

D1101609_ACB_Stage Zero Guide Block-BSC3 PART FDM REV: X.019 DRAWING FDM REV: X.009

REV.	DATE	DCN #	DRAWING TREE #
v1	29 FEB 2012	E1100335-v5	-
-	-	-	-
-	-	-	-

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

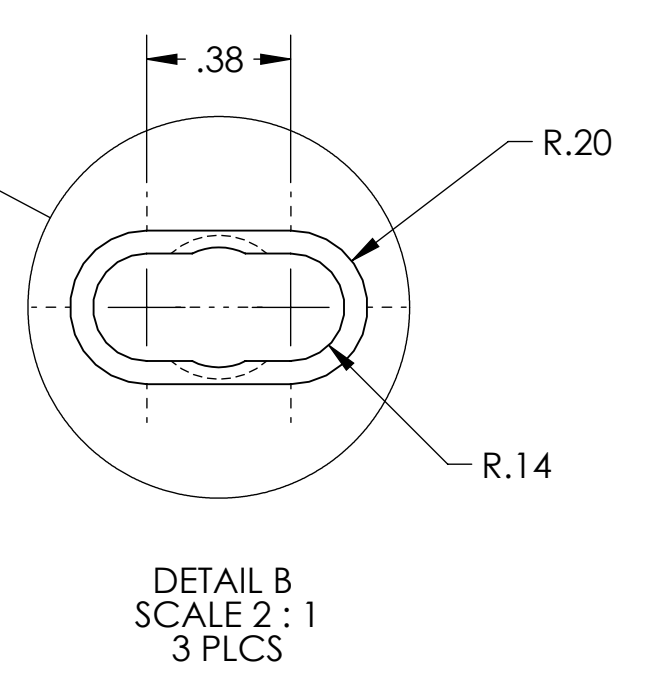
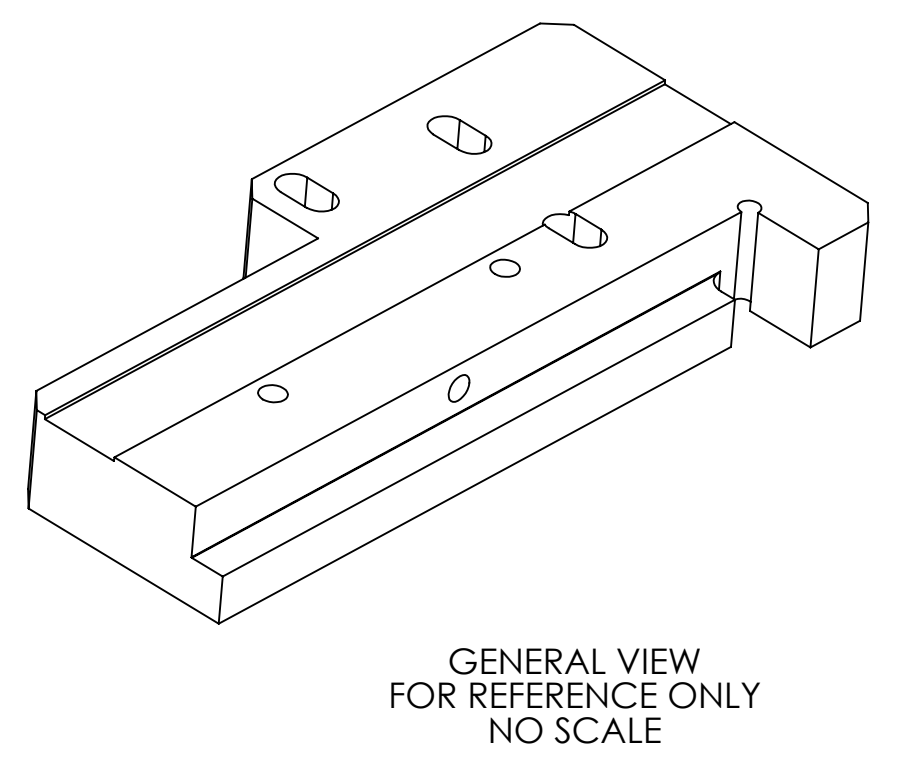
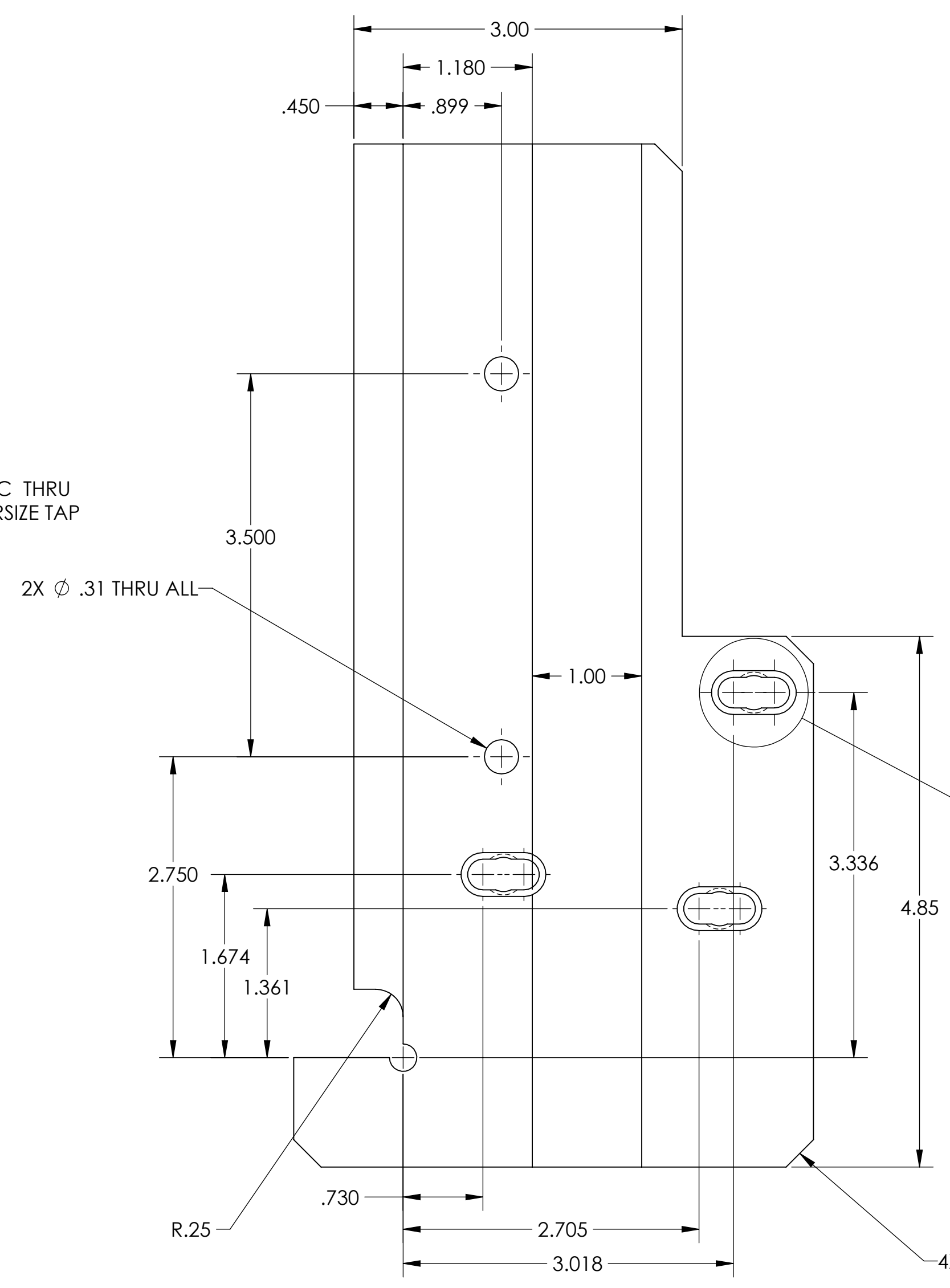
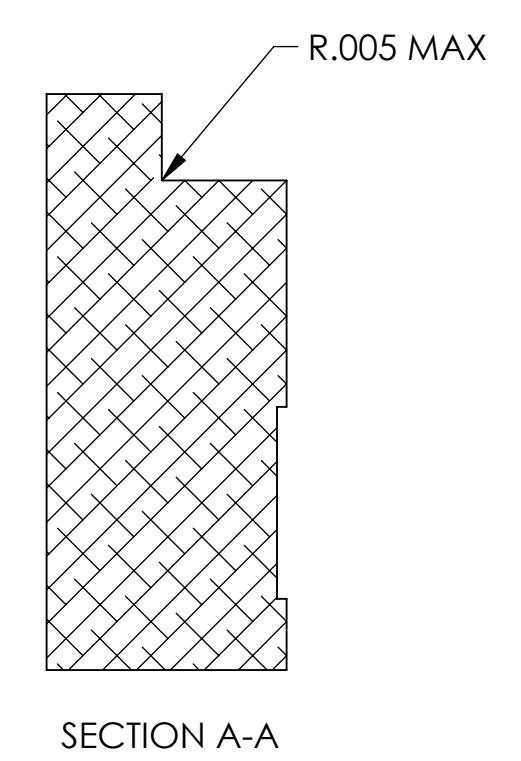
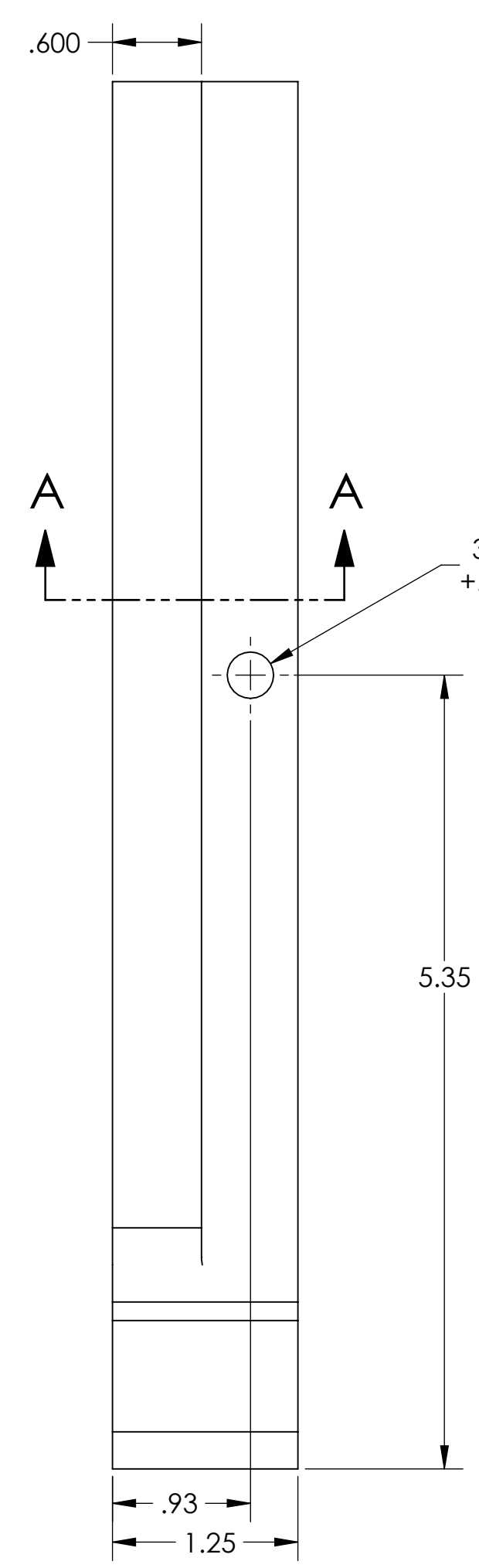
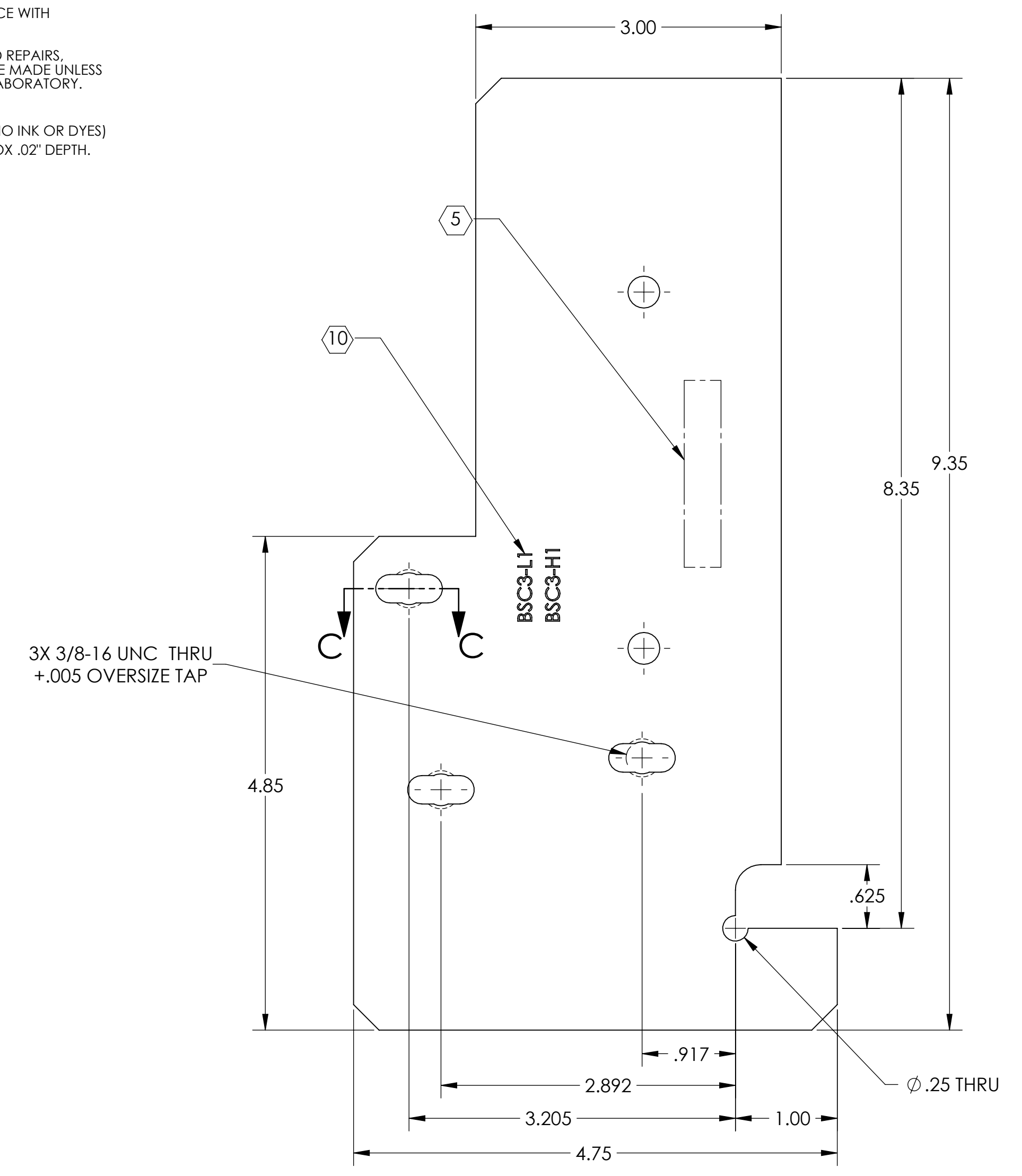
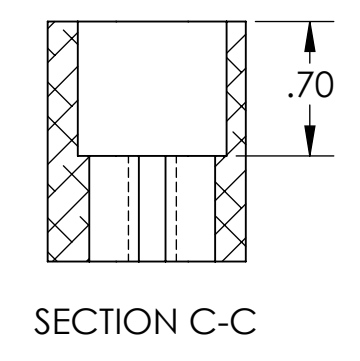
6. APPROXIMATE WEIGHT = 3.670 LBS.

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.

10. SCRIBE, ENGRAVE OR MECHANICALLY STAMP TEXT (NO INK OR DYES) APPROXIMATELY WHERE SHOWN AND LETTERING APPROX .02" DEPTH.



DIMENSIONS ARE IN INCHES		TOLERANCES:		ANGULAR ± 1.0°		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		MATERIAL		FINISH		NEXT ASSY		PART NAME		DESIGNER		DRAFTER		CHECKER		APPROVAL	
		.XX ± .01				1. INTERPRET DRAWING PER ASME Y14.5-1994.		6061-T6 Al		63 μinch		D1101957		ACB_STAGE ZERO_GUIDE BLOCK, BSC3_H1-L1		TQ. NGUYEN		TQ. NGUYEN		L. AUSTIN		M. SMITH	
		.XXX ± .005				2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.								ADVANCED LIGO		SUB-SYSTEM		17 FEB 2012		29 FEB 2012		26 MAR 2012	
						3. DO NOT SCALE FROM DRAWING.								AOS		D		26 MAR 2012					
						4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.								SCALE: 1:1		PROJECTION:		SCALE: 1:1					
														SHEET 1 OF 1									