

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

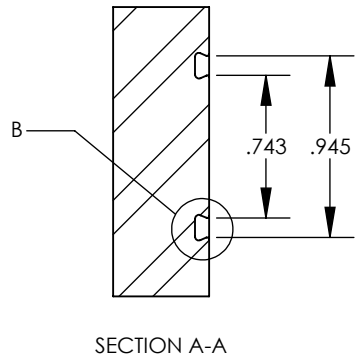
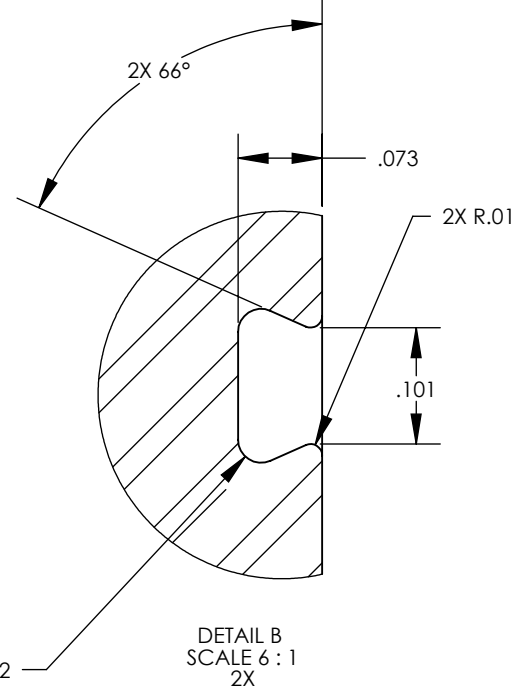
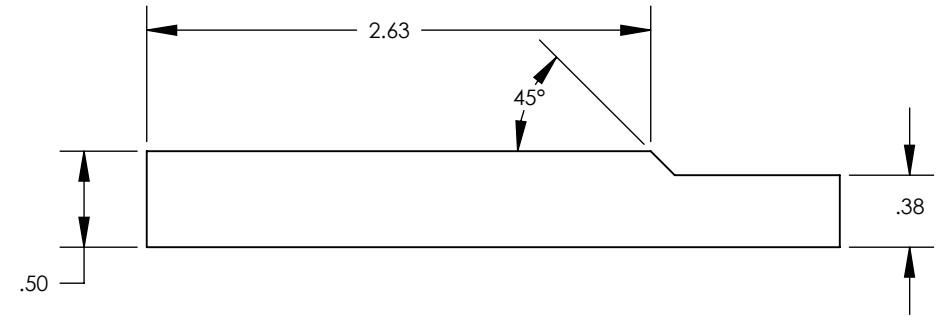
6. APPROXIMATE WEIGHT=0.89 LB.

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

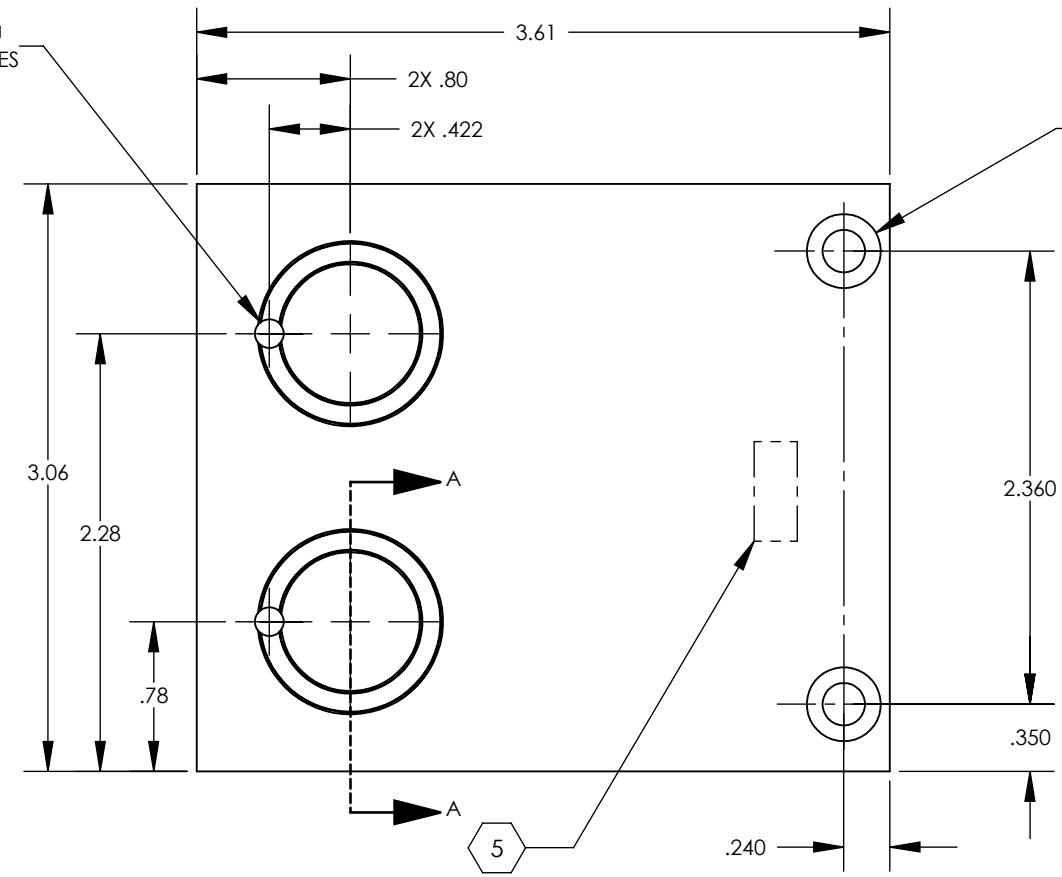
8. PART SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

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

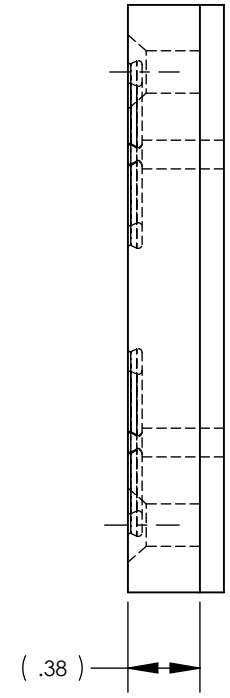
REV.	DATE	DCN #	DRAWING TREE #
v3	28 JUN 2011	E1000335	
v3	22 AUG 2012	E1000335	



2X Ø .15 THRU
BREAK ALL EDGES



2X Ø .221 THRU ALL
∇ Ø .39 X 82°



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± 1.0°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES 0.005" TO 0.015".
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE REFER TO LIGO E0900237 FOR LIST OF APPROVED COOLANTS.

MATERIAL 99.999% COPPER FINISH 63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM AOS

NEXT ASSY D1000863, D1002564

PART NAME			SLC COPPER PLATE		REV.
DESIGNER	N.Nguyen	01 Jun 2010	SIZE	DWG. NO.	v3
DRAFTER	TQ. NGUYEN	25 MAY 2010	B	D1000909	
CHECKER	M. SMITH	30 JUN 2010	SCALE:	1:1	
APPROVAL	D. COYNE	10 SEP 2010	PROJECTION:		SHEET 1 OF 1

D1000909_AdlLIGO_AOS_SLC 4-Way Copper Plate, PART PDM REV: X-018, DRAWING PDM REV: X-034