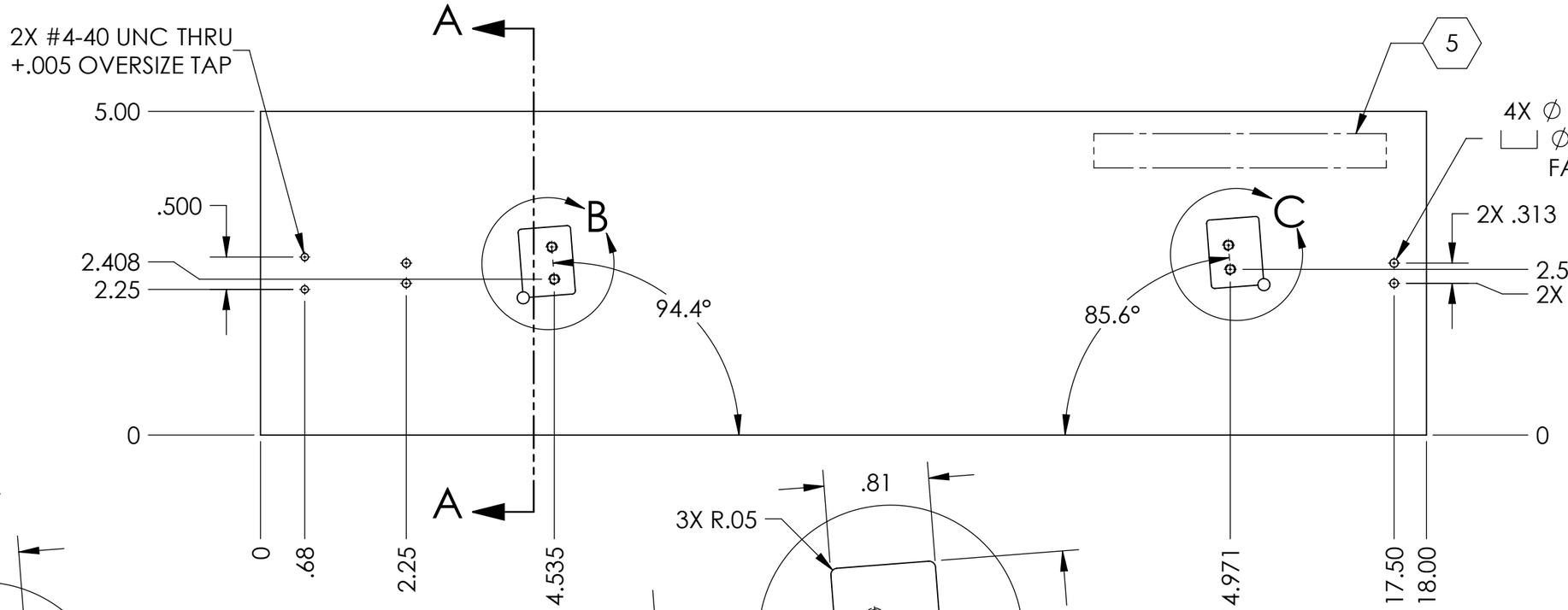
NOTES CONTINUED:

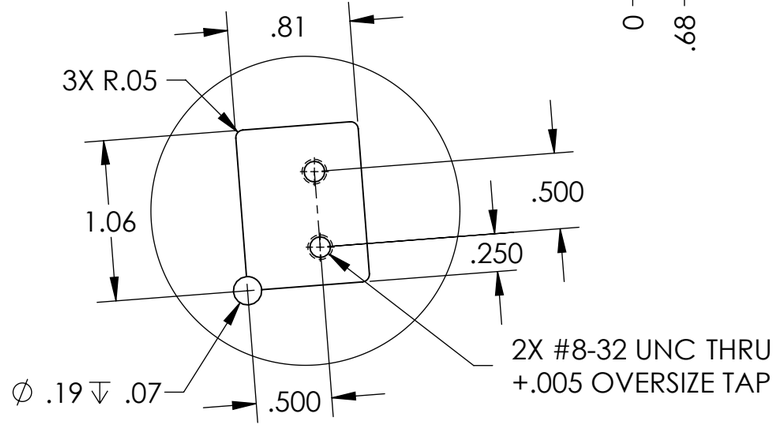
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 101 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX
6. APPROXIMATE WEIGHT = 4.370 LB.
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	09 APR 2010	E0900502	E0900353
v2	02 SEP 2010	E1000347	E0900353
-	-	-	-

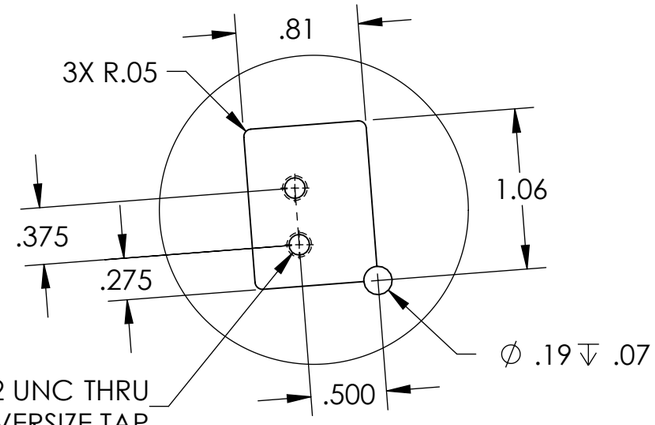




SECTION A-A



DETAIL B
SCALE 1 : 1



DETAIL C
SCALE 1 : 1

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.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: BASE PLATE, UPPER WIRE JIG				
	MATERIAL: 6061-T6 Al	FINISH: 63 µinch	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: SUS	DESIGNER: B. MOORE 21 SEP 2009	SIZE: B	DWG. NO.: D0902109	REV.: v2	
			NEXT ASSY: D0902108		DRAFTER: B. MOORE 03 MAR 2010				
					CHECKER: M. MEYER 04 MAR 2010				
					APPROVAL	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1	

D0902109_AdvLIGO_SUS_HSTS_Base_Plate_Upper_Wire_Jig, PART PDM REV: X-007, DRAWING PDM REV: X-005