REV.	DATE	DCN #	DRAWING TREE #
v1	25 MAY 2012	E1100335-v5	-
-	-	E1100335	-
-	-		-

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: DXXXXXXX-VY, TYPE-XX, S/N XXX

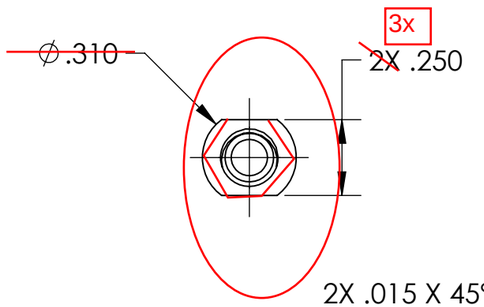
6. APPROXIMATE WEIGHT = .026 LB.

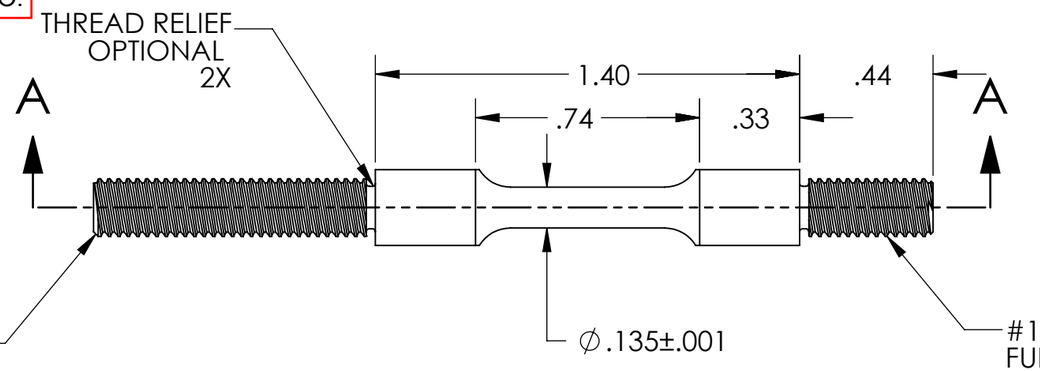
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

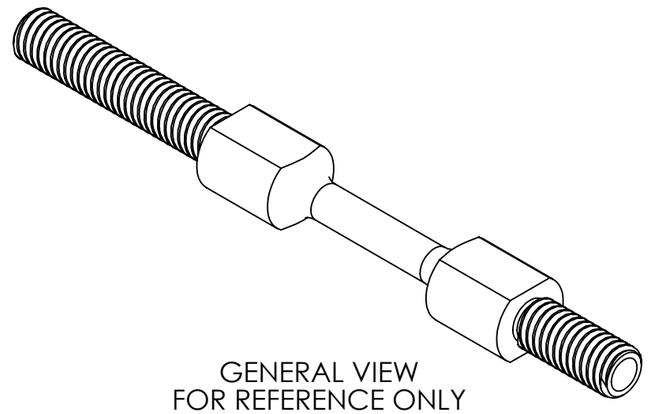
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

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.

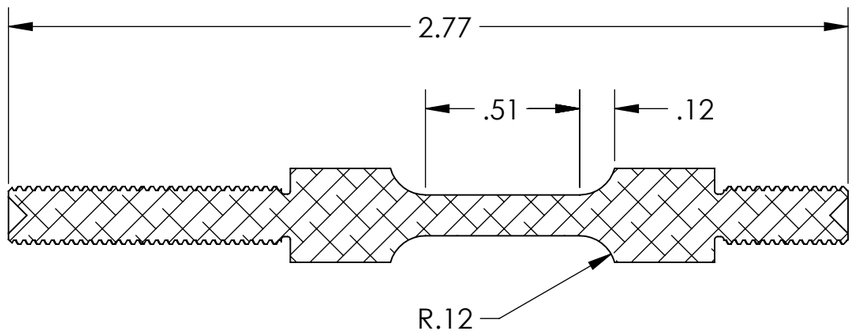
10. Age hardening bake to achieve a Rockwell C hardness of 48-52 after fabrication. Provide these measurements in certification documentation to LIGO.







GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE



SECTION A-A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)									
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1.0°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATLEY 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.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: ACB SUSPENDED ROD				
	MATERIAL: ~~316 SSTL~~ Maraging Steel C250 or C300	FINISH: 63 µinch	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	DESIGNER: TQ. NGUYEN 25 MAY 2012	SIZE: B	DWG. NO.: D1200781	REV.: v1 V2
			NEXT ASSY: D1001005		DRAFTER: TQ. NGUYEN 25 MAY 2012			
					CHECKER: L. AUSTIN			
					APPROVAL: M. SMITH	SCALE: 2:1	PROJECTION:	SHEET 1 OF 1

D1200781_aLIGO_AOS_ACB Suspended Rod, PART PDM REV: X-001, DRAWING PDM REV: X-000