

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: DXXXXXX-VY, TYPE-XX, S/N XXX

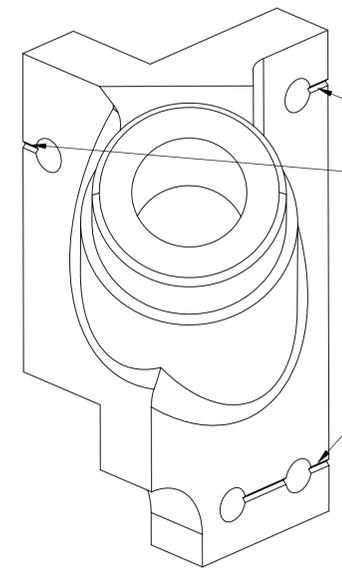
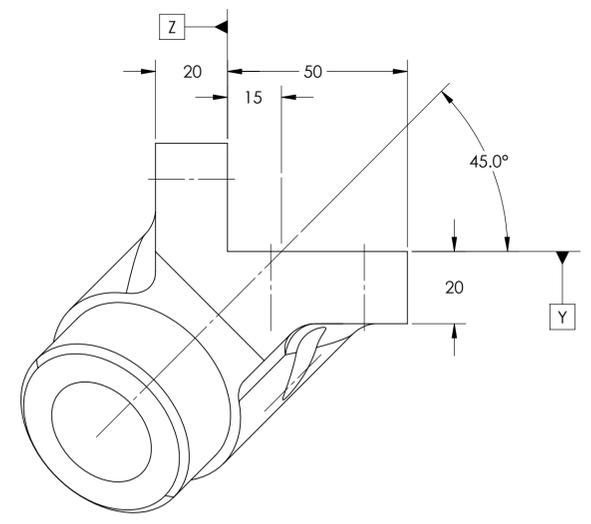
6. APPROXIMATE WEIGHT = 2.33 LB.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

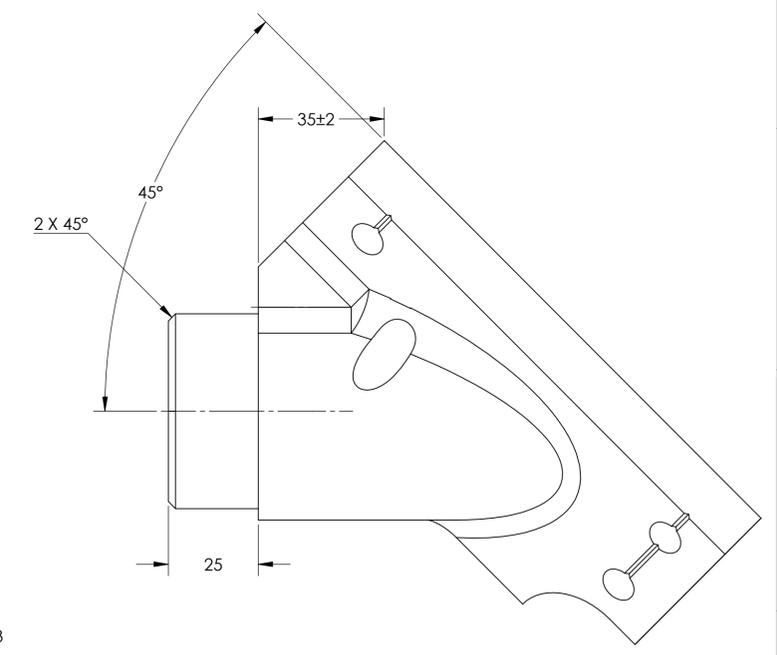
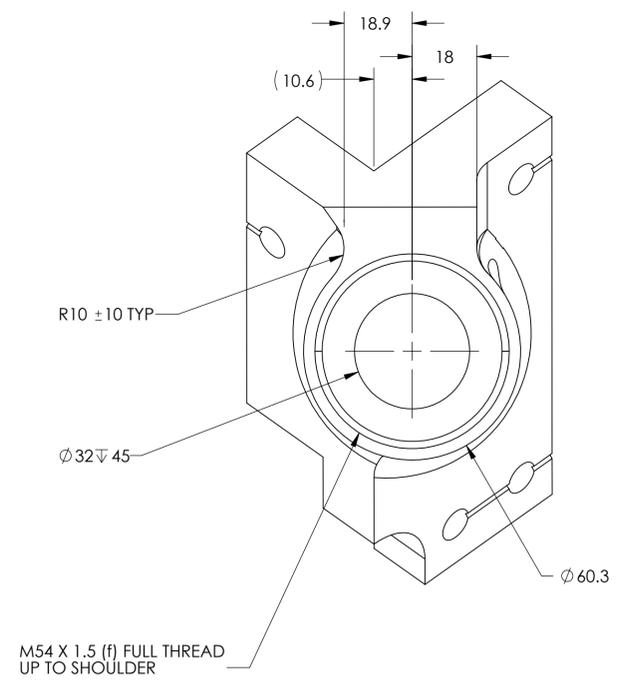
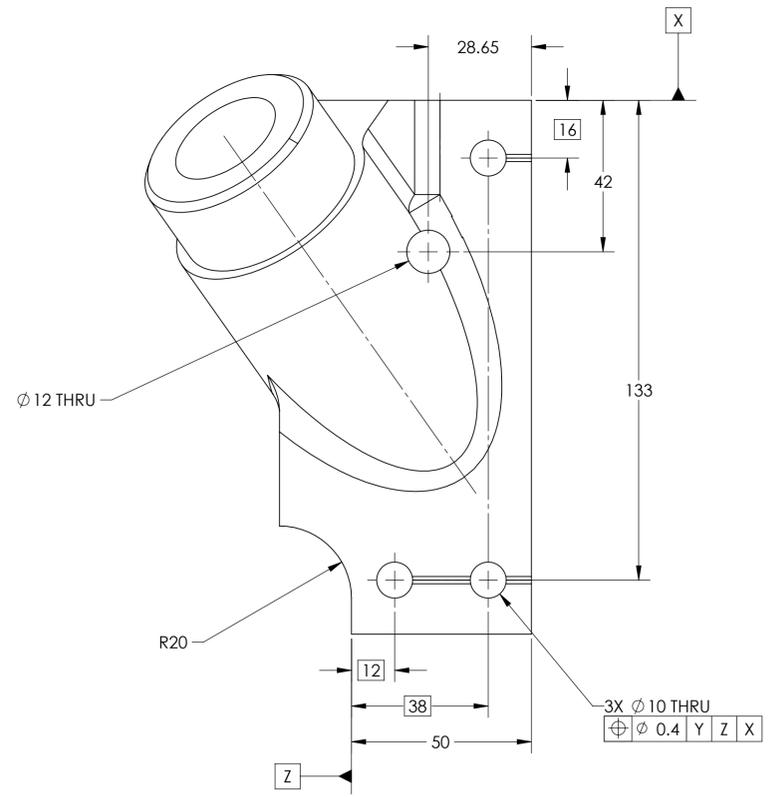
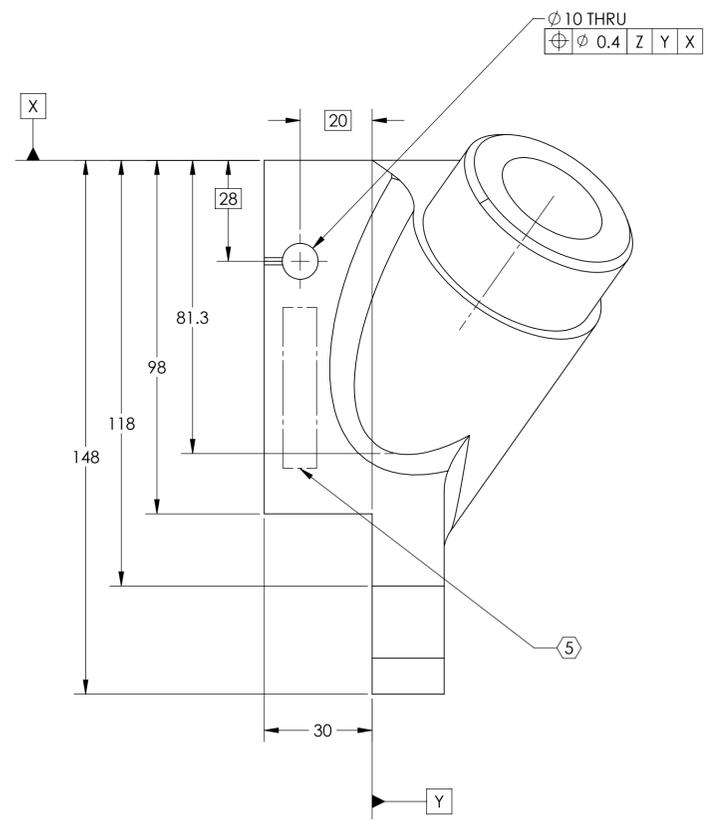
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL MATERIAL IS TO BE VIRGIN MATERIAL [i.e. NO WELD REPAIRS, FLUGS OR RECYCLED MATERIAL]. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

REV.	DATE	DCN #	DRAWING TREE #
V3	8 JAN 2013	E1300014	-
-	-	-	-
-	-	-	-



ENGRAVE 90° VEE GROOVE X 1 DP



DIMENSIONS ARE IN MILLIMETERS		TOLERANCES:		ANGULAR ± .5°		MATERIAL		FINISH		NEXT ASSY		SYSTEM		SUB-SYSTEM		PART NAME		DESIGNER		DRAFTER		CHECKER		APPROVAL		SIZE		DWG. NO.		REV.	
.XX ± .25		.XXX ± .12				6061-T6 Al		63 μinch		D080501		ADVANCED LIGO		SUS		BS UPPER STRUCTURE STAY BRACKET 2		J O'DELL		J O'DELL		AJB		JOD		D		D080507		v3	
																								SCALE: 1:1		PROJECTION:		SHEET 1 OF 1			

D080507 BS UPPER STRUCTURE STAY BRACKET 2 PART FDM REV: X003 DRAWING FDM REV: X000