

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 = 1.587 LB.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

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

9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.

11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.

12. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	6 SEP 2012	E1100335-v5	-
v2	12 SEP 2012	E1100335	-
-	-	-	-

D

C

B

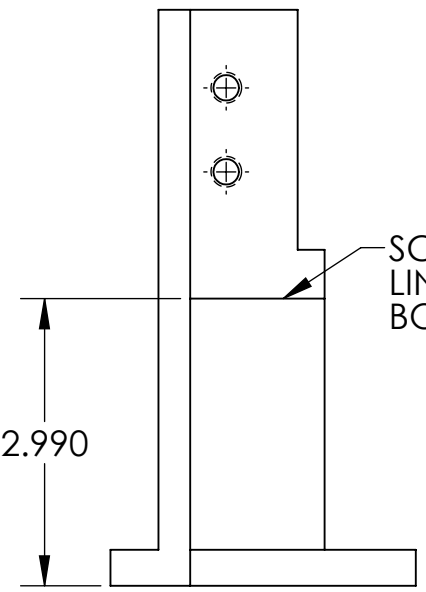
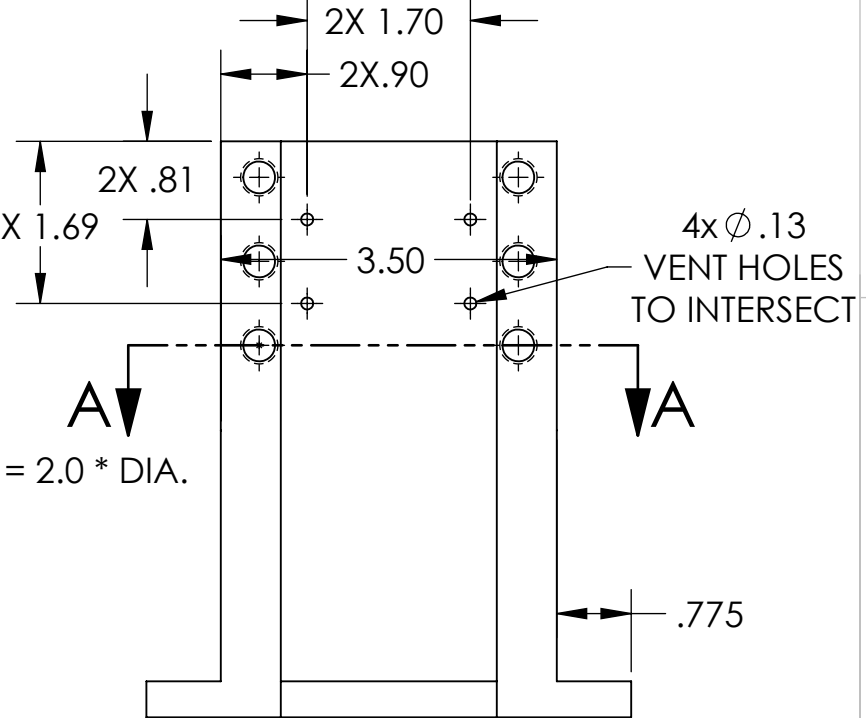
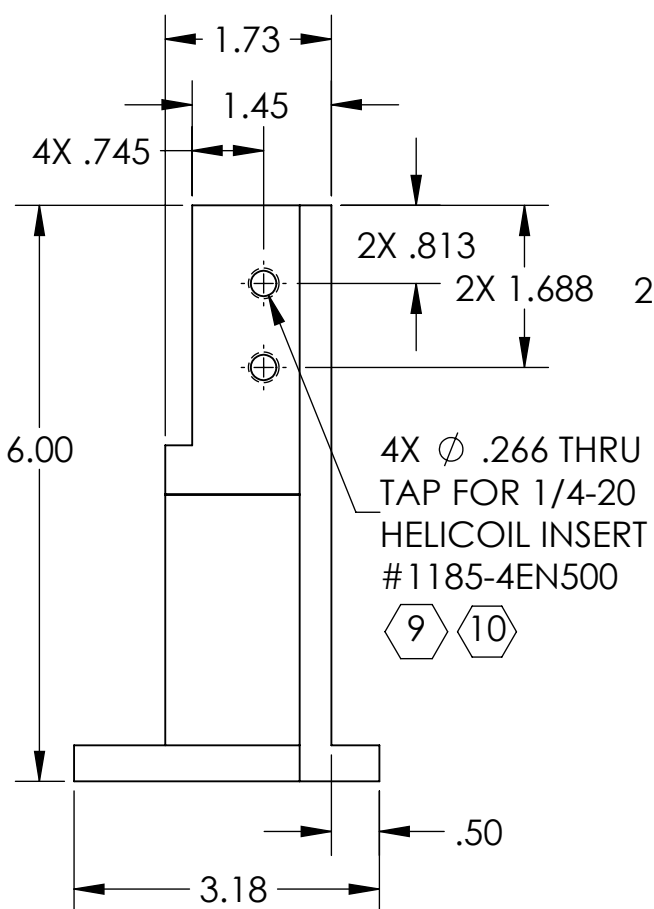
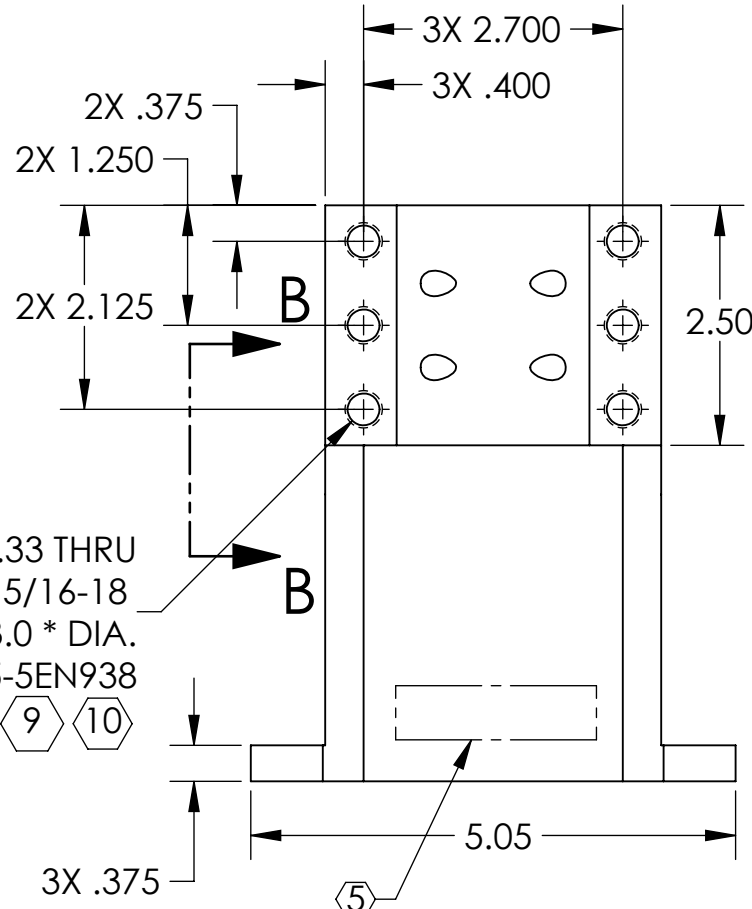
A

D

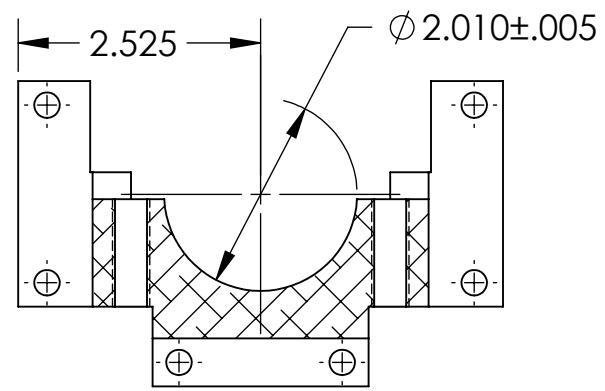
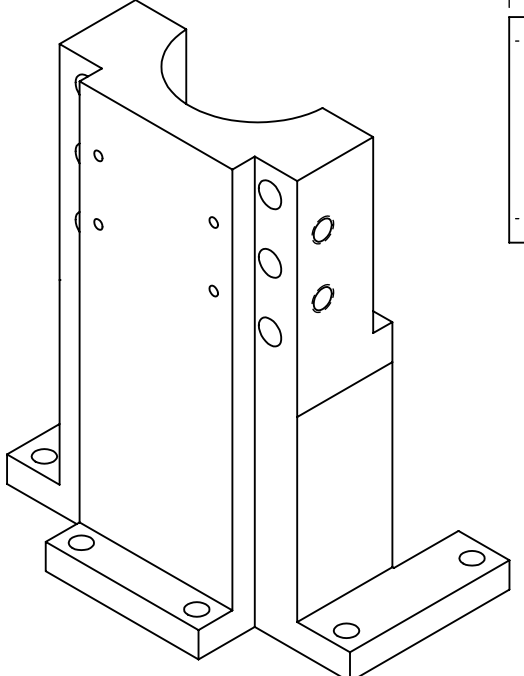
C

B

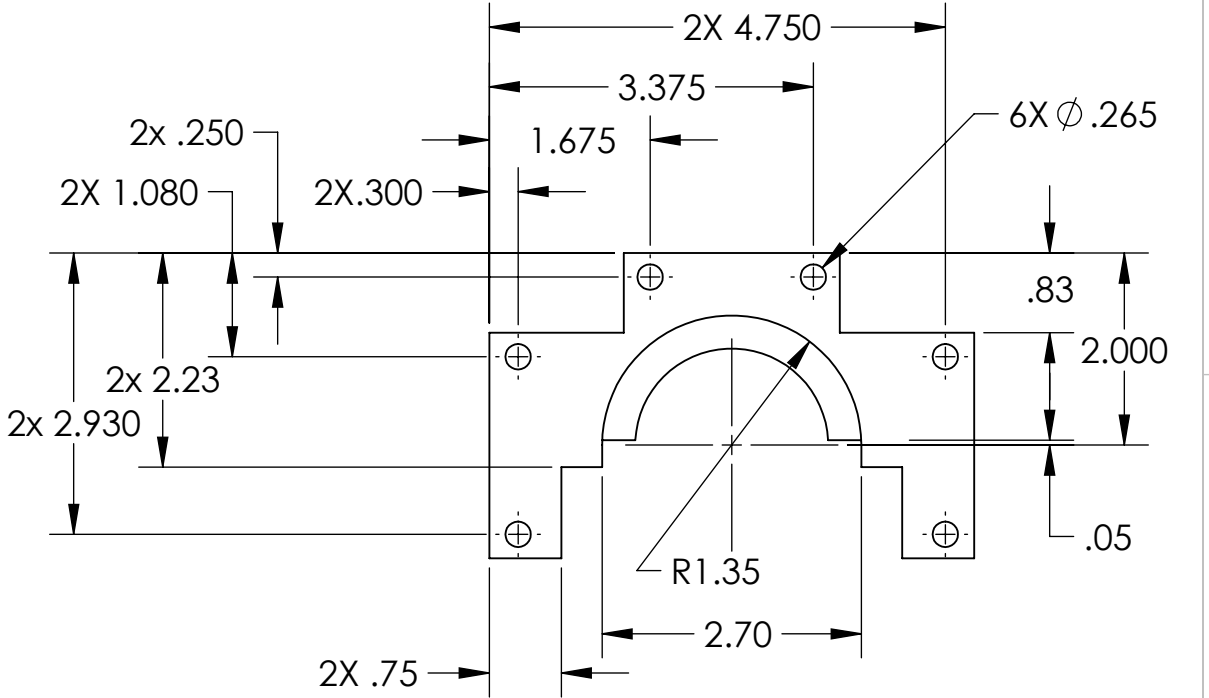
A



VIEW B-B SCALE 1 : 2



SECTION A-A SCALE 1 : 2



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN		1. INTERPRET DRAWING PER ASME Y14.5-1994.	
TOLERANCES:		2. BREAK EDGES, .005-.015	
.XX ± .01		3. DO NOT SCALE FROM DRAWING.	
.XXX ± .005		4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
ANGULAR ± 1°		MATERIAL	6061-T6
		FINISH	63 µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM AOS SUB-SYSTEM SLC

NEXT ASSY D1201228

PART NAME				ANTI-ROTATION BLOCK, ACB			
DESIGNER	J. LEWIS	24 AUG 12	SIZE	DWG. NO.	B	REV.	v2
DRAFTER	J. LEWIS	24 AUG 12		D1201198			
CHECKER			SCALE:	1:1	PROJECTION:		SHEET 1 OF 1
APPROVAL							

D1201198, PART PDM REV: X-010, DRAWING PDM REV: X-012