

D1200090 Spacer ISI Support Tube HAM5 LLO aLIGO, PART PDM REV: X-002, DRAWING PDM REV: X-002

REV.	DATE	DCN #	DRAWING TREE #
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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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 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.

2X ϕ .41 THRU ALL
 \square ϕ .68 ∇ .24
 \sphericalangle ϕ .70 X 90°, NEAR SIDE
 \sphericalangle ϕ .46 X 90°, FAR SIDE

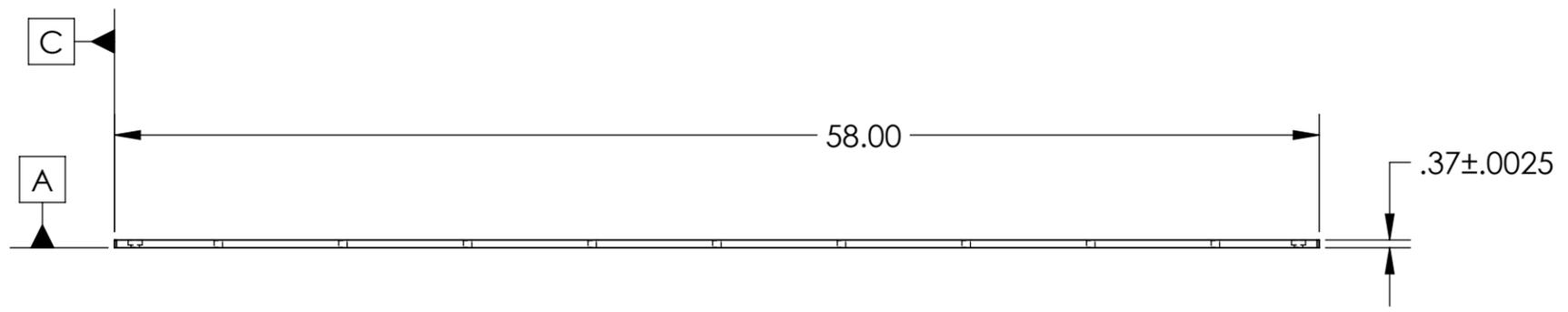
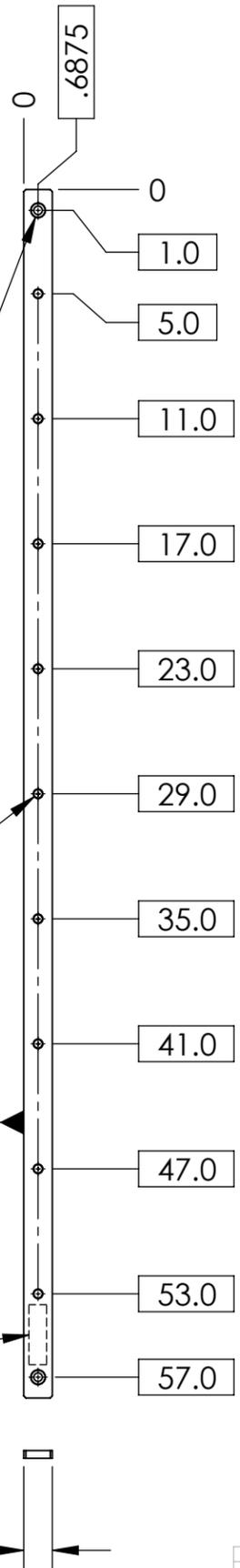
\oplus .012	A	B	C
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9X ϕ .41 ∇ THRU
 \sphericalangle ϕ .46 X 90°

\oplus .012	A	B	C
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D
C
B
A

D
C
B
A



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO		CALIFORNIA INSTITUTE OF TECHNOLOGY		MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				SYSTEM		SUB-SYSTEM		DESIGNER		SBARNUM	
TOLERANCES: .XX ± .01 .XXX ± .005				HAM ISI		SEI		DRAPER		SBARNUM	
ANGULAR ± 0.5°				MATERIAL		NEXT ASSY		CHECKER		CRAMENT	
				6061 Alloy		D0900456		APPROVAL		KMASON	
				FINISH		SCALE: 1:8		PROJECTION:		SHEET 1 OF 1	
				63 μ inch		B		D1200090		v2	

8 7 6 5 4 3 2 1