

① 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: DXXXXXXX-VY, TYPE-XX, S/N XXX

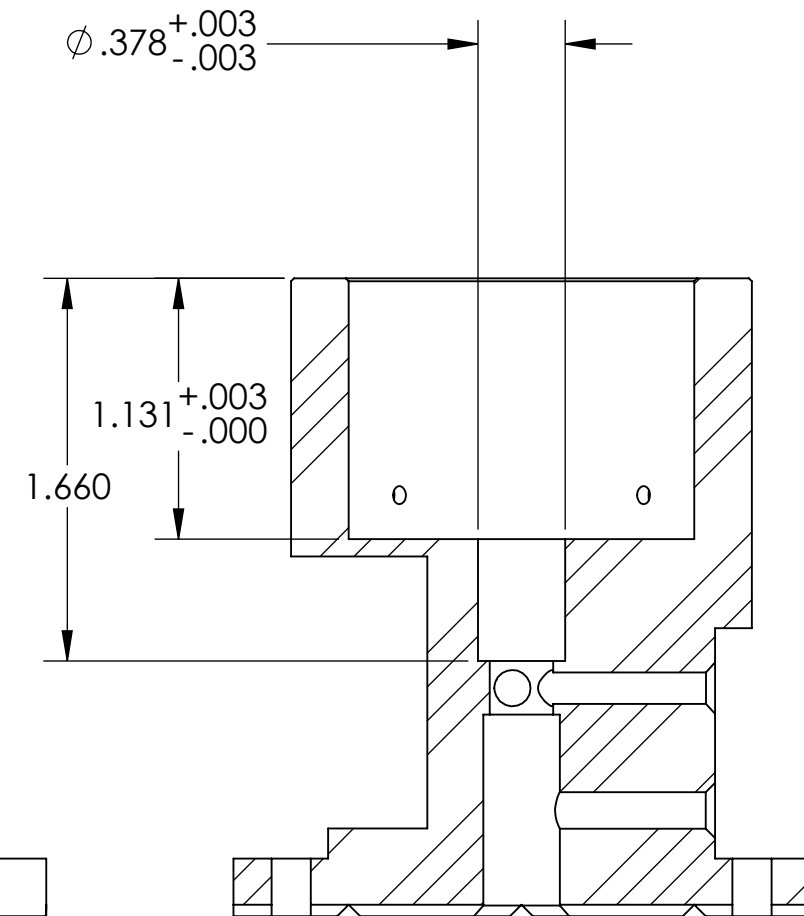
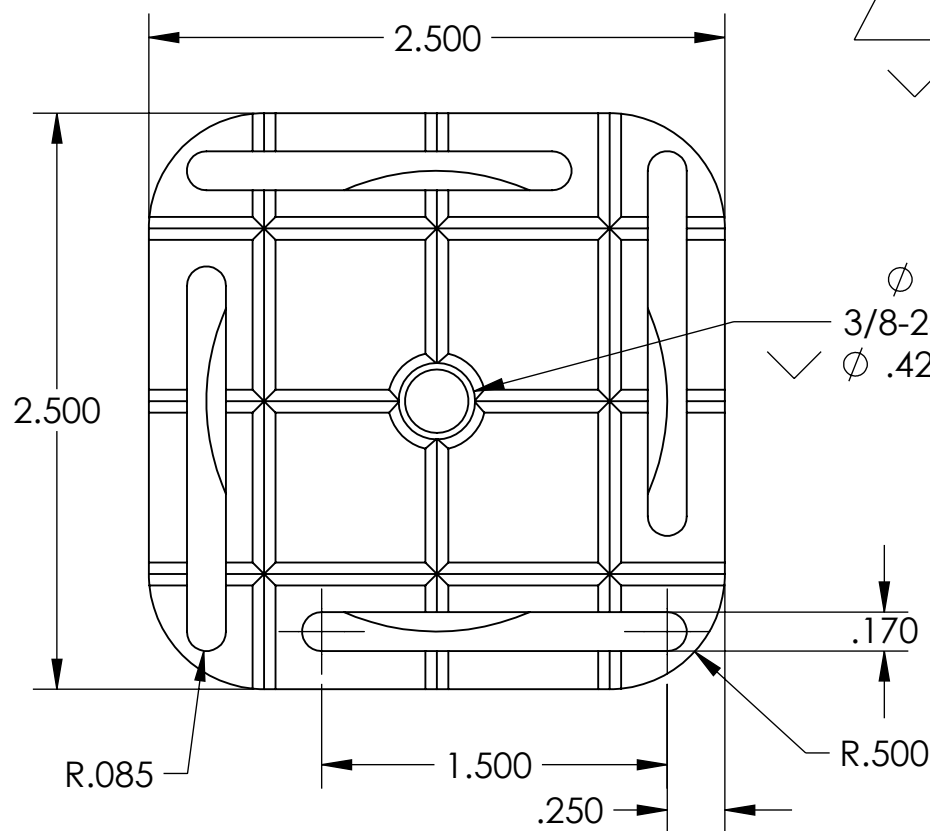
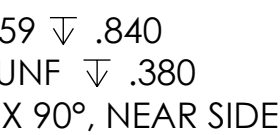
3. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

REFER TO LIGO E0900364

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

5. 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.

⑥ MATERIAL: VICTREX GRADE TDS-450G.
REFER TO LIGO E0900364



Technical drawing of a mechanical part. The part has a semi-circular top. A horizontal line is drawn at a height of .050 from the base. A vertical line is drawn from the center of the semi-circle down to the base. A horizontal line is drawn from the center of the semi-circle to the left, intersecting the .050 height line. A diagonal line is drawn from the center of the semi-circle down to the base. A horizontal line is drawn from the center of the semi-circle to the right, intersecting the base. The distance from the center of the semi-circle to the right edge of the part is .100.

DETAIL B
SCALE 8 : 1

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|--|---|---|-----------------------|---|-------------|-------------|--------------|---|--------------|
| NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) | |  CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY | | PART NAME High-Reliability Ultra-Fast Mechanical Shutter (HRUF) Base | | | | | |
| DIMENSIONS ARE IN INCHES | 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. | SYSTEM | SUB-SYSTEM ISC | DESIGNER | D. SCHAETZL | 04 JAN 2023 | SIZE | DWG. NO. | REV. |
| TOLERANCES: .XX ± .01 .XXX ± .005 | | | | DRAFTER | D. GRIFFITH | 05 JAN 2022 | c | D2300001 | v2 |
| ANGULAR ± 0.5° | MATERIAL Polyetheretherketone (PEEK)  | FINISH 63 μinch | NEXT ASSY D2200426 | CHECKER | SEE DCC | SEE DCC | | | |
| | | | | APPROVAL | | | SCALE: 1.2:1 | PROJECTION:  | SHEET 1 OF 1 |