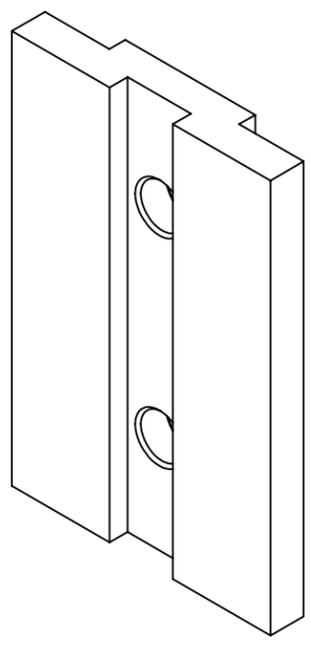
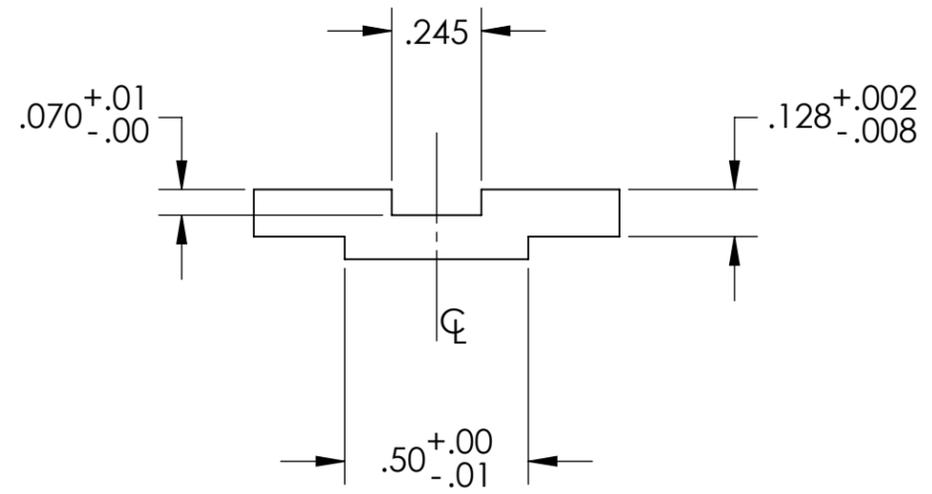


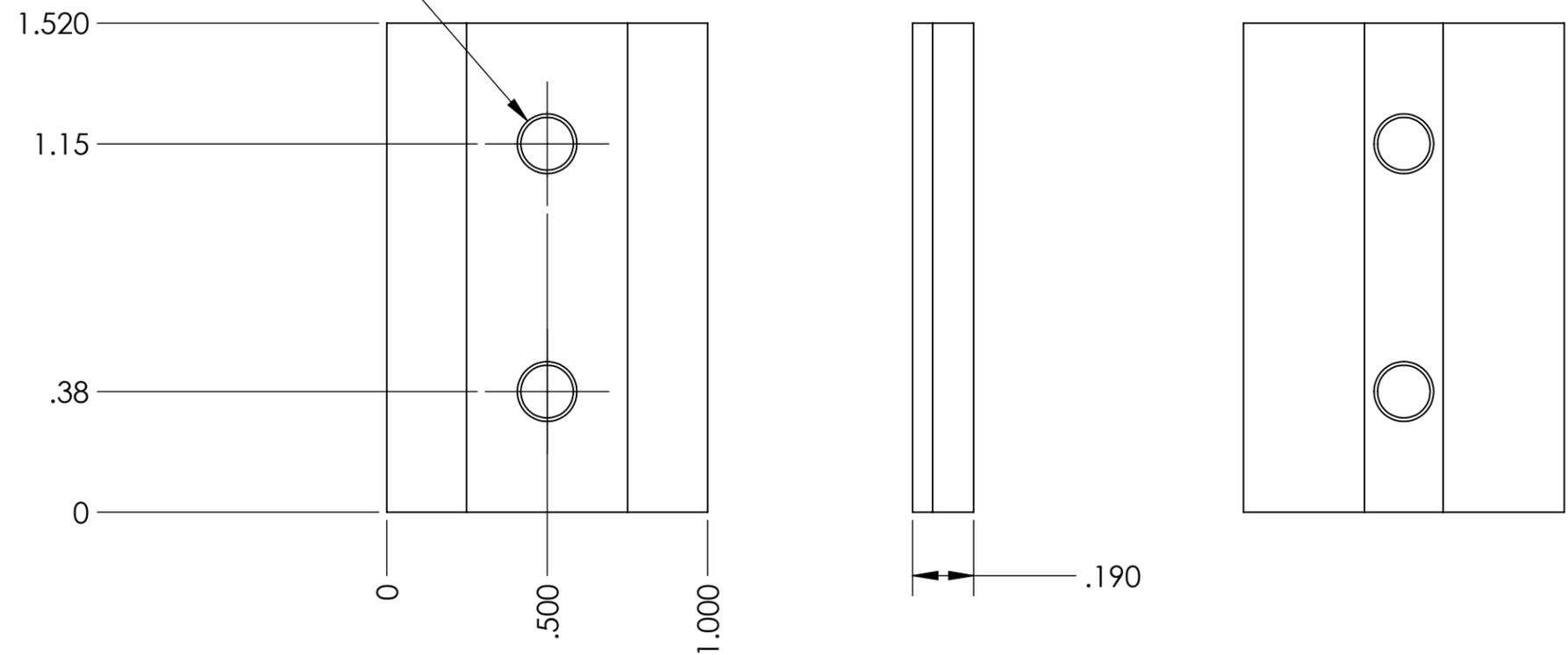
NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT 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

REV.	DATE	DCN #	DRAWING TREE #
V1	MAY 2013	-	-
-	-	-	-
-	-	-	-

6. APPROXIMATE WEIGHT = 2gram.
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. **MATERIAL: PEEK, VICTREX 450CA (KETRON® PEEK-CA30 LSG). AVAILABLE FROM BOEDEKER PLASTICS. MATERIAL CERTIFICATION DOCUMENTATION IS REQUIRED. www.boedeker.com/peek_p.htm**
10. 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.



2X ϕ .136 THRU ALL
 8-32 UNC - 1B THRU ALL
 ✓ ϕ .186 X 90°, NEAR SIDE
 ✓ ϕ .186 X 90°, FAR SIDE



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME			
DIMENSIONS ARE IN INCHES		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED 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		SUB-SYSTEM ISC		aLIGO Linear Motor Coil Guide	
TOLERANCES: .XX ± .01 .XXX ± .005		MATERIAL PEEK		FINISH 63 μinch		NEXT ASSY D1003318		DESIGNER SBARNUM	
ANGULAR ± 0.5°						AUG 2012		SIZE DWG. NO. B D1200990	
						16 MAY 2013		REV. v1	
						PFRITSCHEL		SCALE: 2:1 PROJECTION: SHEET 1 OF 1	

D1200990 aLIGO Linear Motor Coil Guide, PART PDM REV: X-000, DRAWING PDM REV: