

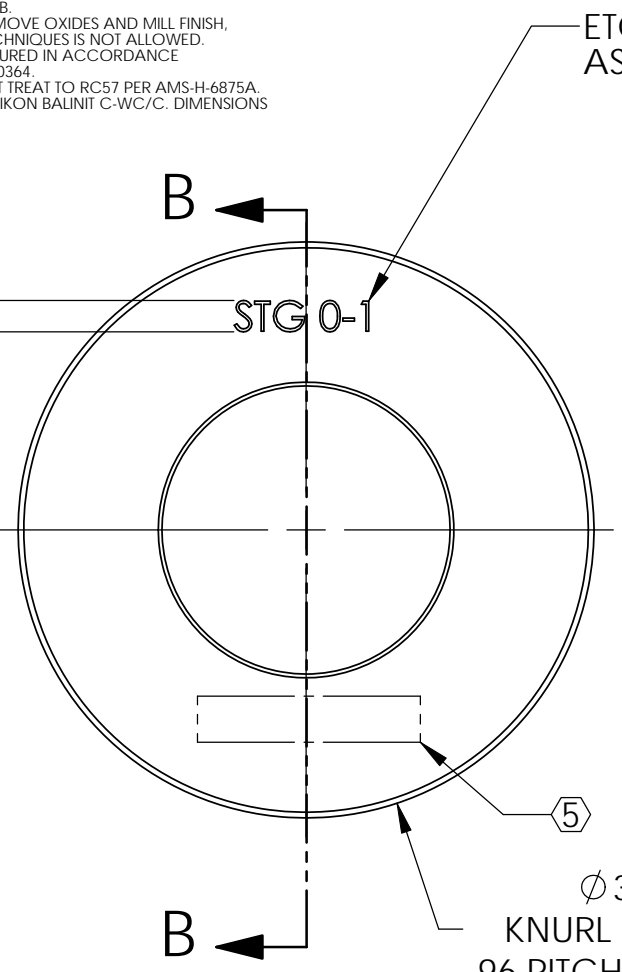
D1000860, Stage 0-1 Locker, aLIGO BSC-ISI, PART PDM REV: X-009, DRAWING PDM REV: X-007

- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED.
EXAMPLE DXXXXXX-VY, TYPE-XX, S/N XXX.
 - 6. APPROXIMATE WEIGHT = 1.147 LB.
 - 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 - 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - 9. BEFORE FINAL MACHINING HEAT TREAT TO RC57 PER AMS-H-6875A.
 - 10. COAT ALL SURFACES WITH OERLIKON BALINIT C-WC/C. DIMENSIONS APPLY AFTER COATING.

REV.	DATE	DCN #	DRAWING TREE #
v1	01 Mar. 2010	E1000115	E1000025
v2	25 Oct. 2010	E1000353	E1000025

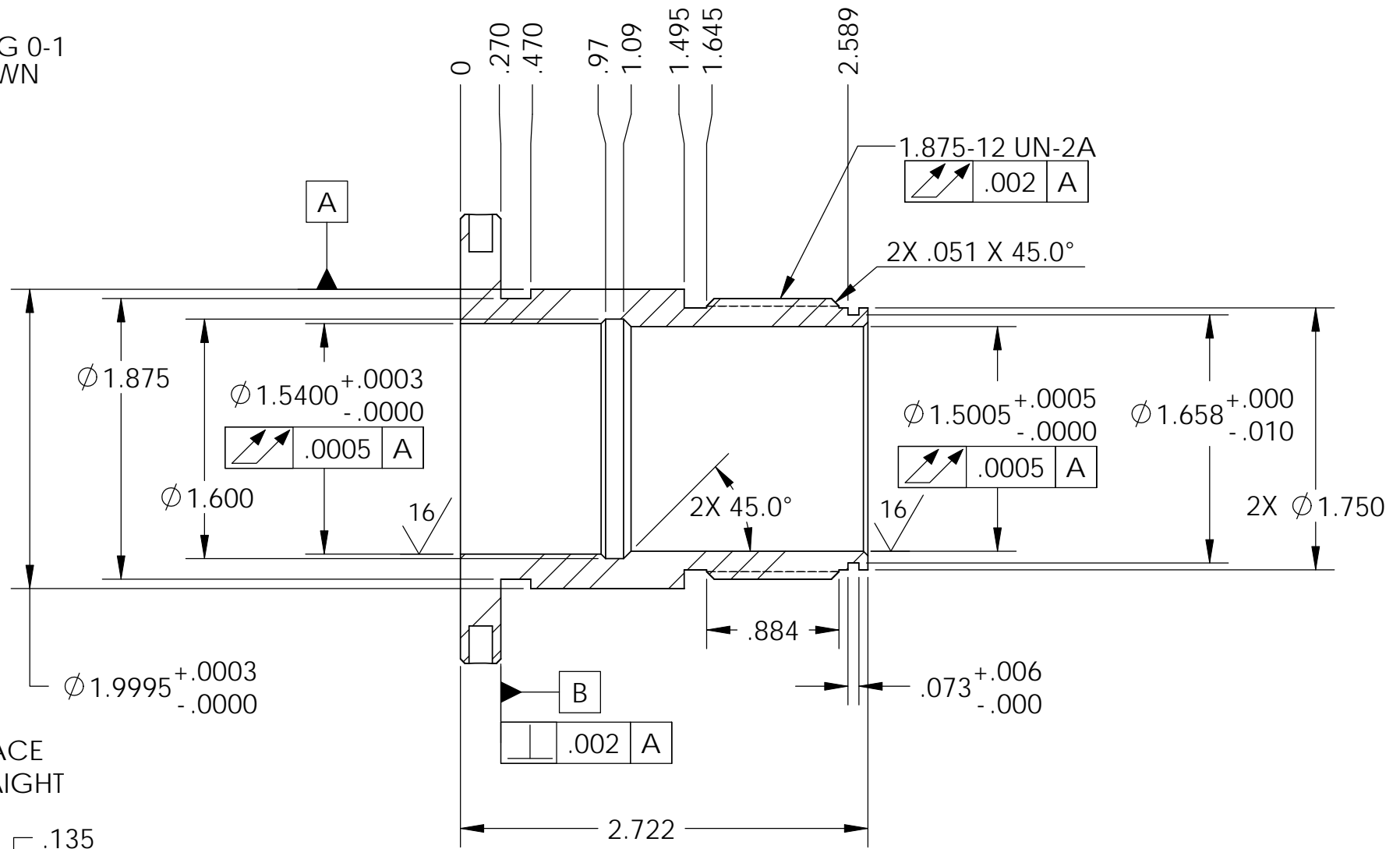
D
C
B
A

D
C
B
A

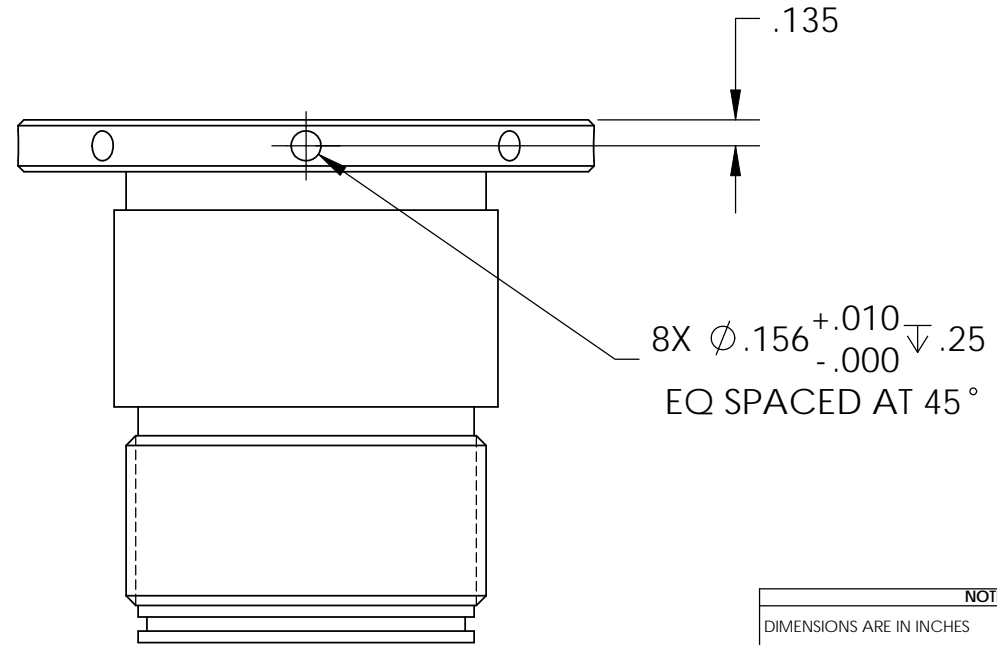


ETCH STG 0-1 AS SHOWN

Ø 3.000
KNURL SURFACE
96 PITCH, STRAIGHT



SECTION B-B



8X Ø .156 ^{+.010} _{-.000} ∇ .25
EQ SPACED AT 45°

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		SUB-SYSTEM		SLEEVE, STAGE 0-1 LOCKER, aLIGO BSC-ISI	
TOLERANCES: .XX ± .015 .XXX ± .005				NEXT ASSY		D1000854		DESIGNER	A.STEIN
ANGULAR ± .5°				MATERIAL		AISI 440C PER AMS 5630		DRAFTER	M.HILLARD
				FINISH		63 µinch		CHECKER	F.MATICHARD
								APPROVAL	K.MASON
								SIZE	DWG. NO.
								B	D1000860
								REV.	v2
								SCALE: 1:1	PROJECTION:
								SHEET 1 OF 1	