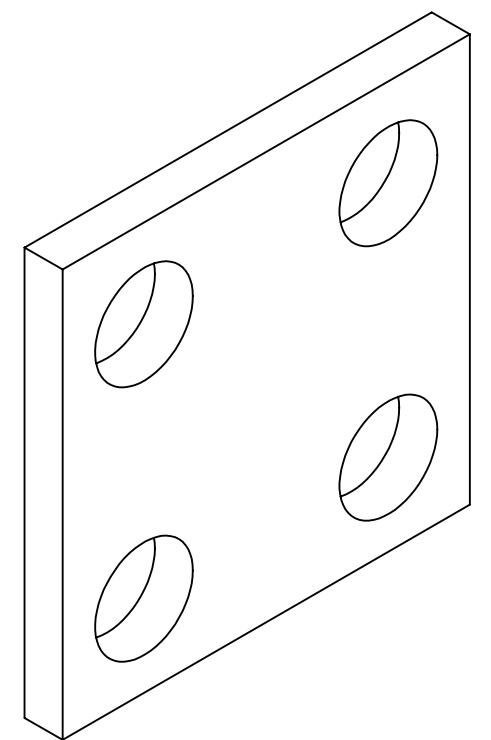
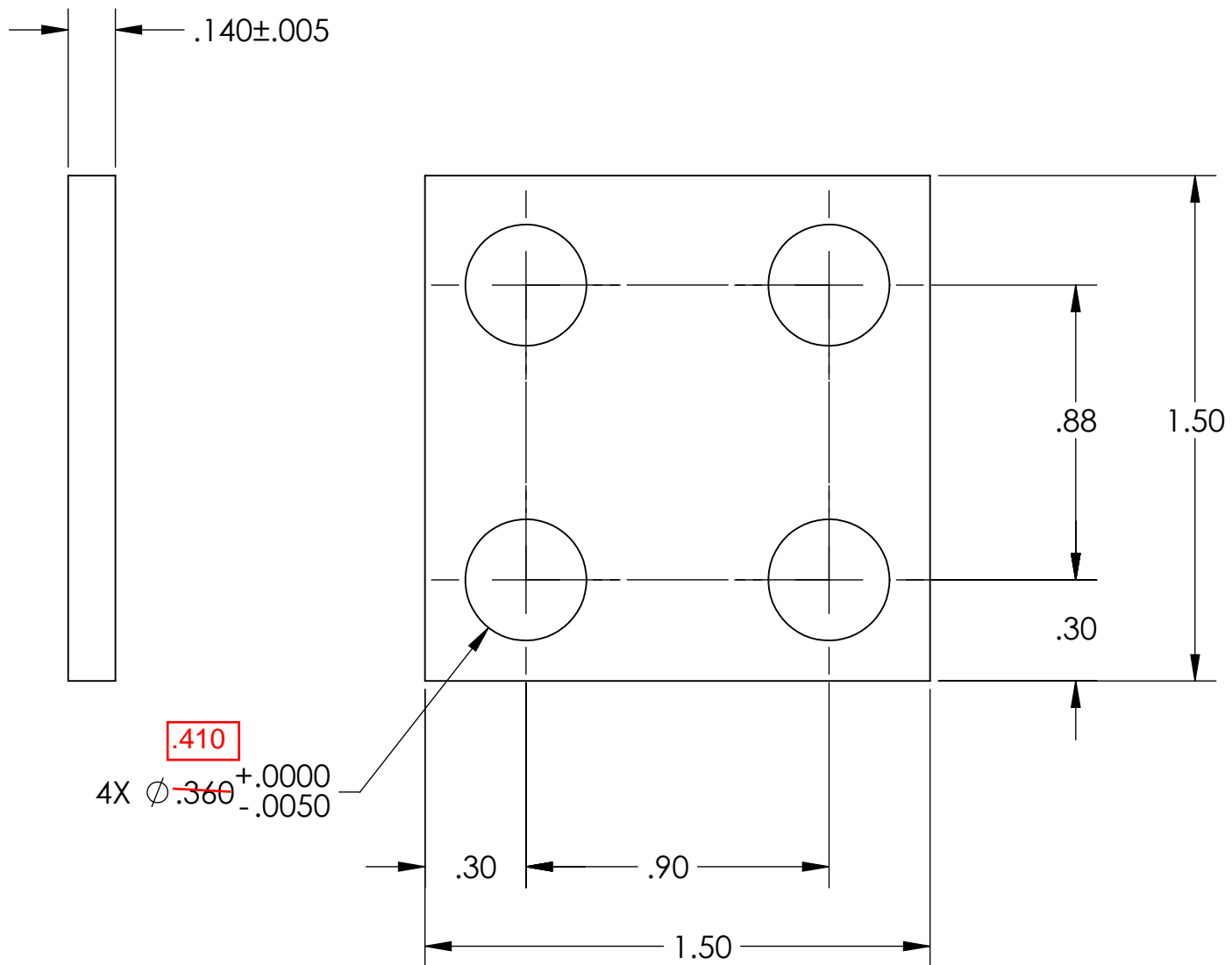


NOTES CONTINUED:

- 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
- 6. APPROXIMATE WEIGHT = X.XXX 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 HELL COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELL COIL PRODUCT CATALOG, HC2000, REV 4~~
- 10. ~~ALL HELL 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. 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.
- 12. ~~SURFACE FINISH TO BE AS PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR COUGES.~~
- 13. ~~PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E1000083. AFTER FABRICATION, THE INDICATED HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING TO APPROXIMATELY 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF THE HOLE.~~
- 14. ~~DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.~~
- 15. ~~BEND RADIUS. UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.~~

REV.	DATE	DCN #	DRAWING TREE #



MCB flexure rod shim, PART PDM REV: , DRAWING PDM REV:

DIMENSIONS ARE IN		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES:	.XX ±	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.	SYSTEM	SUB-SYSTEM	DESIGNER	MCB FLEXURE ROD SHIM
	.XXX ±	3. DO NOT SCALE FROM DRAWING.	4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	FINISH	μinch	CHECKER	SIZE DWG. NO.
ANGULAR ± °		MATERIAL	6061-T6 AL	NEXT ASSY		APPROVAL	B D1300646
							SCALE: 2:1 PROJECTION: SHEET 1 OF 1