

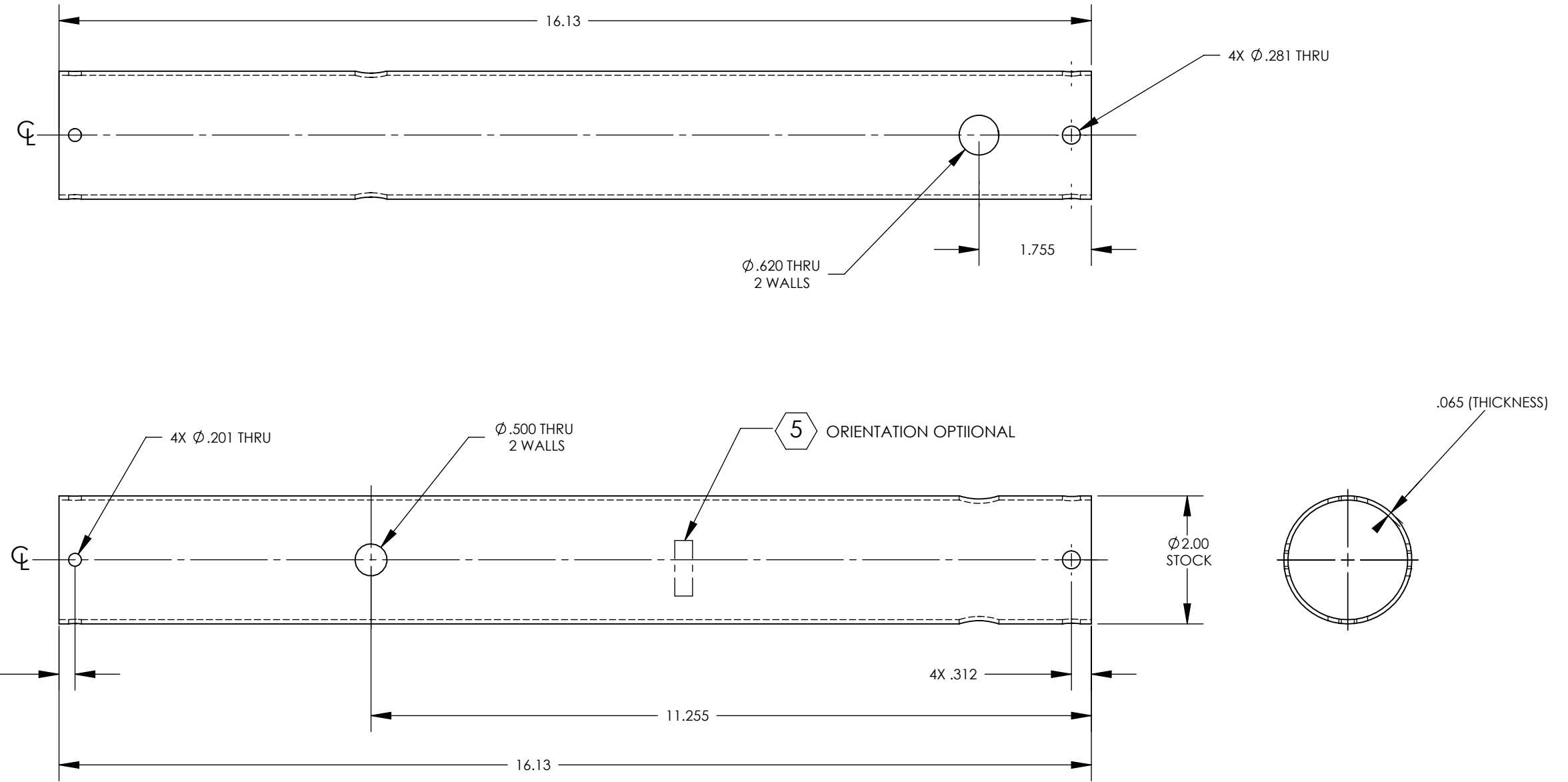
NOTES CONTINUED:

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=0.613 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. ELECTROPOLISHING PER E0900364, SECTION 5.1, TO REMOVE ALL SURFACE OXIDES AND POTENTIALLY EMBEDDED CONTAMINANTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	19 JUL 2010	E1000285	



D1002612_AdlIGO_AOS_SLC_UpperTube, PART PDM REV: X-004, DRAWING PDM REV: X-012

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .03 .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.		SLC UPPER TUBE	
MATERIAL 6061-T6 Al		FINISH 63 μinch		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
NEXT ASSY D1002582				DESIGNER N.Nguyen 01 Jul 2010		SIZE DWG. NO. B D1002612	
				DRAFTER TQ. NGUYEN 19 JUL 2010		REV. v1	
				CHECKER M. SMITH 01 NOV 2010		SCALE: 1:2	
				APPROVAL D. COYNE 10 NOV 2010		PROJECTION: SHEET 1 OF 1	