

REV.	DATE	DCN #	DRAWING TREE #
Α	20APR'05	Е050122-00-К	

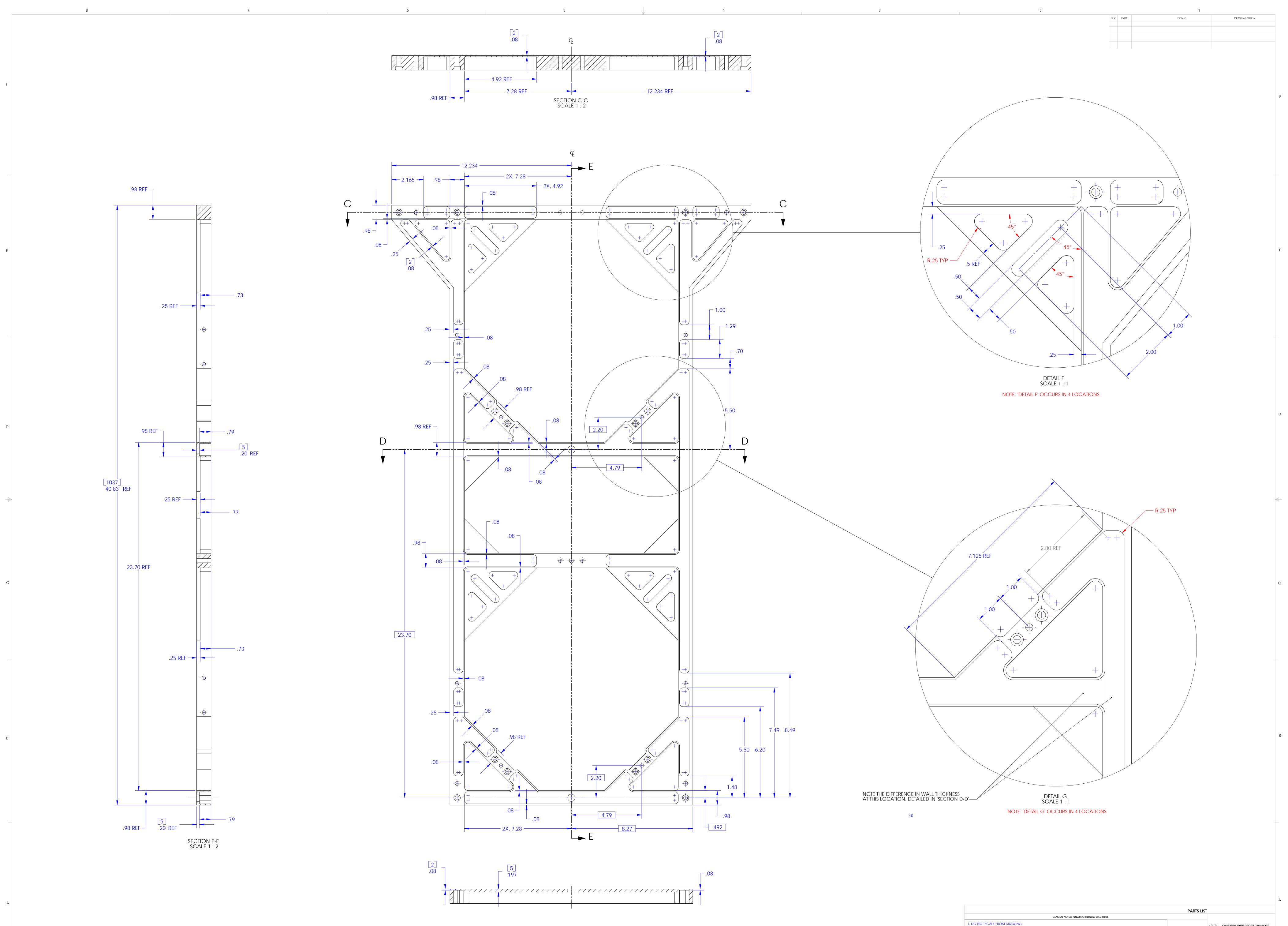
E

D

В

A

GENERAL NOTES: (UNLESS OTHERWISE SPECIFIED)			
1. DO NOT SCALE FROM DRAWING.		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
2. REMOVE ALL SHARP EDGES, R.02 MIN.		IGR, GLASGOW UNIVERSITY GEO 600 GROUP	
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE.	DIMENSIONS ARE IN II TOLERANCES:	NCHES	
③ SCRIBE, ENGRAVE OR MECHANICALLY STAMP DRAWING (NO INKS OR DYES) PART NUMBER, REVISION ON NOTED SURFACE O FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND	F & AR = 0.05		SYSTEM ADVANCED LIGO
PROCEED CONSECUTIVELY. USE .12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALL CHARACTERS.			sub-system sus
S/N 001	6061-T6 /	AI	NEXT ASSY ASSEMBLY RIG_SINGLE CATCHER
5. THE COMPONENT IS SYMMETRIC ABOUT THE 4	^{FINISH} 32 μ inch		
6. DUAL DIMENSIONS (MILLIMETERS) APPEAR IN SQUARE BRACKETS[], PRIMARILY FOR ADVANCED LIGO TECHNICAL REFERENCE	NAME	DATE	INNER FACEPLATE
7. BACKGROUND INFORMATION:	DRAWN RAJ CHECKED MPL	04/05 APR 05	size dwg. no. E D050090 A1
Initial discussions with machinists at caltech inicated that water jet cutting would be used to achieve the basic shapes, then any finishing would be done by milling with a R.25" cutter.	APPROVED		E D030070 A1 SCALE: 1:2 PROJECTION: Image: Comparison of the state of
			4



SECTION D-D SCALE 1 : 2

5

4

6

7

8

2. REMOVE ALL SHARP EDGES, R.02 MIN.

3

2

DIMENSIONS ARE IN INCHES

 SCRIBE, ENGRAVE OR MECHANICALLY STAMP DRAWING (NO INKS OR DYES) PART NUMBER, REVISION ON NOTED SURFACE OF FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALL CHARACTERS.

 A VIBRATORY TOOL MAY BE USED. EXAMPLE:
 D050090-A1

 S/N 001
 S/N 001

 SYSTEM ADVANCED LIGO SUB-SYSTEM SUS

 PROCEED CONCOUNTED

 A VIBRATORY TOOL MAY BE USED. EXAMPLE: D050090-A1 S/N 001

 5. THE COMPONENT IS SYMMETRIC ABOUT THE Q

 6. DUAL DIMENSIONS (MILLIMETERS) APPEAR IN SQUARE BRACKETS[], PRIMARILY FOR ADVANCED LIGO TECHNICAL REFERENCE

 7. BACKGROUND INFORMATION:

 7. BACKGROUND INFORMATION:

 8. DOT MULLIMENT AT CALLECT INICATED THAT WATER JET CUTTING WOULD BE USED

 9. DOT MULLIMENT AT CALLECT INICATED THAT WATER JET CUTTING WOULD BE USED

 9. DOT MULLIMENT AT CALLECT INICATED THAT WATER JET CUTTING WOULD BE USED

 9. DOT MULLIMENT AT CALLECT INICATED THAT WATER JET CUTTING WOULD BE USED

 9. DOT MULLIMENT AT CALLECT INICATED THAT WATER JET CUTTING WOULD BE USED

 9. DOT MULLIMENT AT CALLECT INICATED THAT WATER JET CUTTING WOULD BE USED

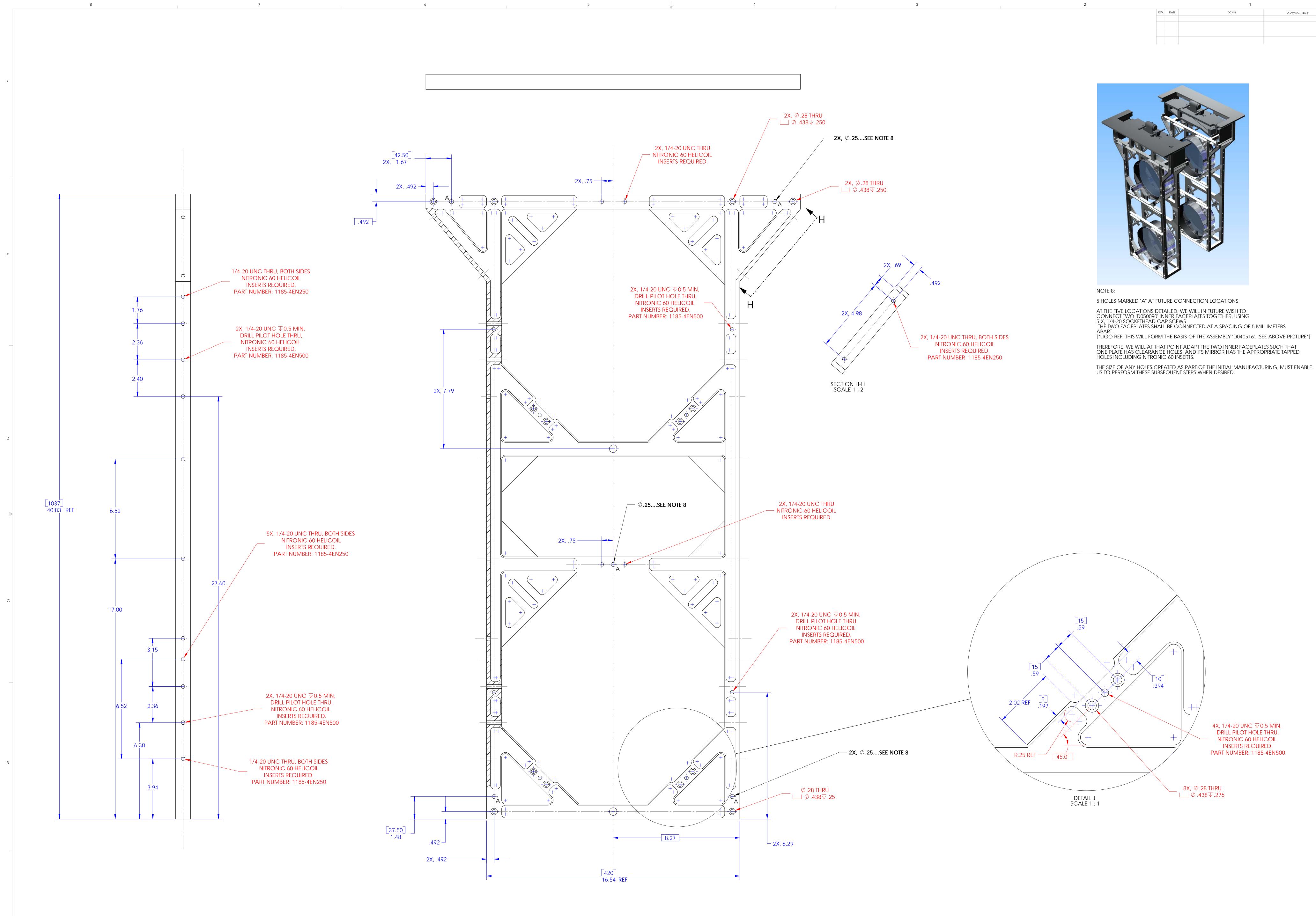
 9. DOT MULLIMENT AT CALLECT INICATED THAT WATER JET CUTTING WOULD BE USED

 9. DOT MULLIMENT AT CALLECT INICATED THAT WATER JET CUTTING WOULD BE USED

 9. DOT MULLIMENT AT CALLECT INICATED THAT WATER JET CUTTING WOULD BE USED

 9. DOT MULLIMENT AT CALLECT INICATED THAT WATER JET CUTTING WOULD BE USED

 9. DOT MULLIMENT AT CALLECT INICATED THAT UNCLUMITED A R 25° CUTTER.



5

8

A

7

7

8

6

6

5

4

4

3

3

2

1				
REV.	DATE	DCN #	DRAWING TREE #	

2

	PARTS LIST		
GENERAL NOTES: (UNLESS OTHERWISE SPECIFIED)			
1. DO NOT SCALE FROM DRAWING.		CALIFORNIA INSTITUTE OF TECHNOLOGY	
2. REMOVE ALL SHARP EDGES, R.02 MIN.	DIMENSIONS ARE IN INCHES TOLERANCES:	IGR, GLASGOW UNIVERSITY GEO 600 GROUP	
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE.	X ± 0.05		
 3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE. 3. SCRIBE, ENGRAVE OR MECHANICALLY STAMP DRAWING (NO INKS OR DYES) PART NUMBER, REVISION ON NOTED SURFACE OF PAFOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALL CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: D050090-A1 	.XXX ± 0.005 RANGULAR± 0.1 °	SYSTEM ADVANCED LIGO	
FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .12" HIGH CHARACTERS. UNLESS THE SIZE OF THE PART DICTATES SMALL CHARACTERS.		sub-system sus	
A VIBRATORY TOOL MAY BE USED. EXAMPLE: D050090-A1 S/N 001	6061-T6 AI	NEXT ASSY ASSEMBLY RIG_SINGLE CATCHER	
5. THE COMPONENT IS SYMMETRIC ABOUT THE Q	FINISH	PART NAME	
-	32 µ inch	- INNER FACEPLATE	
6. DUAL DIMENSIONS (MILLIMETERS) APPEAR IN SQUARE BRACKETS[], PRIMARILY FOR ADVANCED LIGO TECHNICAL REFERENCE	DRAWN RAJ 04/05	SIZE DWG. NO. REV.	
7. BACKGROUND INFORMATION:	CHECKED MPL APR 05	size dwg. no. E D050090 A1	
INITIAL DISCUSSIONS WITH MACHINISTS AT CALTECH INICATED THAT WATER JET CUTTING WOULD BE USED TO ACHIEVE THE BASIC SHAPES, THEN ANY FINISHING WOULD BE DONE BY MILLING WITH A R.25" CUTTER.		SCALE: 1:4 PROJECTION:	

A

В