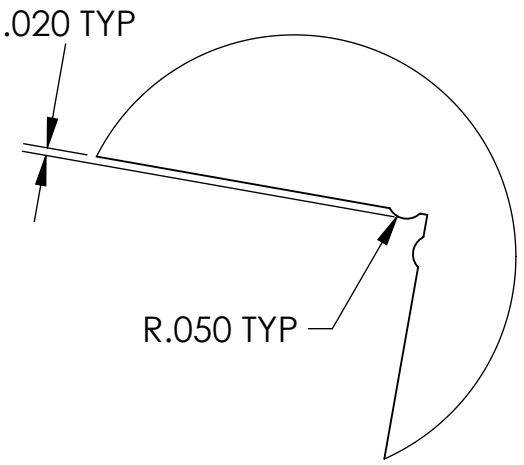
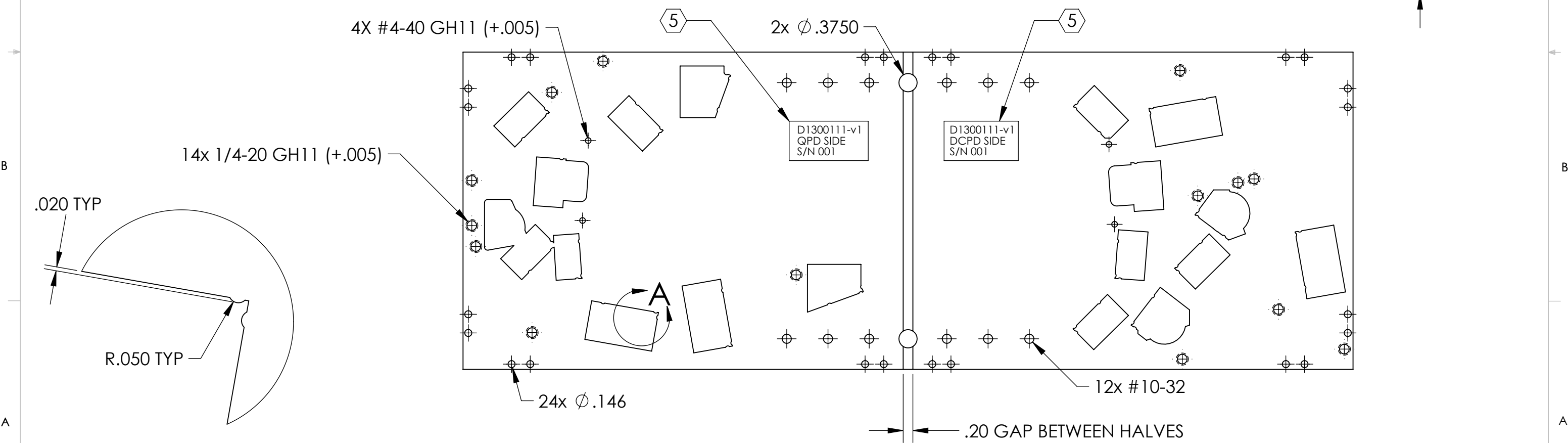
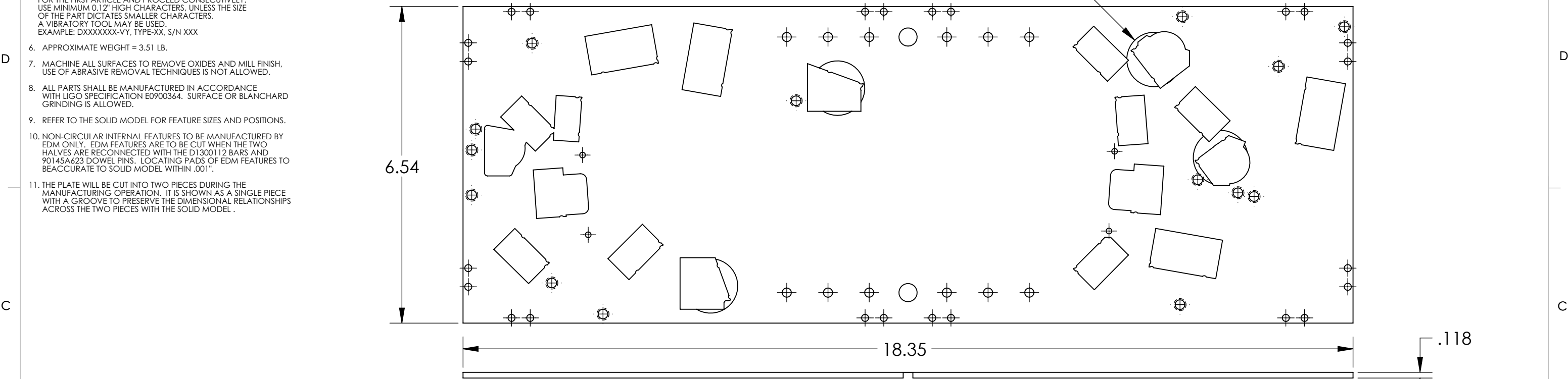


NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. APPROXIMATE WEIGHT = 3.51 LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364. SURFACE OR BLANCHARD GRINDING IS ALLOWED.
- 9. REFER TO THE SOLID MODEL FOR FEATURE SIZES AND POSITIONS.
- 10. NON-CIRCULAR INTERNAL FEATURES TO BE MANUFACTURED BY EDM ONLY. EDM FEATURES ARE TO BE CUT WHEN THE TWO HALVES ARE RECONNECTED WITH THE D1300112 BARS AND 90145A623 DOWEL PINS. LOCATING PADS OF EDM FEATURES TO BE ACCURATE TO SOLID MODEL WITHIN .001".
- 11. THE PLATE WILL BE CUT INTO TWO PIECES DURING THE MANUFACTURING OPERATION. IT IS SHOWN AS A SINGLE PIECE WITH A GROOVE TO PRESERVE THE DIMENSIONAL RELATIONSHIPS ACROSS THE TWO PIECES WITH THE SOLID MODEL.

REV.	DATE	DCN #	DRAWING TREE #
v1	8 FEB 2013	E1300123-x0	-
v2	24 JUN 2013	E1300123-v1	-
-	-	-	-

D1300111 QUGO OMC BONDING TEMPLATE, LIGHTSIDE, PART PDM REV: X-001, DRAWING PDM REV: X-001



DETAIL A  
SCALE 2 : 1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES .005-.015 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		aLIGO OMC BONDING TEMPLATE, LIGHTSIDE	
MATERIAL AISI 304		FINISH 63 μinch		SYSTEM ADVANCED LIGO		SUB-SYSTEM ISC	
NEXT ASSY D1300110				DESIGNER J.LEWIS		DATE 6 FEB 2013	
				DRAFTER J.LEWIS		DATE 8 FEB 2013	
				CHECKER		SIZE DWG. NO. B D1300111	
				APPROVAL		REV. v2	
				SCALE: 1:2		PROJECTION:  SHEET 1 OF 1	