NOTES CONTINUED:

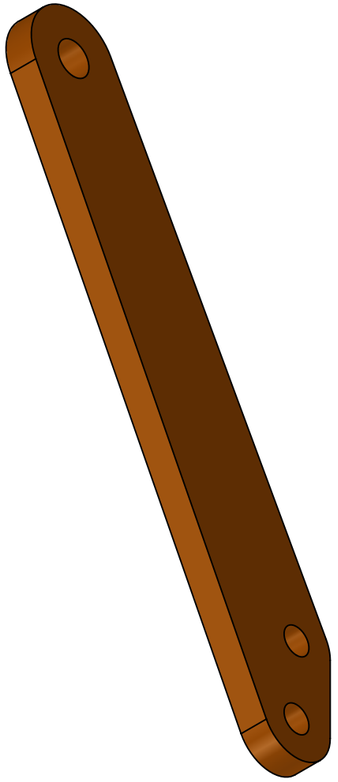
5. BAG AND TAG WITH DRAWING NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) FOLLOWED WITH A UNIQUE THREE DIGIT SERIAL NUMBER FOR EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

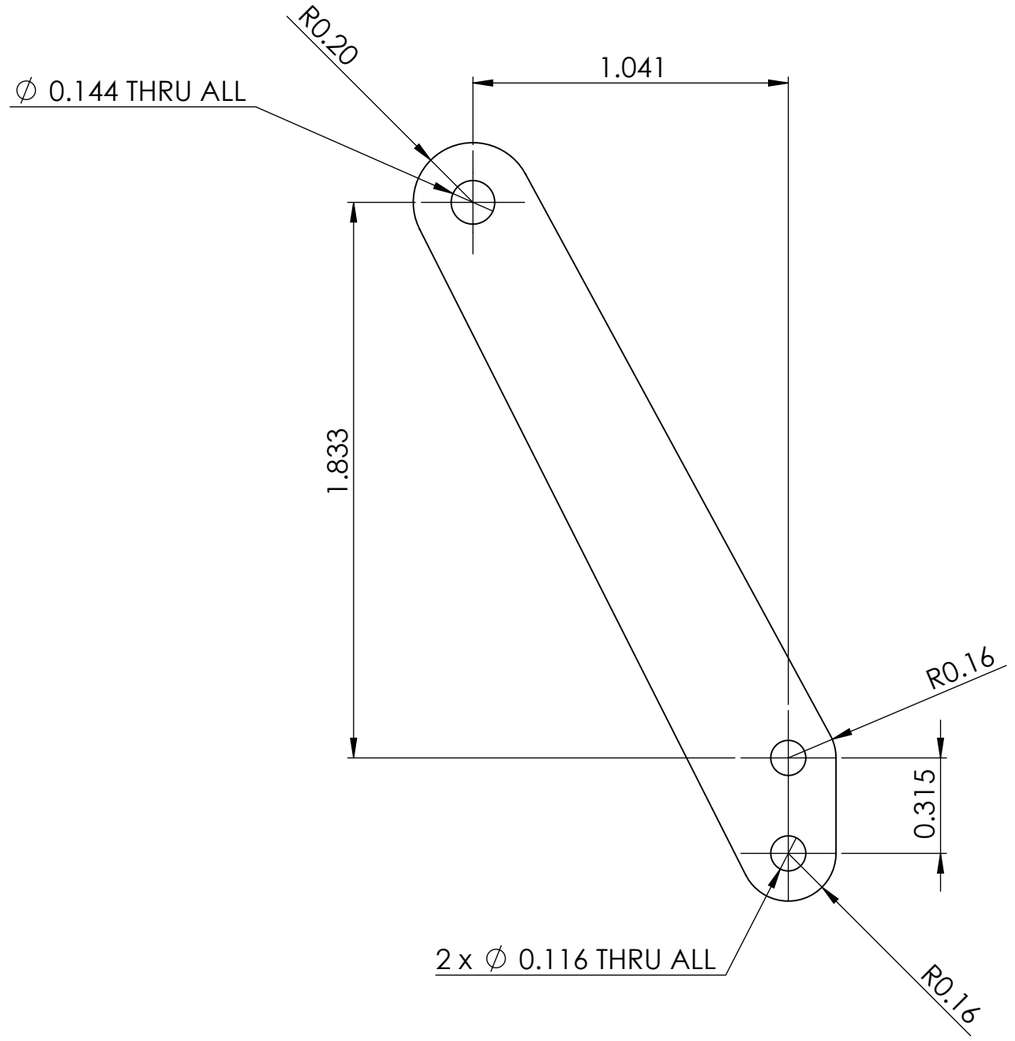
6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO SPECIFICATION E0900364

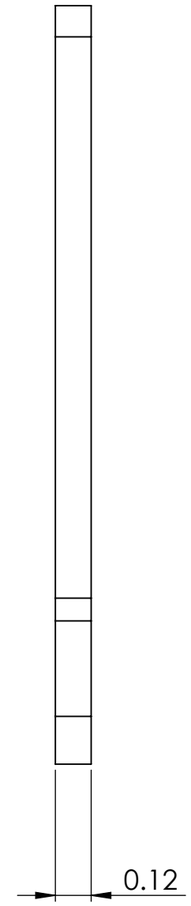
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364

8. 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

REV.	DATE	DCN #	DRAWING TREE #
v3	2 AUG 2021	E2100338	







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.
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	FINISH
MACOR	63 µinch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM	SUB-SYSTEM
A+	SUS

NEXT ASSY: D2000275

PART NAME: A+, SUS, HDS Thermal SAMS Strut

DESIGNER	NG; CAO	
DRAFTER	S. KARAT	07 OCT 2020
CHECKER	E. SANCHEZ	
APPROVAL		

SIZE: B — DWG. NO.: D2000269 — REV.: v3

SCALE: 2:1 — PROJECTION: — SHEET 1 OF 1

PART PDM VERSION: y-009
DWG PDM VERSION: y-010
D2000269 A+, SUS, HDS Thermal SAMS Strut