

NOTES CONTINUED:

5. BAG AND TAG PARTS WITH PART NUMBER, REVISIONS, QUANTITY, AND MANUFACTURING DATE.

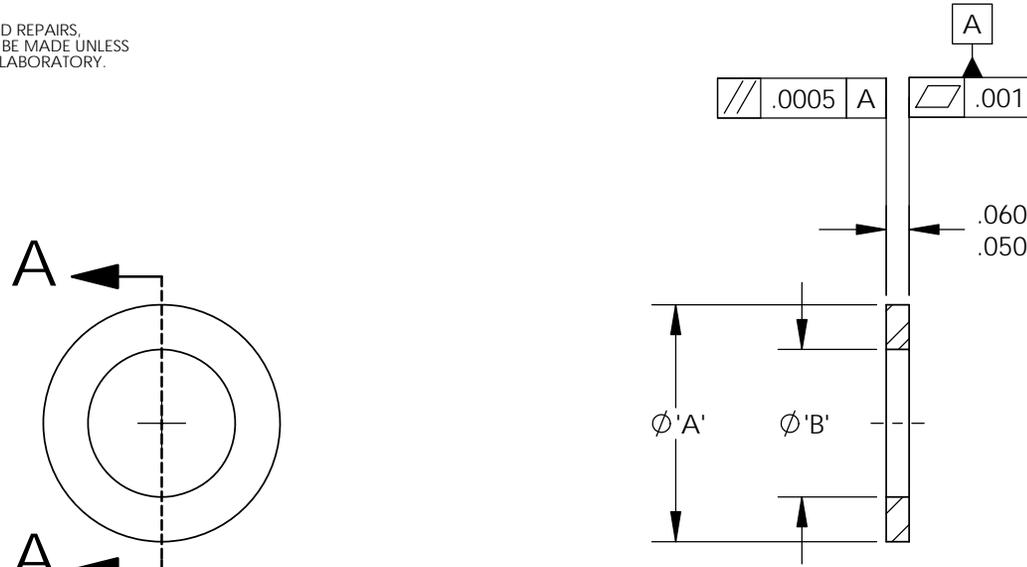
EXAMPLE (TAG):  
DXXXXXX-VY, QTY:TBD, MFR DATE: MM/DD/YYYY

6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

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.

REV.	DATE	DCN #	DRAWING TREE #
v1	26 APR 2011	E1100401-x0	-
v5	17 JAN 2012	E1200055-x0	-
-	-	-	-



SECTION A-A

SPECIFICATIONS

PART NO.	DESCRIPTION	'A'	OD TOLERANCE	'B'	ID TOLERANCE	MATERIAL
D1100785-281	WASHER, FLAT, .17 X .281 O.D.	0.281	+.015 / -.005	0.177	+.015 / -.005	NITRONIC 60 COLD WORKED YIELD STRENGTH: 130 KSI
D1100785-359	WASHER, FLAT, .20 X .359 O.D.	0.359		0.201		
D1100785-472	WASHER, FLAT, .25 X .472 O.D.	0.472		0.257		
D1100785-375	WASHER, FLAT, .25 X .375 O.D.	0.375		0.257		
D1100785-562	WASHER, FLAT, .38 X .562 O.D.	0.562		0.386		
D1100785-530	WASHER, FLAT, .25 X .530 O.D.	0.530		0.257		
D1100785-620	WASHER, FLAT, .38 X .620 O.D.	0.620	+.000 / -.010	0.386		

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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 FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY 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: NITRONIC 60  
FINISH: 63 μinch

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

SYSTEM: ADVANCED LIGO  
SUB-SYSTEM: SUS

NEXT ASSY: N/A

PART NAME: ALIGO, SUS, NITRONIC WASHER, FLAT

DESIGNER	E.SANCHEZ	26 APR 2011	SIZE	DWG. NO.	REV.
DRAFTER	E.SANCHEZ	26 APR 2011	A	D1100785	v5
CHECKER	SEE DCC	SEE DCC	SCALE: 2:1	PROJECTION:	SHEET 1 OF 1
APPROVAL	SEE DCC	SEE DCC			