

- 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 = 12.30 LB.
 - 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. INDICATED TAPPED HOLES +.005 OVERSIZE BOTH DRILL AND TAP.
 - 11. SCRIBE OR YAG LASER ETCH .03 WIDE TYP.

MANUFACTURING PROCESS:

COLD STABILIZE PLATES.

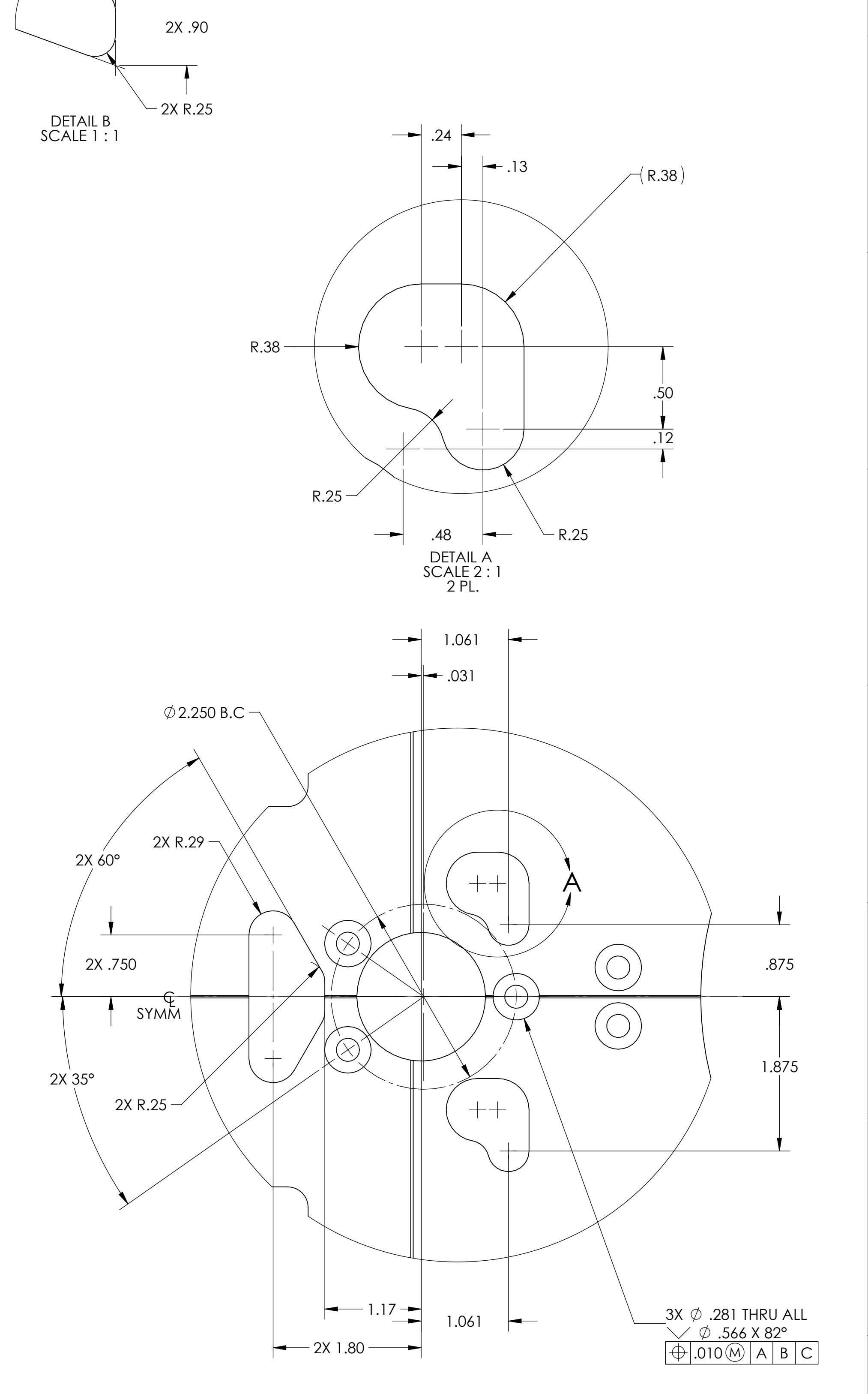
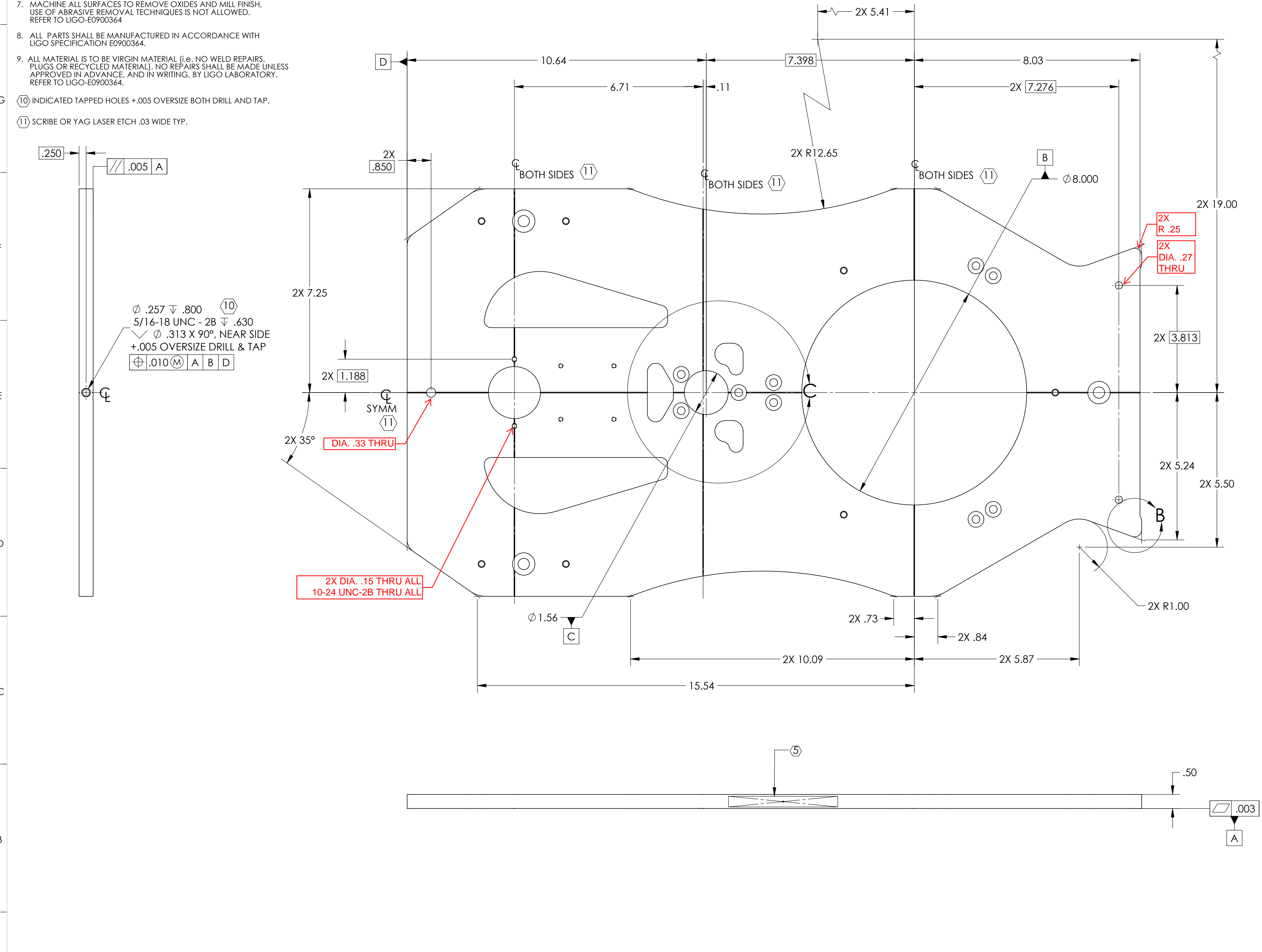
ON TOOLROOM VERTICAL MACHINE, CLAMP PART TO ANGLE PLATE. MATCH HOLE FOR 5/16-18 OVERSIZE THREAD PER (10) ON (1) END OF EACH PART.

HAND DEBURR PARTS WITH BURR KNIVES & ROTARY CARBIDE BURRS.

HAND TAP ALL REQUIRED HOLES, .005 OVERSIZE TAP PER (10).

INSPECT PARTS. ASSURE FLATNESS OF .003 OR BETTER OVER FACE 'A'. SEND MATERIAL SERIS.

REV.	DATE	DCN #	DRAWING TREE #
v1	27 MAR 2012	E1200317-x0	-
v2	22 JUN 2012	-	-
-	-	-	-



<p>NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)</p> <p>1. INTERPRET DRAWING PER ASME Y14.5-1994.</p> <p>2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.</p> <p>3. DO NOT SCALE FROM DRAWING.</p> <p>4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.</p>		<p>LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY</p>		<p>PART NAME aLIGO TMS TELE PRIMARY 3 TUBE END PLATE</p>	
<p>DIMENSIONS ARE IN INCHES</p> <p>TOLERANCES: .XX ± .01 .XXX ± .005</p> <p>ANGULAR ± 0.5°</p>		<p>SYSTEM ADVANCED LIGO</p>		<p>SUB-SYSTEM AOS</p>	
<p>MATERIAL 6061-T6 Al</p>		<p>FINISH 63 μinch</p>		<p>NEXT ASSY D1102361</p>	
<p>DESIGNER: J. TRRRAZAS 29 AUG 2011</p> <p>DRAFTER: E.SANCHEZ 27 MAR 2012</p> <p>CHECKER: SEE DCC SEE DCC</p> <p>APPROVAL: SEE DCC SEE DCC</p>		<p>SIZE: D</p> <p>DWG. NO.: D1101727</p> <p>SCALE: 1:2</p> <p>PROJECTION:</p>		<p>SHEET 1 OF 2</p>	

D1101727-ALIGO TMS TELE PRIMARY 3 TUBE END PLATE PART PDM REV: X.031 DRAWING PDM REV: X.005

