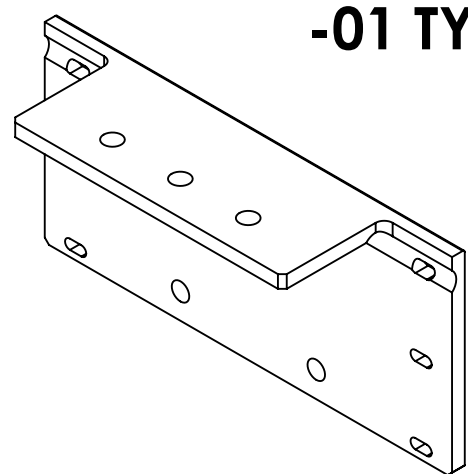


NOTES CONTINUED:

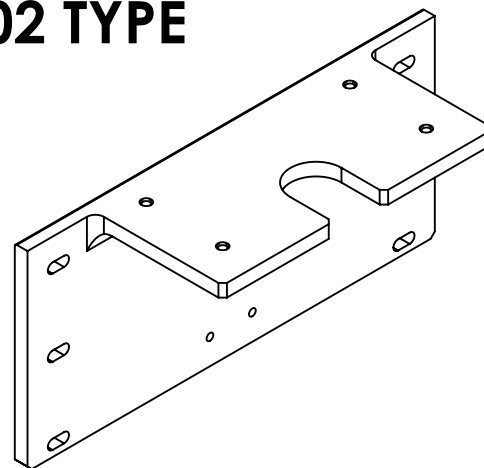
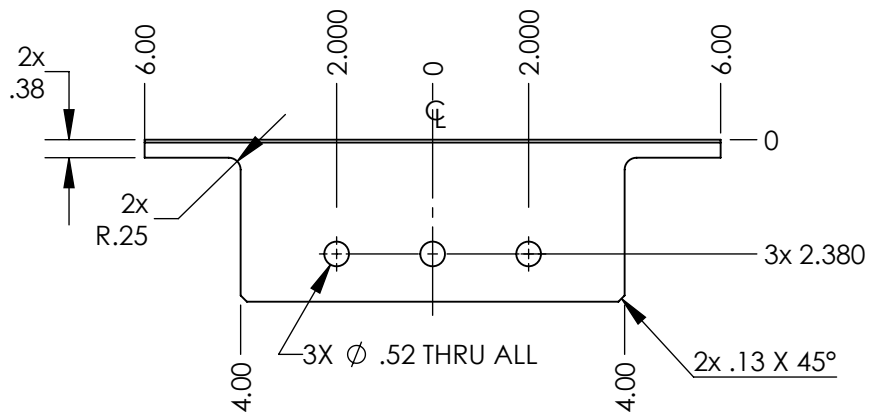
⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE 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. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364
- 7. 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 SPECIFICATION E0900364
- 8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- ⑦ ELECTROPOLISH ALL SURFACES TO REMOVE .0005-.001 PER SURFACE.
- ⑩ MATERIAL: MAKE FROM 6" X 6" X.375" WALL SSTL ANGLE.

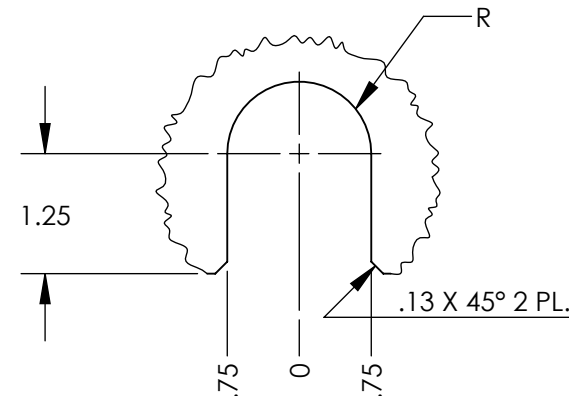
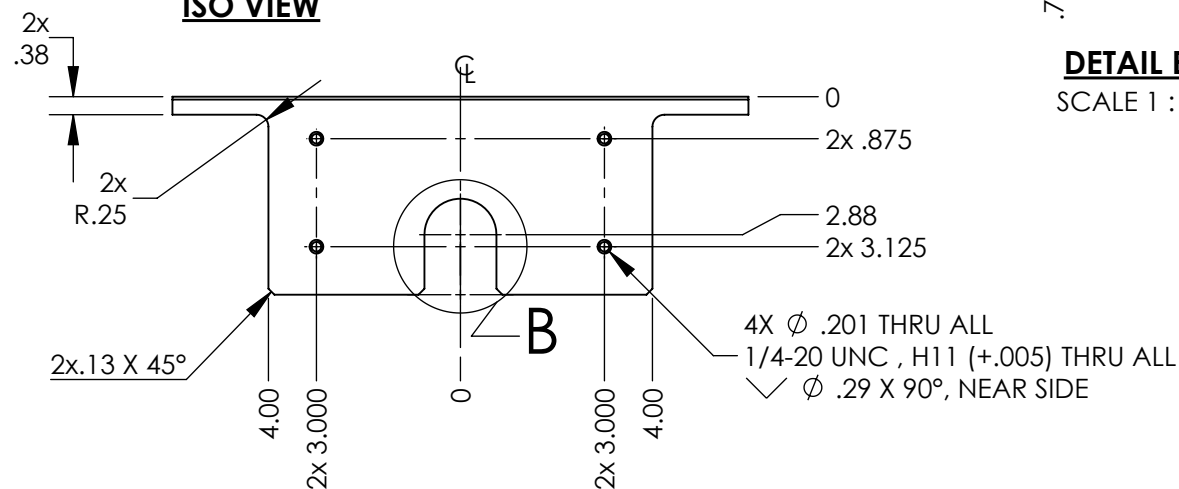


-01 TYPE -02 TYPE

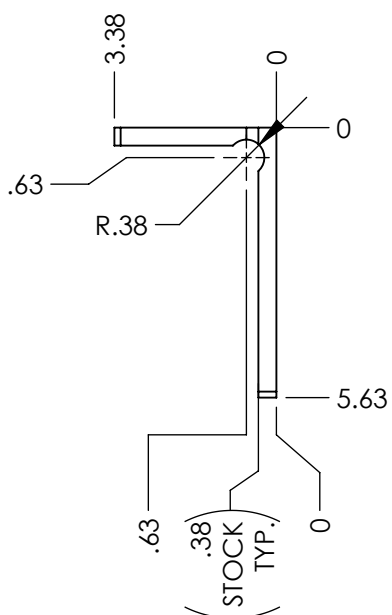
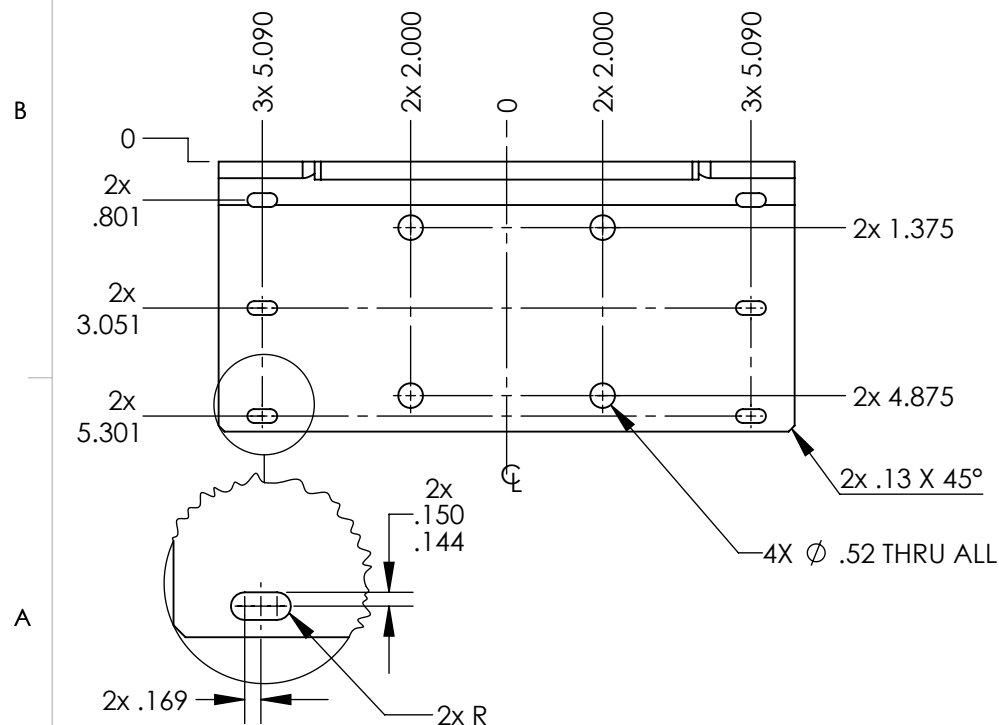
ISO VIEW



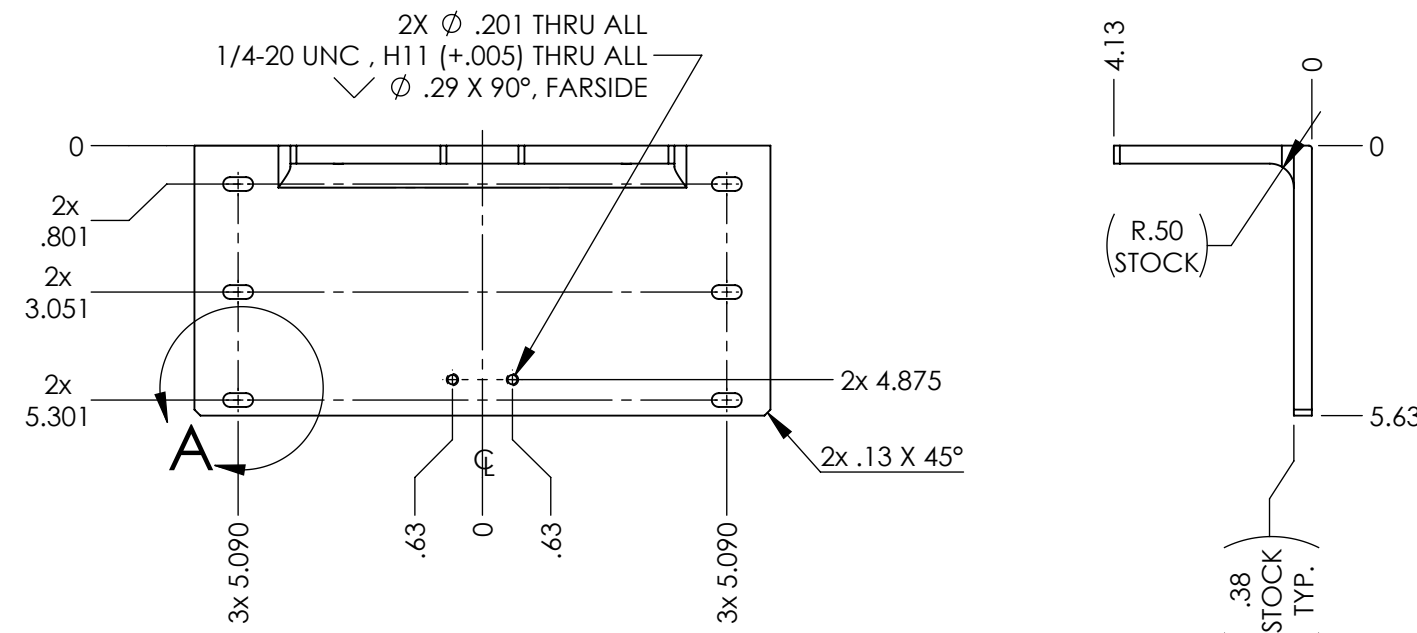
ISO VIEW



DETAIL B
SCALE 1 : 2



DETAIL A
SCALE 1 : 2
6 PL THRU



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 0.5°

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.
 3. DO NOT SCALE FROM DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME LIGO, NCAL, MT. PLATFORM ASSY., PIER BASE	
SYSTEM	SYS	SUB-SYSTEM	DESIGNER E.SANCHEZ 07 FEB 2019
NEXT ASSY	D1900145	DRFTER	E.SANCHEZ 26 JUN 2019
		CHECKER	SEE DCC
		APPROVAL	SEE DCC
MATERIAL	304 SSTL ⑩	FINISH	μinch ⑦
		SIZE DWG. NO.	B D1900243
		SCALE: 1:4	PROJECTION:
		SHEET 1 OF 1	