

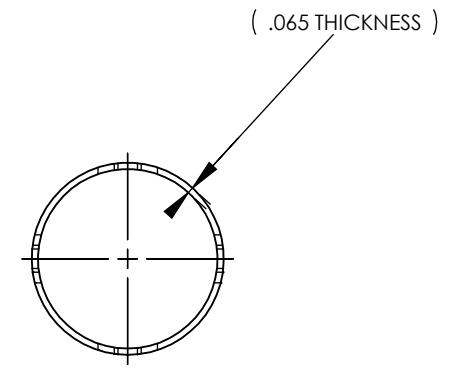
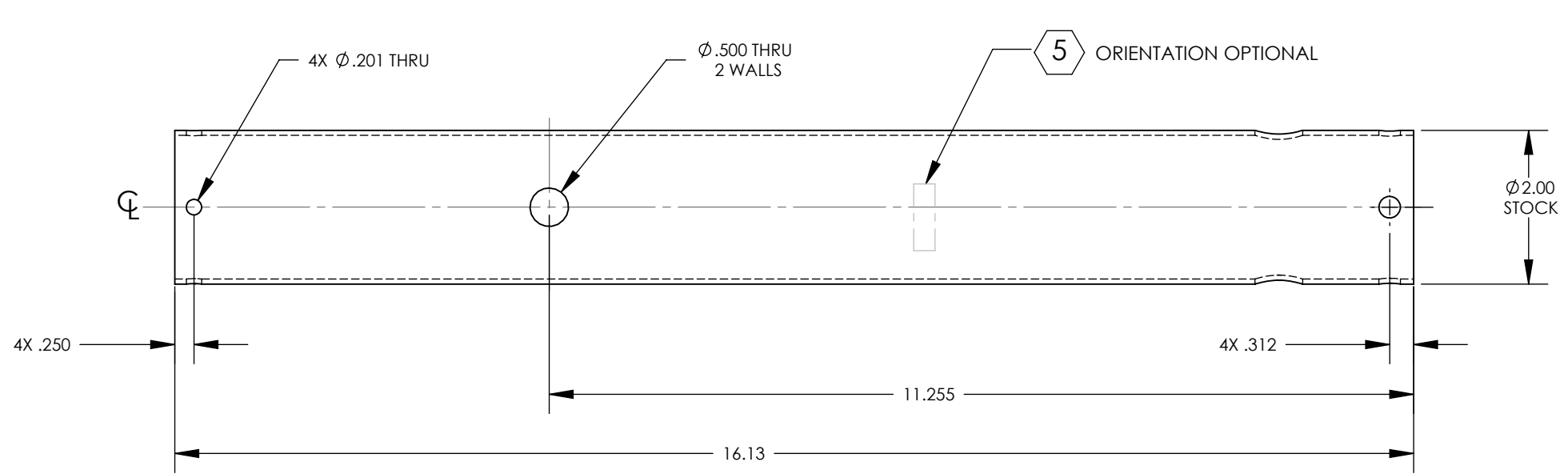
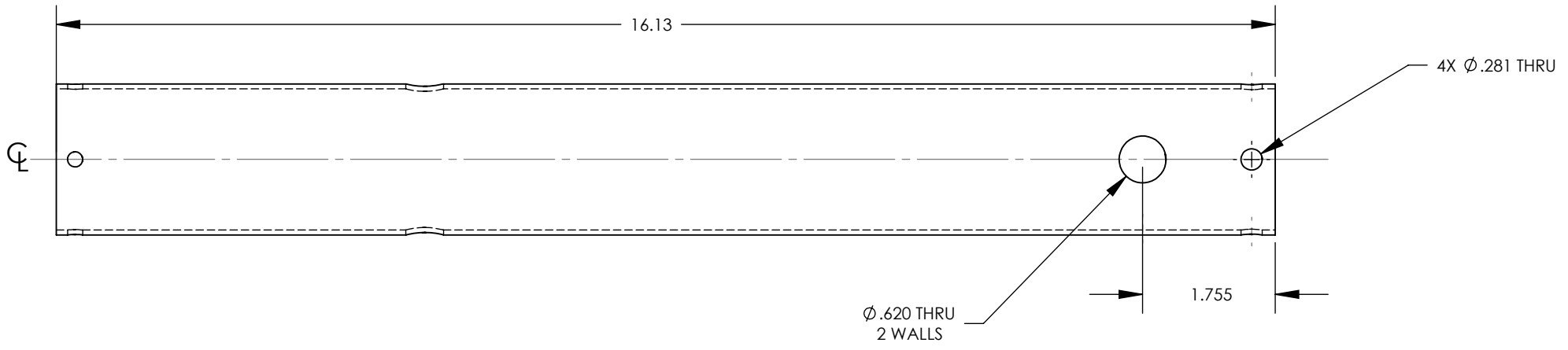
NOTES CONTINUED:

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: DXXXXXX-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 ELECTROPOLISH PER E0900364, SECTION 5.2.1.2, TO REMOVE ALL SURFACE OXIDES AND POTENTIALLY EMBEDDED CONTAMINANTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	19 JUL 2010	E1000285	
v2	4 APR 2011	E1100216	



⑤ ORIENTATION OPTIONAL

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO 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 ⑨		SYSTEM ADVANCED LIGO SUB-SYSTEM AOS		DESIGNER N.Nguyen 01 Jul 2010	
NEXT ASSY D1002582				DRAFTER TQ. NGUYEN 19 JUL 2010		SIZE DWG. NO. B D1002612	
				CHECKER M. SMITH 01 NOV 2010		REV. v2	
				APPROVAL D. COYNE 10 NOV 2010		SCALE: 1:2 PROJECTION: SHEET 1 OF 1	

D1002612_AdlIGO_AOS_SLC_UpperTube, PART PDM REV: X-004, DRAWING PDM REV: X-013