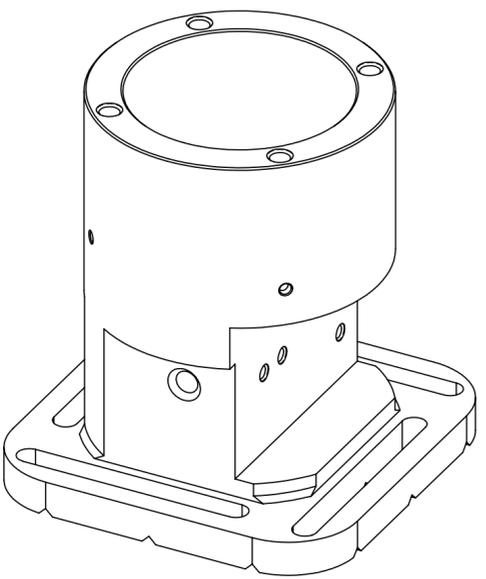
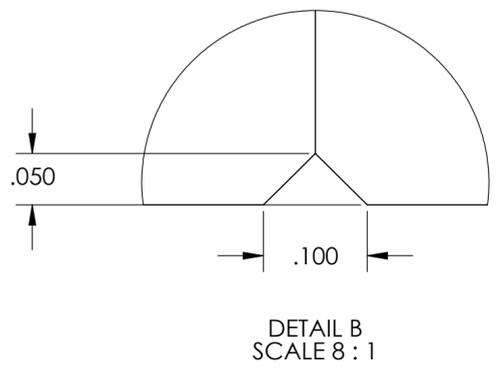
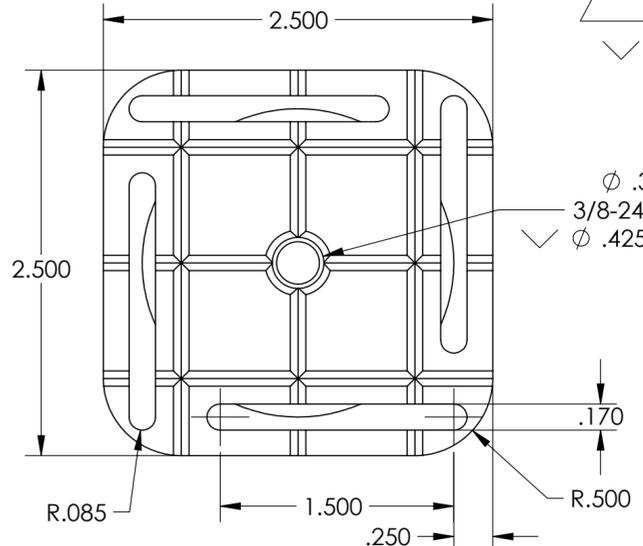
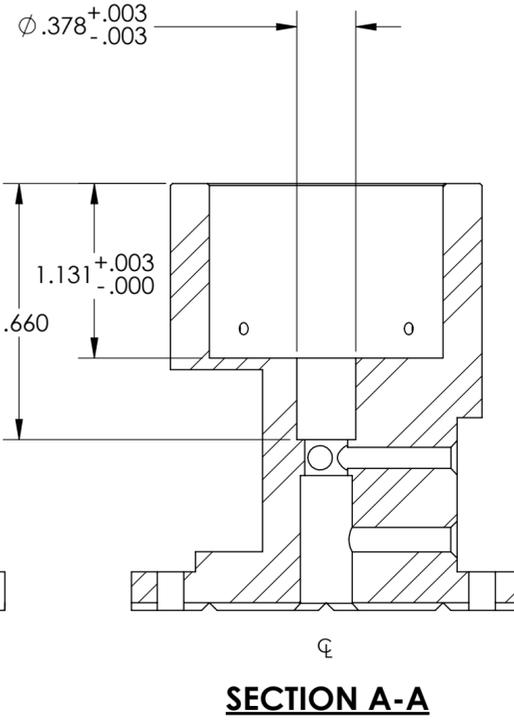
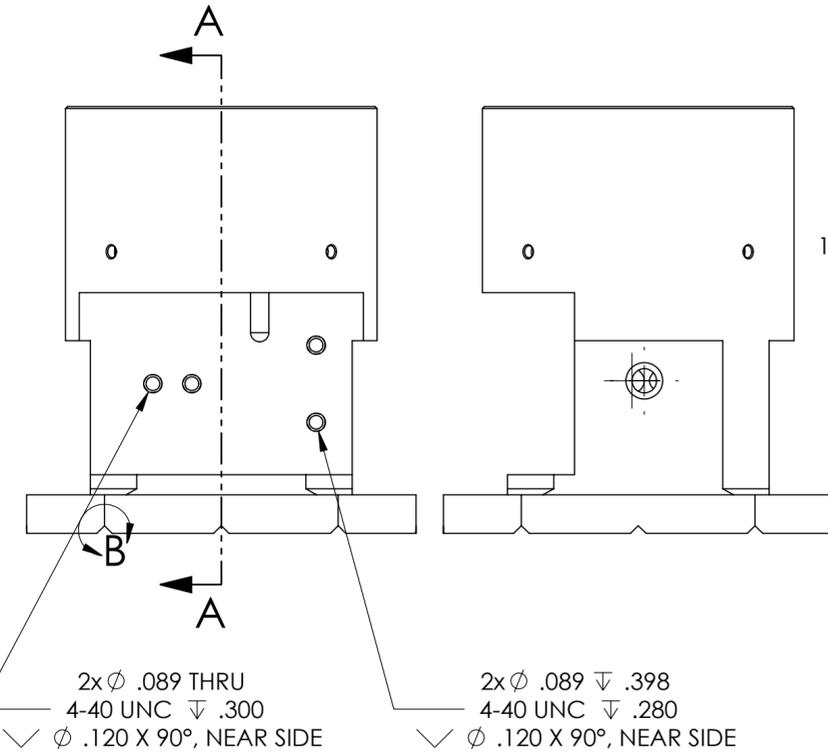
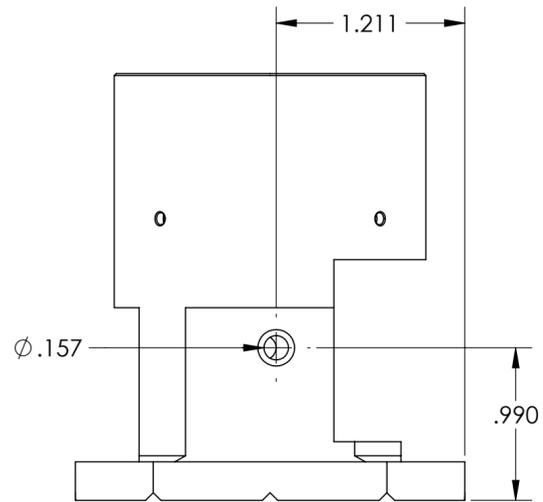
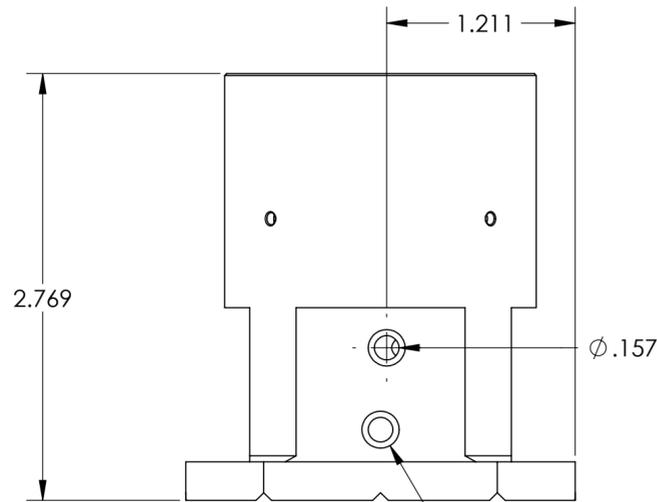
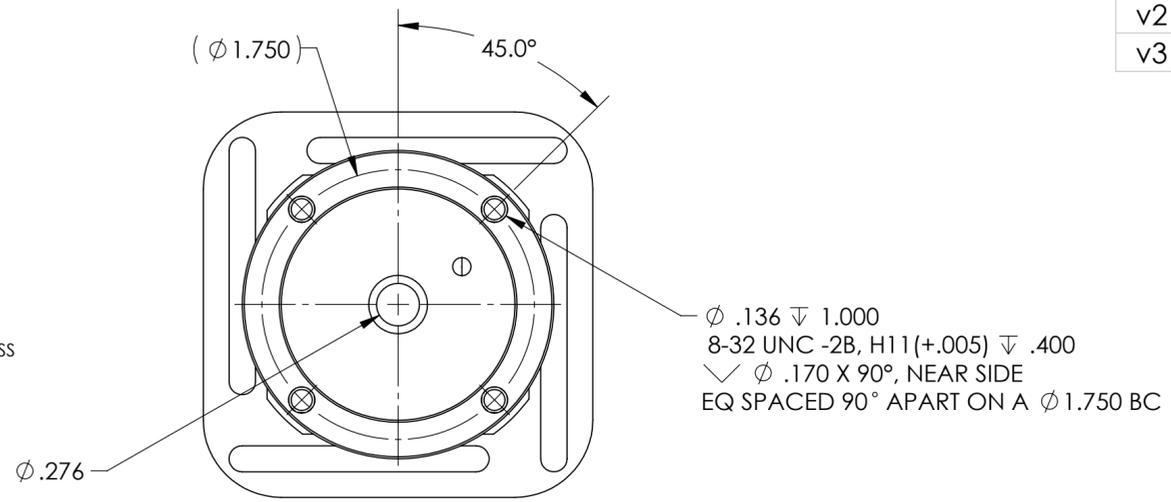


NOTES:

- 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: DXXXXXX-VY, TYPE-XX, S/N XXX
2. APPROXIMATE WEIGHT = 119.3g.
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

REV.	DATE	DCN #	DRAWING TREE #
v1	05 JAN 2022	-	-
v2	-	-	-
v3	05 JUN 2024	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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 Polyetheretherketone (PEEK) ⑥ **FINISH** 63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM **SUB-SYSTEM** ISC **NEXT ASSY** D2200426

PART NAME High-Reliability Ultra-Fast Mechanical Shutter (HRUF) Base

DESIGNER D. SCHAETZL	04 JAN 2023	SIZE c	DWG. NO. D2300001	REV. v2
DRAFTER D. GRIFFITH	05 JAN 2022			
CHECKER SEE DCC	SEE DCC			
APPROVAL		SCALE: 1.2:1	PROJECTION:	SHEET 1 OF 1