

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 = X.XXX LB.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. REFER TO LIGO-E0900364

3X ϕ .021 THRU ALL
1/4-20 UNC - 2B THRU ALL
 ϕ .251 X 90°, NEAR SIDE
 ϕ .251 X 90°, FAR SIDE

\oplus .014 (M) A B C

2X
 \oplus .014 (M) A B C

5X R.10

2.34

2.25

4X R

.75

2X .98

2X .28

1.88

2X R

1.75

1.50

.38

0

.28

.30

.975

R.26

2.85

4.00

5.25

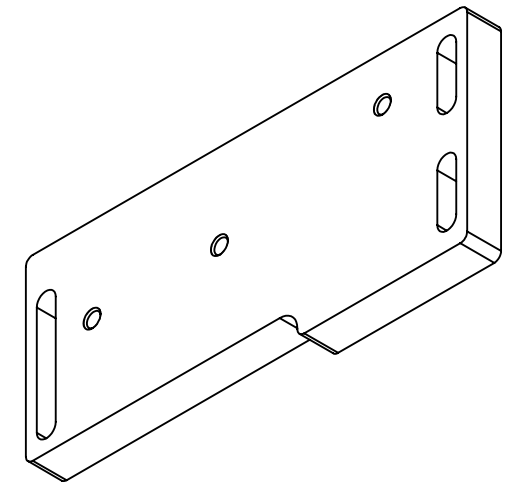
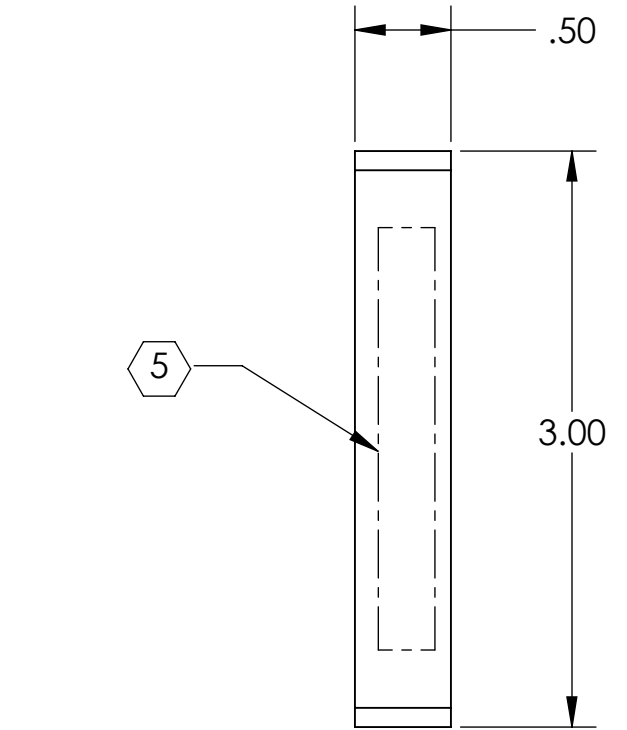
6.20

A

\parallel .005 A

6.50

C



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
TOLERANCES:
.XX \pm .01
.XXX \pm .005
ANGULAR \pm 0.5°

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-T6 Al
FINISH 125 μ inch

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
SYSTEM ADVANCED LIGO
SUB-SYSTEM ISC
NEXT ASSY D1200382

| | | | |
|-----------|----------------------------|--------------------------|---------------------------|
| PART NAME | | ALS Upper Periscope Base | |
| DESIGNER | BJJ Slagmolen | SIZE DWG. NO. | B |
| DRAFTER | BJJ Slagmolen 29 Sept 2011 | D1101868 | REV. v2 |
| CHECKER | SBARNUM 1 JUL 2013 | | |
| APPROVAL | PFRITSCHEL D1200380 | SCALE: 1:1 | PROJECTION: SHEET 1 OF 1 |