

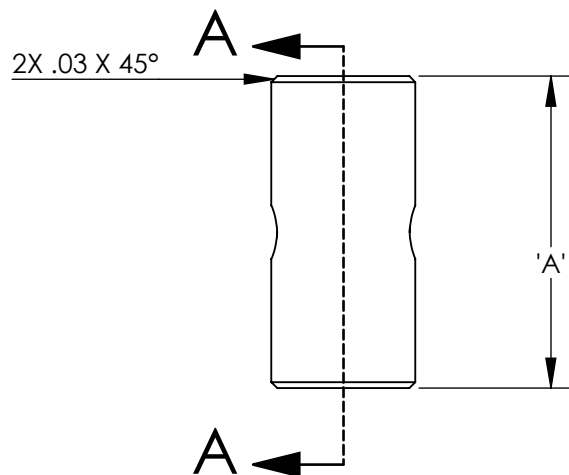
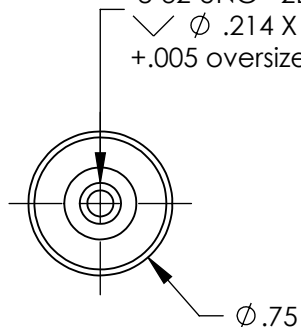
## NOTES CONTINUED:

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

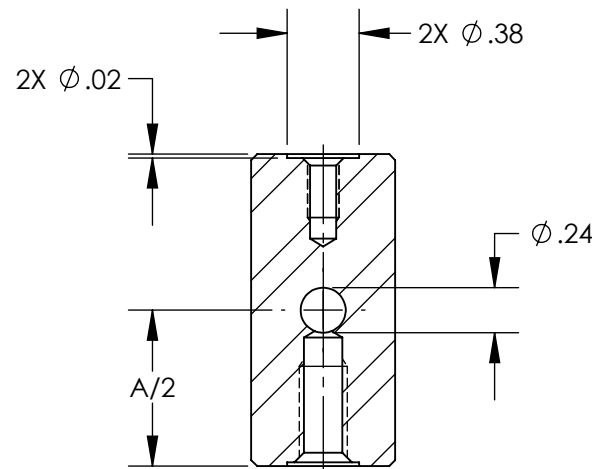
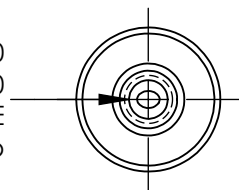
6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

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

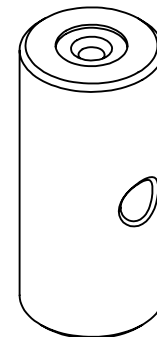
$\phi .136 \nabla .420$   
8-32 UNC - 2B  $\nabla .330$   
 $\surd \phi .214 \times 90^\circ$ , NEAR SIDE  
+.005 oversize drill & tap



$\phi .201 \nabla .650$   
1/4-20 UNC - 2B  $\nabla .500$   
 $\surd \phi .300 \times 90^\circ$ , NEAR SIDE  
+.005 oversize drill & tap



SECTION A-A



ISO VIEW

TABLE 1

| IDENTIFYING NUMBER | 'A' (INCHES) |
|--------------------|--------------|
| D1400377-1         | 1.625        |
| D1400377-2         | 2.625        |

## NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:  
.XX  $\pm .01$   
.XXX  $\pm .005$

ANGULAR  $\pm 1.0^\circ$

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.

MATERIAL

304 SSTL

FINISH

63  $\mu$ inch



CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM

-

SUB-SYSTEM

-

NEXT ASSY

D1400322

PART NAME

M2ISS, Intensity Stabilization System, .75 DIA. PEDESTAL

DESIGNER

E.SANCHEZ 07 NOV 2014

DRAFTER

E.SANCHEZ 07 NOV 2014

CHECKER

SEE DCC SEE DCC

APPROVAL

SEE DCC SEE DCC

SIZE

A

DWG. NO.

D1400377

REV.

v3

SCALE: 1:1

PROJECTION:



SHEET 1 OF 1