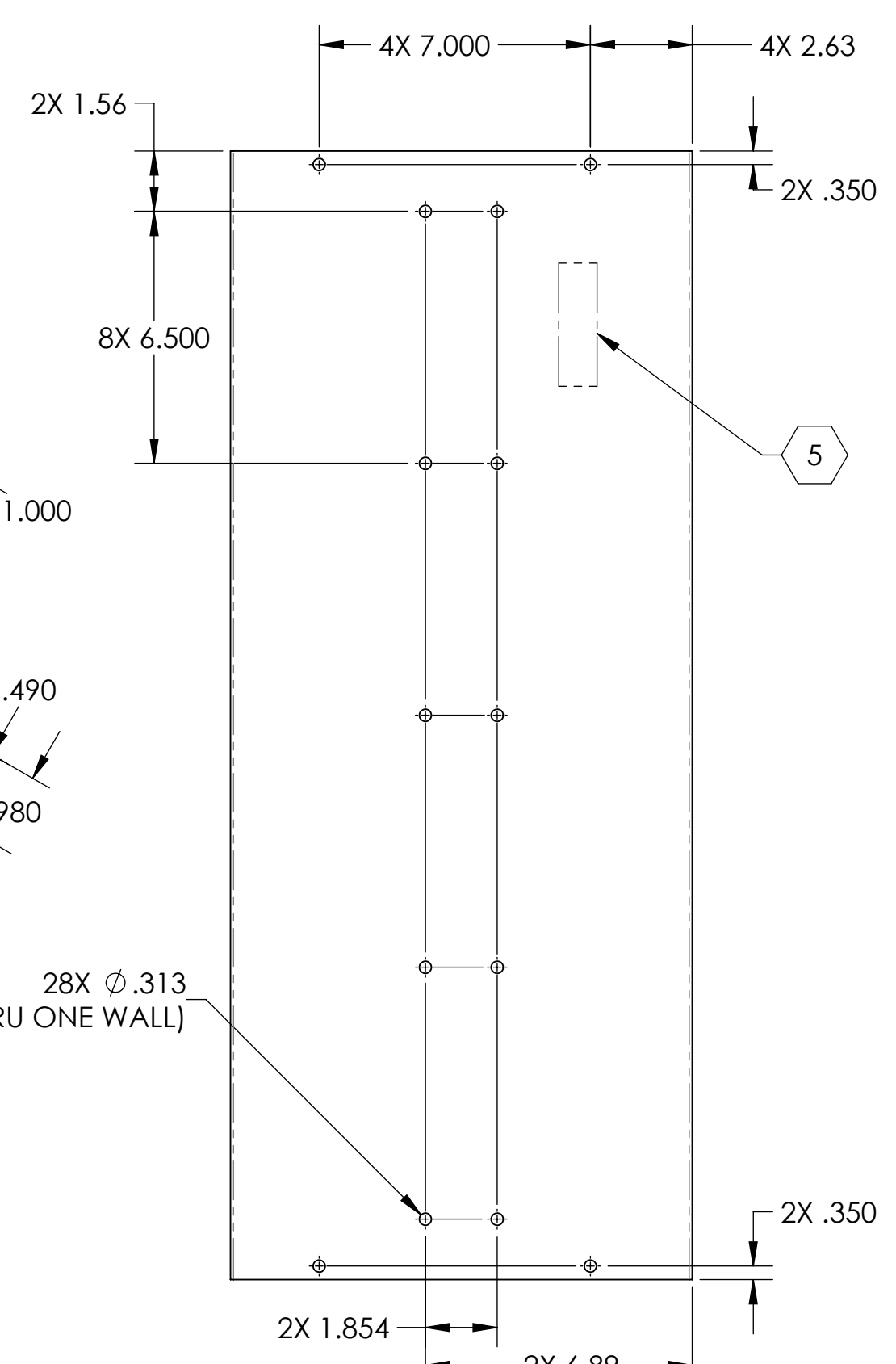
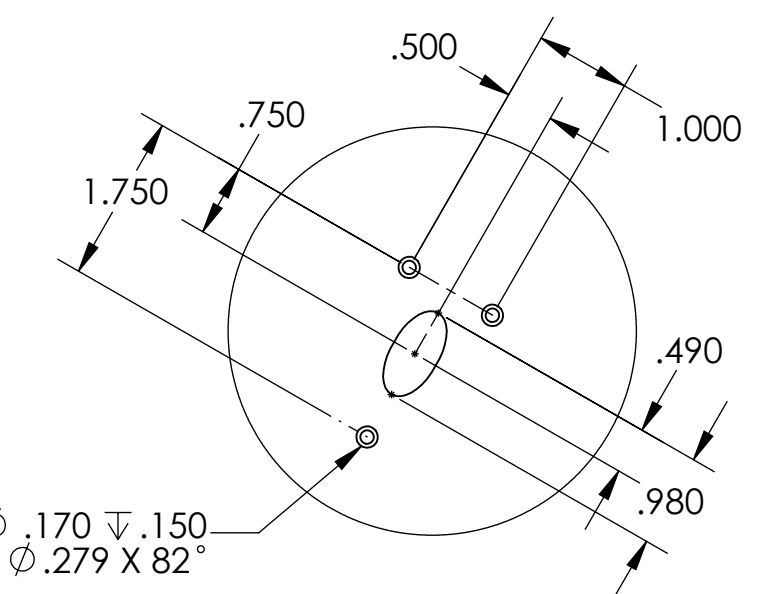
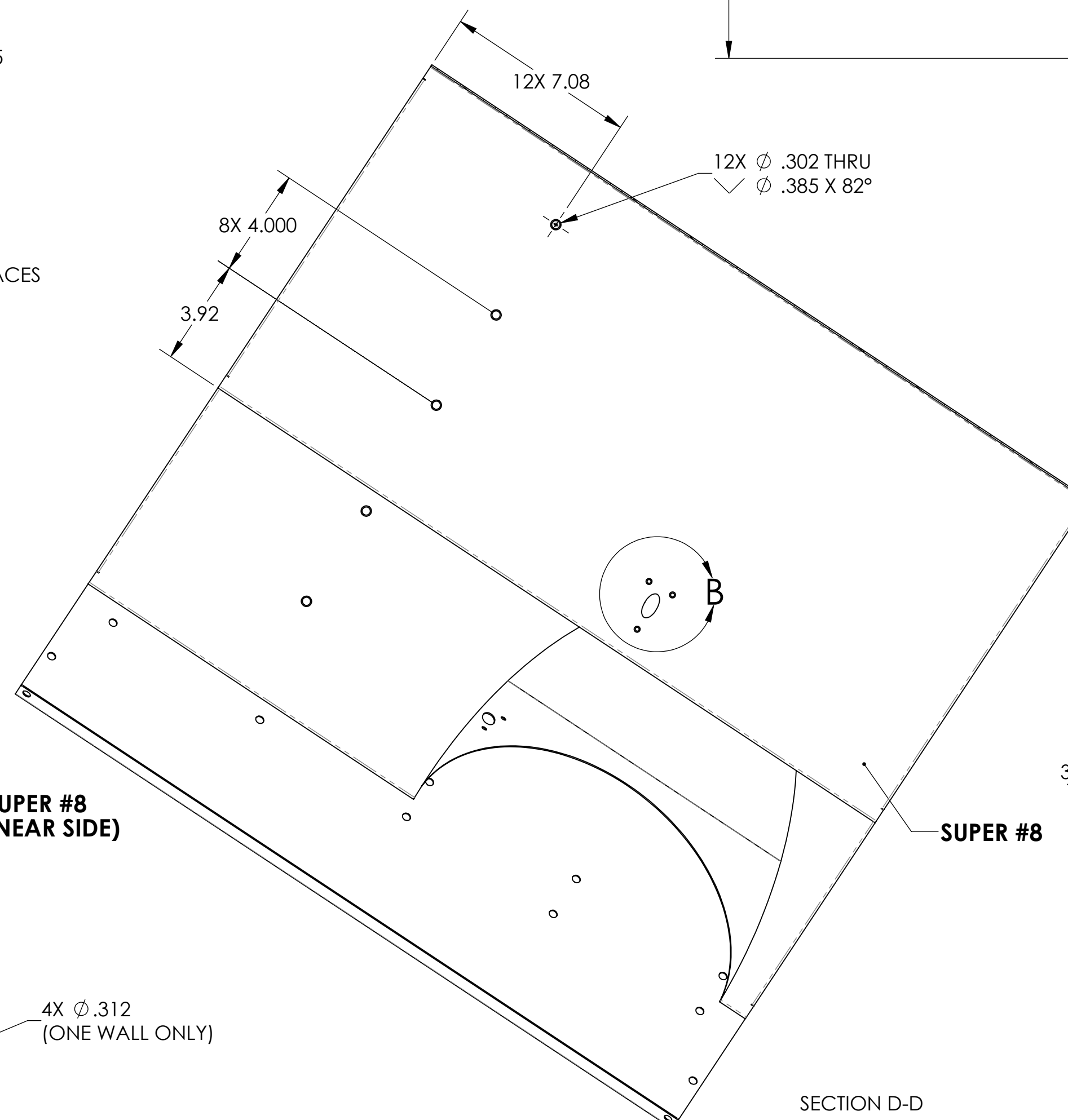
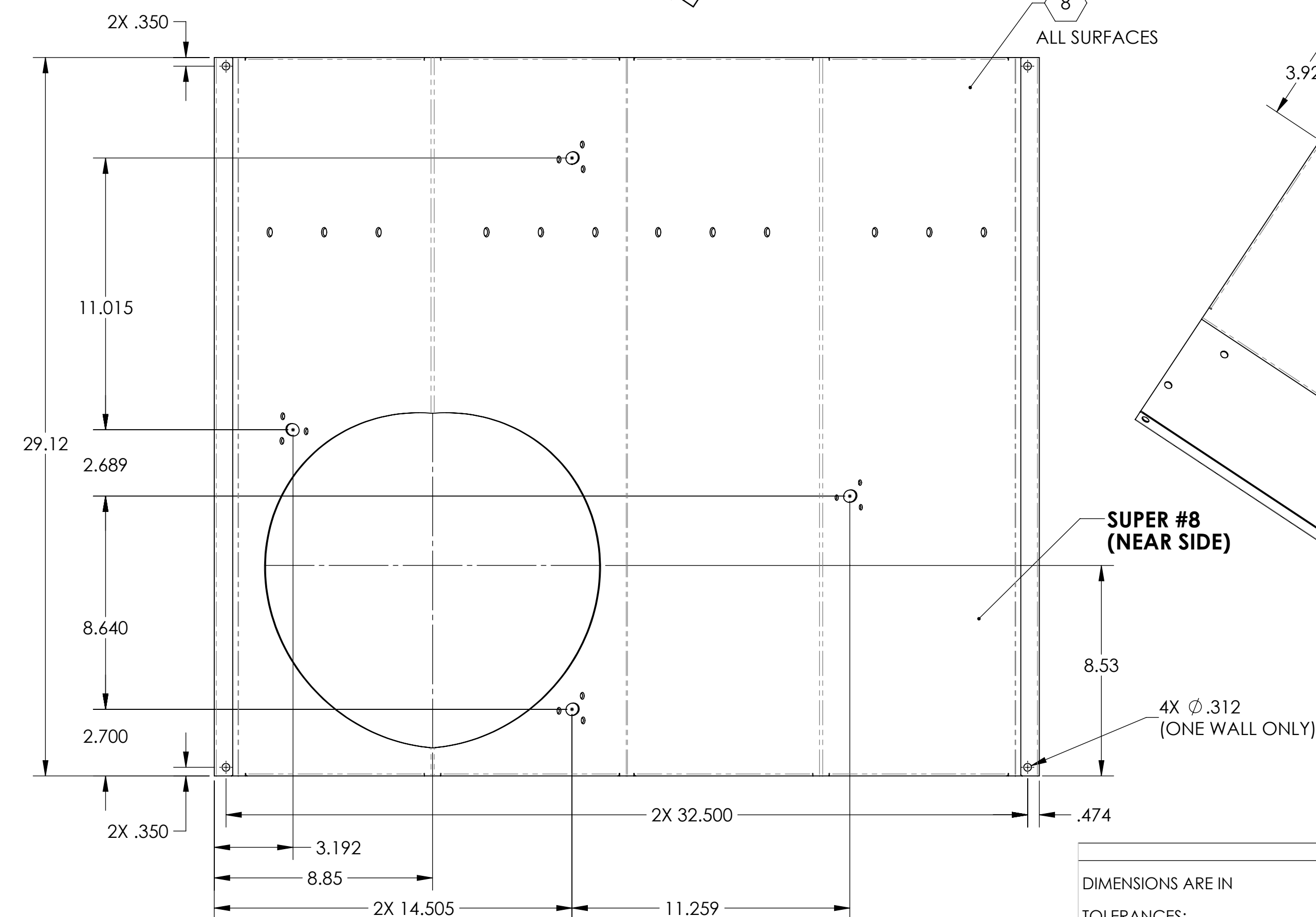
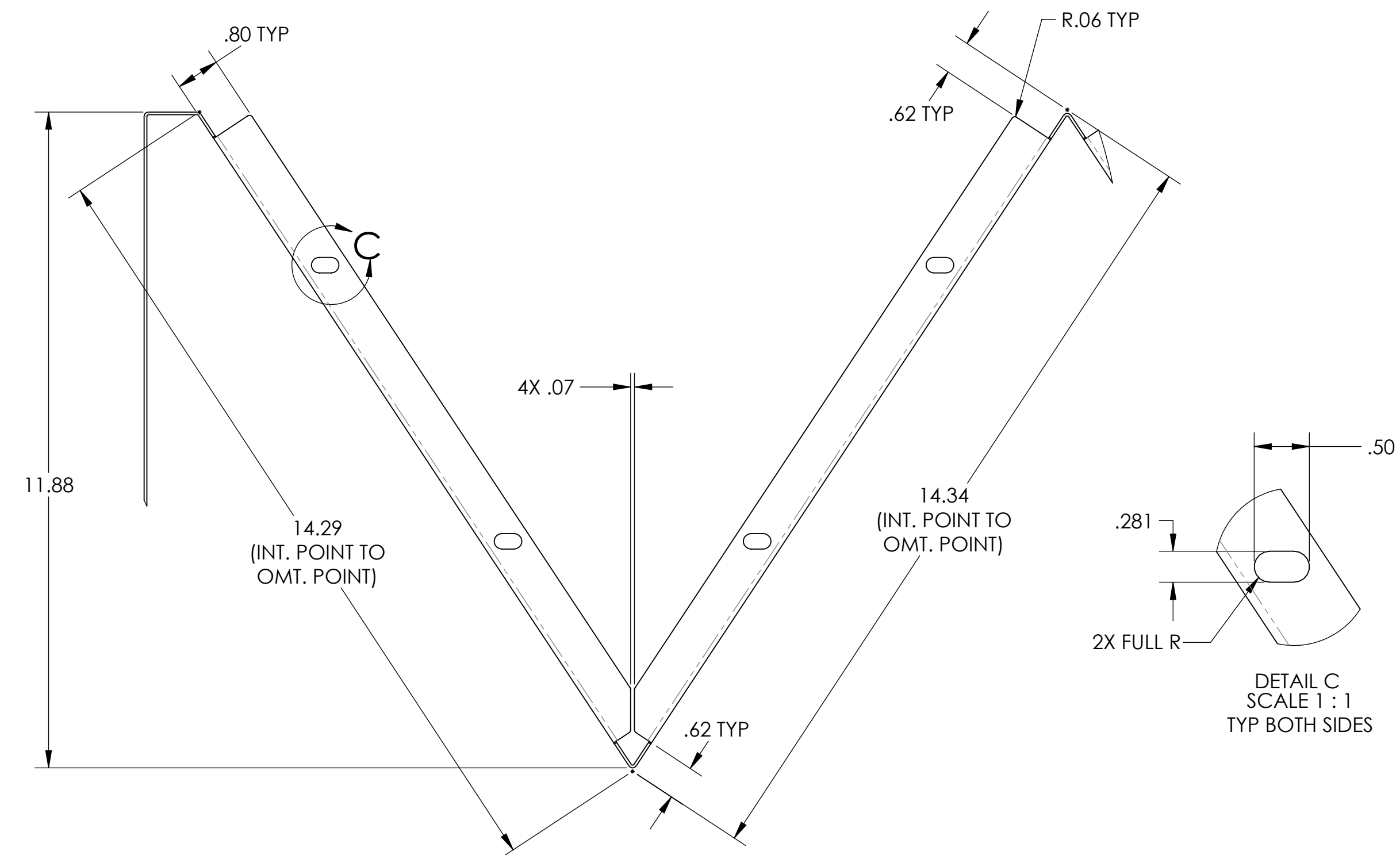
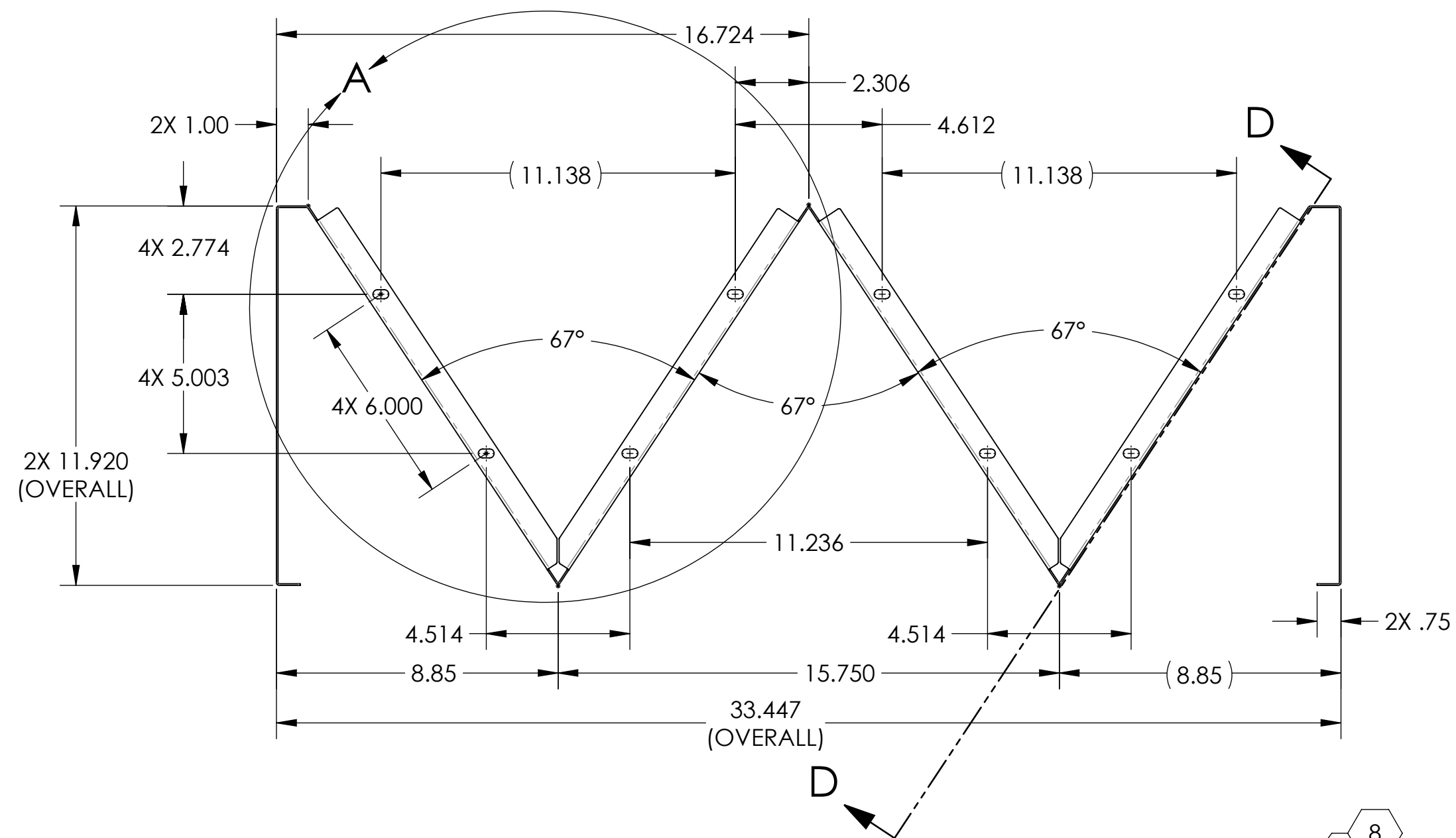


NOTES: UNLESS OTHERWISE SPECIFIED

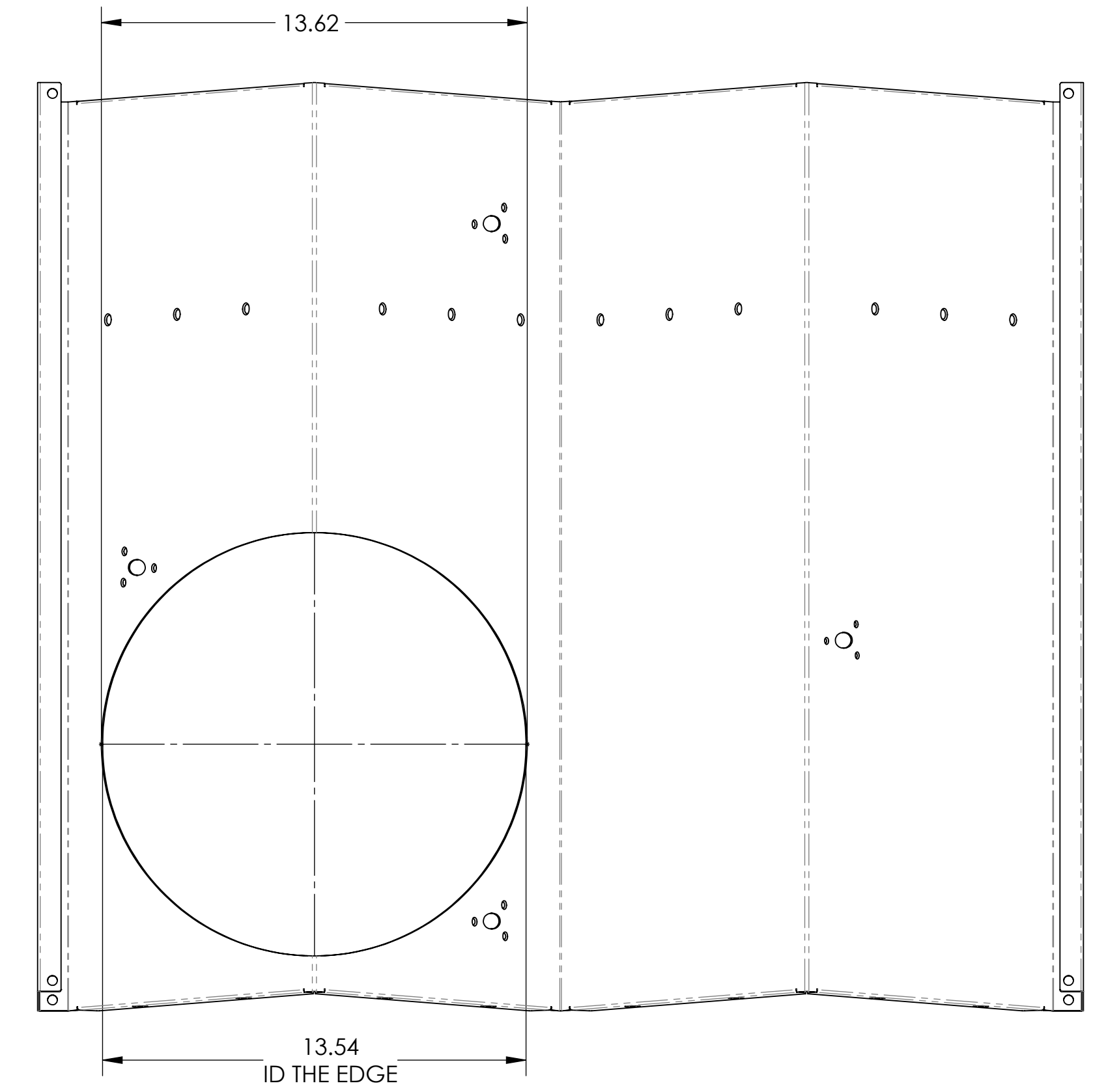
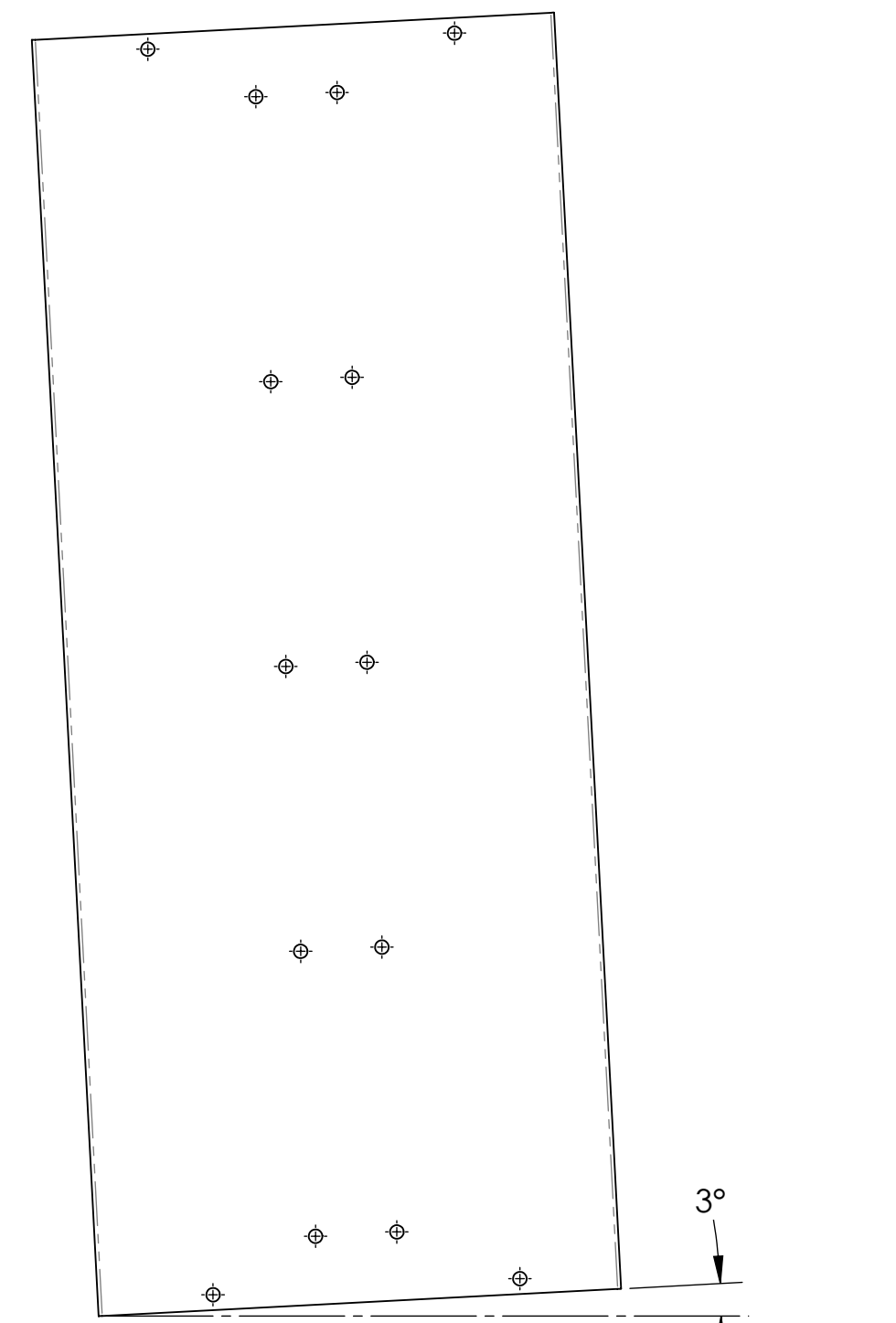
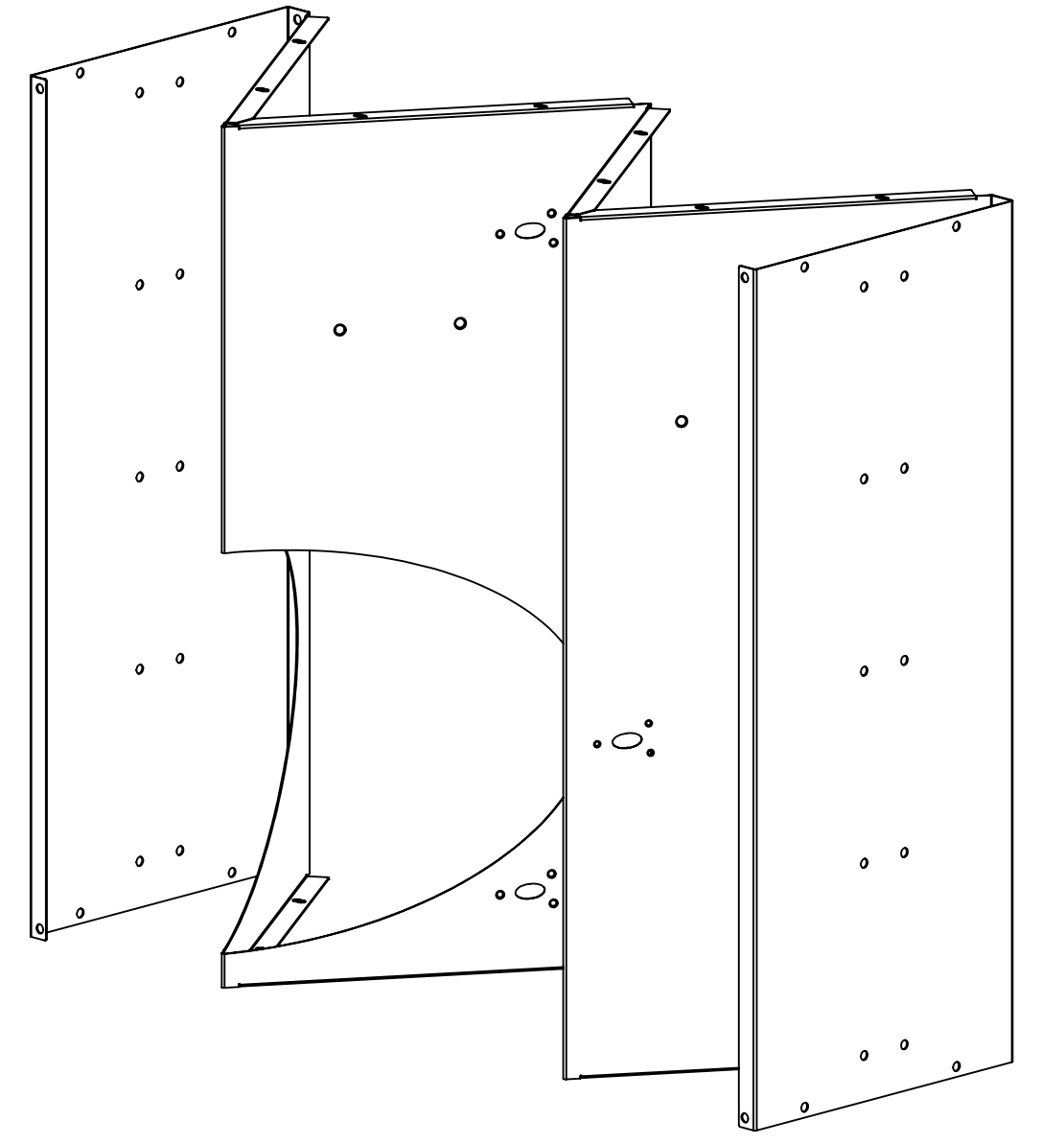
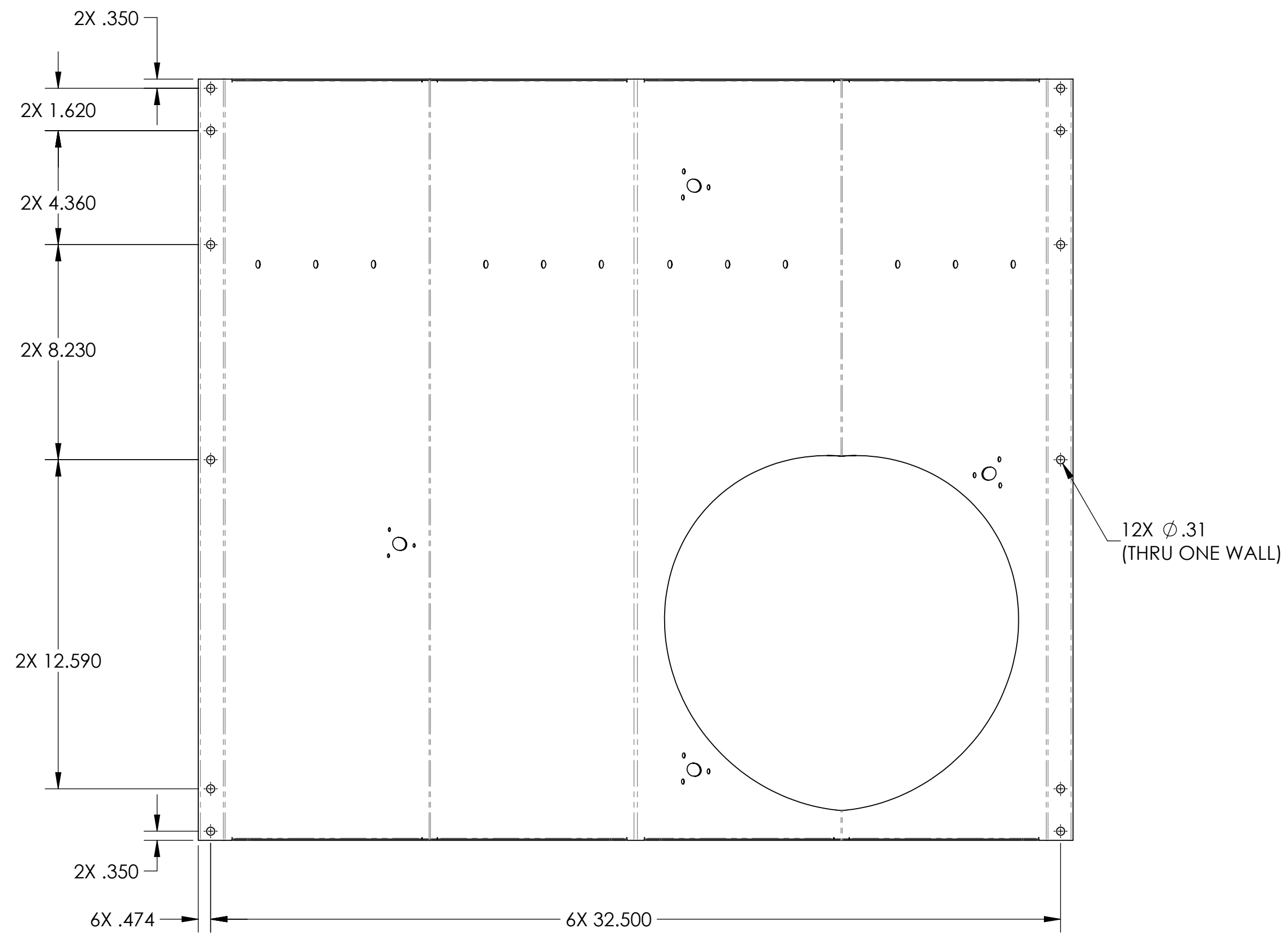
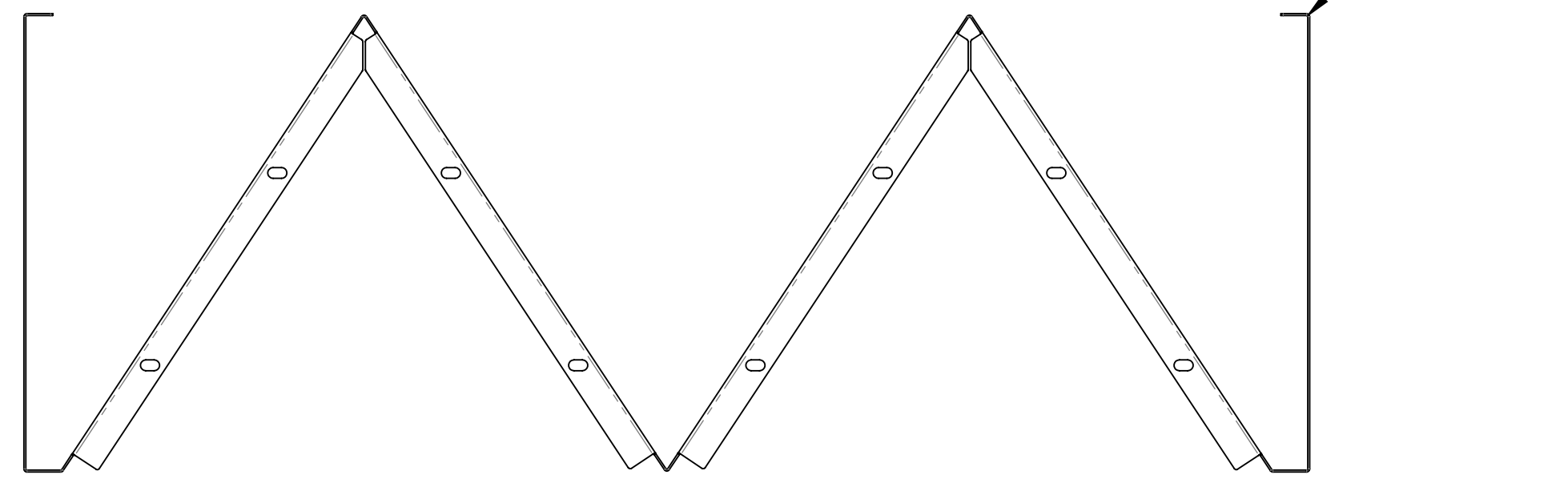
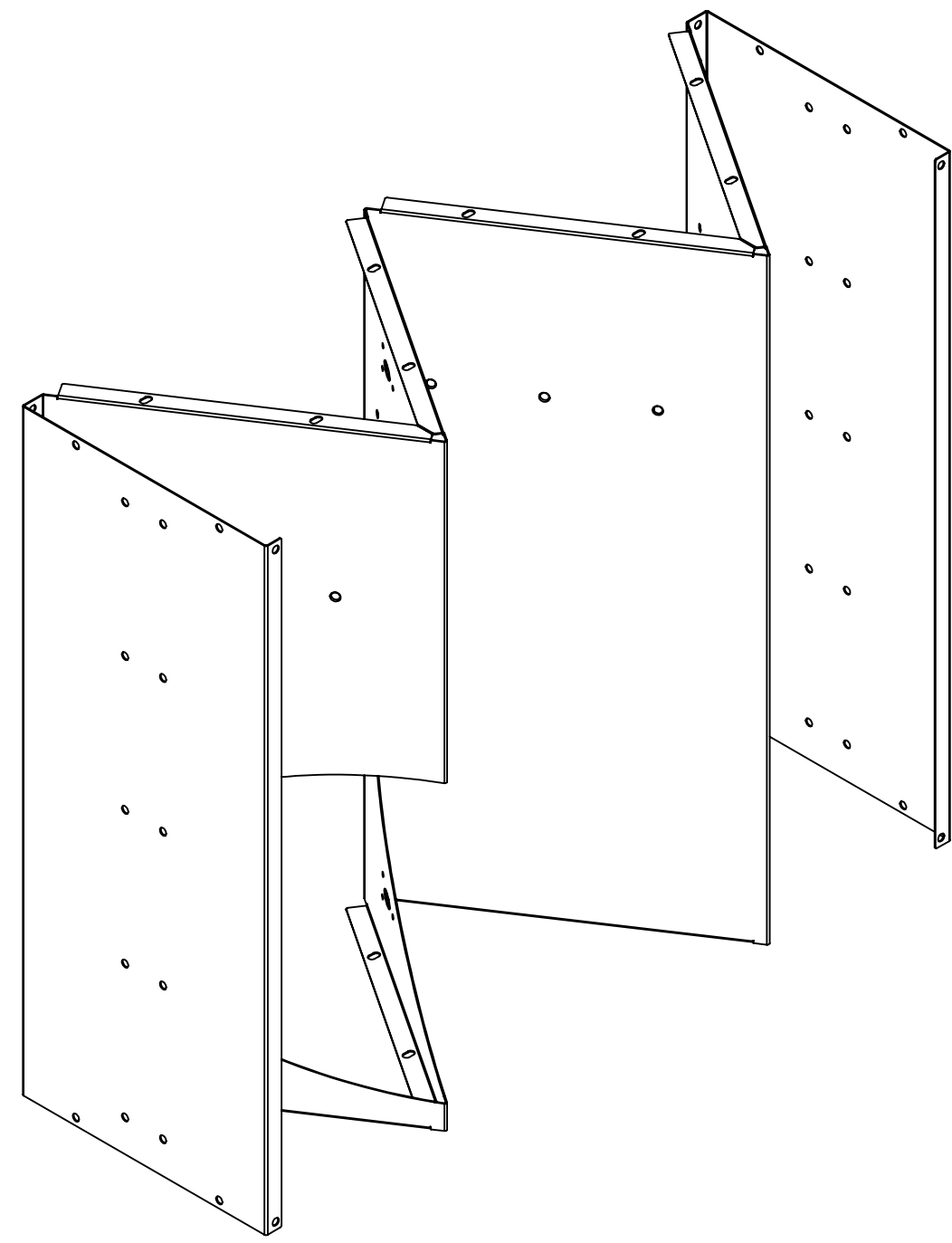
1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES .005-.015 ON ALL EDGES AND HOLES
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINE FLUIDS MUST BE FULLY SYNTHETIC, FULL WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE PER LIGO DOCUMENT E0900237.
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK (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
DO NOT APPLY MARK ON SUPER #8 SIDE
6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPEC E0900364.
7. ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NO WELD REPAIRS OR PLUGS) UNLESS APPROVED IN ADVANCE, IN WRITING, BY LIGO PER SPECIFICATION E0900364.
8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
9. SEE CAD FILE # D1200296.SLDPRT TO GENERATE ELLIPSE CURVES.
10. SEE FLAT-PATTERN CAD FILE FOR CHAMFER OF 13.62" DIAMETER HOLE.

REV.	DATE	DCN #	DRAWING TREE #
v1	17 FEB 2012	E1100335	-
v2	27 APR 2012	-	-
v3	25 JUN 2012	-	-
v4	5 OCT 2012	E1100335	-
v5	23 OCT 2012	-	-



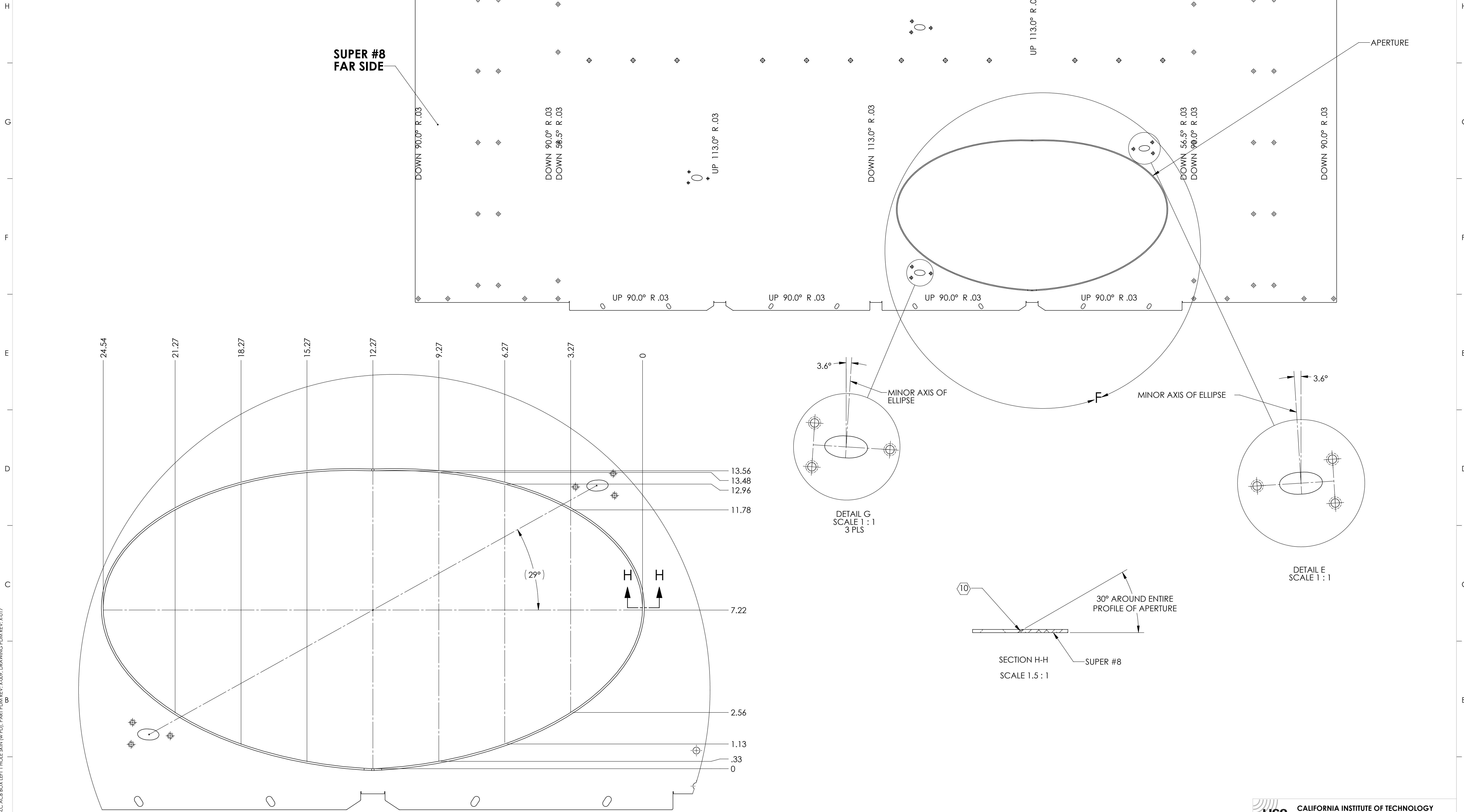
DIMENSIONS ARE IN		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± .02 .XXX ± .010		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES .005-.015. FOR MACHINED PARTS. ROUND 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.		SYSTEM ADVANCED LIGO		ACB 1 HOLE LEFT QPD SKIN (w pd)	
ANGULAR ± .5°		MATERIAL 18 GAUGE, 304 SSSL		SUB-SYSTEM AOS		DESIGNER N.Nguyen	
		FINISH SUPER #8		NEXT ASSY D1200314		CHECKER L.AUSTIN	
						APPROVAL M.SMITH	
						SIZE DWG. NO. D1200313	
						REVISION v5	
						SCALE: 1:4 PROJECTION: SHEET 1 OF 3	

D:\200313_Audi\GO_AOS_SIC_ACB_BOX_LEFT_HOLE_SKIN (w_PDI)_PART_PDM_REV_X-009_DRAWING_PDM_REV_X-017



D1200313_AduLIGO_ACS_SLC_ACB_BOX_LEFT_THOLE_SKIN (w/PD). PART FROM REV. X:009. DRAWING FROM REV. X:017

8 7 6 5 4 3 2 1



**SUPER #8
FAR SIDE**

APERTURE

**DETAIL F
SCALE 1 : 2**

**DETAIL G
SCALE 1 : 1
3 PLS**

**DETAIL E
SCALE 1 : 1**

**SECTION H-H
SCALE 1.5 : 1**

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE DWG. NO.	D1200313	v5
SCALE: 1:4	PROJECTION:	SHEET 3 OF 3

D:\200313_Adu\GO_ACS_SLC_ACB_BOX_LEFT_HOLE_SKIN_V.PDI PART FROM REV. X:079 DRAWING FROM REV. X:017