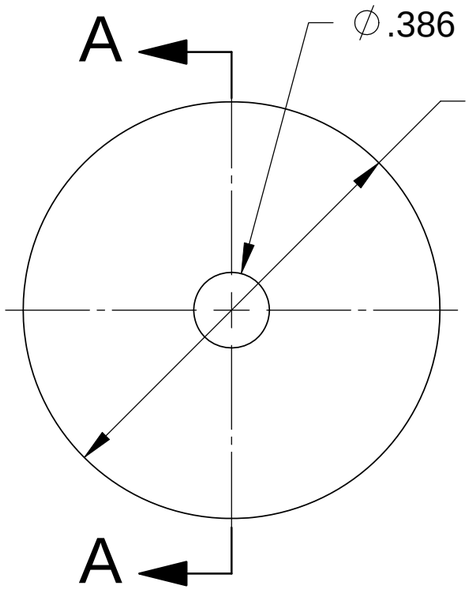
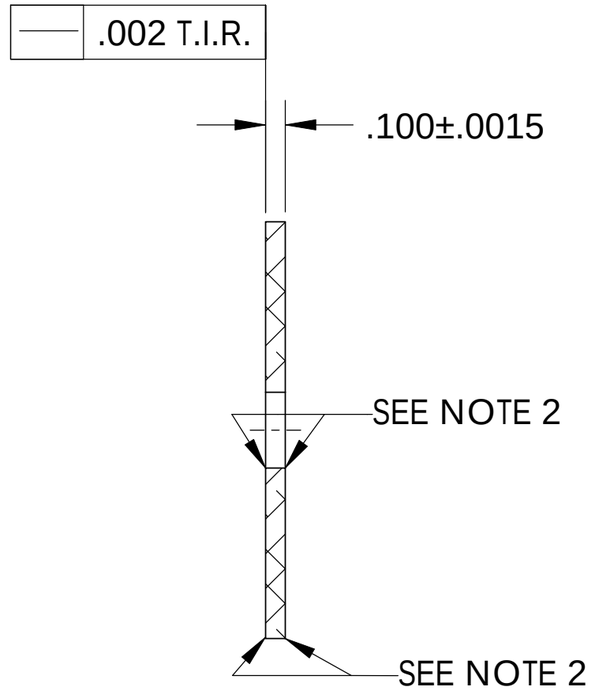
NOTES CONTINUED:

5. BAG AND TAG PARTS SEPARATELY WITH THEIR DRAWING PART NUMBER, REVISION, AND SERIAL NUMBER. SERIAL NUMBERS START AT 001 (UNLESS OTHERWISE SPECIFIED) FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY.
   EXAMPLE:
   DXXXXXXX-vY
   S/N-001
6. APPROXIMATE WEIGHT = .10 LB [44.2 G].
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-E0900364.
9. WATERJET CUT FROM .125 SHEET STOCK.
10. DOUBLE ASC GRIND TO 63 µinch Ra AND ELECTROPOLISH PER LIGO SPECIFICATION E0900364 SECTION 5.2.2.2 APPLIED TO STAINLESS STEEL.

REV.	DATE	DCN #	DRAWING TREE #
v1	15 MAR 2011	E1100080-v1	-
v2	27 JUN 2011	E1100351	-
-	-	-	-





SECTION A-A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± °

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATLEY 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.

MATERIAL 304 SSTL

FINISH 10

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO

SUB-SYSTEM AOS

NEXT ASSY D1003120

PART NAME ALIGO ETM TELESCOPE TUBE LARGE WASHER

DESIGNER	K. MAILAND	10 MAY 2010
DRAFTER	C. CONLEY	15 MAR 2011
CHECKER		
APPROVAL		

SIZE A **DWG. NO.** D1001108 **REV.** v2

SCALE: NONE **PROJECTION:** SHEET 1 OF 1

D1001108 aLIGO ETM TELESCOPE TUBE LARGE WASHER, PART PDM REV: X-025, DRAWING PDM REV: X-006