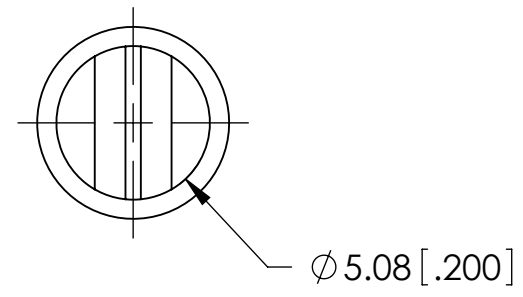
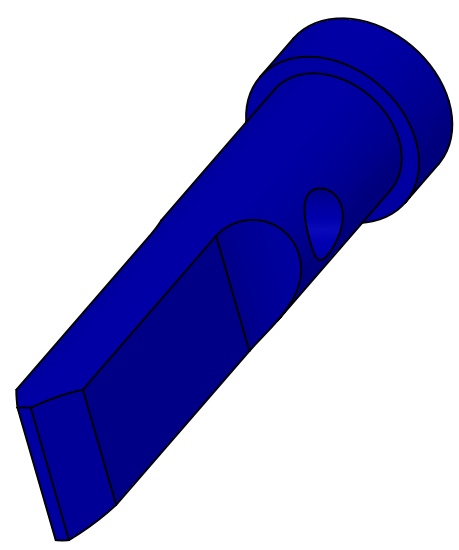
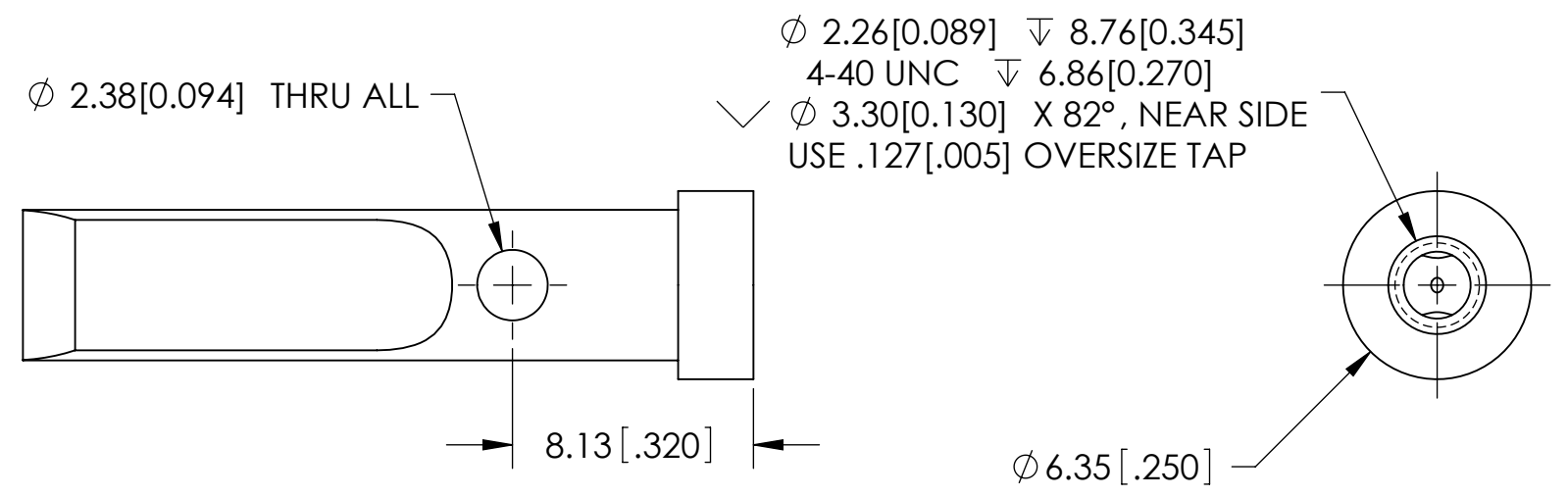
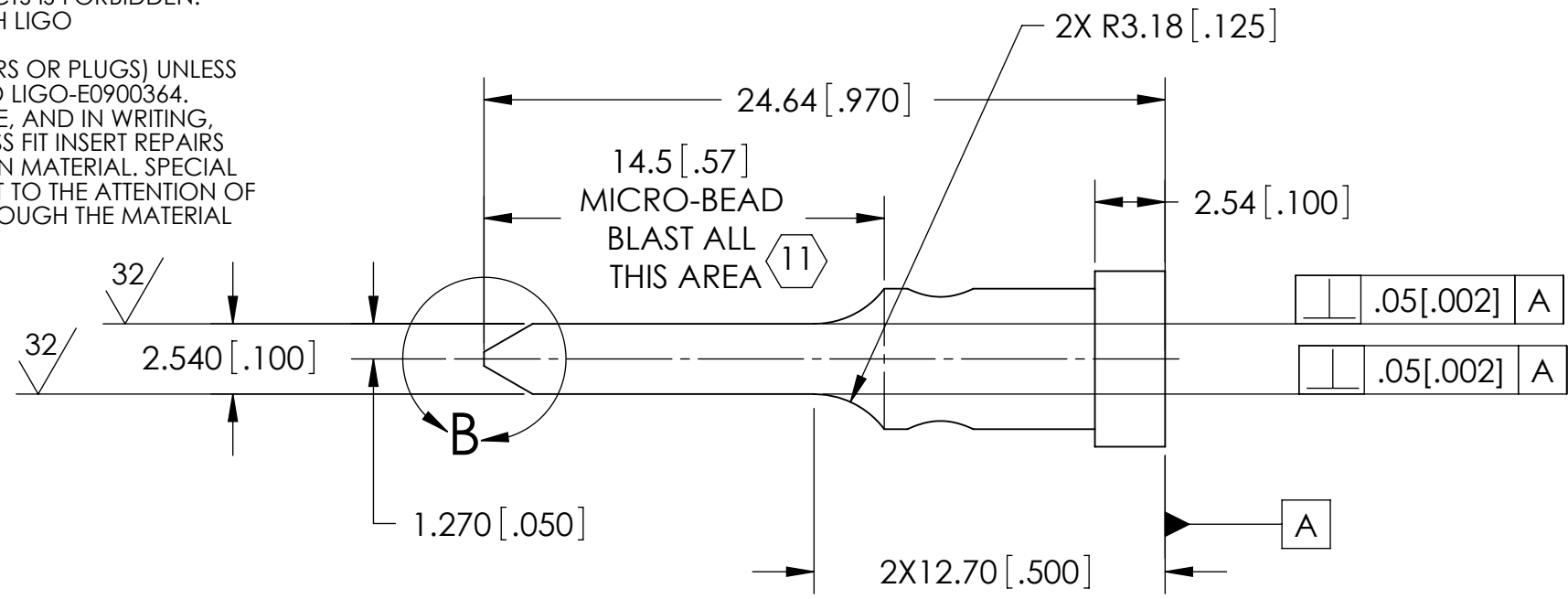
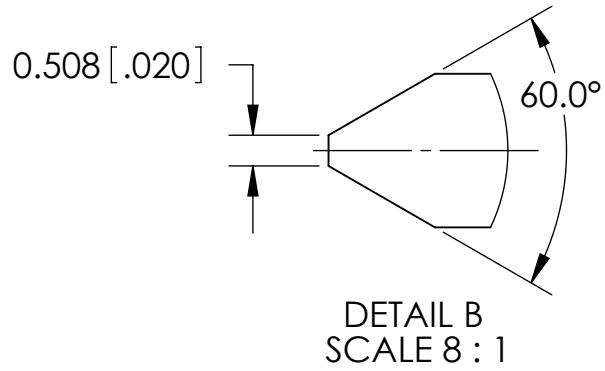


REV.	DATE	DCN #	DRAWING TREE #
v5	23 May 2011	E1100500	E1100450
v6	02 DEC 2020	E2000604	

NOTES CONTINUED:

- 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
- 5. SCRIBE, ENGRAVE, 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. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IFF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
EXAMPLE (PART) : 001-V1
EXAMPLE (TAG) DXXXXXXX-VY, TYPE-XX, S/N XXX QTY:TBD.
- 6. APPROXIMATE WEIGHT = 0.002 LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES (INCLUDING SANDING OR SCOURING FOR MATTE FINISH) IS NOT ALLOWED. USE OF SCOTCH-BRITE OR SIMILAR PRODUCTS IS FORBIDDEN.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL MATERIAL TO BE VIRGIN MATERIAL, (I.E. NOT WELD REPAIRS OR PLUGS) UNLESS APPROVED IN ADVANCE AND IN WRITING BY LIGO, REFER TO LIGO-E0900364.
- 10. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE. THE MATERIAL USED MUST BE VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF AND WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH THE MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E09000364.
- 11. THE MACHINE USED TO MICRO-BEAD BLAST THE PARTS MUST BE COMPLETELY CLEANED OUT PRIOR TO USE. ALL NEW GLASS BEADS OF 35 MICRON (.001") DIAMETER WILL BE USED FOR THE PARTS.



DIMENSIONS ARE IN MM [INCHES]		TOLERANCES:		ANGULAR ± .5°		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		MATERIAL		FINISH		NEXT ASSY		PART NAME		DESIGNER		DRAFTER		CHECKER		APPROVAL					
		.XX ± .381 [0.015]		.XXX ± .127 [0.005]		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .76 [0.03] x 45°. 3. DO NOT SCALE FROM DRAWING.		6061-T6 Al		63 μinch		D1100937		BOSEM FLAG, αLIGO SUS		M.EVANS 31 Mar, 2011		M.HILLARD 23 May 2011		J.LEWIS 23 May 2011		J.ROMIE 23 May 2011					
														LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		SUB-SYSTEM		ADVANCED LIGO		SUS		SCALE: 4:1		PROJECTION:		SHEET 1 OF 1	
																SIZE DWG. NO.		B		D1100573		REV.		v6			

D1100573, PART PDM REV: X-025, DRAWING PDM REV: X-025