

REV.	DATE	DCN #	DRAWING TREE #
v1	21 JUN 2011	-	-
-	-	-	-
-	-	-	-

NOTES CONTINUED:

5. SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 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): 001-v1
EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD

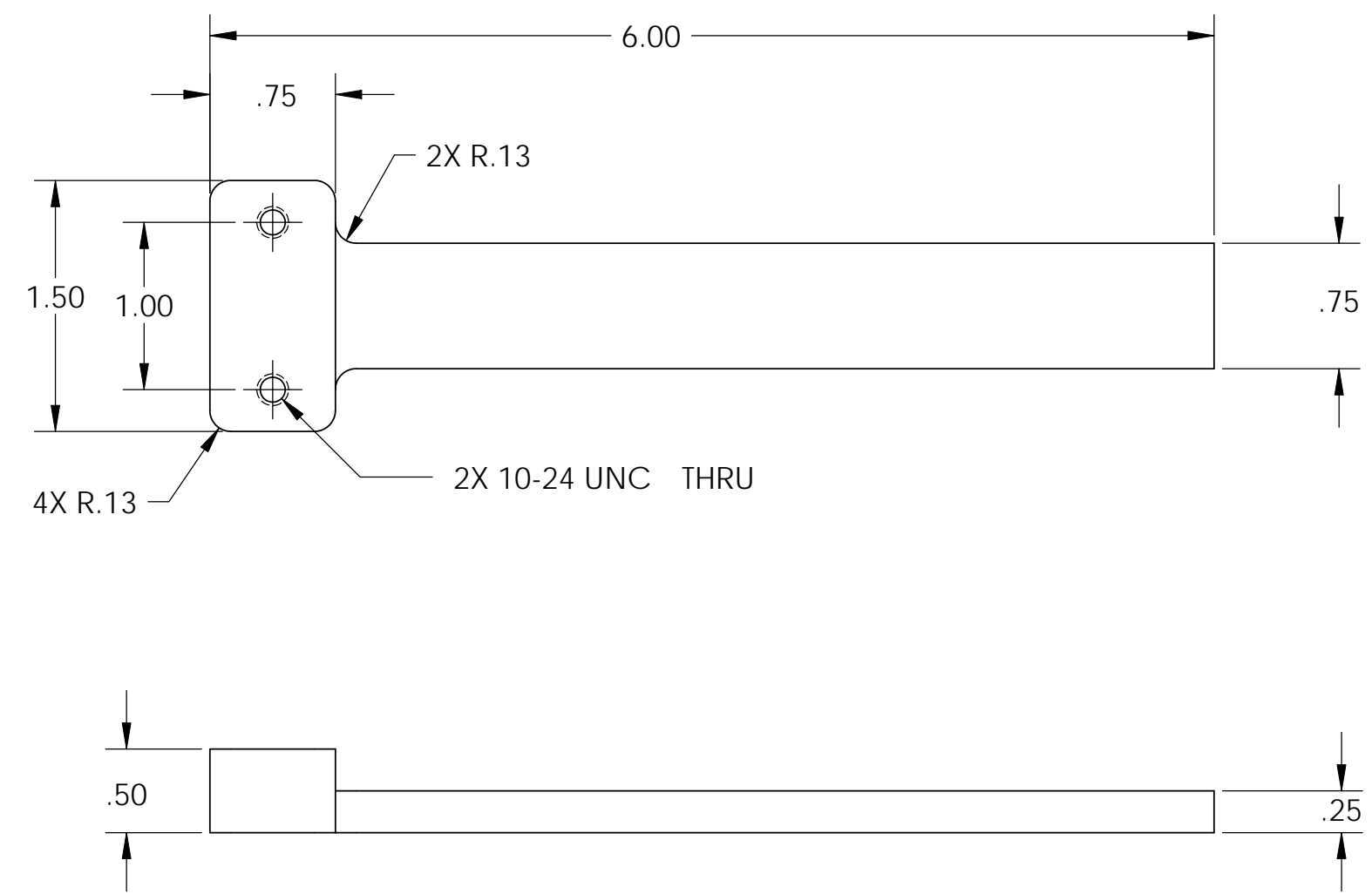
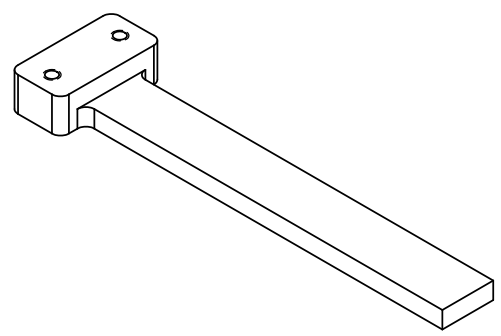
6. APPROXIMATE WEIGHT = 0.098 LB.

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.

10. MACHINE FILLET RADII .003-.010.



D1101184_aLIGO ACB BEND FIXTURE PLATE, PART PDM REV: X-002, DRAWING PDM REV: X-003

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES R0.2 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. REFER TO LIGO E0900237 FOR LIST OF APPROVED COOLANTS.		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
TOLERANCES: .XX ± .01 .XXX ± .005		MATERIAL 6061-T6 Al		FINISH 63 μinch		NEXT ASSY	
ANGULAR ± 1.0°						DESIGNER N. KILPATRICK 21 JUN 2011 DRAFTER N. KILPATRICK 21 JUN 2011 CHECKER APPROVAL	
						PART NAME aLIGO ACB BEND FIXTURE PLATE	
						SIZE DWG. NO. B D1101184	
						REV. v1	
						SCALE: 1:1 PROJECTION: SHEET 1 OF 1	