

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 = .1278 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.

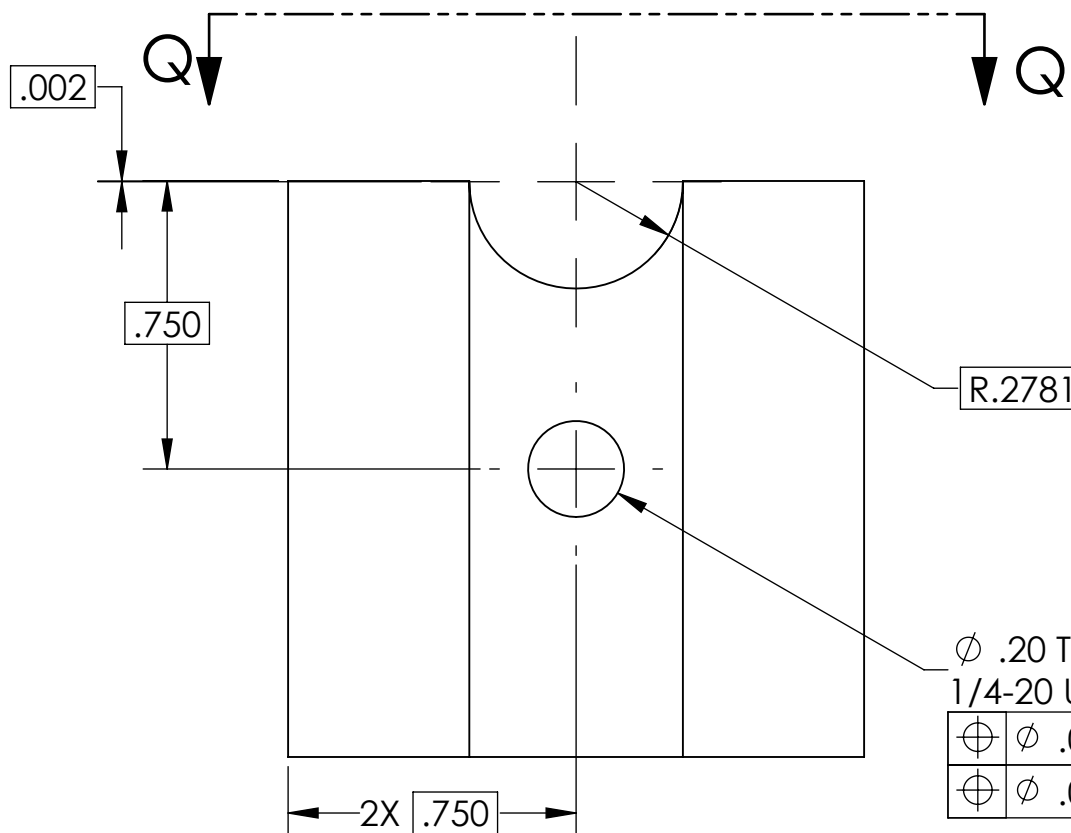
10. All X.XXX DIMENSIONS ARE BASIC.

TOLERANCE UNLESS OTHERWISE

SPECIFIED:

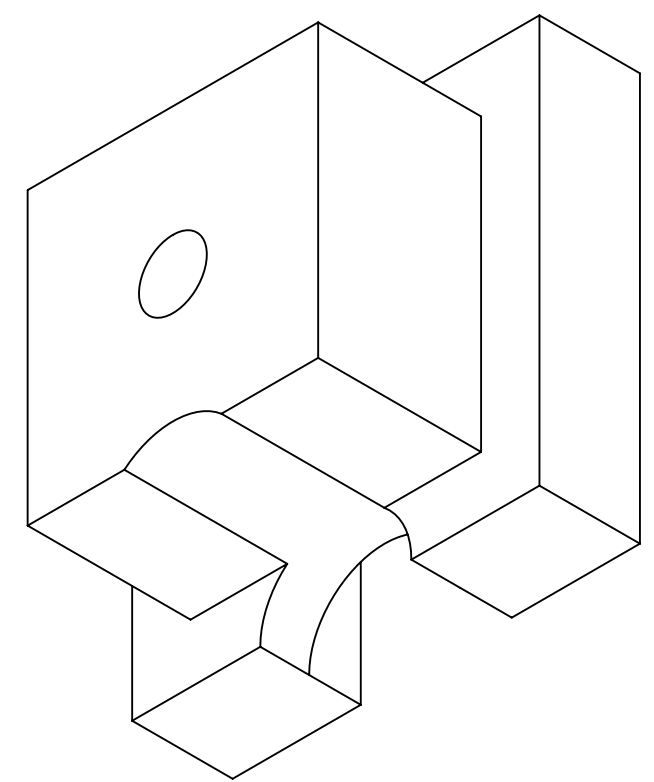
	.010	A	B	C
	.005	B	C	

REV.	DATE	DCN #	DRAWING TREE #
V1	Jun 6, 2012	E1200606	-
V2	Jun 11 2012	-	-
V3	Jul 20 2012	-	-



Ø .20 THRU ALL  
1/4-20 UNC - 1B THRU ALL

⊕	Ø .025	A	B	C
⊕	Ø .010	B	C	



D

D

C

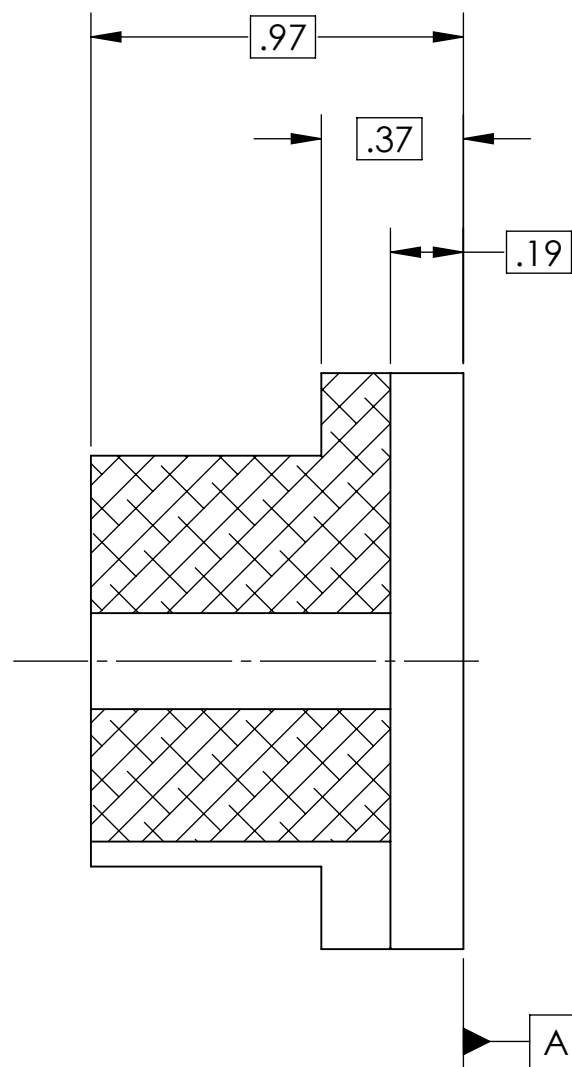
C

B

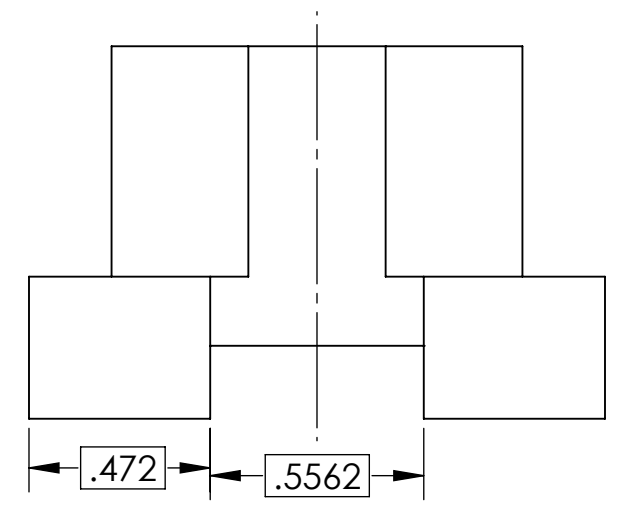
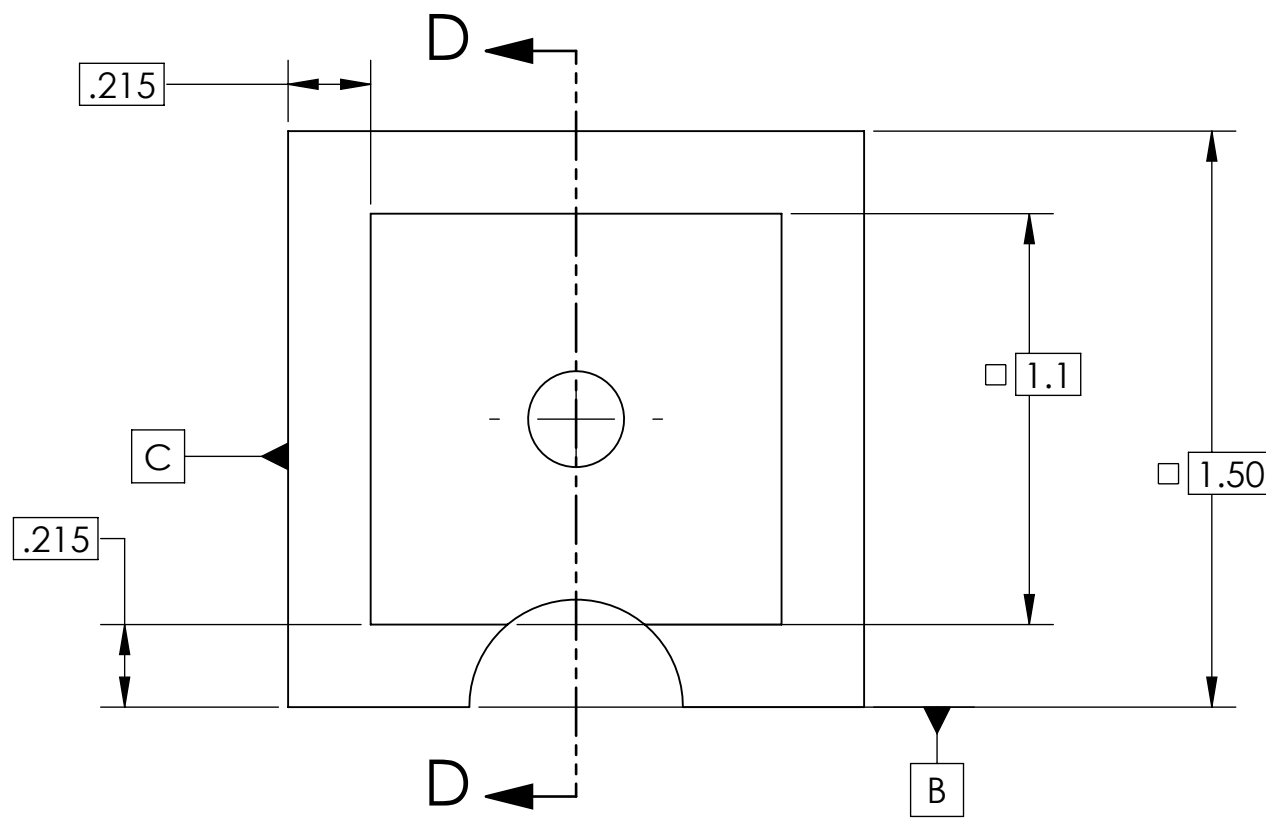
B

A

A



SECTION D-D



SECTION Q-Q

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .XXX ±	
ANGULAR ± 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	63 μinch

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **ISC**

NEXT ASSY: **D060409**

PART NAME <b>AL Mass Replacement for ECD Magnet Assembly</b>			
DESIGNER	SBARNUM	18 MAY 2012	SIZE DWG. NO.
DRAFTER	SBARNUM	18 MAY 2012	<b>B</b>
CHECKER			<b>D1200749</b>
APPROVAL	PFRITSCHL	21 MAY 2012	SCALE: 2:1
			PROJECTION:
			SHEET 1 OF 1

D1200749 AL Mass Replacement for ECD Magnet Assembly, PART PDM REV: X-000, DRAWING PDM REV: X-000