

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 = X.XXX LB.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. REFER TO LIGO-E0900364

| REV. | DATE | DCN # | DRAWING TREE # |
|------|------------|----------|----------------|
| V2 | 1 JUL 2013 | E1300516 | - |
| - | - | - | - |
| - | - | - | - |

D

D

C

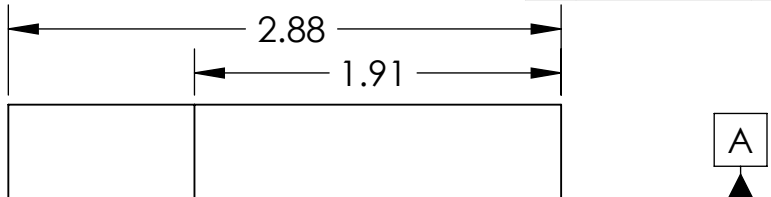
C

B

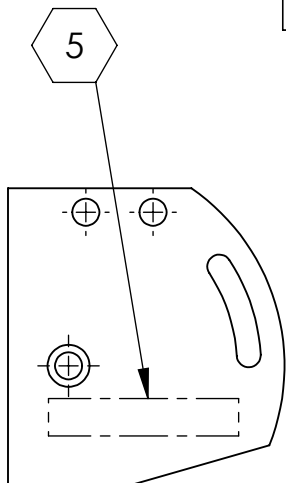
B

A

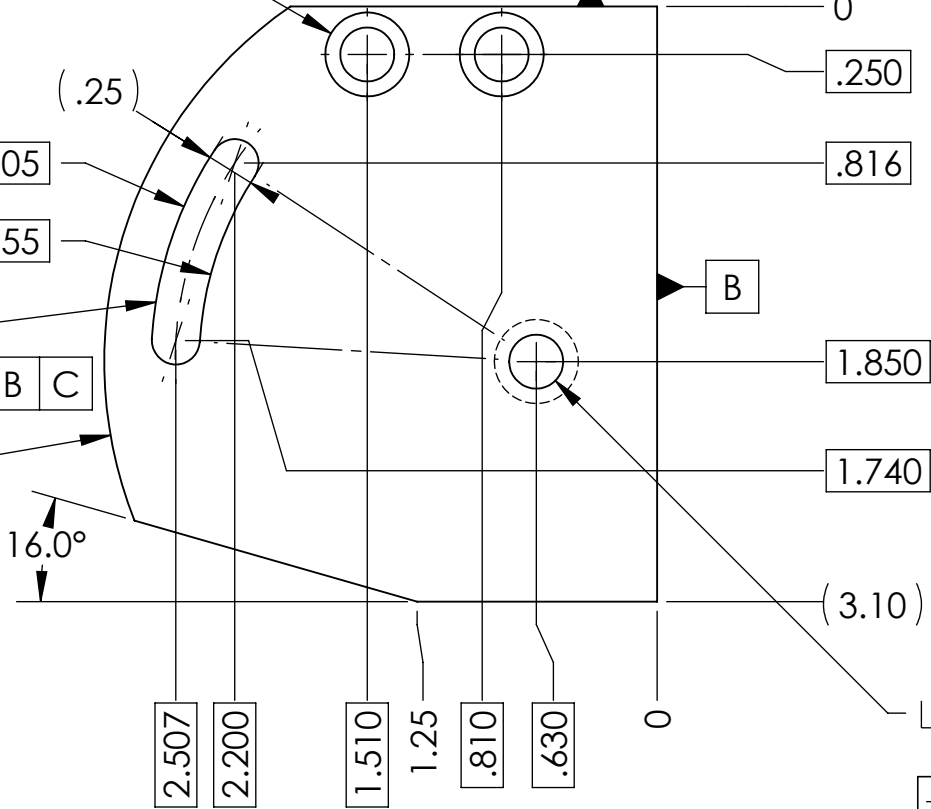
A



2X ϕ .281 THRU ALL
 \square ϕ .438 ∇ .250
 \oplus ϕ .014 (M) A B C



$\frac{1}{2}$.02
 \oplus .014 (M) A B C



ϕ .281 THRU ALL
 \square ϕ .438 ∇ .250
 OTHER SIDE
 \oplus ϕ .014 (M) A B C

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

| | |
|---|---|
| DIMENSIONS ARE IN INCHES [MM] | 1. INTERPRET DRAWING PER ASME Y14.5-1994. |
| TOLERANCES: .XX \pm .01 .XXX \pm .005 | 2. REMOVE ALL SHARP EDGES: .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. |
| ANGULAR \pm 0.5° | 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 | 6061-T6 Al |
| FINISH | 125 μ inch |

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 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **ISC**

NEXT ASSY: **D1200382**

| | | | |
|-----------|-----------------------------|---|-----------------|
| PART NAME | | ALS Upper Periscope Rotation Base (Y-End) | |
| DESIGNER | BJJ Slagmolen | SIZE | DWG. NO. |
| DRAFTER | BJJ Slagmolen February 2011 | A | D1200381 |
| CHECKER | SBARNUM 1 JUL 2013 | SCALE: 1:1 | PROJECTION: |
| APPROVAL | PFRITSCH 1 JUL 2013 | SHEET 1 OF 1 | REV. v2 |