

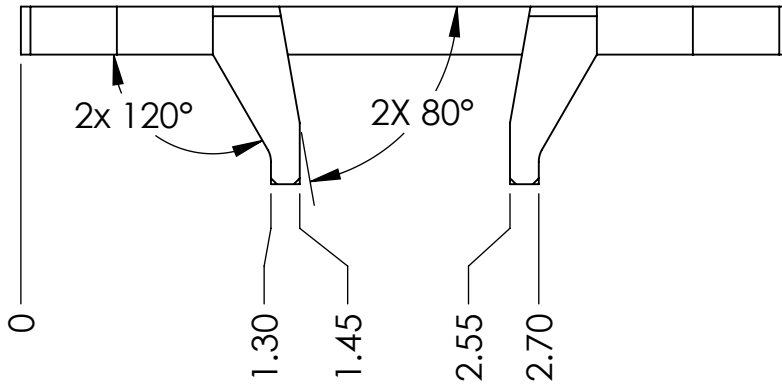
NOTES CONTINUED:

5. 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

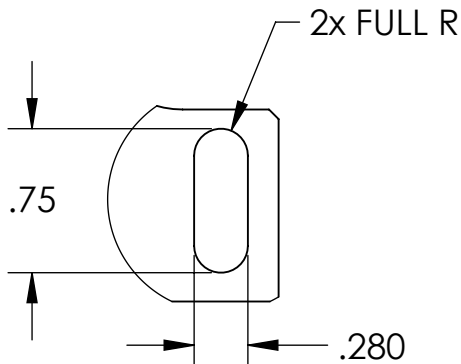
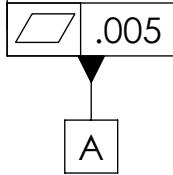
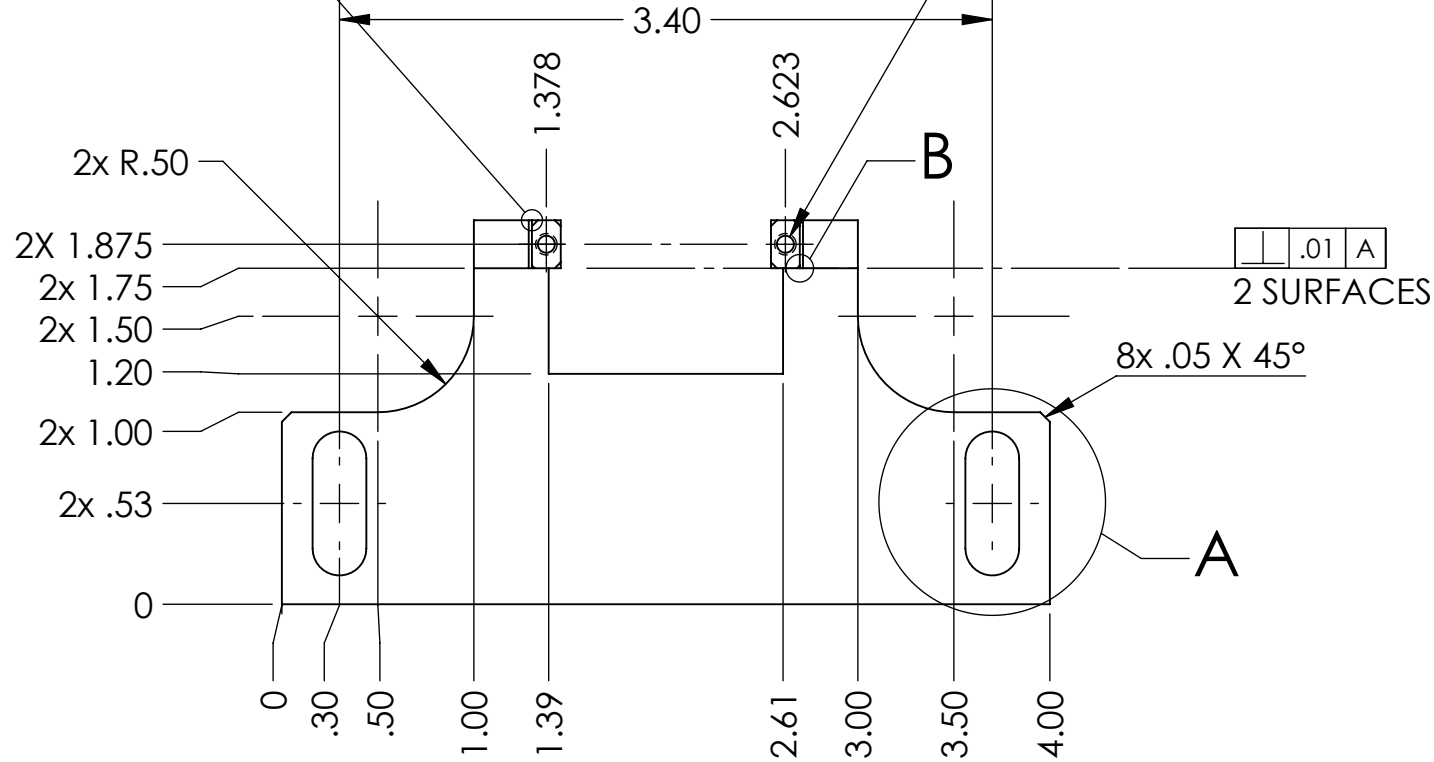
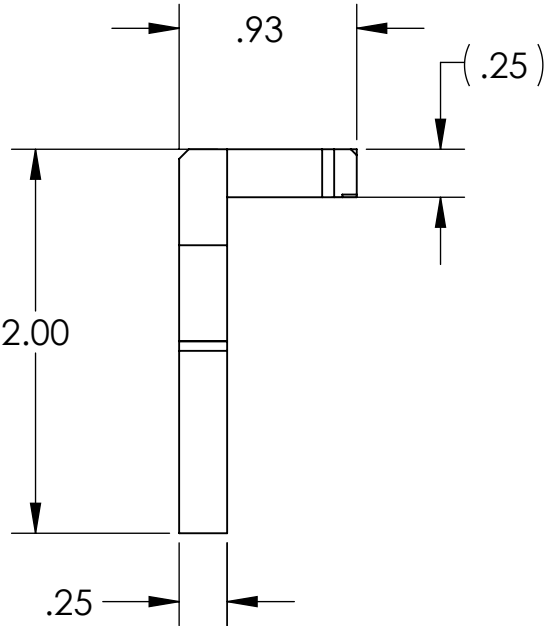
- 6. APPROXIMATE WEIGHT = .098 LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. 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.

3X .03 X 45°
CORNER
CHAMFER

DETAIL C
SCALE 4:1
2 PL.

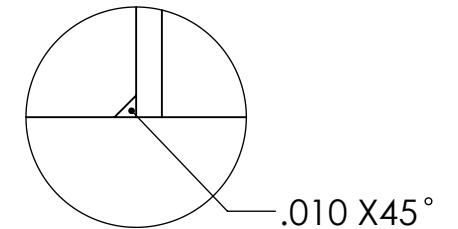
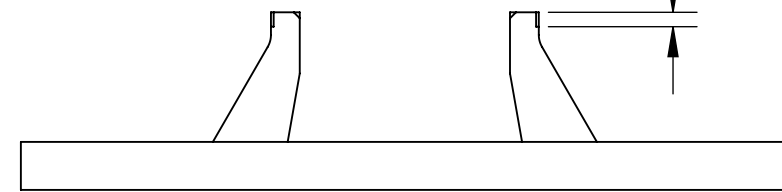


Ø .089 ∇ .30
4-40 UNC - 2B ∇ .224
+.005 OVERSIZE DRILL & TAP



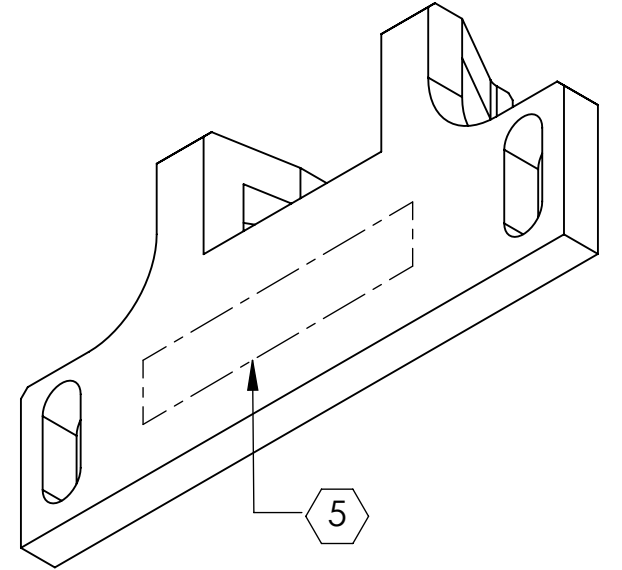
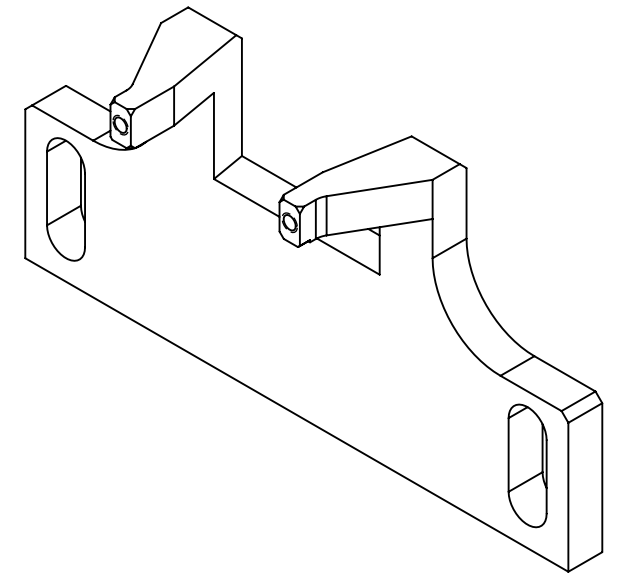
DETAIL A
2 PLACES

2X .08 LONG CHAMFER, SEE DETAIL B



DETAIL B
SCALE 8:1
2 PLACES

REV.	DATE	DCN #	DRAWING TREE #
v1	29 MAY 2013	-	-
v2	03 DEC 2013	E1300914-x0	-
-	-	-	-



D1003325 Fast Shutter Hardstop, PART PDM REV: X-001, DRAWING PDM REV: X-003

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± .5°	
MATERIAL	6061-T6 Al
FINISH	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	PART NAME	
	Fast Shutter Cap	
SYSTEM	SUB-SYSTEM	DESIGNER
ADVANCED LIGO	ISC	SBARNUM
NEXT ASSY		DRAFTER
D1003318		SBARNUM
		CHECKER
		JLEWIS
		APPROVAL
		PFRITSCHEL

DATE	20 MAY 2013	SIZE	DWG. NO.	REV.
DATE	23 MAY 2013		B	D1003325
		SCALE:	1:1	
		PROJECTION:		SHEET 1 OF 1