

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 = .004 LB.

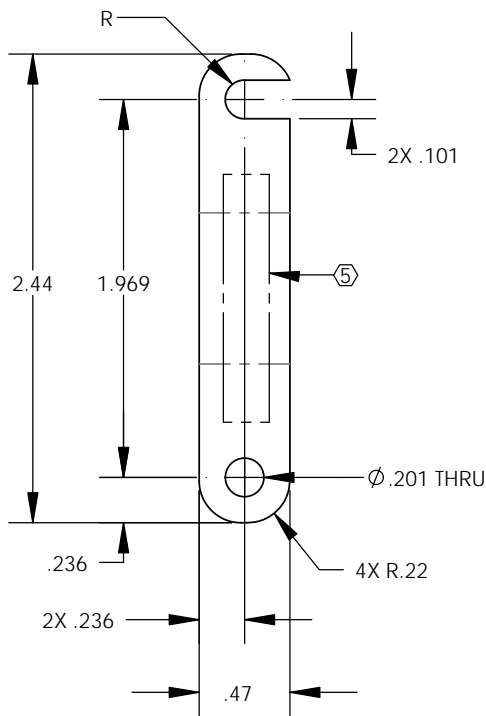
7. FLOUREL COMPOUND TO CONSIST OF
 100 PARTS FLOURER FC2180 OR FE5641
 20 PARTS MT BLACK (N990)
 3 PARTS MAGLITE (MgO)
 6 PARTS Ca (OH) 2
 3 PARTS CaO

8. WATER SOLUABLE RELEASE AGENT TO BE USED IF REQUIRED

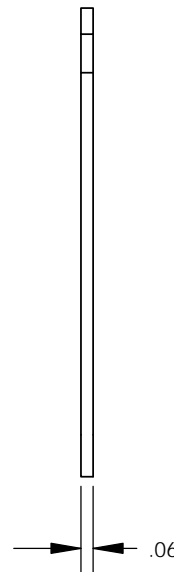
9. MOLDED PARTS MUST BE KETP FREE FROM HYDROCARBONS, AND BE HANDLED WITH CLEAN TOOLS OR CLEAN NITRILE GLOVES.

10. FLASH REMOVAL TO BE DONE WITH BLADE NOT ABRASIVE.

11. PARTS TO BE FOIL WRAPPED



REV.	DATE	DCN #	DRAWING TREE #
v1	02 NOV 2011	-	-
v2	10 NOV 2011	E1101092-x0	-
v3	01 DEC 2011	E1101132-x0	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .01
 .XXX ± .005

ANGULAR ± 0.5°

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES: .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL: FLUROELASTOMER
 FINISH: - μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
 SUB-SYSTEM: SUS
 NEXT ASSY: D1102146

PART NAME: aLIGO SUS, CABLE CLAMP FLOUREL PAD, OSEM/ECD (REDESIGNED)

DESIGNER	E.SANCHEZ	02 NOV 2011	SIZE	DWG. NO.	REV.
DRAFTER	E.SANCHEZ	02 NOV 2011	A	D1102147	v3
CHECKER	SEE DCC	SEE DCC	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1
APPROVAL	SEE DCC	SEE DCC			