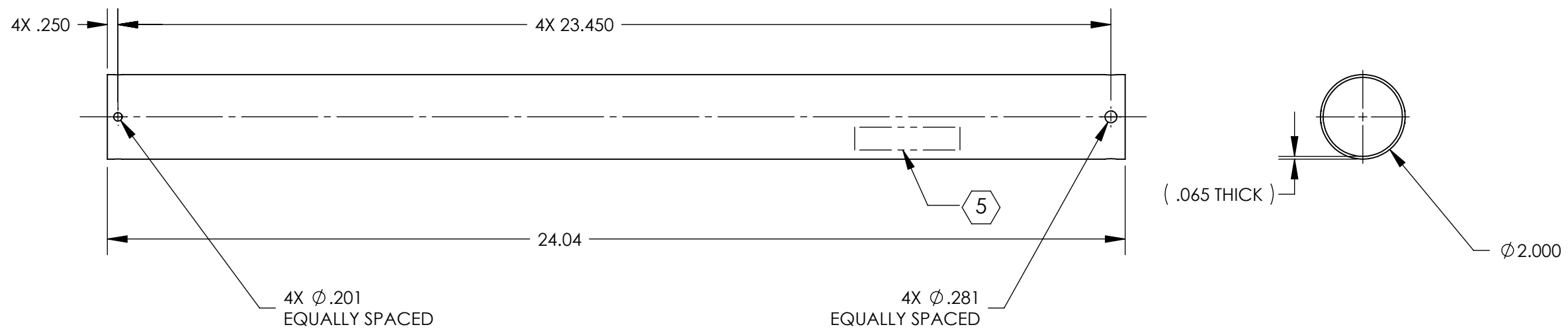


NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
EXAMPLE (PART): 001-v1
EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD
- 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS OR PLUGS) UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO. REFER TO LIGO-E0900364.
- 9. 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 SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.
- 10. ELECTROPOLISHING PER E0900364, SECTION 5.1 TO REMOVE ALL SURFACE OXIDES AND POTENTIALLY EMBEDDED CONTAMINANTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	18 NOV 2010	E1000736	-
-	-	-	-
-	-	-	-



D1001044_AdlIGO_AOS_ITM Elliptical Down Tube, PART PDM REV: X-002, DRAWING PDM REV: X-001

DIMENSIONS ARE IN		TOLERANCES:		ANGULAR ± .5°		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
.XX ± .02		.XXX ± .010				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.		SYSTEM		ITM ELLIPTICAL DOWN TUBE	
MATERIAL		FINISH		NEXT ASSY		DESIGNER		DRAFTER		SIZE DWG. NO.	
6061-T6 Al, TUBE		5		D1002850		MRUIZ		05 NOV 2010		B D1001044	
						CHECKER		APPROVAL		REV.	
										v1	
						SCALE: 1:3		PROJECTION:		SHEET 1 OF 1	