

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

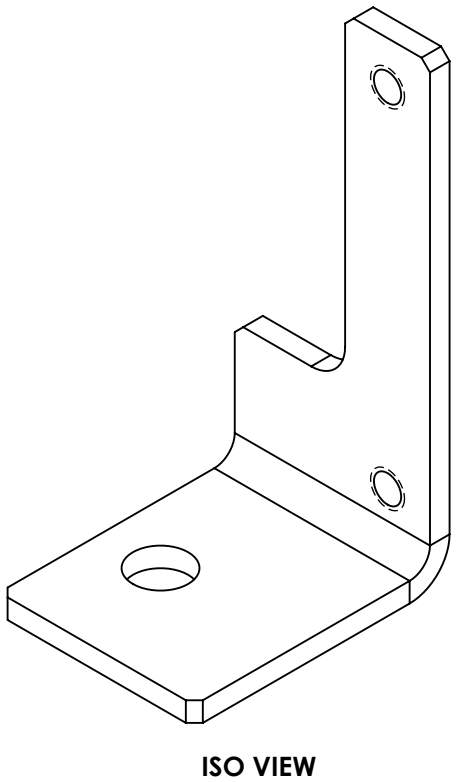
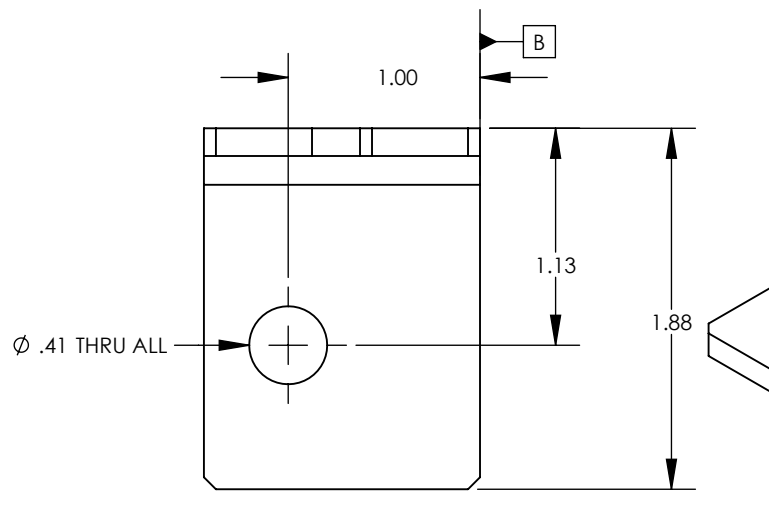
10. MAY BE MACHINED AT MFR'S DISCRETION. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO E-0900364

11. NOTES 8 AND 9 DO NOT APPLY IF MACHINED.

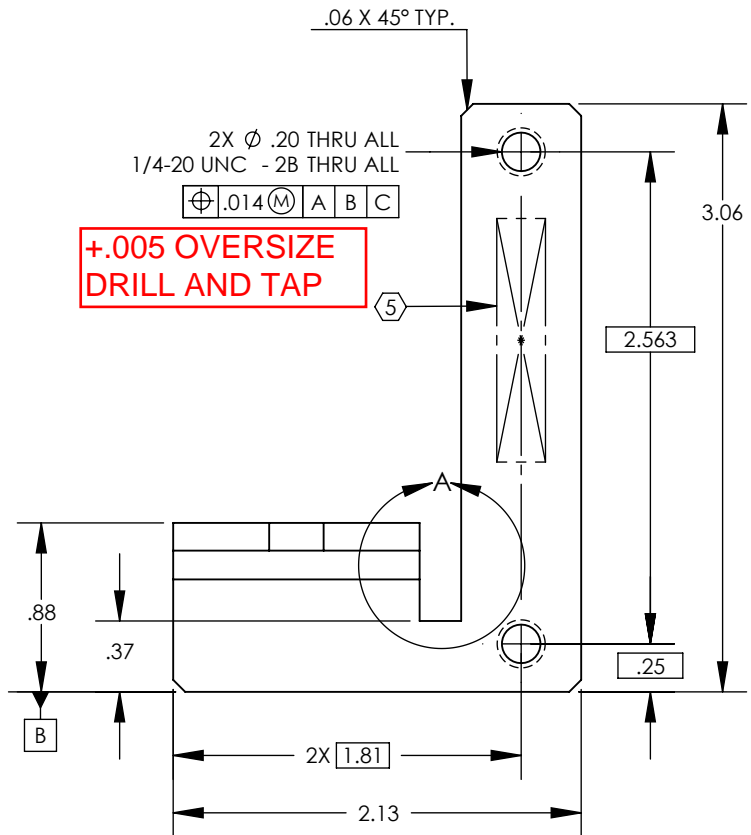
6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
7. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
8. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING.
9. ELECTROPOLISH AFTER FABRICATION TO REMOVE .0005 - .001 FROM ALL SURFACES.

REV.	DATE	DCN #	DRAWING TREE #
v1	18 JUL 2011	E1100681-x0	-
-	-	-	-
-	-	-	-

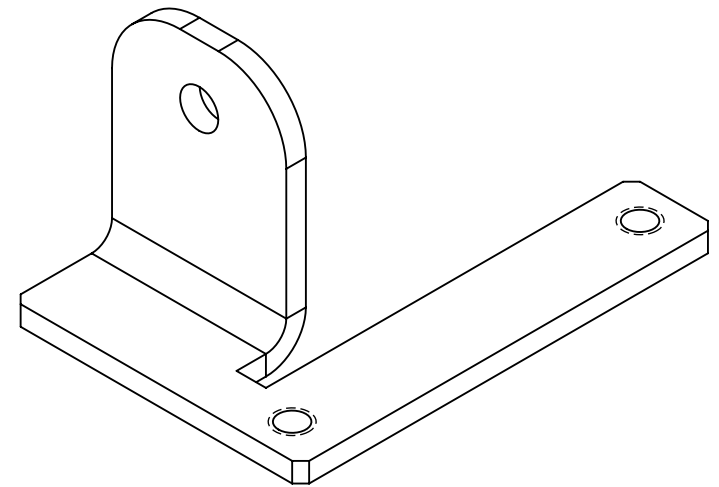
D1101303\_ALIGO\_SUS\_UHV\_CONNECTOR\_CLAMP\_MT\_BRACKET\_PART\_PDM\_REV\_X-001\_DRAWING\_PDM\_REV\_X-000



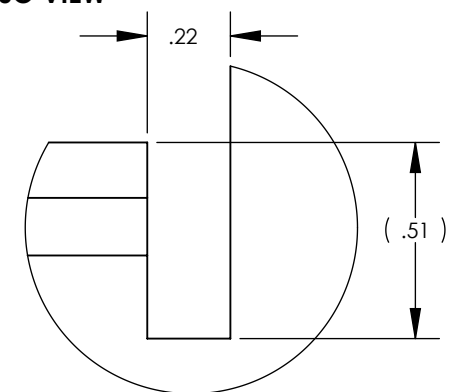
ISO VIEW



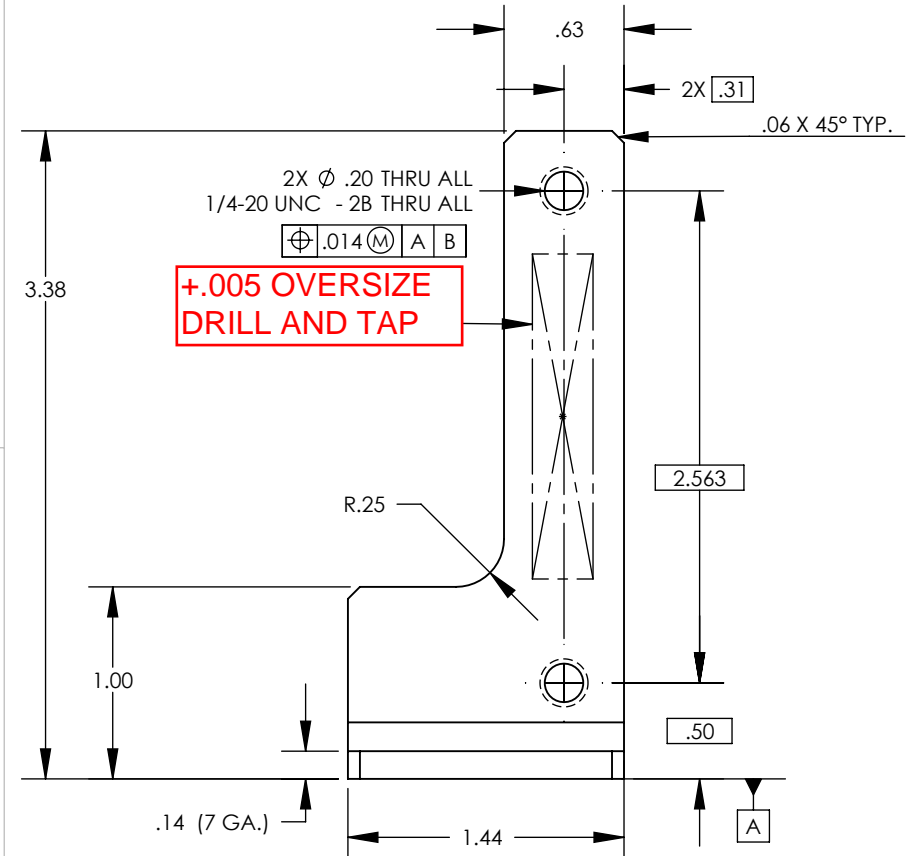
**+0.005 OVERSIZE DRILL AND TAP**



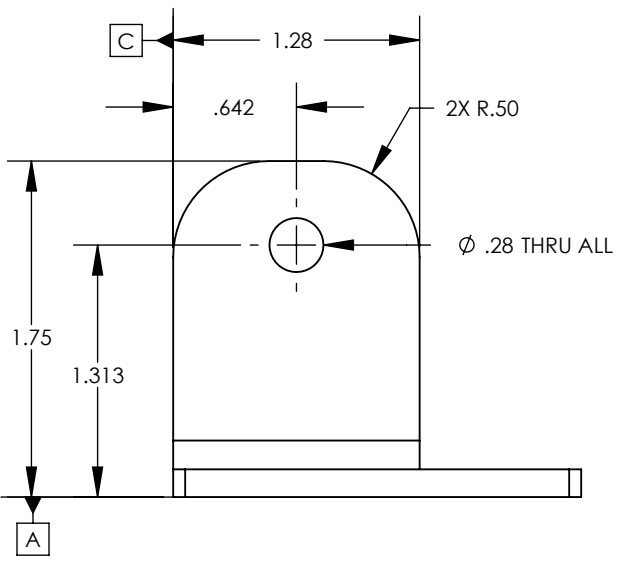
ISO VIEW



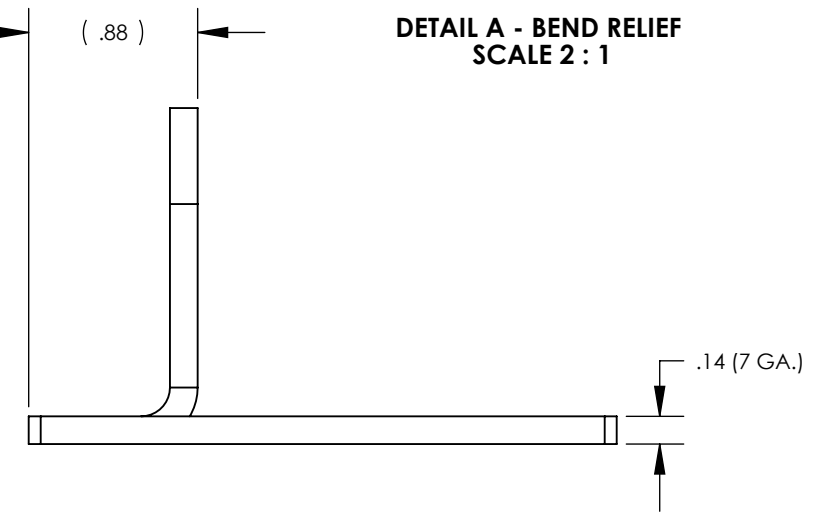
DETAIL A - BEND RELIEF SCALE 2:1



**+0.005 OVERSIZE DRILL AND TAP**



BASIC DETAIL PENRE BRACKET



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:  
 .XX ± .01  
 .XXX ± .005  
 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.

MATERIAL	6061 AL ALLOY	FINISH	63 μinch
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
ALIGO		ALIGO. SUS, UHV CONNECTOR CLAMP, MT. BRACKET	
DESIGNER	ESANCHEZ	11 JUL 2011	SIZE DWG. NO.
DRAFTER	ESANCHEZ	11 JUL 2011	B D1101303
CHECKER			REV.
APPROVAL			v1
NEXT ASSY		D1101305	
SCALE: 1:1		PROJECTION:	
		SHEET 1 OF 1	