

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

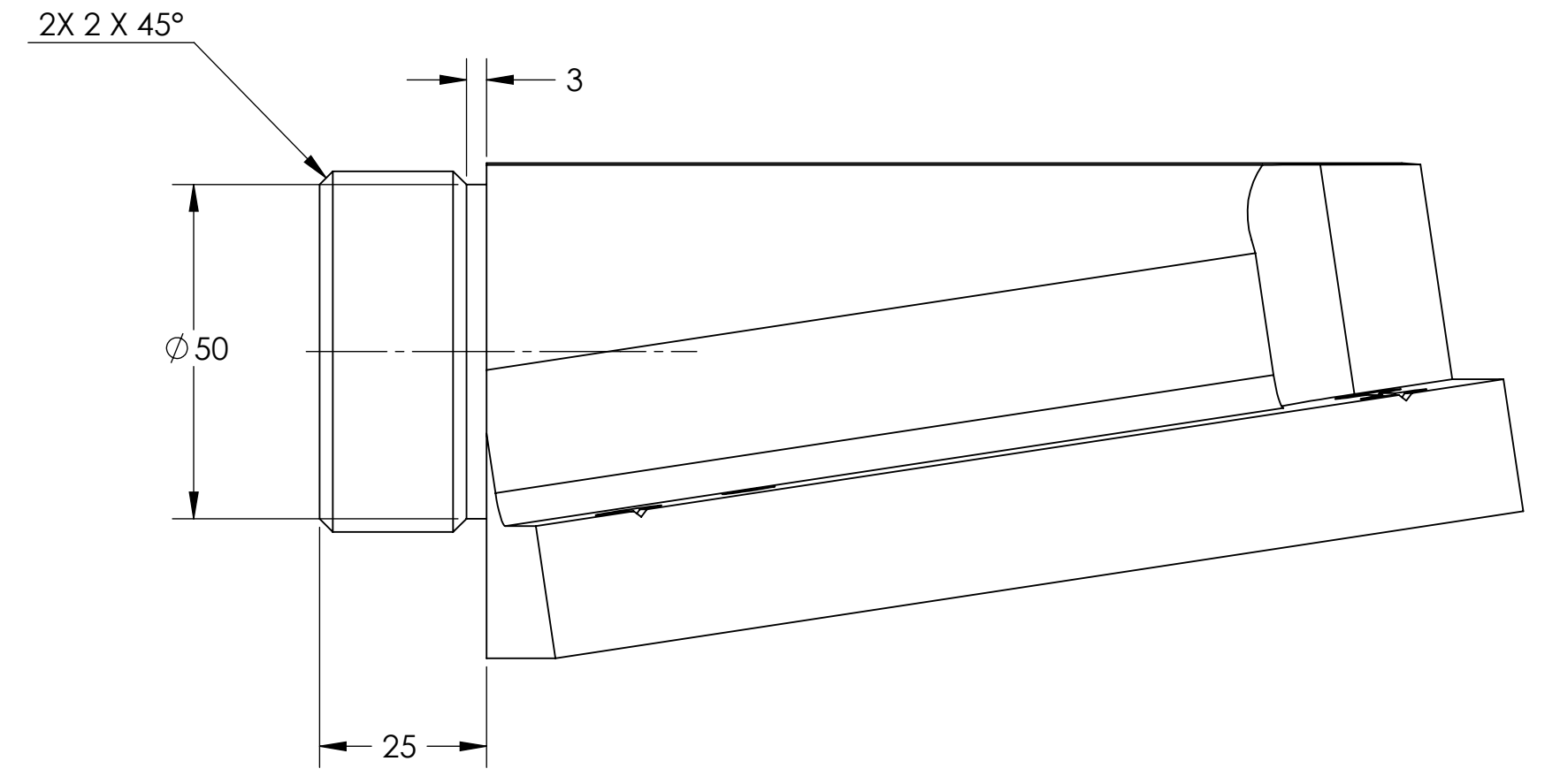
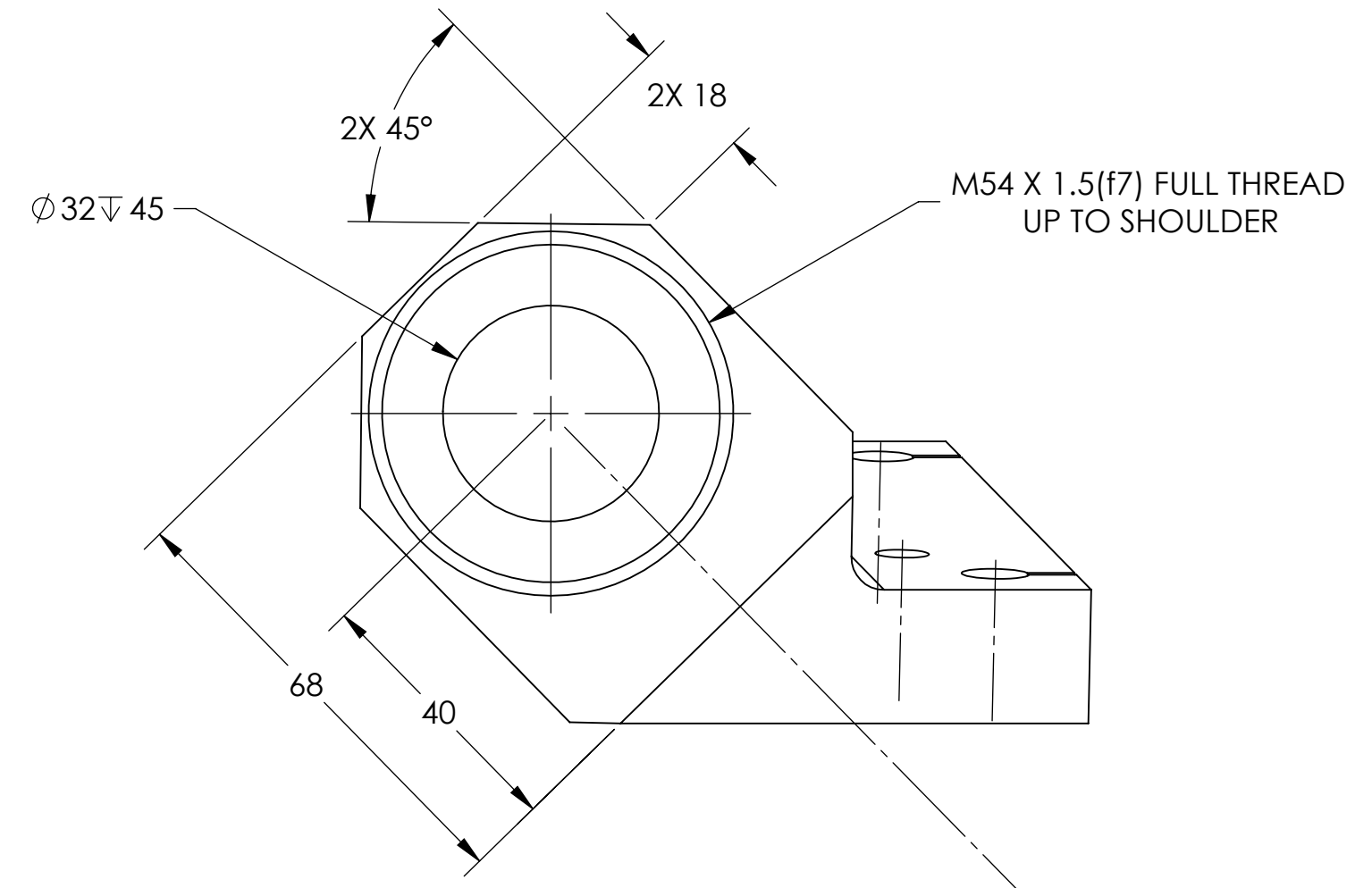
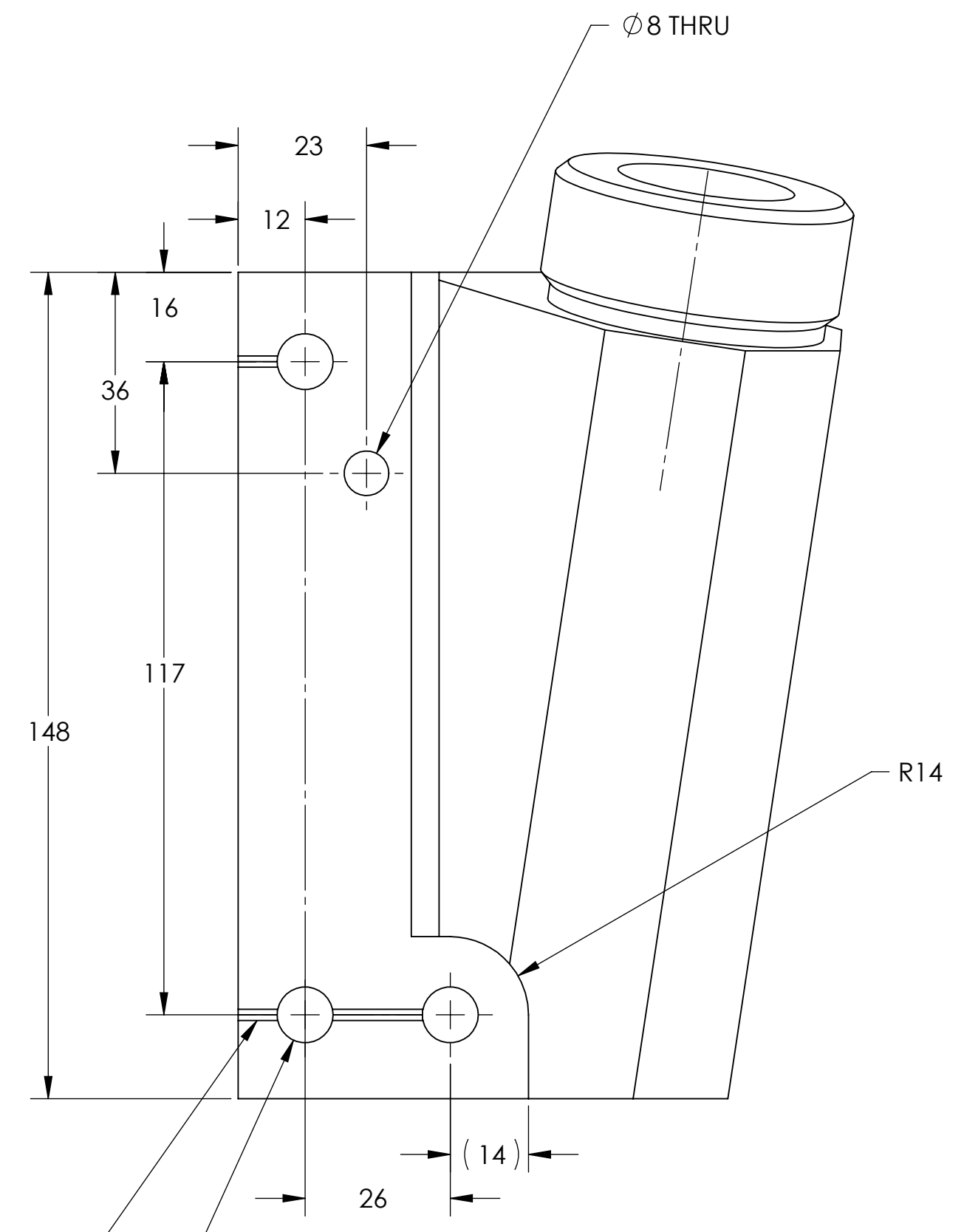
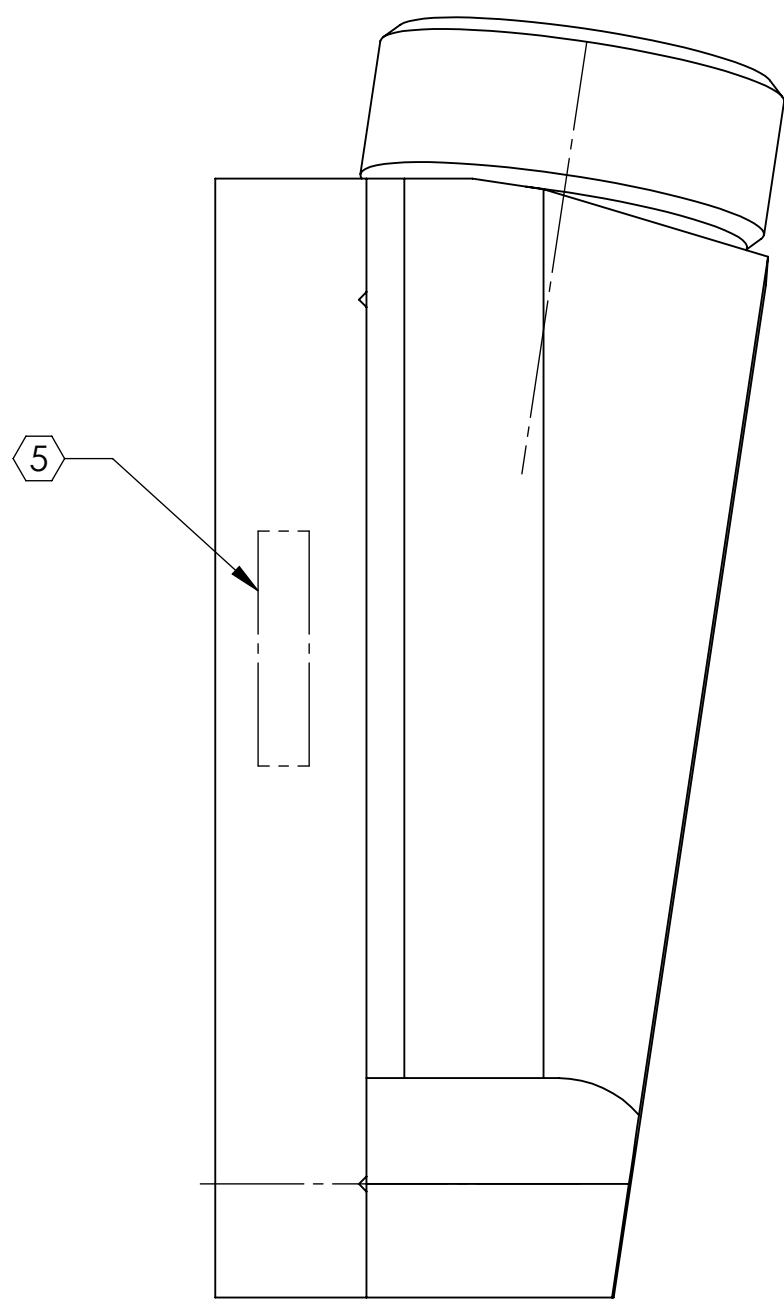
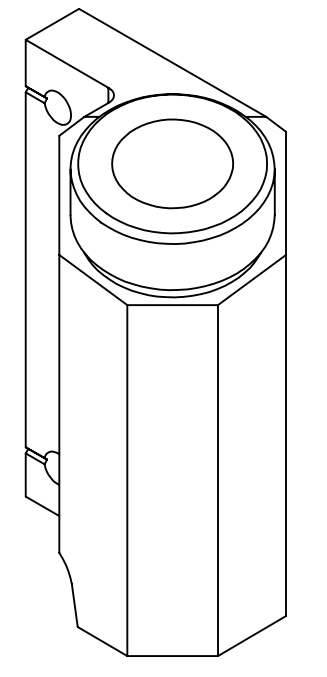
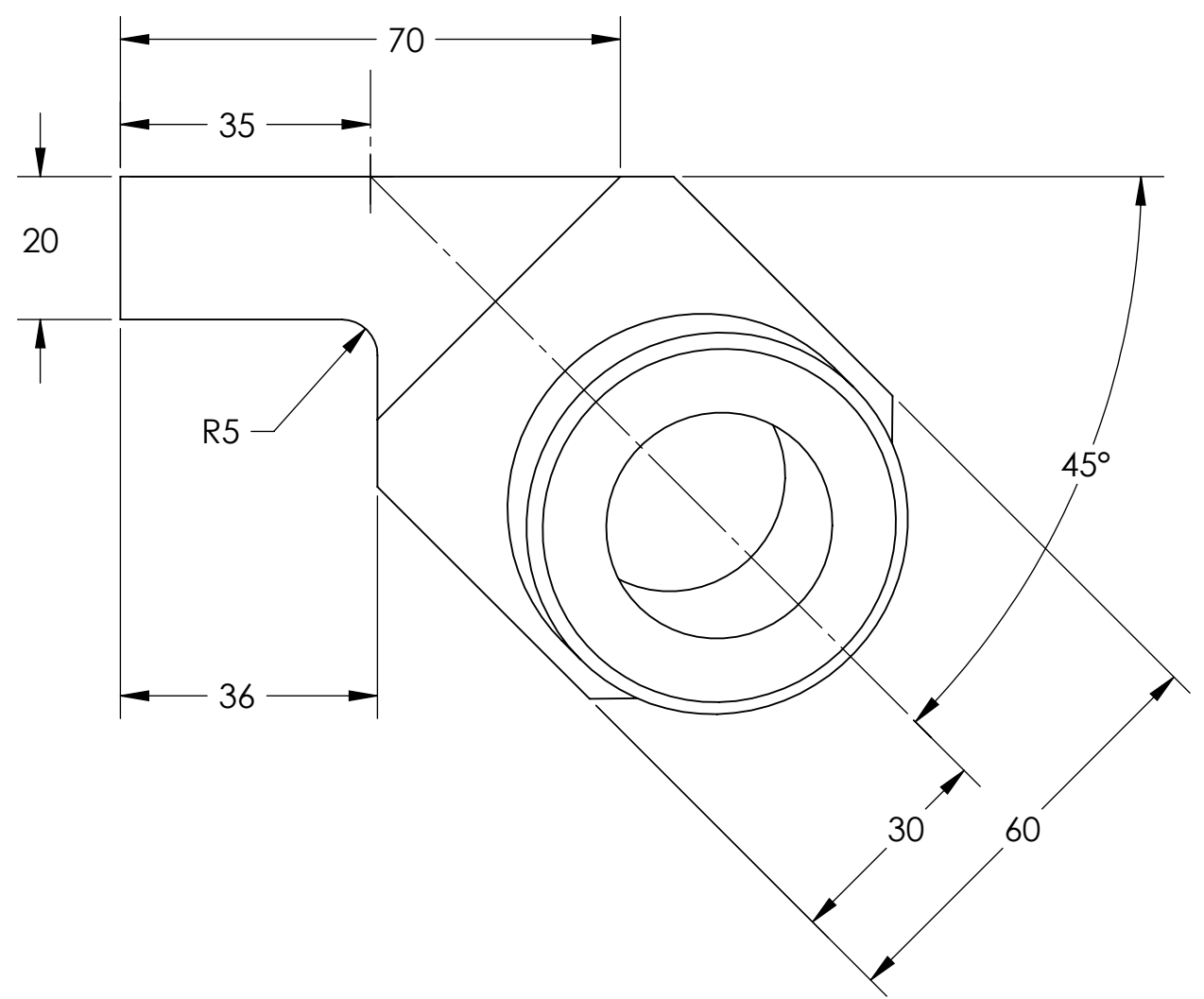
6. APPROXIMATE WEIGHT = 3.5 LB.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

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

9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, FLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

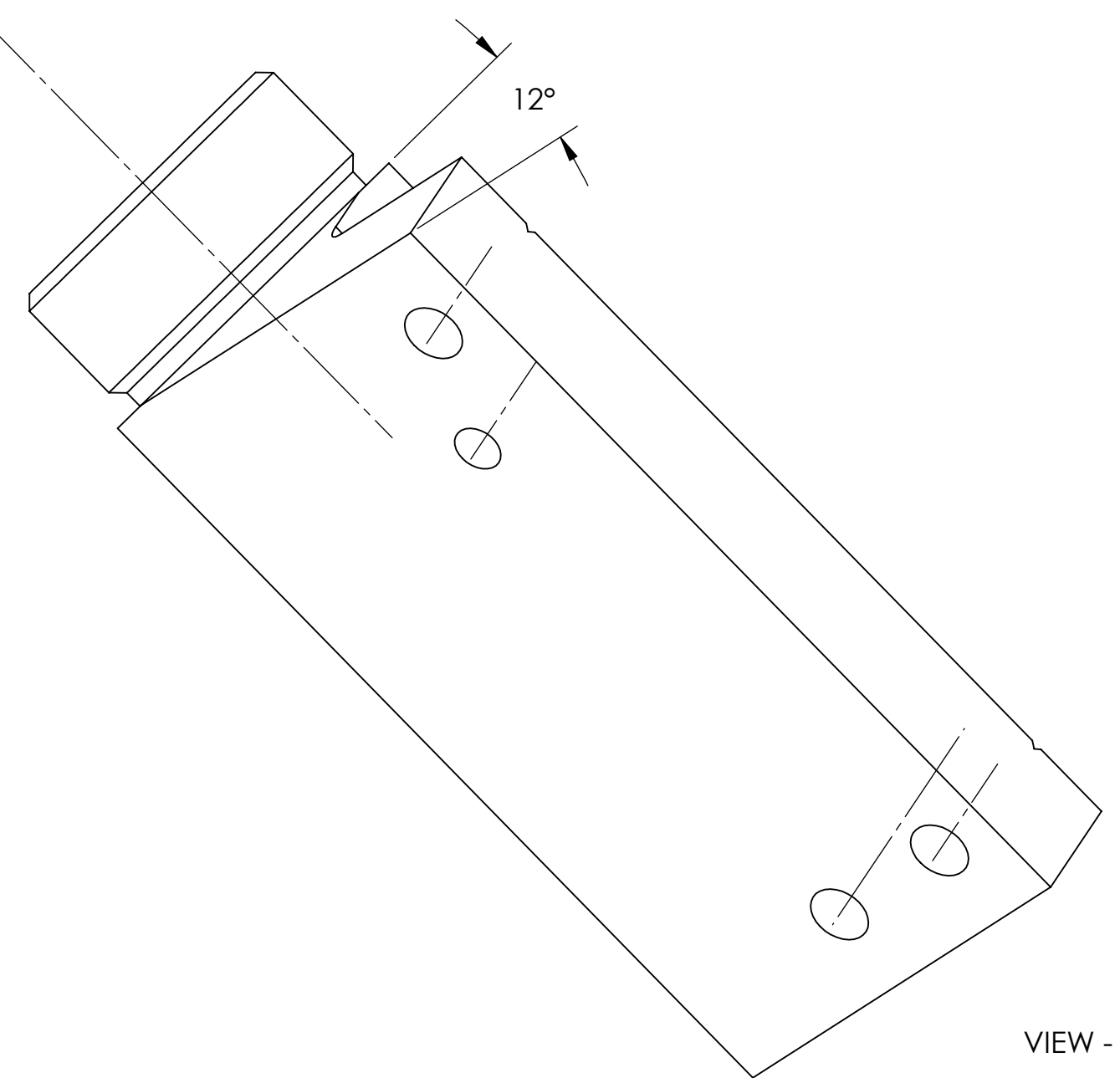
REV.	DATE	DCN #	DRAWING TREE #
V1	3 MAR 2011	E1100272	-
-	-	-	-
-	-	-	-



2X ENGRAVE 90° V GROOVE X 1 DEEP EDGE TO HOLE

3X Ø 10 THRU

NOTE: THIS PART IS A MIRROR IMAGE OF D1003278



VIEW -

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN MILLIMETERS TOLERANCES: .XX ± .25 .XXX ± .13 ANGULAR ± .5°		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		12 DEG BS/FM BSC STAY BRACKET	
MATERIAL	6061-T6 Al	FINISH	63 µinch	DESIGNER	K. BUCKLAND 23 FEB 2011
				DRAFTER	K. BUCKLAND 3 MAR 2011
				CHECKER	
				APPROVAL	
SYSTEM: ADVANCED LIGO SUB-SYSTEM: SUS NEXT ASSY: D080501				SIZE: D DWG. NO.: D1100349	REV.: v1
				SCALE: 1:1 PROJECTION:	SHEET 1 OF 1

D1100349.dwg, SUS, 12 DEG BS/FM BSC STAY BRACKET, PART PDM REV. X.010, DRAWING PDM REV. X.004