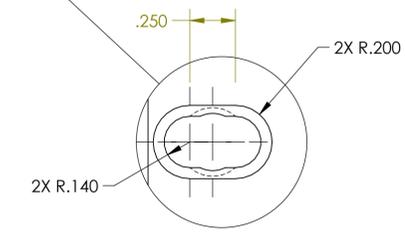
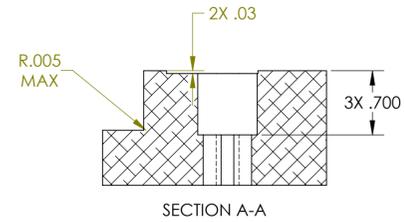
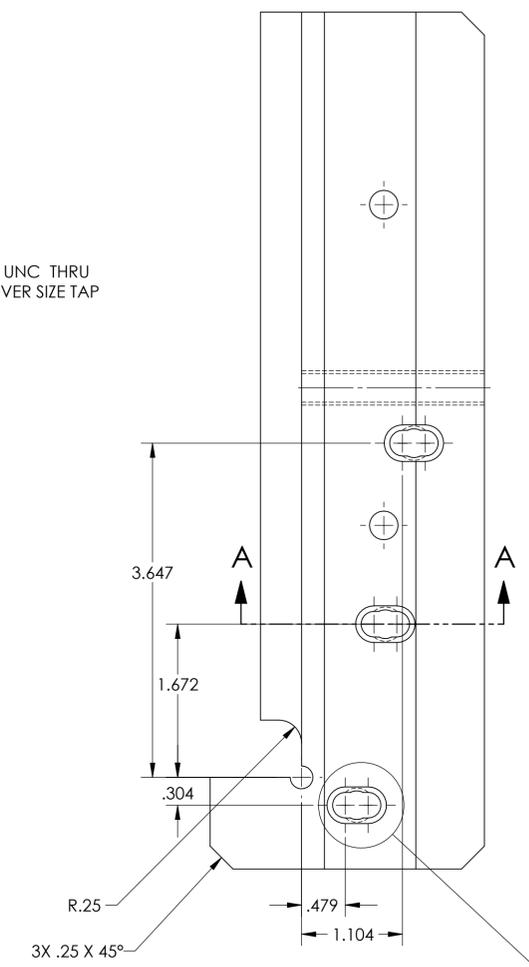
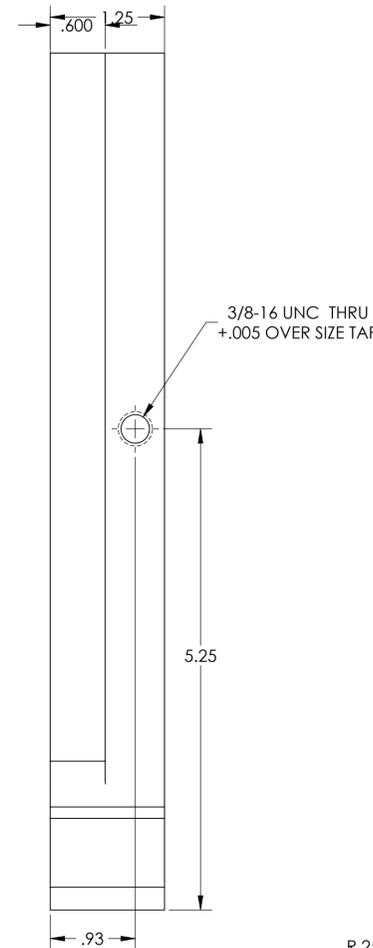
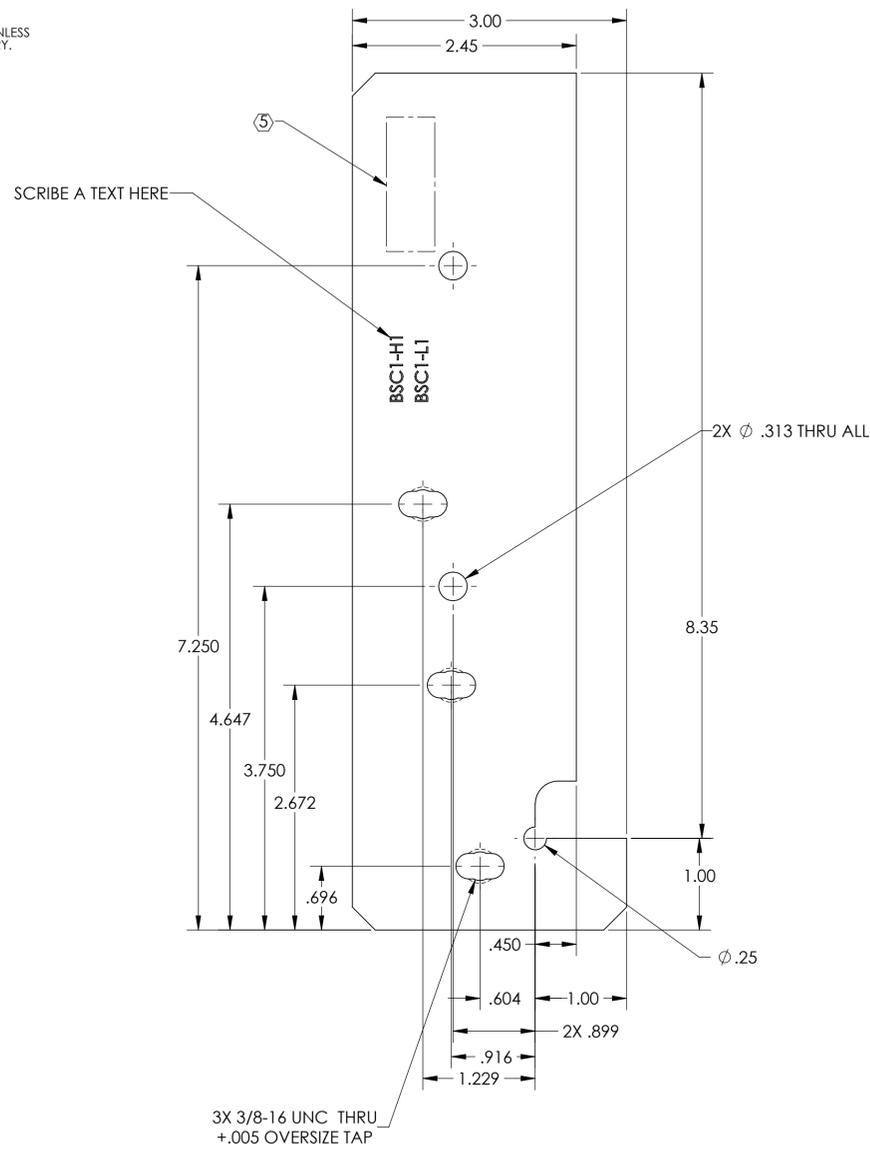


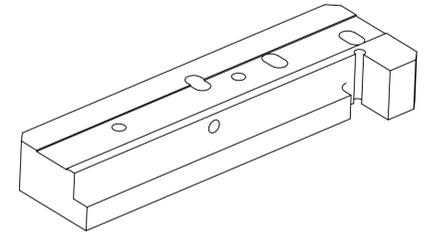
NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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 = 2.478 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.
 11. 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.

REV.	DATE	DCN #	DRAWING TREE #
v1	10 JUL 2012	E1100335	



DETAIL B
SCALE 2 : 1
3 PLS



GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				PART NAME	
DIMENSIONS ARE IN INCHES				ACB_STAGE ZERO_GUIDE BLOCK, BSC 1_H1-L1	
TOLERANCES: .XX ± .01 .XXX ± .005				DESIGNER TQ. NGUYEN 17 FEB 2012	
ANGULAR ± 1.0°				DRAFTER TQ. NGUYEN 16 AUG 2011	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED 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.				SIZE DWG. NO.	
MATERIAL 6061-T6 Al		FINISH 63 μinch		D D1101610	
NEXT ASSY		DESIGNER TQ. NGUYEN 17 FEB 2012		REV. v1	
MATERIAL 6061-T6 Al		FINISH 63 μinch		SCALE: 1:1	
MATERIAL 6061-T6 Al		FINISH 63 μinch		PROJECTION:	
MATERIAL 6061-T6 Al		FINISH 63 μinch		SHEET 1 OF 1	

D1101610_ACB_StageZeroGuideBlock-BSC1_PART FDM REV: X023_DRAWING FDM REV: X007