

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. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364
 - 7. 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 SPECIFICATION E0900364
 - 8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- ⑦ ELECTROPOLISH ALL SURFACES TO REMOVE .0005-.001 PER SURFACE.
- ⑩ MATERIAL: MAKE FROM EXTRUDED ALUMINUM T-BAR 6063 T52 2" HIGH X 2" WIDE X .25" THICK
- ⑪ RIGHT HAND SHOWN, LEFT HAND SYMMETRICALLY OPPOSITE.

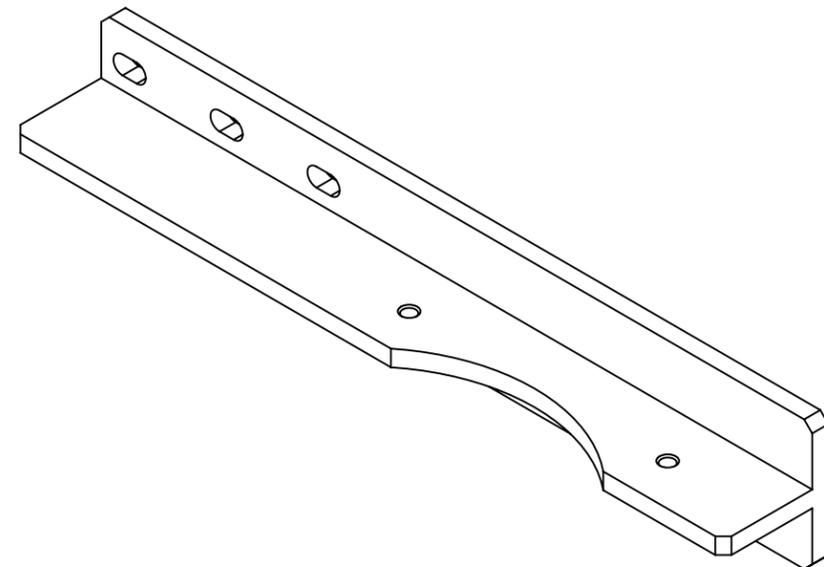
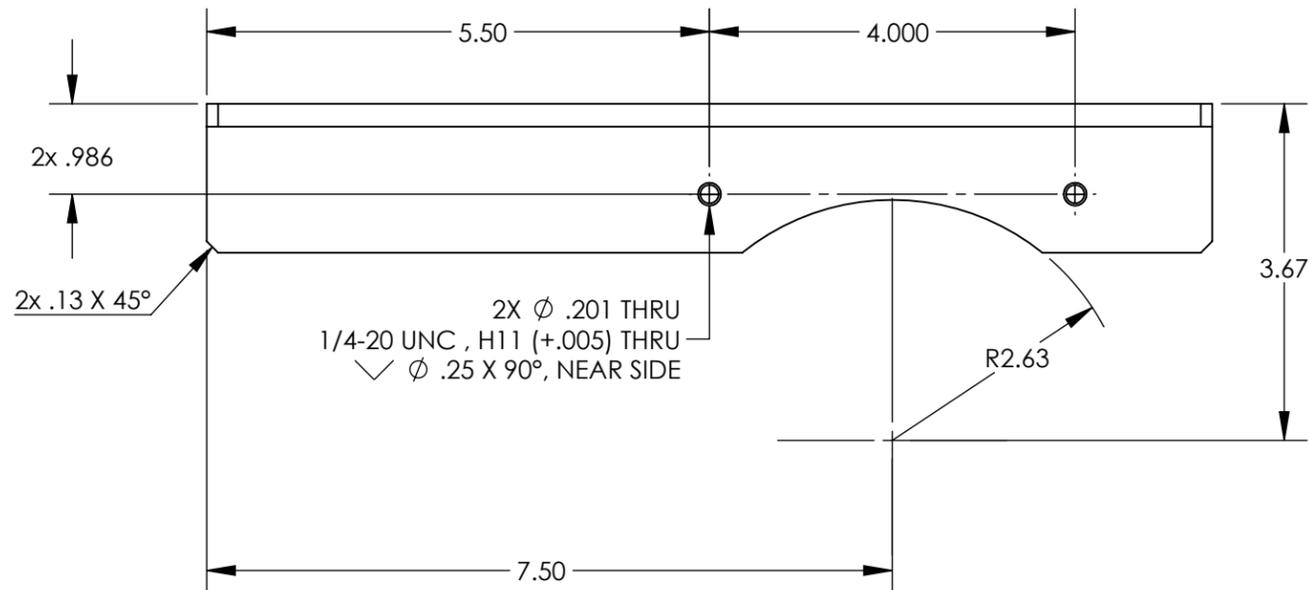
⑪ -01 TYPE (SHOWN)
-02 TYPE (OPPOSITE)

REV.	DATE	DCN #	DRAWING TREE #
v1	26 JUN 2019	-	-
v2	09 JUL 2019	E1900194-x0	-
-	-	-	-

C

B

A



ISO VIEW

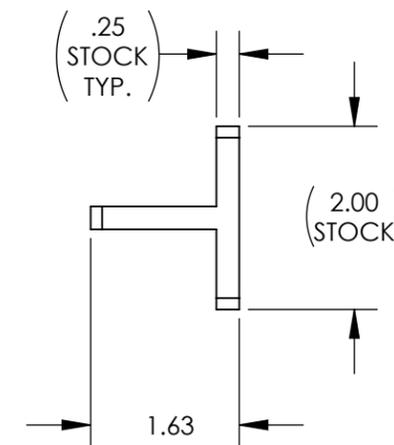
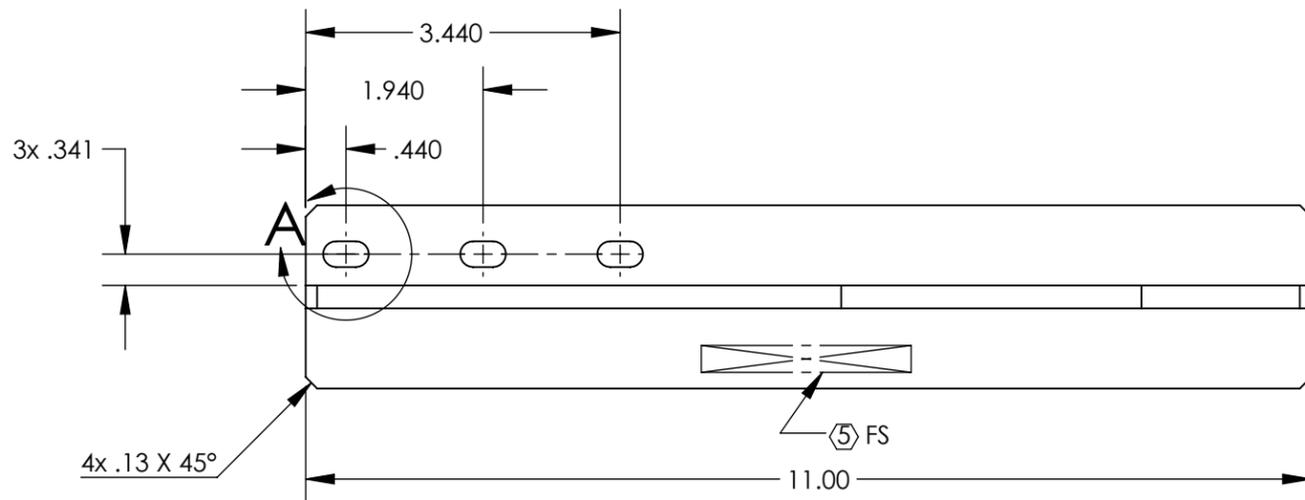
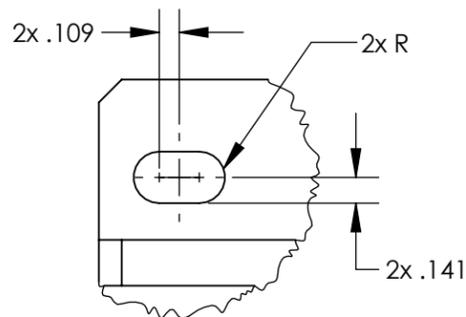
D

C

B

A

DETAIL A
SCALE 1 : 1
2 PL.
THRU



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± 0.5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS.
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 ⑩

FINISH ⑦ μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM SYS SUB-SYSTEM

NEXT ASSY D1900145

PART NAME
LIGO, NCAL, MT. PLATFORM ASSY., HEPI SUPPORT

DESIGNER E.SANCHEZ 17 MAY 2019
DRAFTER E.SANCHEZ 26 JUN 2019
CHECKER SEE DCC SEE DCC
APPROVAL SEE DCC SEE DCC

SIZE DWG. NO. B D1900246
SCALE: 1:2 PROJECTION: SHEET 1 OF 1

REV. v2