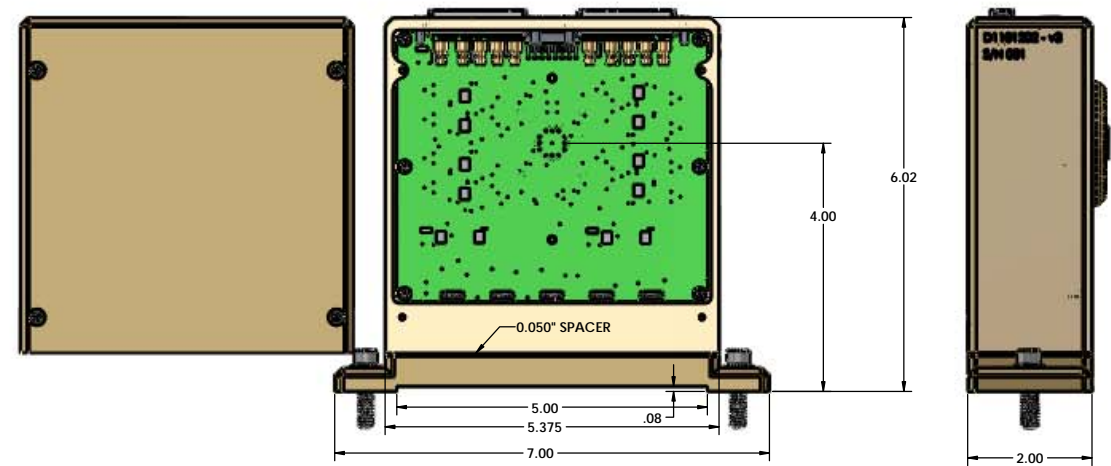
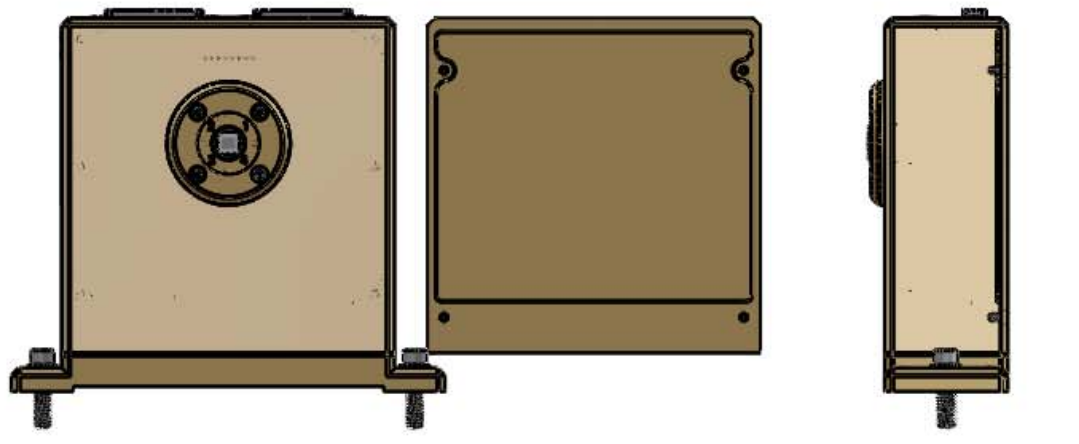
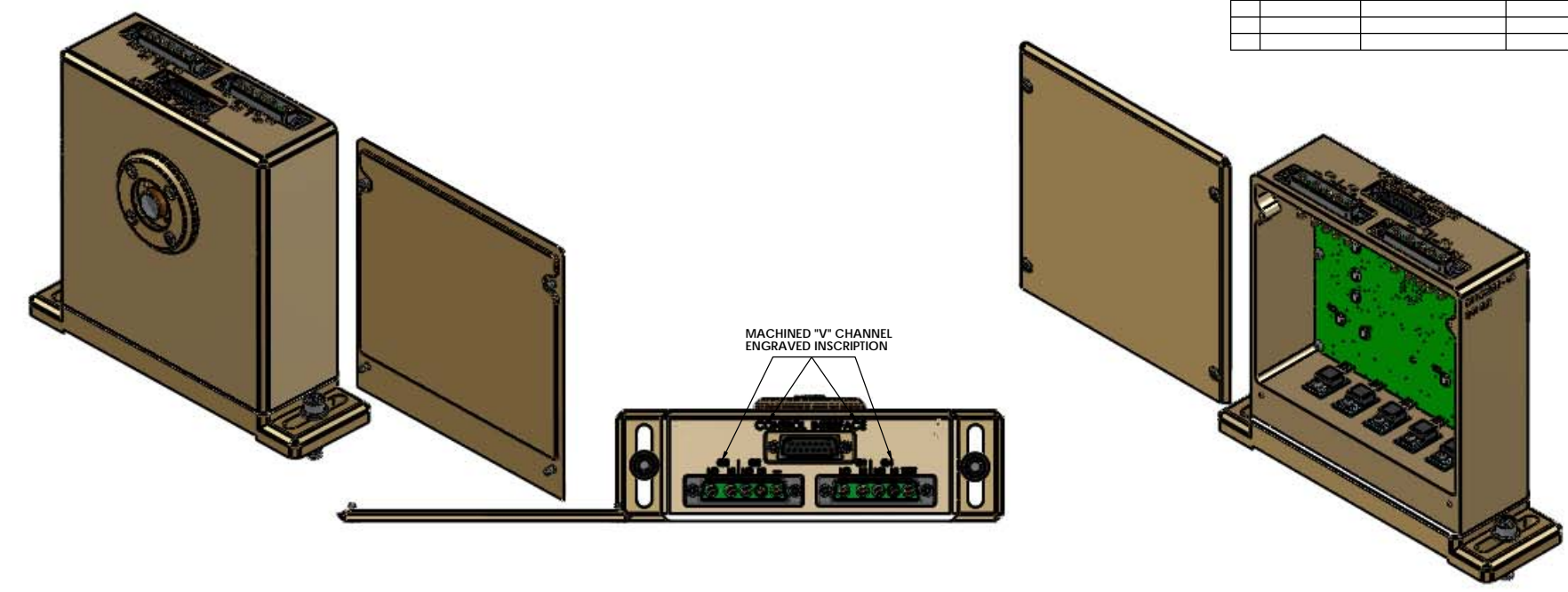
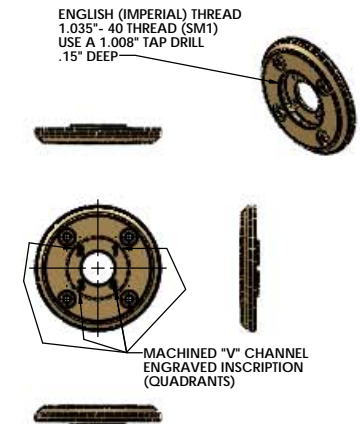
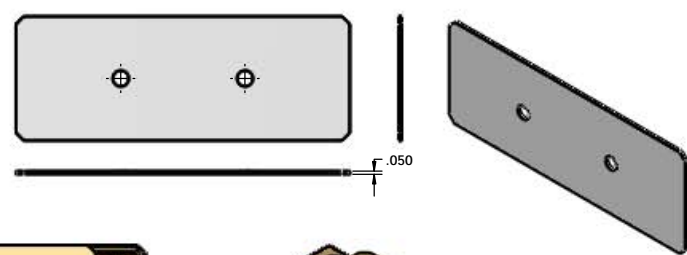


REV.	DATE	DCN #	DRAWING TREE #

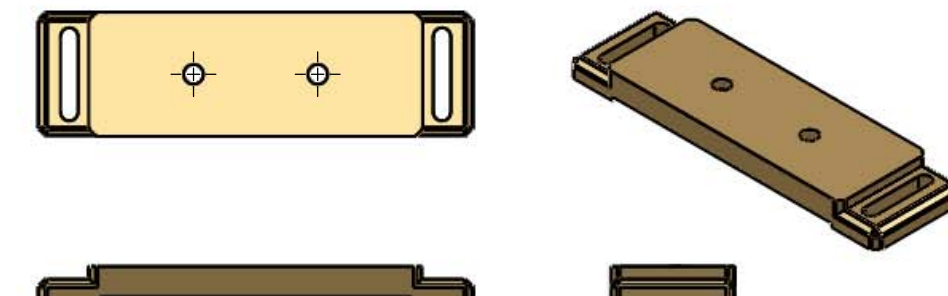
- NOTES CONTINUED:**
- SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP TWO (TWO OR THREE) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXV1, TYPE XX, S/N XXX
  - APPROXIMATE WEIGHT - X.XXXX LB.
  - MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO E090034.
  - ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E090034.
  - ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4.
  - ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.
  - 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 E090034.
  - SURFACE FINISH TO BE AS PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
  - PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION THE INDICATED HOLES WILL BE MARGED PRIOR TO PORCELAIN COATING TO APPROXIMATELY 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF THE HOLE.
  - DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.
  - BEND RADII, 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 RADII SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.
- NOTES 9, 10, 13, 14 and 15 DO NOT APPLY TO THIS PART



**SPACER FOR BASE  
DCC# D1101205**



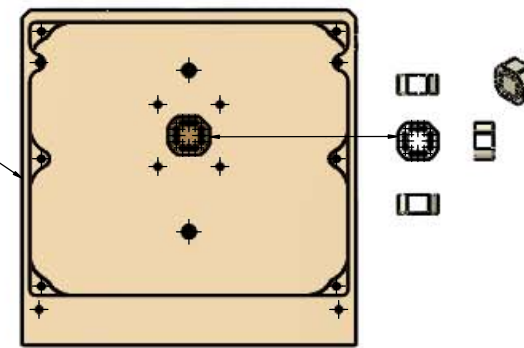
INTERCHANGEABILITY LISTING				
AS OF THIS DATE	THIS DCC # (PART NUMBER)	IS EQUIVALENT TO	THIS DCC # (PART NUMBER)	WITH THESE DIFFERENCES
FEB/21/2012	D1101204-v3 (PHOTO HOOD)	=	D1102420-v1 (PHOTO HOOD)	
FEB/21/2012	D1101206-v3 (PEEK SPACER)	=	D1102422-v1 (PEEK SPACER)	



**BASE  
DCC# D1101201**

**MAIN BODY  
DCC# D1101202**

**PHOTODIODE  
ALIGNMENT SPACER  
DCC# D1101206**



D:\101000-04\_ASC\_AIR\_ENCLOSURE\_TOP\_ASSEMBLY\_PARTS\_REV\_001\_DRAWING\_DRAWING\_0000

NOTES AND TOLERANCES: UNLESS OTHERWISE SPECIFIED		CALIFORNIA INSTITUTE OF TECHNOLOGY LIGO MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME <b>ASC IN-AIR ENCLOSURE - TOP ASSEMBLY</b>	
1. INTERPRET DRAWING PER ASME Y14.5-1994.		DESIGNER: <b>R. ABBOTT</b>		DATE: 06/01/2012	REV: <b>v5</b>
2. REMOVE ALL SHARP EDGES. .005-.015 FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.		DRAFTER: <b>E. BROWN</b>		SIZE: <b>E</b>	DWG. NO: <b>D1101200</b>
3. DO NOT SCALE FROM DRAWING.		CHECKER:		SCALE: 1:2	PROJECTION:
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		MATERIAL: <b>Material &lt;not specified&gt;</b>		SHEET 1 OF 1	
DIMENSIONS ARE IN: <b>inch</b>		NEXT ASSY:			
TOLERANCES: XX ± XXX ±		FINISH: <b>μinch</b>			
ANGULAR: ±					