

NOTES CONTINUED:

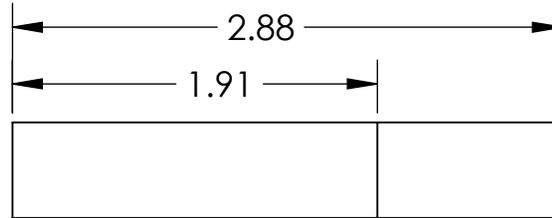
5. SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.  
 EXAMPLE (PART): 001-v1  
 EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD

6. APPROXIMATE WEIGHT = X.XXX LB.

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

8. FINISH: CLEAR ANODIZE

REV.	DATE	DCN #	DRAWING TREE #
V2	1 JUL 2013	E1300516	-
-	-	-	-
-	-	-	-

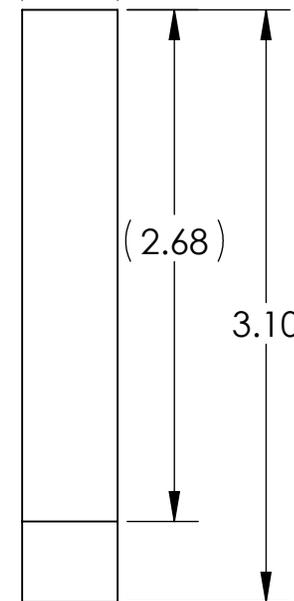


2X  $\phi$  .281 THRU ALL

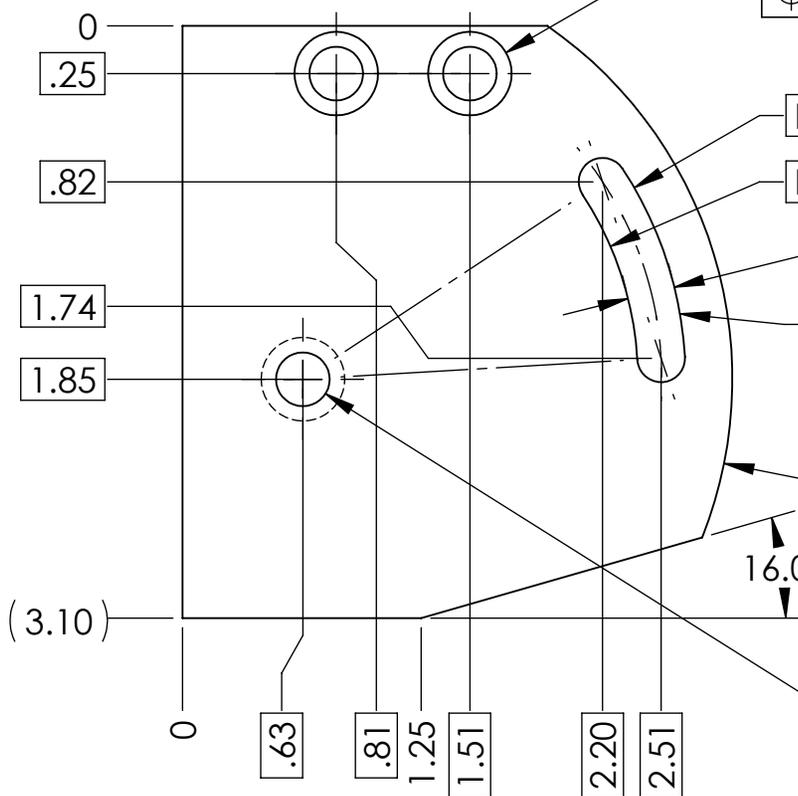
$\square$   $\phi$  .438  $\nabla$  .250

$\oplus$	$\phi$ .014 (M)	A	B	C
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.50



3.10



R2.01

R1.76

(.25)

R2.25

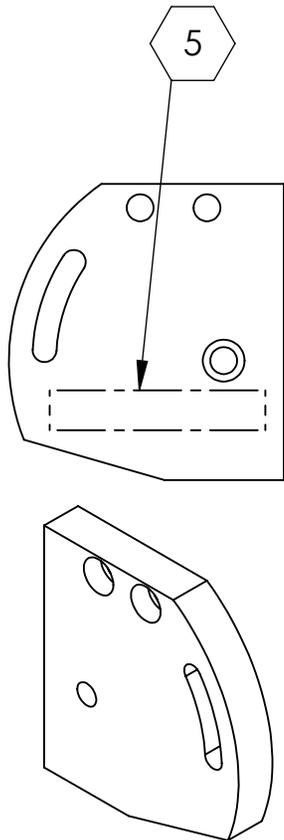
16.0°

$\phi$  .281 THRU ALL

$\square$   $\phi$  .438  $\nabla$  .250

OTHER SIDE

$\oplus$	$\phi$ .014 (M)	A	B	C
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NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:

.XX  $\pm$  .01

.XXX  $\pm$  .005

ANGULAR  $\pm$  0.5°

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES: .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL

6061-T6 Al

FINISH

125  $\mu$ inch



CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM

ADVANCED LIGO

NEXT ASSY

D1101481

SUB-SYSTEM

ISC

PART NAME

ALS Upper Periscope Rotation Base

DESIGNER BJJ Slagmolen

DRAFTER BJJ Slagmolen 29 Sept 2011

CHECKER SBARNUM 1 JUL 2013

APPROVAL PFRITSCH 1 JUL 2013

SIZE DWG. NO.

A

D1101869

REV.

v2

SCALE: 1:1

PROJECTION:



SHEET 1 OF 1