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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 = 1.23 LB [.56 KG].

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

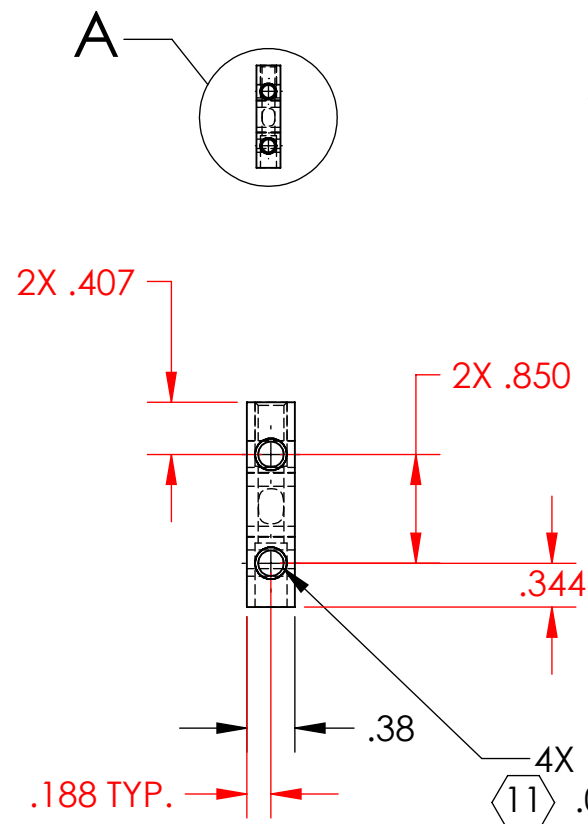
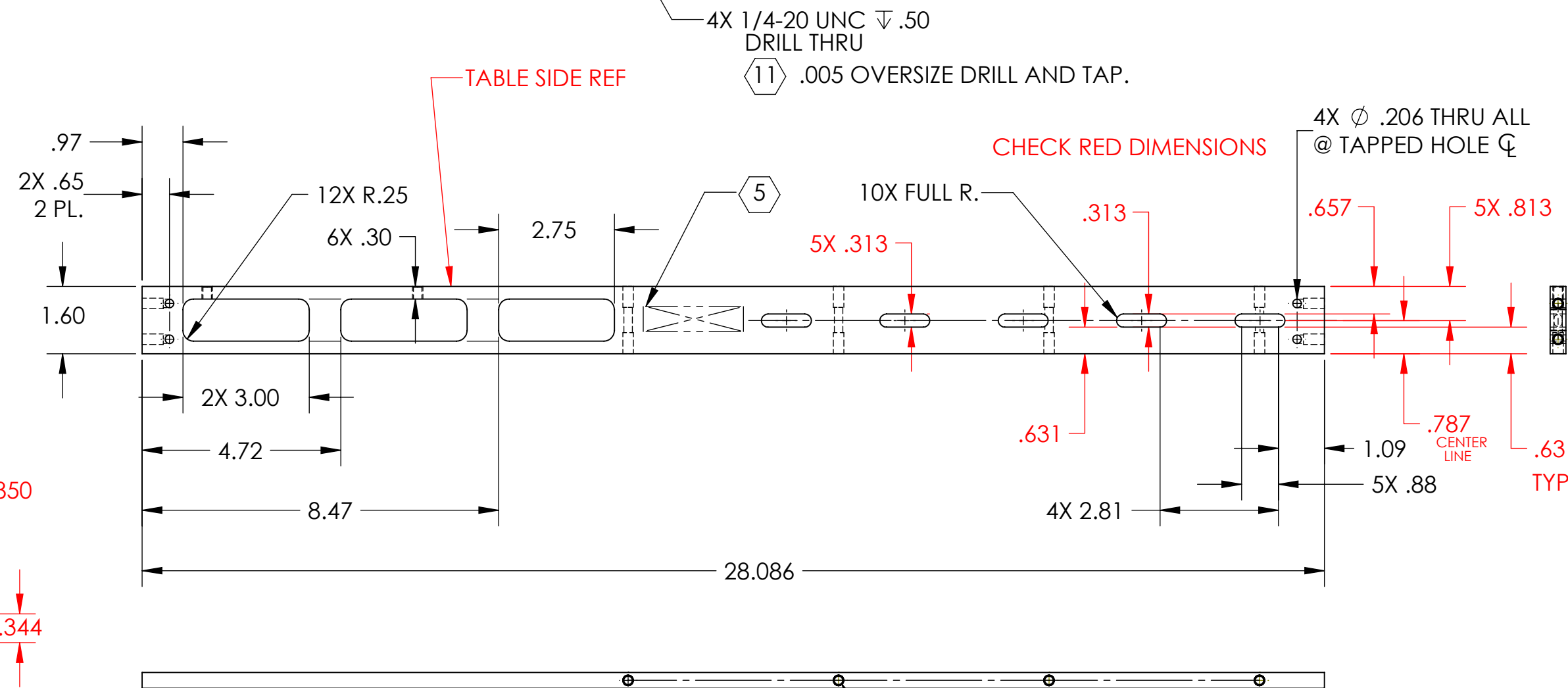
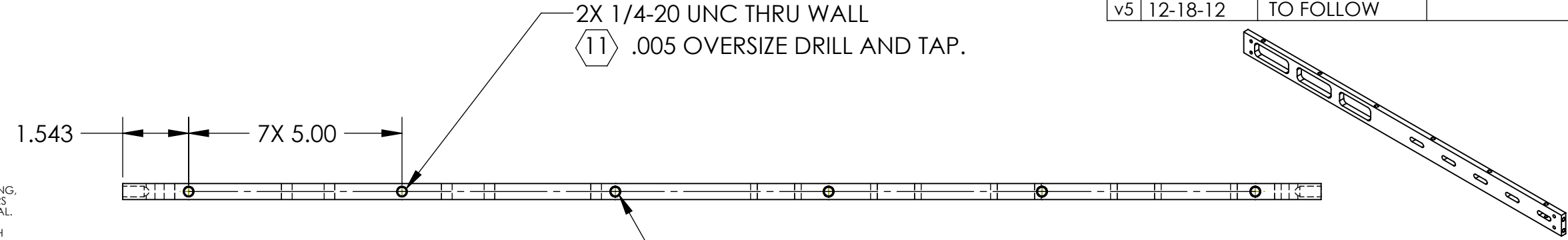
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.

10. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

11. ALL TAPPED HOLES: .005 OVERSIZE BOTH DRILL AND TAP.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 DEC 2010	E1000762-v1	-
v2	11 NOV 2011	E1100080-v1	-
v3	24 MAR 2012	E1200317-x0	-
v4	12 JUL 2012	TO FOLLOW	
v5	12-18-12	TO FOLLOW	



DETAIL A  
SCALE 2 : 3  
BOTH ENDS

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1.0°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005 - .015. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		qLIGO OPTICS TABLE GUSSET PLATE, SMALL	
MATERIAL 6061-T6 Al		FINISH 63 μinch Ra		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
NEXT ASSY D1001160				DESIGNER K. MAILAND		10/09/210	
				DRAFTER M. MILLER		11/09/2010	
				CHECKER SEE DCC		SEE DCC	
				APPROVAL SEE DCC		SEE DCC	
				SCALE: 1:3		PROJECTION:	
				SIZE DWG. NO. B		D1001164	
				REV. v5		SHEET 1 OF 1	

D1001164 qLIGO OPTICS TABLE GUSSET PLATE, SMALL, PART PDM REV: X-037, DRAWING PDM REV: X-041

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