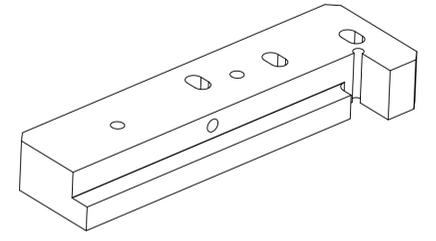
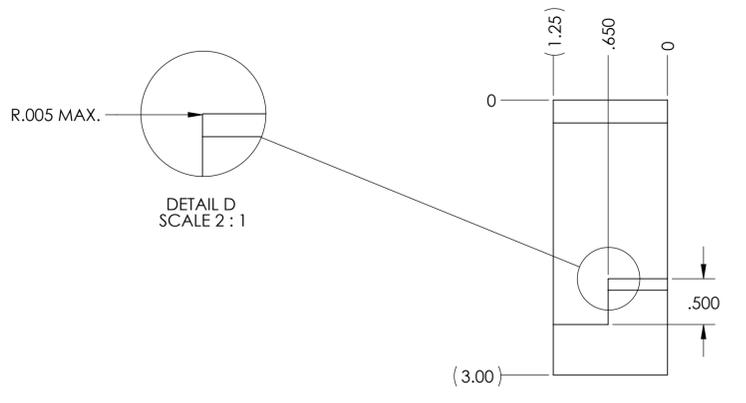


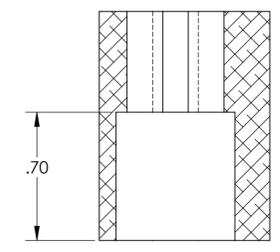
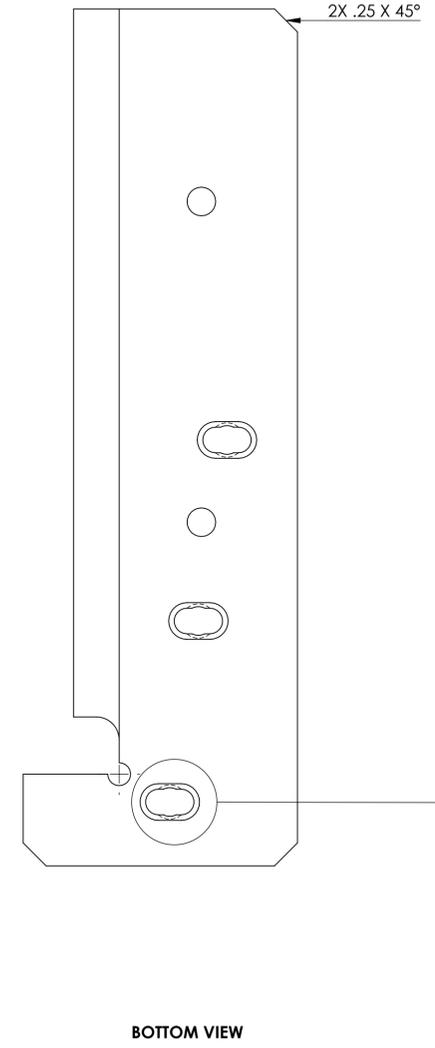
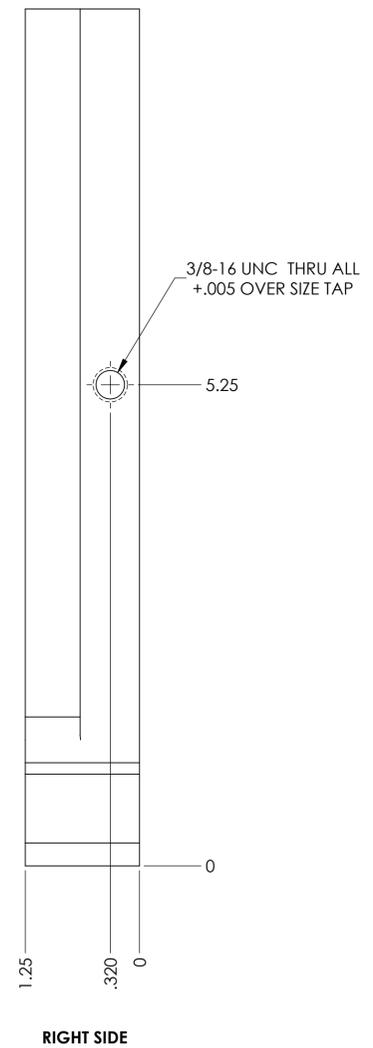
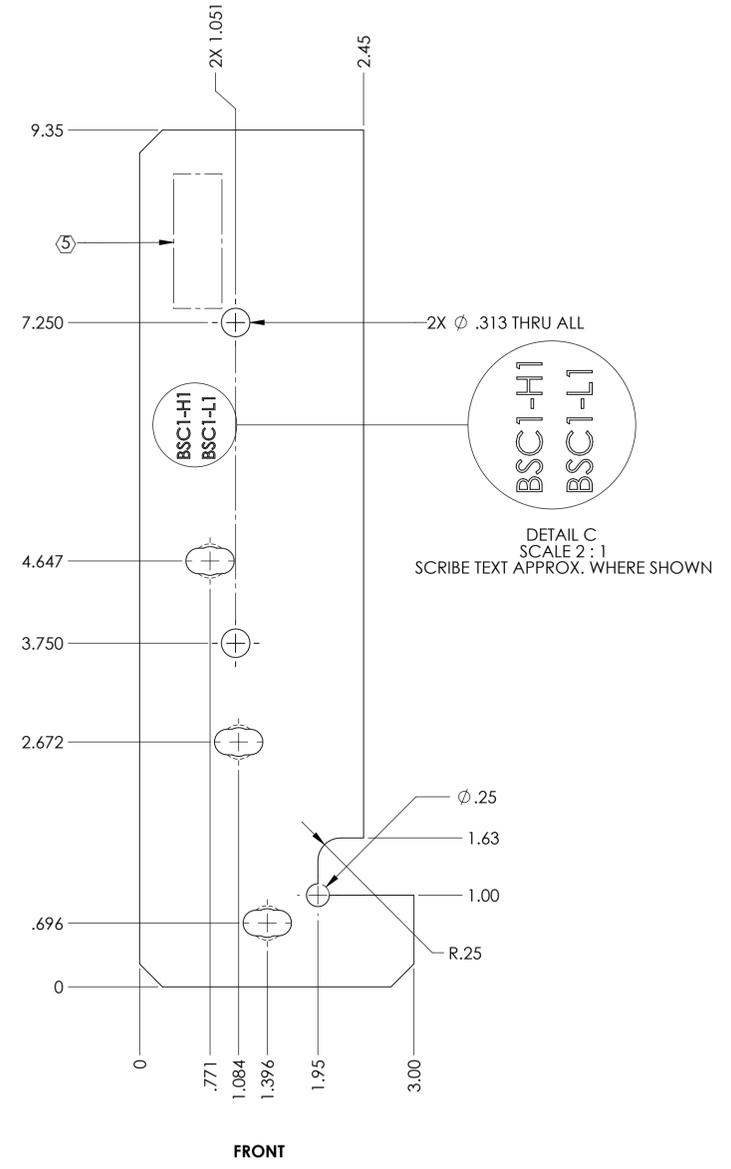
NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001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

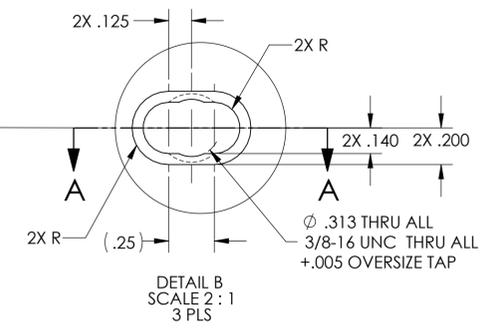
REV.	DATE	DCN #	DRAWING TREE #
v1	10 JUL 2012	-	
v2	15 APR 2013	E1100312-v1	
-	-	-	



ISO VIEW
FOR REFERENCE ONLY
NO SCALE



SECTION A-A
SCALE 2:1



DETAIL B
SCALE 2:1
3 PLS

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				CALIFORNIA INSTITUTE OF TECHNOLOGY LIGO MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME ACB_STAGE ZERO_GUIDE BLOCK, BSC 1_H1-L1				
DIMENSIONS ARE IN INCHES		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS	DESIGNER TQ. NGUYEN	17 FEB 2012	SIZE D	DWG. NO. D1101610	REV. v2
TOLERANCES: .XX ± .01 .XXX ± .005		MATERIAL 6061-T6 Al	FINISH 63 μinch	NEXT ASSY D1003374		CHECKER M. SMITH	SEE DCC	SCALE: 1:1		PROJECTION:
ANGULAR ± 1.0°						APPROVAL C. TORRIE	SEE DCC	SHEET 1 OF 1		

D1101610_ACB_Stage Zero Guide Block-BSC 1_PART FDM REV: X025_DRAWING FDM REV: X012