LIGO Document C	hange Notice (DCN) 7	LIGO – E13 Fitle: UPPE		CTU	RE CLEAR		sheet 1 of 2 OLES
	Change Notice (DCN) Title: UPPER STRUCTURE CLEARANCE Title DCN to change D070538 & D070539						New Rev
D070538-B	Implementation Ring	Test Chain					-v3
D070539-B	Implementation Ring						-v3
The two listed bra	RIPTION (FROM/TO) – ckets have had holes drilled ved from –B to –v3.					ttached) for	details. Both
diameter was taken	CHANGE: These holes were out. See attached drawings.			-			
ACTION: [Incorporate Change	Attach DCN to I	Drawings	\square	Other Action (sp	ecify):Redline	e (attached)
DISPOSITION OF HARDWARE (IDENTIFY SERIAL NUMBERS)			DCN DISTRIBUTION Required: excomm (Lab Grp Leads, LSC Spokesperson) Michael Landry (LHO AdL Liaison)				
(Continue on sheet 2	if needed)		Brian O'Reilly	y (LLC	AdL Liaison)		
List S/Ns to be	e reworked/scrapped: All		7		L Area/Subsys Leac sts): [<i>please delete if/</i> Betsy Bland	-	
List S/N's to b	e built with this change:				Norna Robertson	Janeen Romie	2
List S/Ns to be	e retested per this change:						
Other disposition/instructions or additional comments:			Additional Distribution List for this DCN:				
SAFETY, COST, SCH (If YES, enter CR (CC	EDULE, REQUIREMENTS IMP B) or TCP (TRB) #)	PACT? N	0 Y E	S			
AP	PROVALS:	DATE	OTHER APPROVALS (SPECIFY) DATE			DATE	
ORIGINATOR: BI	ETSY BLAND						
TASK LEADER: J	ANEEN ROMIE						
GROUP LEADER:							
DCC RELEASE:							

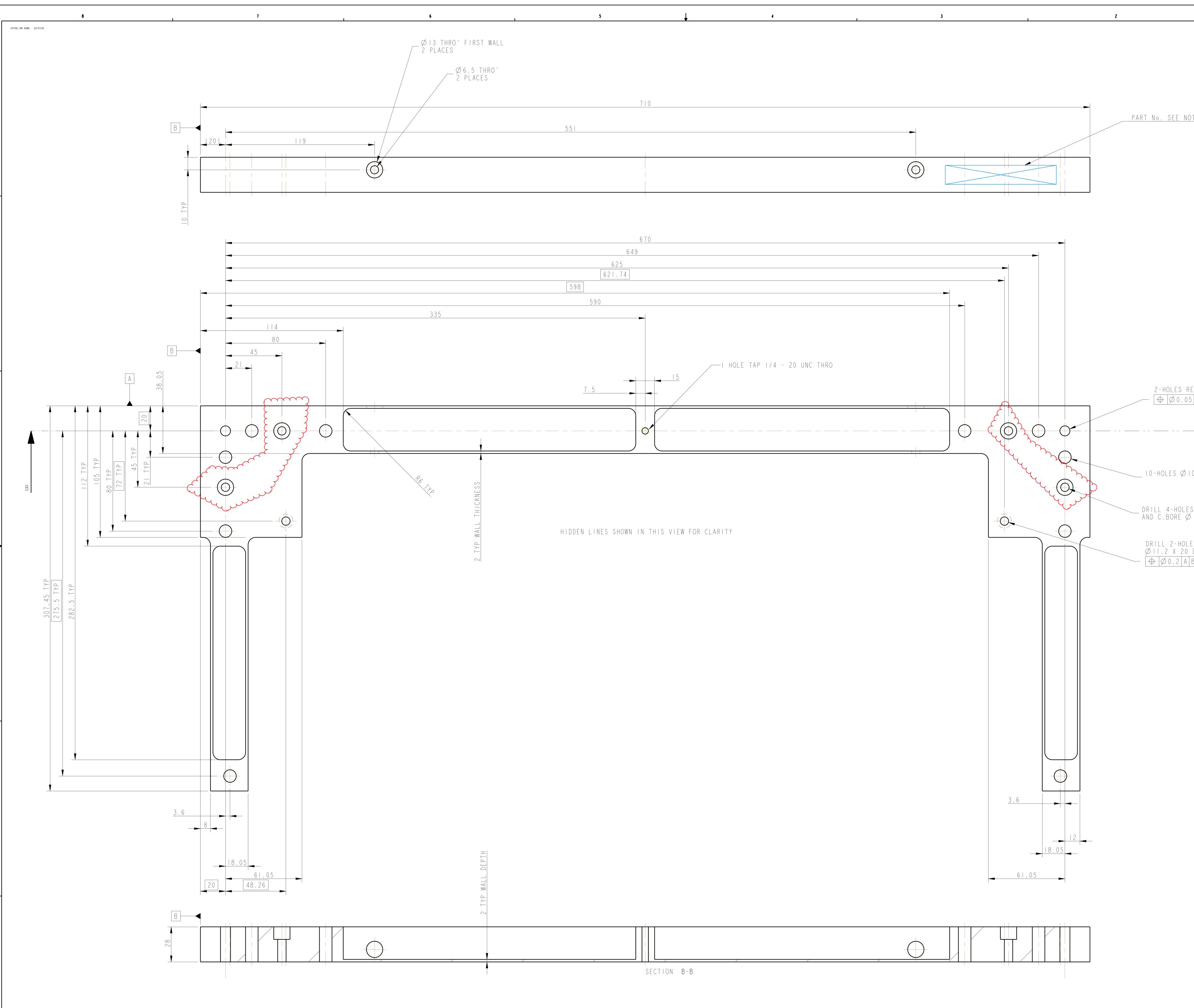


CHANGE DESCRIPTION (FROM/TO) -- continued:

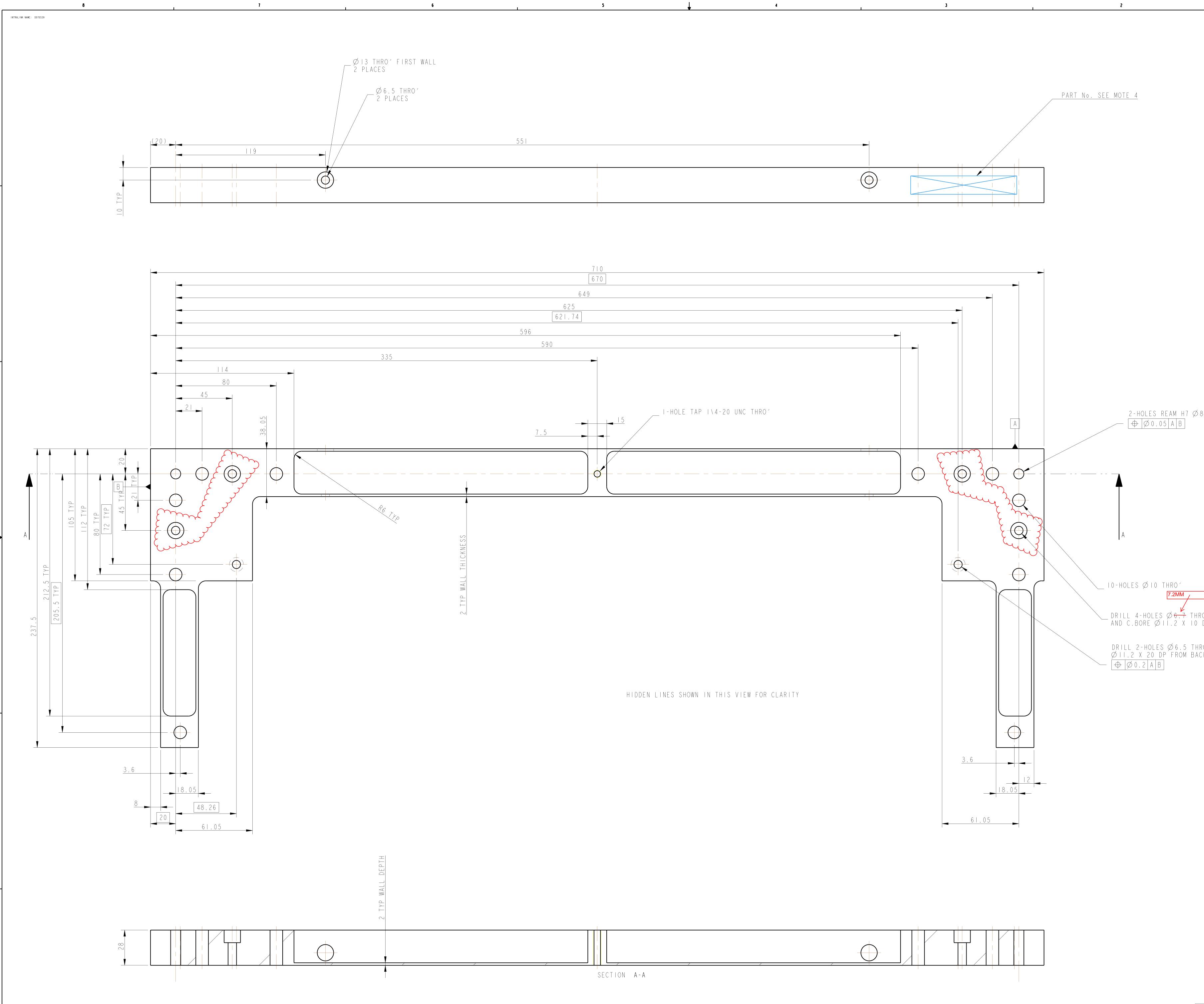
List S/Ns which comply already:

D070538-A-00-0105 LLO D070538-A-00-0007 LLO

D070539-A-00-0105 LLO D070539-A-00-0007 LLO



	REV. DATE		DCN #		DRAWING TREE #		
	V3 19 MAR	2013 E	1300198				
NOTE 4							F
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							E
REAM Ø8	+0.015 /11-7	י) דנוס	\cap '				_
.05 A B	0 (П/)	U				
							D
∕IO THRO	/						
7.2mm		В					
LES Ø 6.7 Ø11.2 X	IO DP						
OLES Ø6. 20 DP FRO	5 THRO′ M BACK	AND C	. Bore				╉
AB							
							C
							_
							8
							_
							A
				V	3		
I. REMOVE ALL SH. R.O2 MIN. 2. DO NOT SCALE 3. ALL MACHINING WATER SOLUBLE	FROM DRAWING. FLUIDS SHALL BE AND FREE OF		RE IN mm [INCHES	SYSTEM a	ALIFORNIA INSTITUTE OF ACHUSETTS INSTITUTE OF GLASGOW UNIVERSITY GEV RUTHERFORD APPLETON L. LIGO	TECHNOLOGY TECHNOLOGY O 600 GROUP ABORATORIES	
SULFUR, CHLOR SUCH AS CINCI CIMTECH AS CINCI C.SCRIBE, ENGRA PARTNUMBER ON PART AND A TH NUMBER. SERIA A 001 FOR TH	INE AND SILICONE, VNATI MILACRON'S STAINLESS STEEL) VE OR STAMP DRAWING NOTED SURFACE OF REE DIGIT SERIAL NUMBERS START F FIRST PART AND	MATERIAL: 60 FINISH: CL m [µin]	AL ALLOY 61-T6 OR 5083-T6 EAN AND DEGREASE Ro = 1.6 NAME DATE	PART NAME IN		VG	
PROCEED CONSE USE .07" HIGH EXAMPLE: D020 TOOL MAY BE U	CUTIVELY. CHARACTERS. 188- 001. A VIBRATORY	DRAWN I CHECKED MB APPROVED JO		$\mathbf{E}^{(s)}$ E DRG. NO.		HEET I OF I	_



	REV. DATE	DCN #	DRAWING TREE #	
	/3 19 MAR 2013	E1300198		
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 NOTES: (UNLESS OTHERWISE SPECIFIED)

 1. REMOVE ALL SHARP EDGES, R.02 MIN.

 2. DO NOT SCALE FROM DRAWING.

 3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)

 4. SCRIBE, ENGRAVE OR STAMP DRAWING PARTANDA THREE DIGIT SERIAL NUMBER, SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE. 07" HIGH CHARACTERS. EXAMPLE: D020188- 001. A VIBRATORY TOOL MAY BE USED.

 DIMENSIONS ARE IN mm [INCHES] ANGULAR ±

 DIMENSIONS ARE IN mm [INCHES] ANGULAR ±

 MATERIAL:
 AL ALLOY 6061-T6 OR 5083-T6 FINISH: CLEAN AND DEGREEASE m [Lin] Ro = 1.6 NUMBER, SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE. 07" HIGH CHARACTERS. EXAMPLE: D020188- 001. A VIBRATORY TOOL MAY BE USED.

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