NOTES CONTINUED:

Ⓢ 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

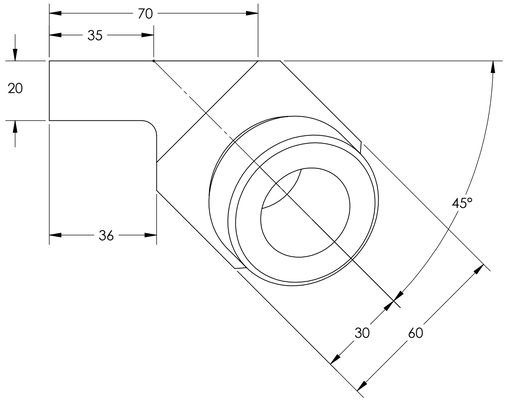
6. APPROXIMATE WEIGHT = 2.73 LB.

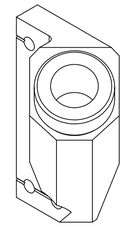
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

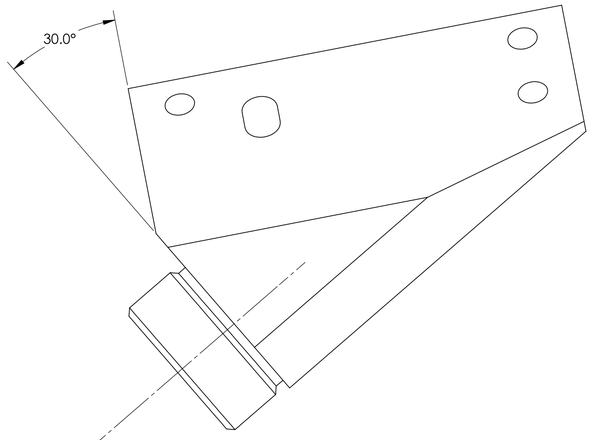
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

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

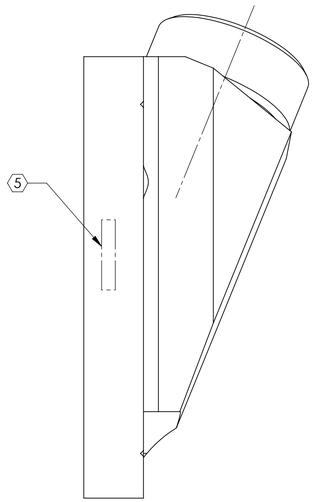
REV.	DATE	DCN #	DRAWING TREE #
V1	18 MAR 2011	E1100272	-
V2	7 JAN 2013	E1300014	-
-	-	-	-

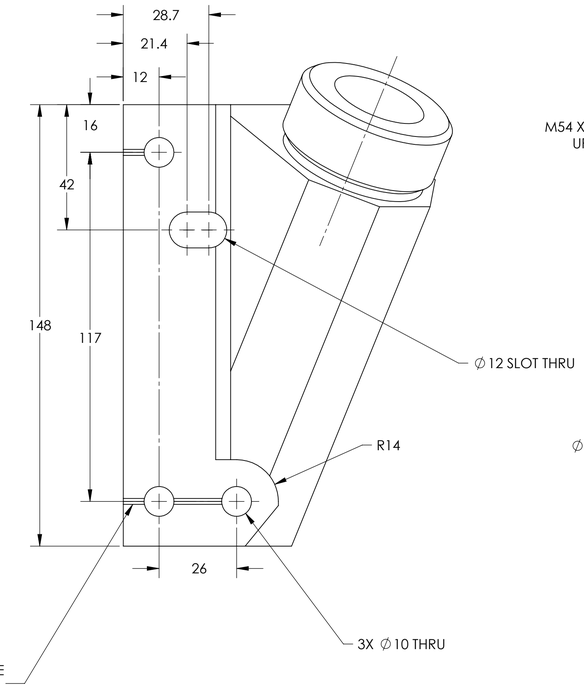


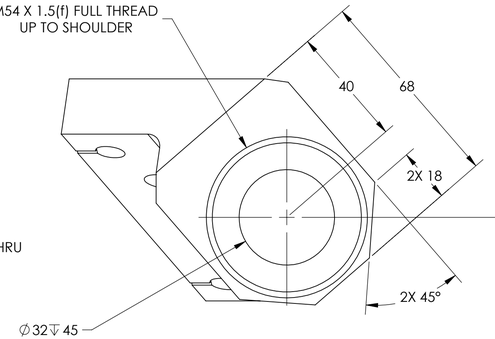


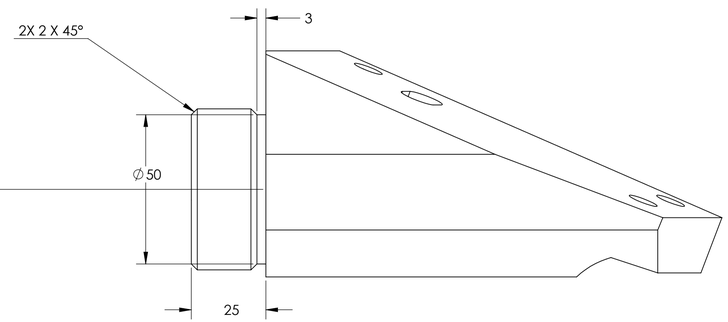


VIEW A-A









NOTE: THIS PART IS A MIRROR IMAGE OF D1100446

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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 APPROXIMATLEY 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.

MATERIAL	FINISH	NEXT ASSY
6061-T6 Al	63 µinch	D080501

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM	SUB-SYSTEM
ADVANCED LIGO	SUS

DESIGNER	K. BUCKLAND	13 DEC 2010	
DRAFTER	K. BUCKLAND	18 MAR 2011	
CHECKER			
APPROVAL			

PART NAME: 30 DEG BS/FM BSC STAY BRACKET

SIZE	DWG. NO.	REV.
D	D1100447	v2

SCALE: 1:1 PROJECTION: SHEET 1 OF 1

D1100447 caLIGO, SUS, 30 DEG BS-FM BSC STAY BRACKET, PART FDM REV- X-005, DRAWING FDM REV- X-001