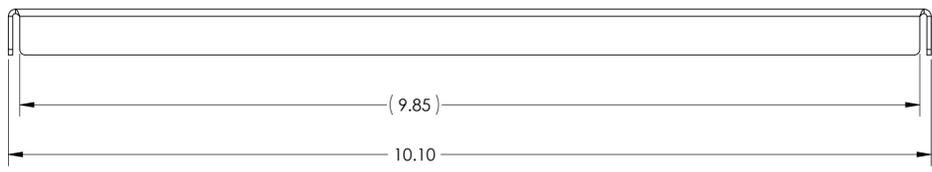
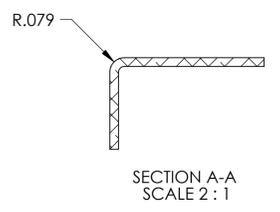
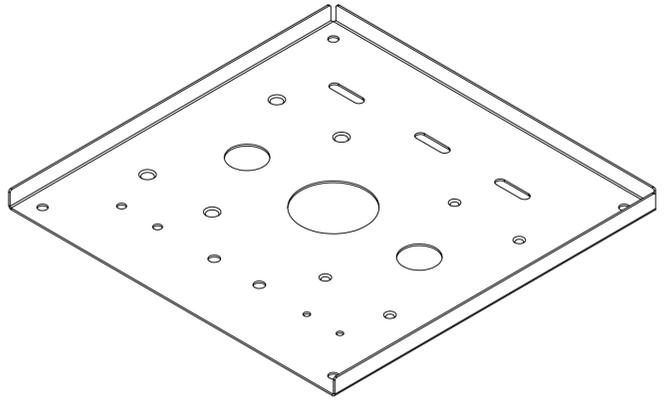


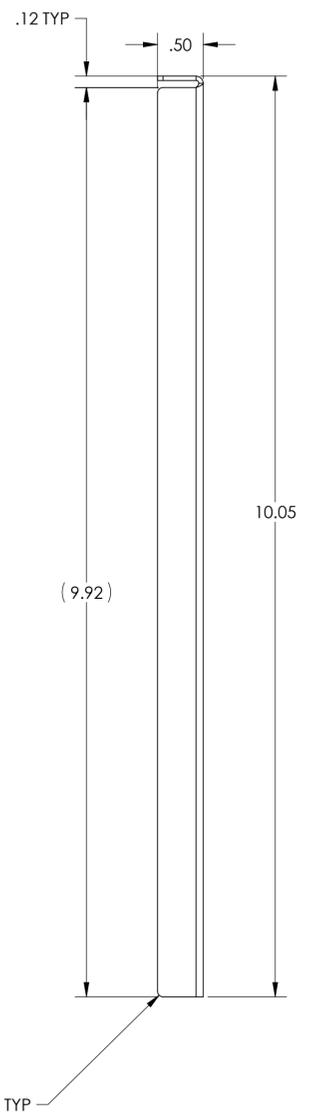
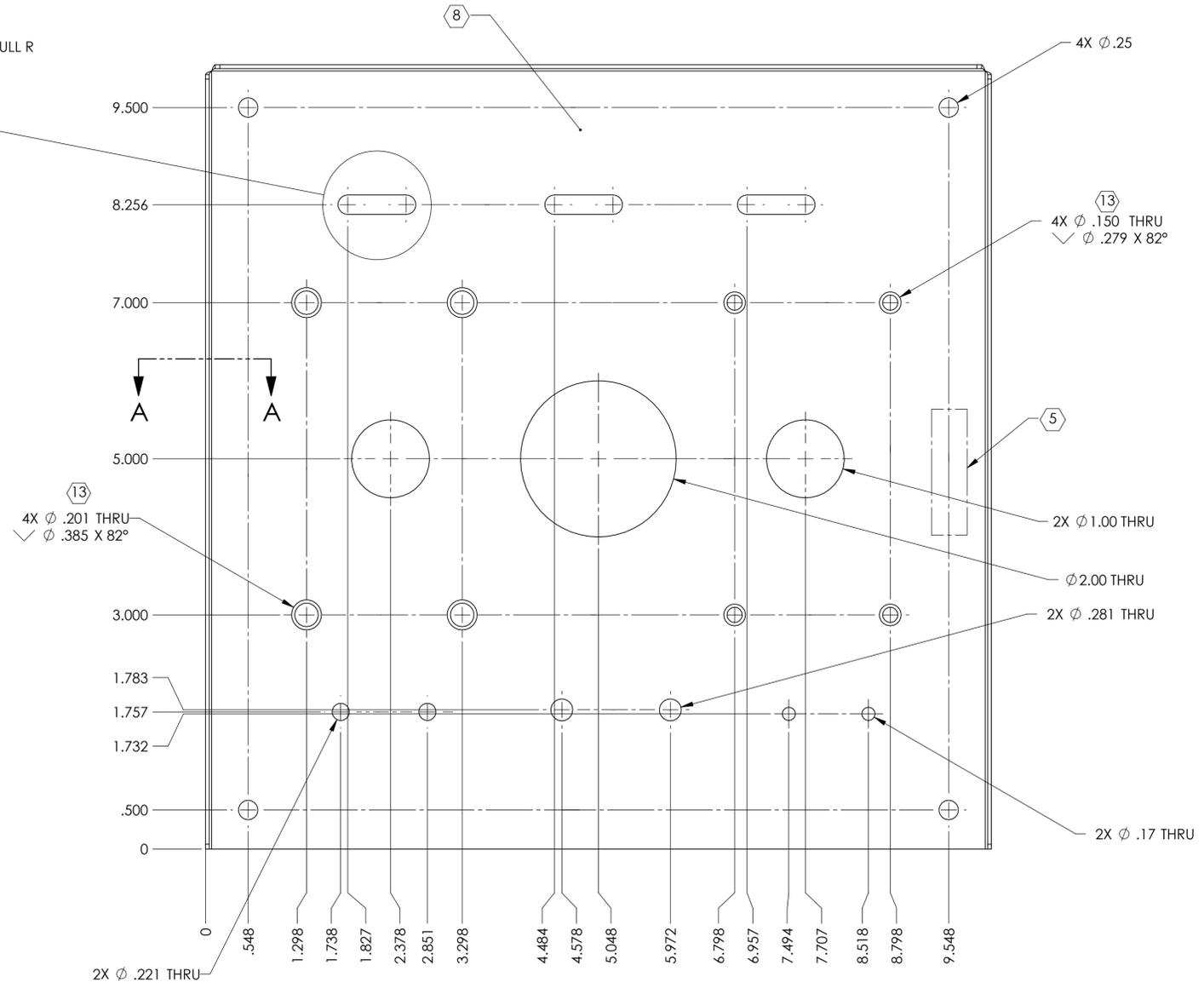
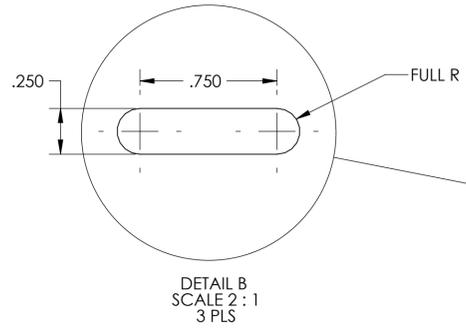
- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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 = X.XXX 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. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
 - 10. PART WILL BE COMPLETELY PORCELAIN COATED PER LIGO SPECIFICATION E1000083
 - 11. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.
 - 12. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.
 - 13. COUNTERSUNK HOLES TO BE CLEANED OF FRIT PRIOR TO BAKING.



REV.	DATE	DCN #	DRAWING TREE #
v1	27 JUN 2011		



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
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.	
DIMENSIONS ARE IN INCHES	TOLERANCES: .XX ± .02 .XXX ± .005
MATERIAL	FINISH
18 GA A424 TYPE I STEEL	9 10
ANGULAR ± 1.0°	

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS
NEXT ASSY	

PART NAME				αLIGO ACB ENAMELING STEEL PLATE			
DESIGNER	N. KILPATRICK	21 JUN 2011	SIZE	DWG. NO.	REV.		
DRAFTER	N. KILPATRICK	21 JUN 2011	D	D1101185	v2		
CHECKER			SCALE: 1:1	PROJECTION:	SHEET 1 OF 1		
APPROVAL							

D1101185-ALIGO-ACB-ENAMELING-STEEL-PLATE-PART-PDM-REV-X-003-DRAWING-PDM-REV-X-010