

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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

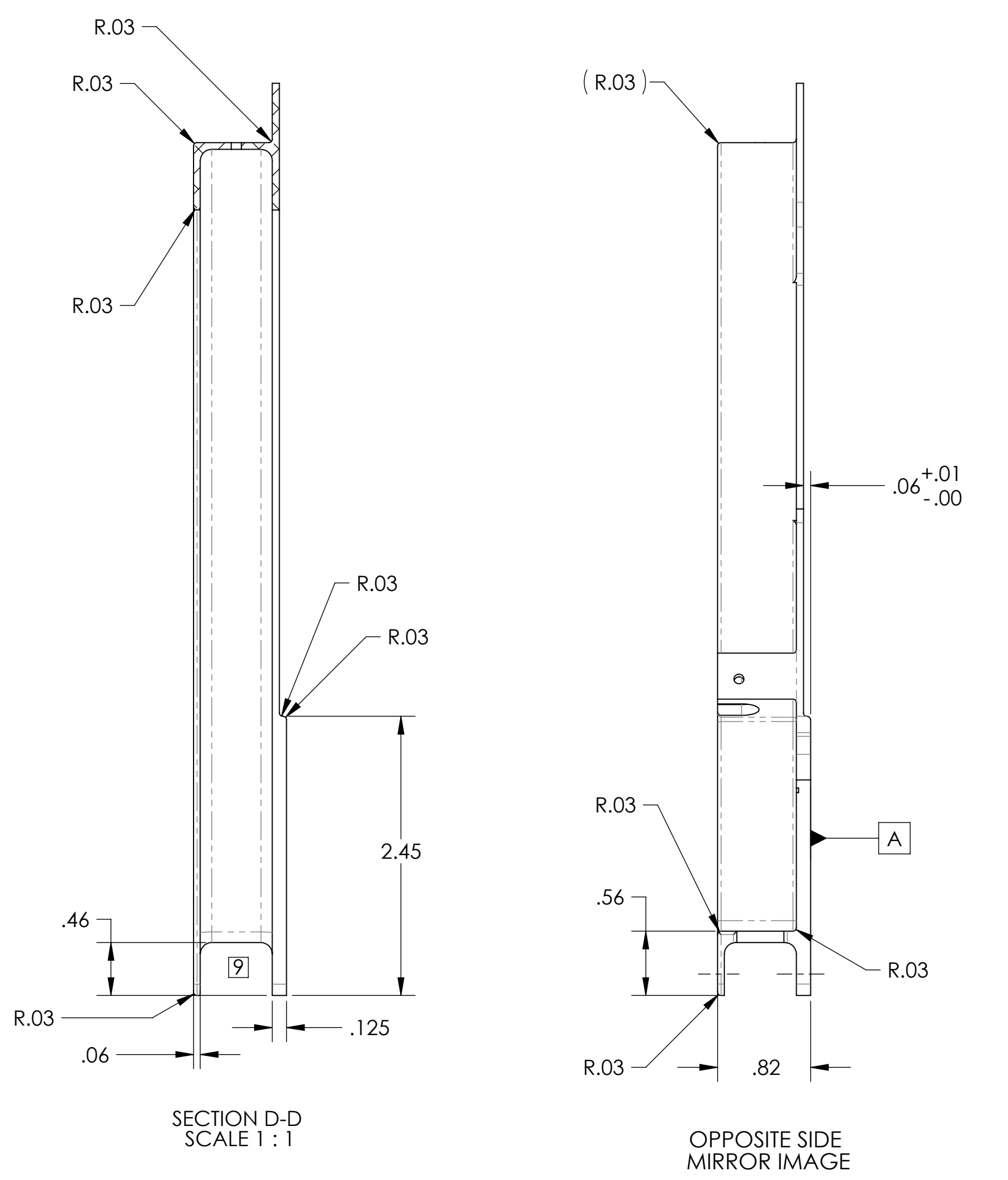
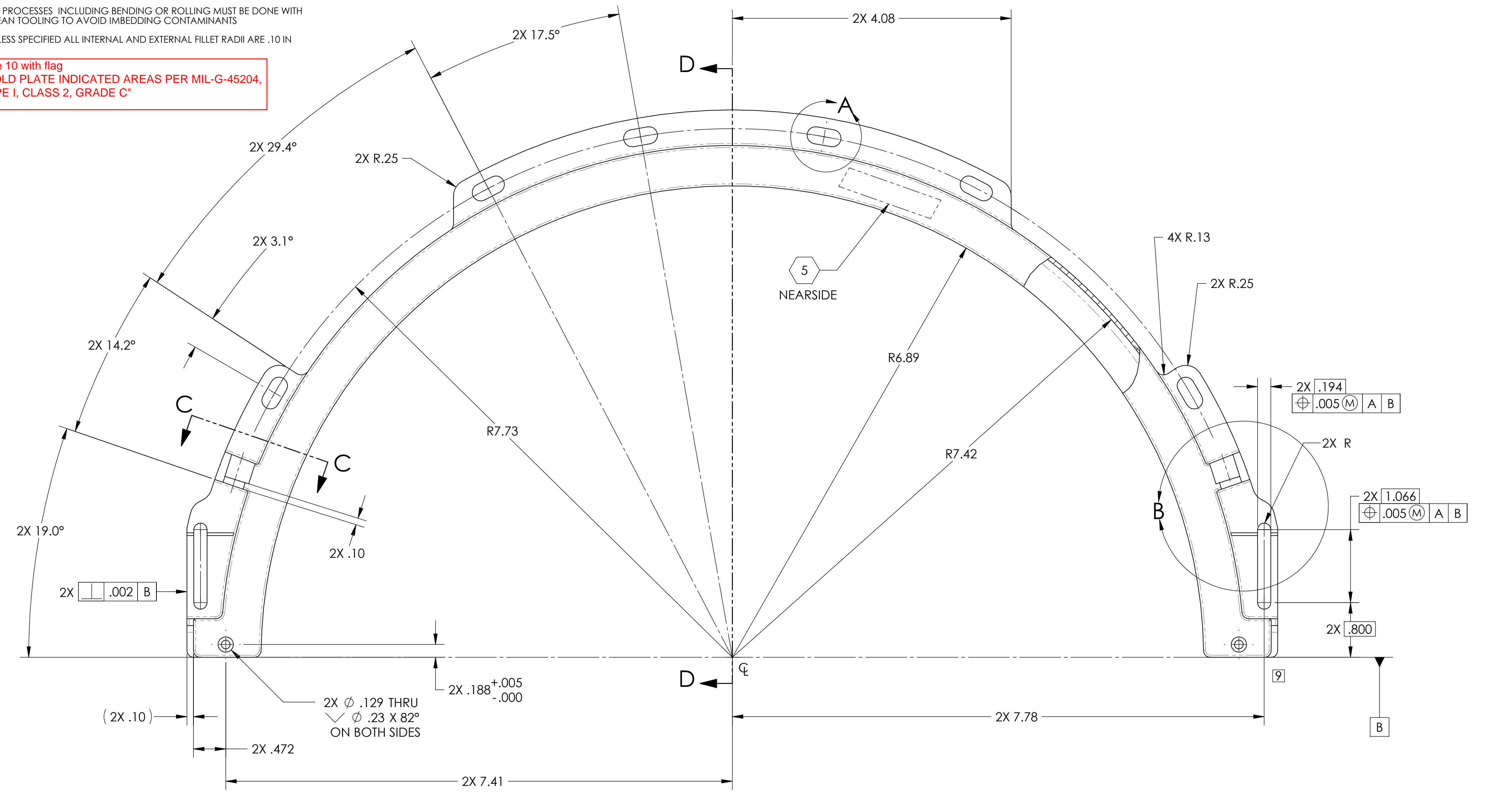
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

8. ALL PROCESSES INCLUDING BENDING OR ROLLING MUST BE DONE WITH CLEAN TOOLING TO AVOID IMBEDDING CONTAMINANTS

9. UNLESS SPECIFIED ALL INTERNAL AND EXTERNAL FILLET RADII ARE .10 IN

redline Appert
2023.06.02

note 10 with flag
"GOLD PLATE INDICATED AREAS PER MIL-G-45204, TYPE I, CLASS 2, GRADE C"

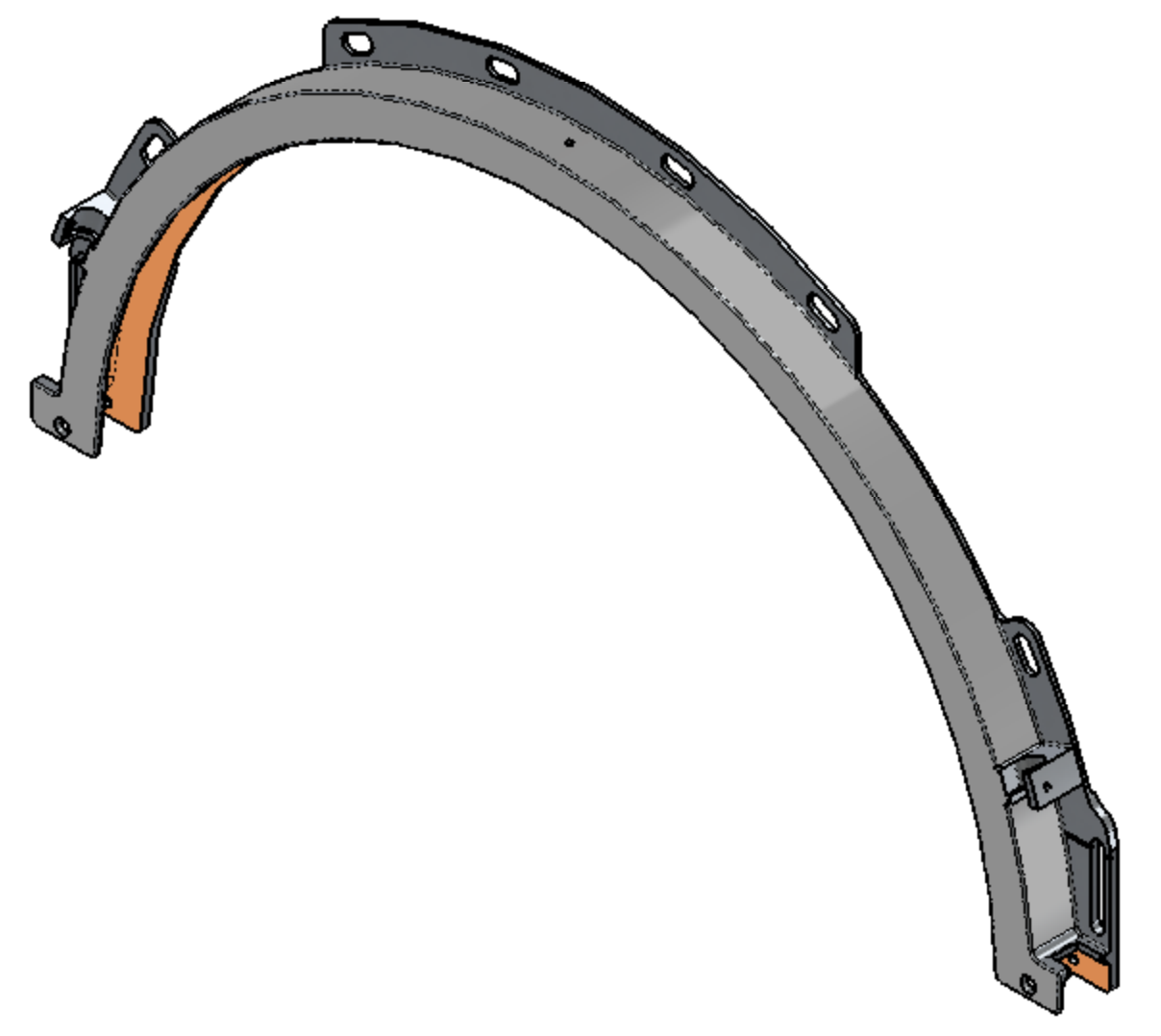


move to note, add flag

TYPE 1 GOLD PLATING PER MIL-G-45204
INTERIOR SURFACES ONLY

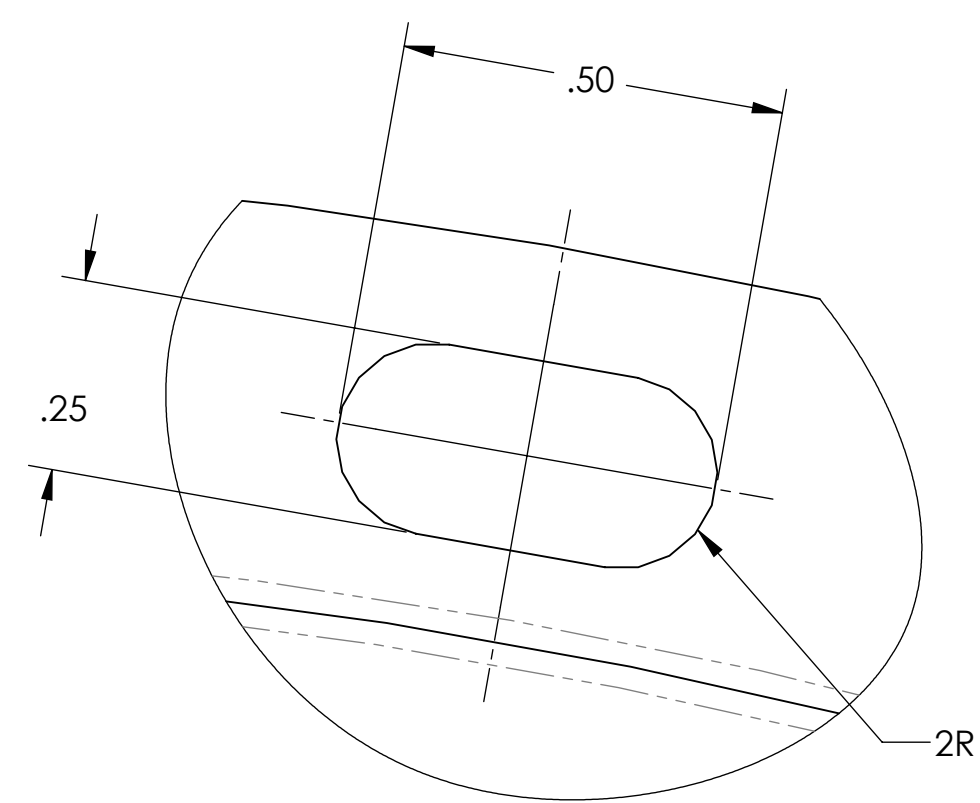
#4-40, .005 OVERSIZED
DRILL AND TAP THRU ALL

callout per ligo spec - use standard SW callout to generate size and tolerance for pilot drill, reference UNC; then, add "H11 (+.005)

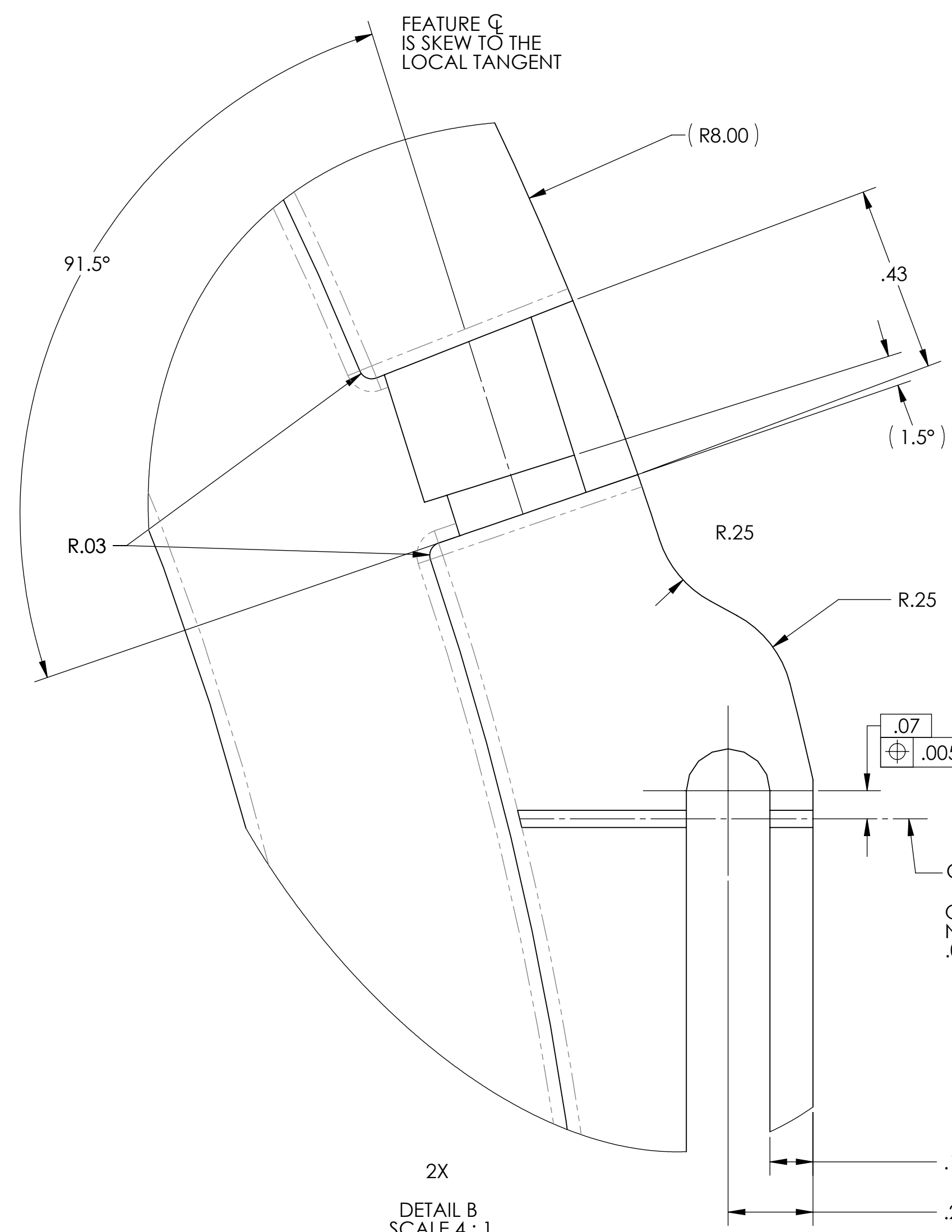


DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME aLIGO TCS UPPER MONOLITHIC RH SHIELD	
TOLERANCES: .XX ± .01 .XXX ± .005		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP 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 ADVANCED LIGO		SUB-SYSTEM AOS	
ANGULAR ± 1.0°		MATERIAL 6061 Alloy		FINISH 32 μinch		NEXT ASSY D1001838	
				DESIGNER M. JACOBSON		21 APR 2010	
				DRAFTER A. COLE		7/13/2010	
				CHECKER M. JACOBSON		9/22/2011	
				APPROVAL A. BROOKS		9/23/2011	
				SIZE D		DWG. NO. D1001679	
				SCALE: 1:2		PROJECTION:	
						SHEET 1 OF 2	
						REV. v6	

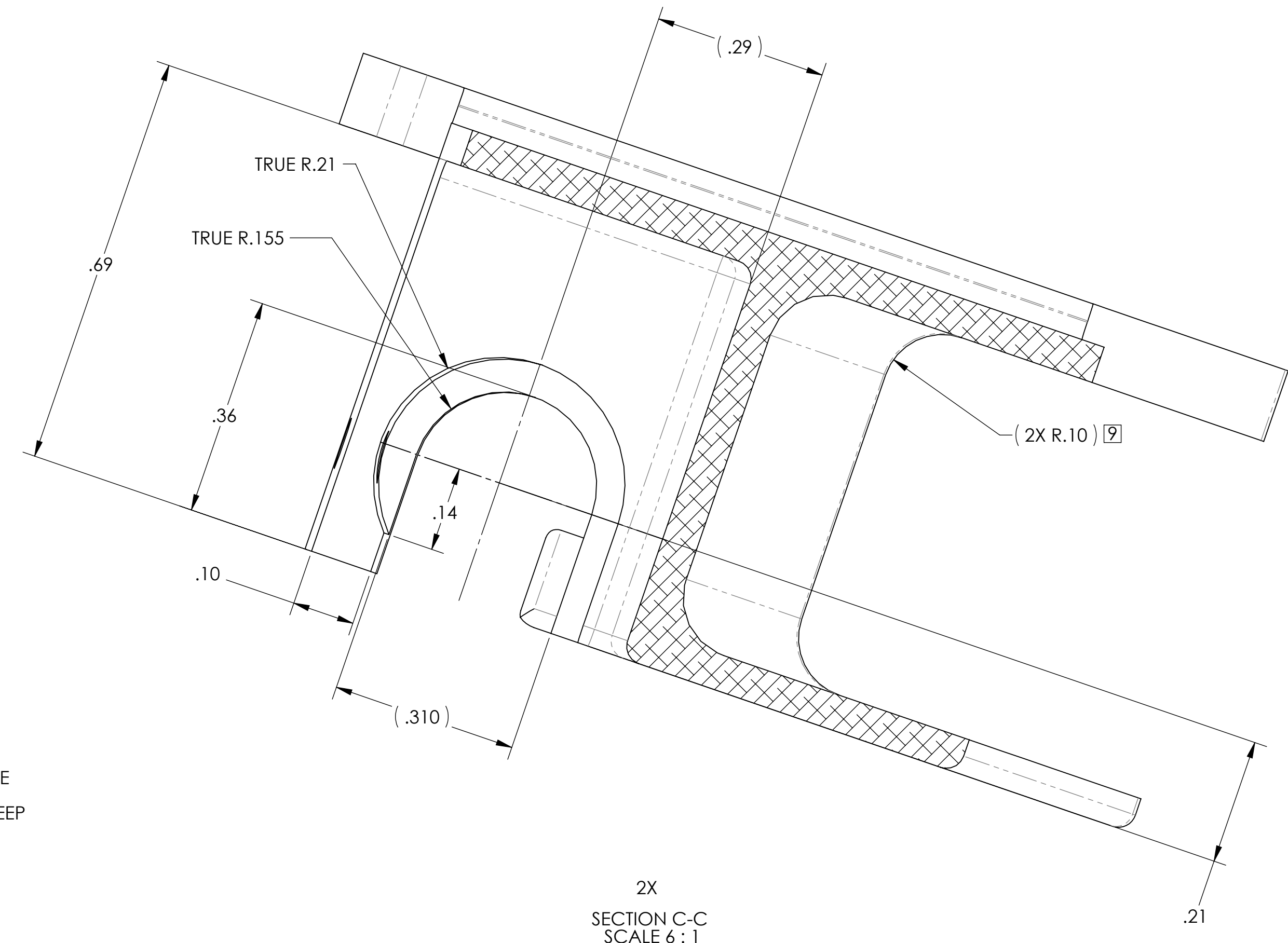
D1001679_ALIGO TCS UPPER MONOLITHIC RH SHIELD PART PDM REV: X043 DRAWING PDM REV: X038



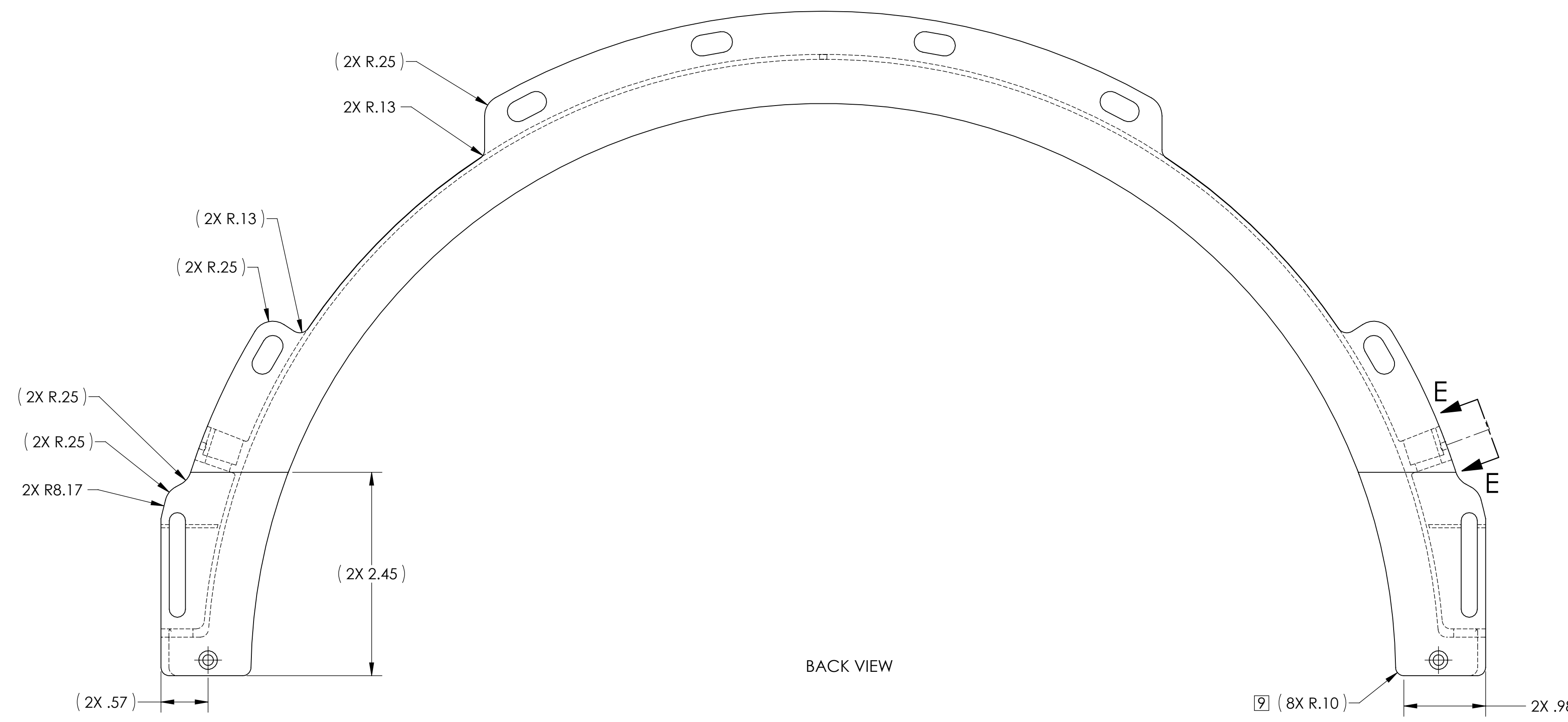
6X
DETAIL A
SCALE 4 : 1



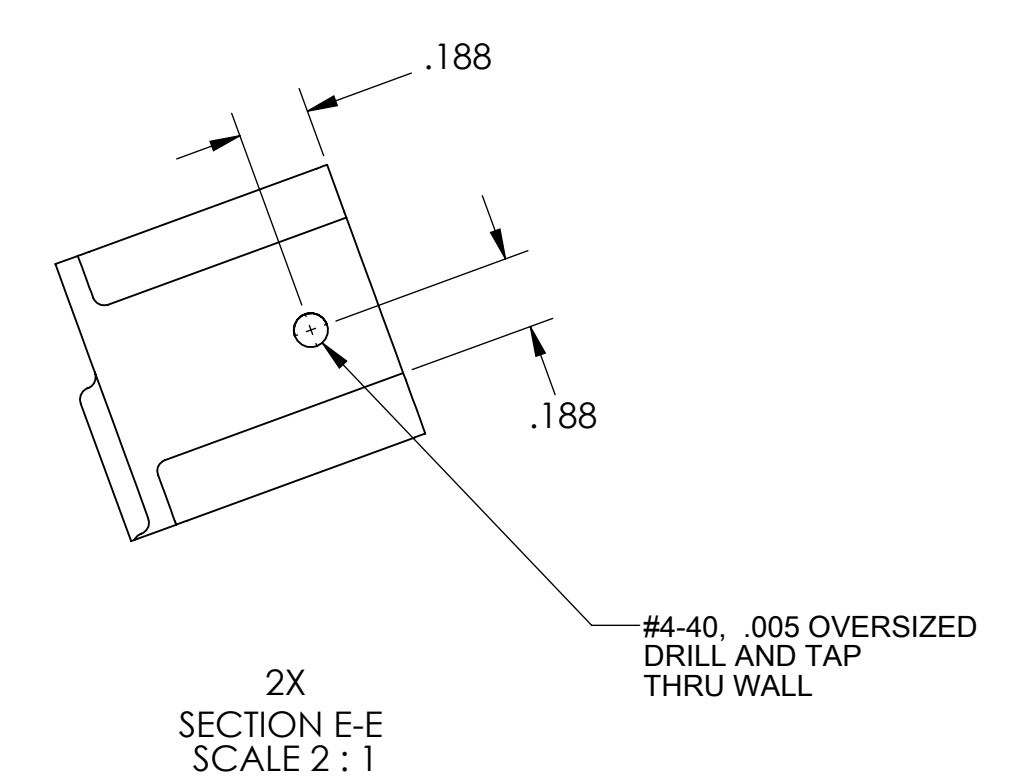
2X
DETAIL B
SCALE 4 : 1



2X
SECTION C-C
SCALE 6 : 1



BACK VIEW



2X
SECTION E-E
SCALE 2 : 1

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE DWG. NO.	REV.
D D1001679	V6
SCALE: 1:2	PROJECTION:
SHEET 2 OF 2	

D1001679_ALIGO_TCS_UPPER_MONOLITHIC_RING_HEATER_SHIELD_PART_PDM_REV_X043_DRAWING_PDM_REV_X038