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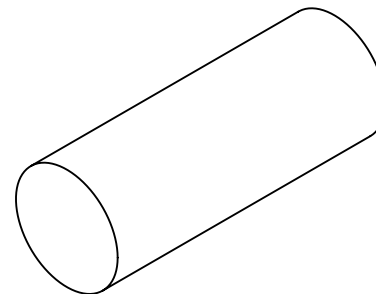
NOTES CONTINUED:

5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 101 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.

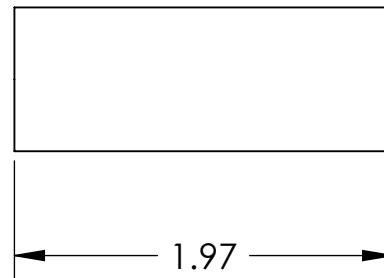
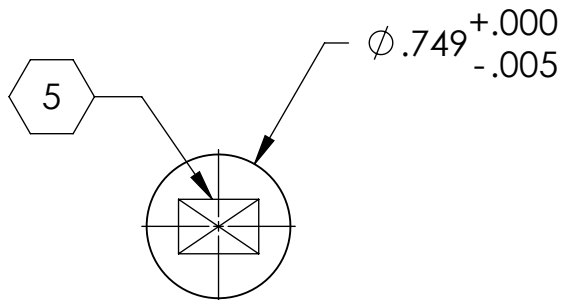
EXAMPLE (PART): 101-v1  
 EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD

- 6. APPROXIMATE WEIGHT = 0.251 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.

REV.	DATE	DCN #	DRAWING TREE #
A	24 JUN 2004	E040303-00	-
v1	09 JUL 2010	E0900501	E0900353
-	-	-	-



ISOMETRIC VIEW



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:  
 .XX ± .03  
 .XXX ± .005

ANGULAR ± 0.5°

- 1. INTERPRET DRAWING PER ASME Y14.5-1994.
- 2. REMOVE ALL SHARP EDGES, R.02 MIN.
- 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, 316 OR 302 SSSL  
 FINISH 32 μinch

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM SUS NEXT ASSY D020534

PART NAME ROLL INSERT, T-SECTION

DESIGNER	C. TORRIE	22 NOV 2002	SIZE	DWG. NO.	REV.
DRAFTER	B. MOORE	15 DEC 2009	A	D020676	v1
CHECKER	M. MEYER	18 JAN 2010	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1
APPROVAL					

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