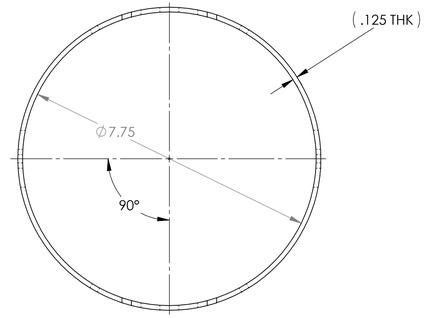
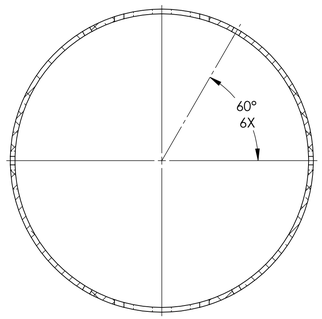
NOTES: UNLESS OTHERWISE SPECIFIED

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, SILCONE, AND CHLORINE. REFER TO LIGO E0900237 FOR LIST OF APPROVED COOLANTS.
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.

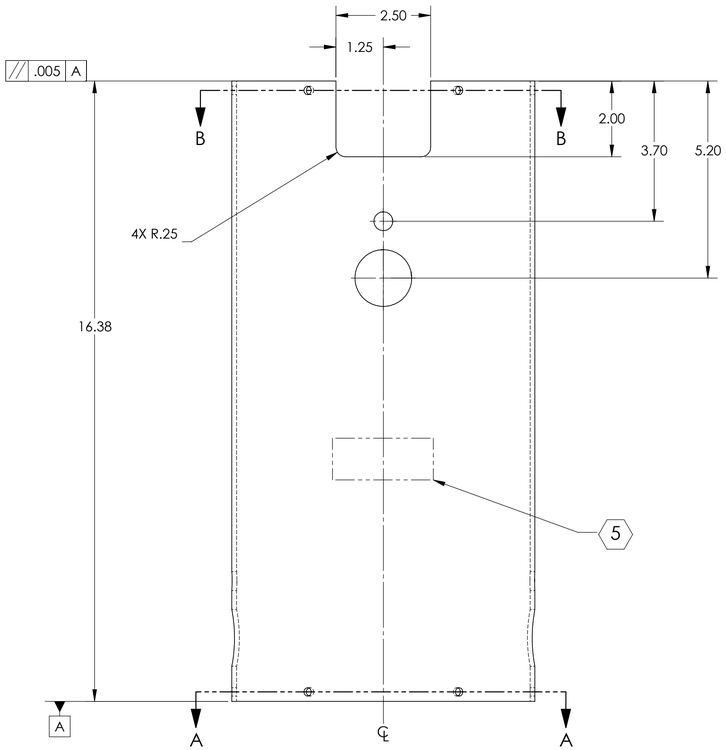
   EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX
6. APPROXIMATE WEIGHT =4.713 LB.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
9. ELECTROPOLISH INSIDE AND OUTSIDE OF TUBE TO REMOVE .0005-.001" PER SURFACE.

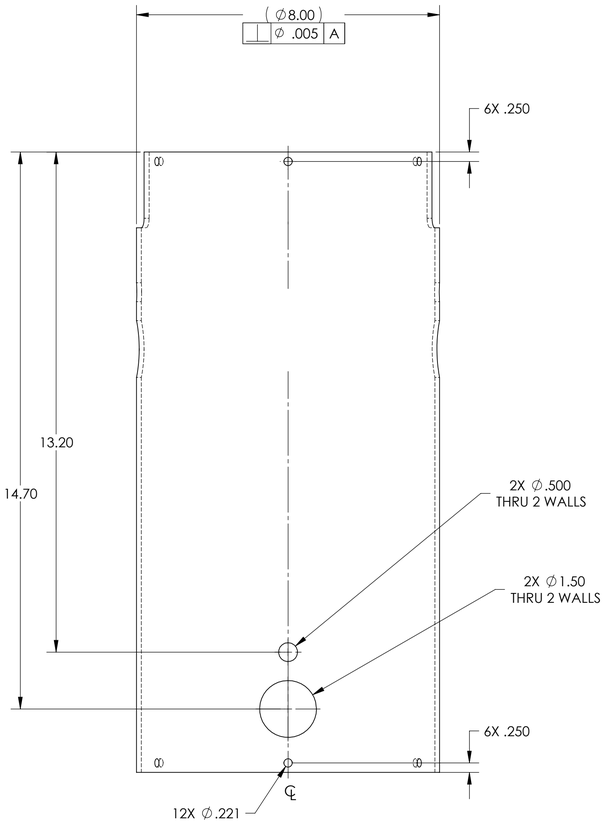
REV.	DATE	DCN #	DRAWING TREE #
v3	03 JUN 2010	E1000285	-
v2	04 APR 2011	E1100216	-
v3	19 MAY 2011	E1101007	-

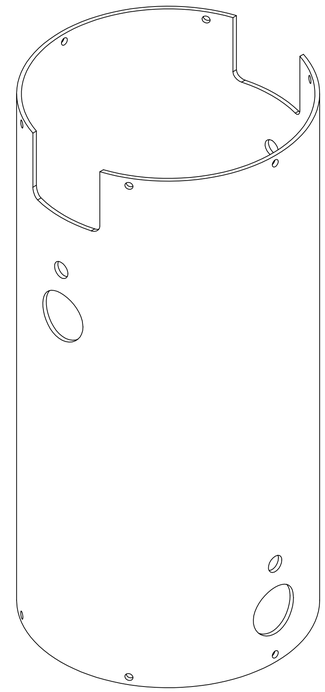




SECTION B-B

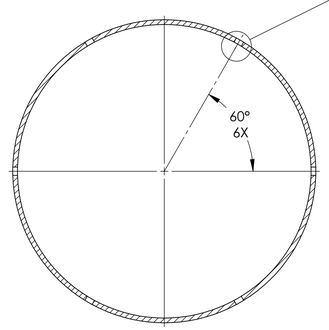






FOR REFERENCE ONLY
NO SCALE

DETAIL H
SCALE 2 : 1



SECTION A-A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)											
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1.0°	MATERIAL: 6061-T6 Al	FINISH: 63 µinch	LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	NEXT ASSY: D1002563	PART NAME: SLC DAMPING 8 DIA TUBE				
							DESIGNER	N.Nguyen	01 Jul 2010	SIZE: D	DWG. NO.: D1002561 REV.: v3
							DRAFTER	TQ. NGUYEN	15 JUL 2010		
							CHECKER	M. SMITH	01 NOV 2010		
							APPROVAL	D. COYNE	10 NOV 2010	SCALE: 1:2	PROJECTION: SHEET 1 OF 1

D1002561_AdLIGO_AOS_SLC Damping 8 Dia Tube, PART PDM REV:-X-011_DRAWING PDM REV:-X-018