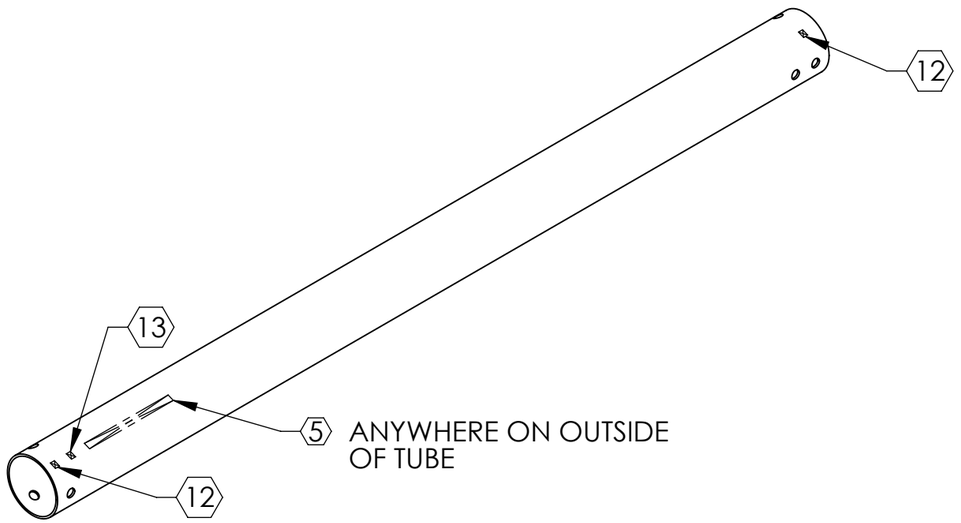
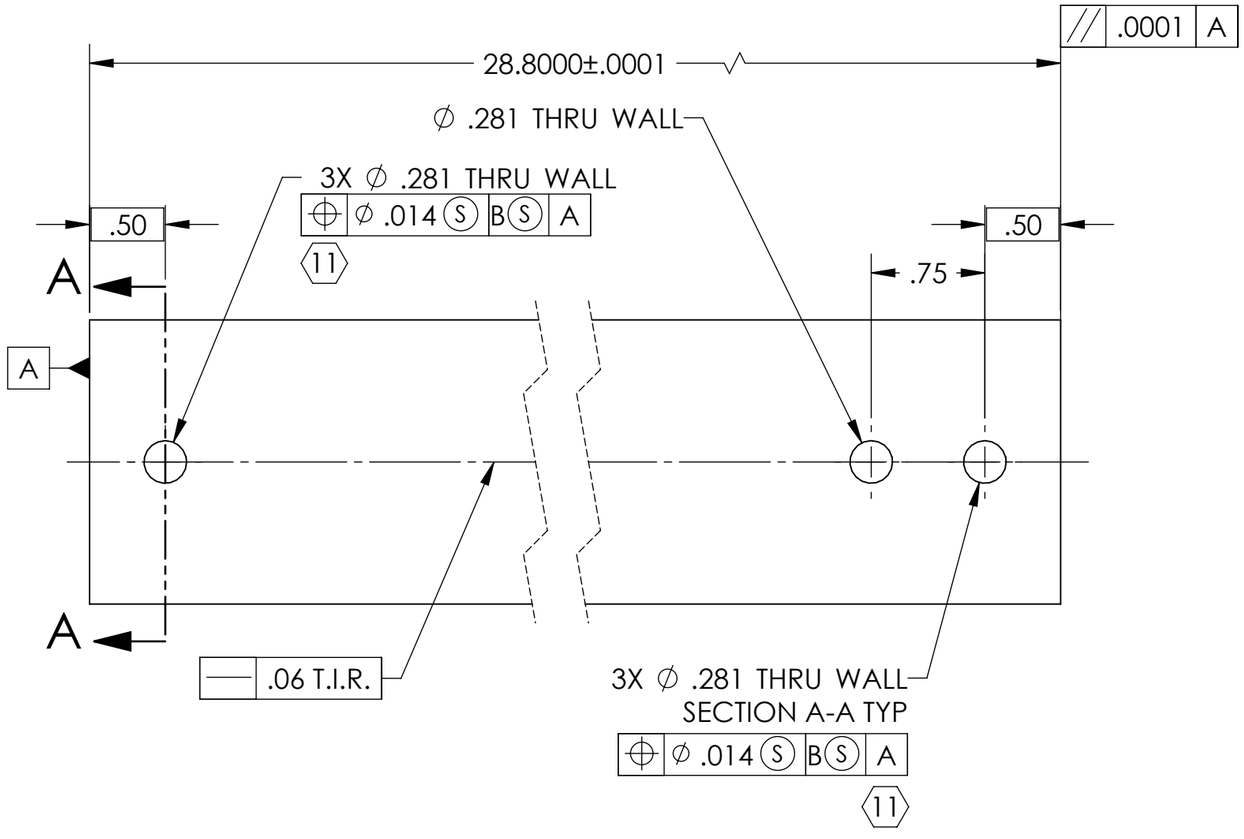
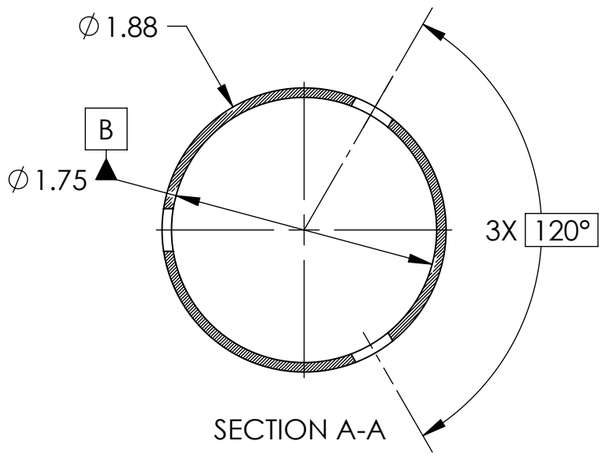
NOTES CONTINUED:

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: DXXXXXXX-VY, TYPE-XX, S/N XXX
6. APPROXIMATE WEIGHT = 2.97 LB (1.35 kg).
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.
9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE 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 SHOUL DBE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTITIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.
11. ALIGNMENT OF HOLE PATTERN AT SECTION A-A WITH HOLE PATTERN AT OPPOSITE END IS NOT REQUIRED.
12. PARTS TO BE MARKED SEQUENTIALLY AT EACH END BEGINNING WITH 'AA' & 'AB' (FOR THE FIRST PART), 'AC' & 'AD' FOR THE SECOND PART ETC., IN THE APPROXIMATE LOCATIONS SHOWN BETWEEN ANY TWO RADIALLY PATTERNED HOLES. CHARACTER HEIGHT .12" MINIMUM.
13. PARTS TO BE MADE IN GROUPS OF THREE TO OPTIMIZE LENGTH EQUIVALENCE WITHIN GROUPS. MARK EACH PART IN A GROUP WITH AN IDENTICAL GROUP NUMBER. MARK AT APPROXIMATE LOCATION SHOWN. CHARACTER HEIGHT .12" MINIMUM. SYNTAX: G1 (FOR GROUP 1), G2, G3, ETC..
14. ELECTROPOLISH PER LIGO SPECIFICATION E0900364, SECTION 5.2.2 (APPLIED TO INVAR 36).

REV.	DATE	DCN #	DRAWING TREE #
v1	03-SEPT-2010	E1000365	-
V2	16-NOV-2010	E1000688	-
-	-	-	-







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: Invar 36 Bar	FINISH: 63 µinch Ra (14)		

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	PART NAME: ADLIGO ETM TELE TUBE					
NEXT ASSY: D1000243		DESIGNER	KMAILAND	08-10-2009	SIZE: B	DWG. NO.: D1000072	REV.: v2
		DRAFTER	I ROMERO	04-MAY-2010			
		CHECKER	K MAILAND	04-MAY-2010			
		APPROVAL	K MAILAND	04-MAY-2010	SCALE: NONE	PROJECTION:	SHEET 1 OF 1

D1000072 ADLIGO_ETM_TELE_TUBE, PART PDM REV: X-030, DRAWING PDM REV: X-017