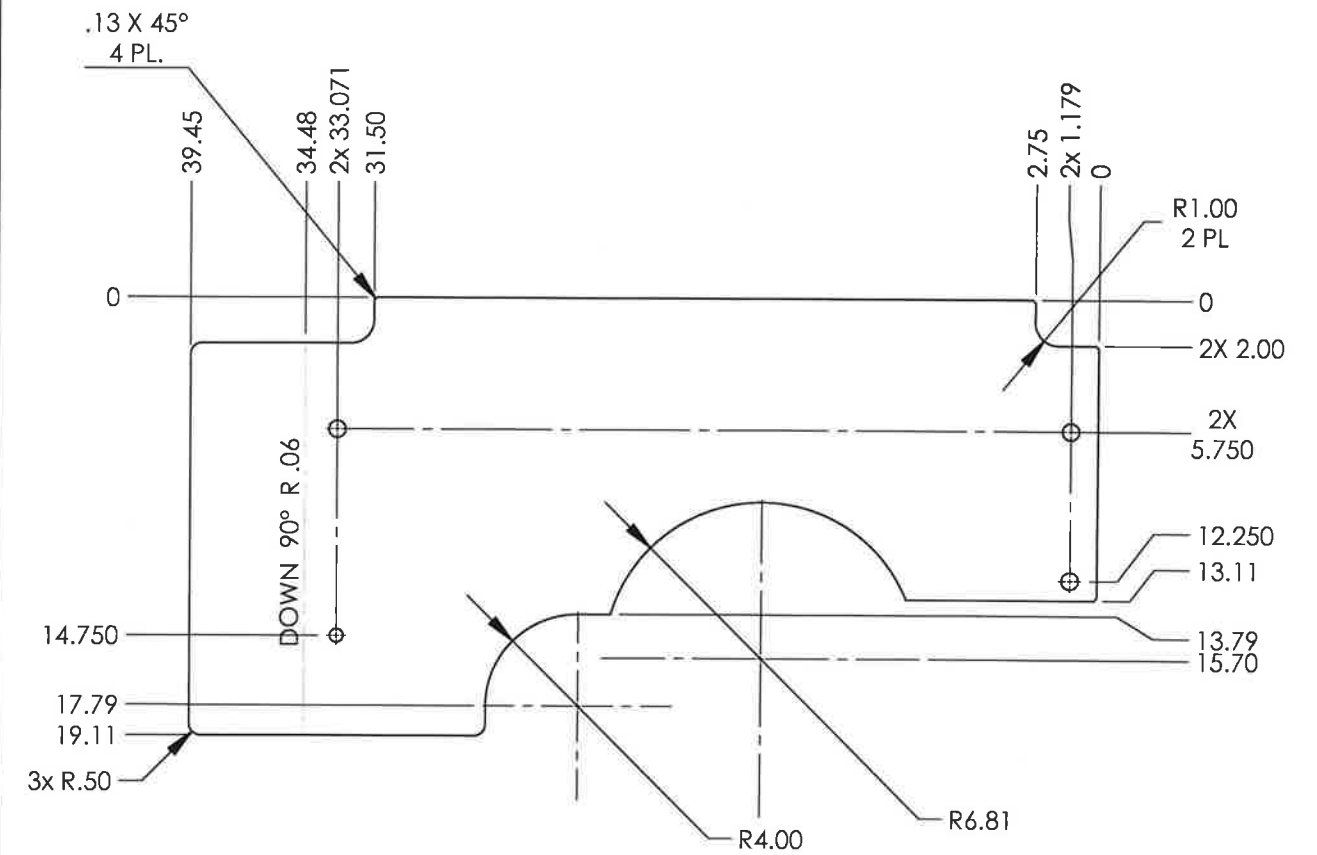
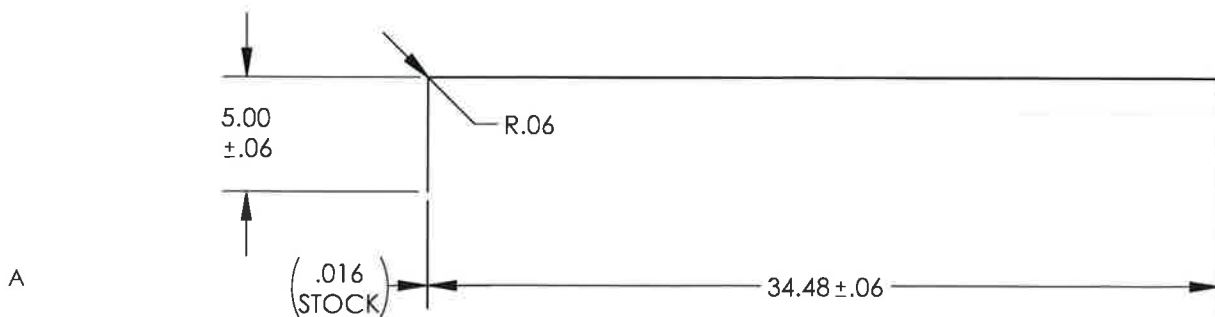
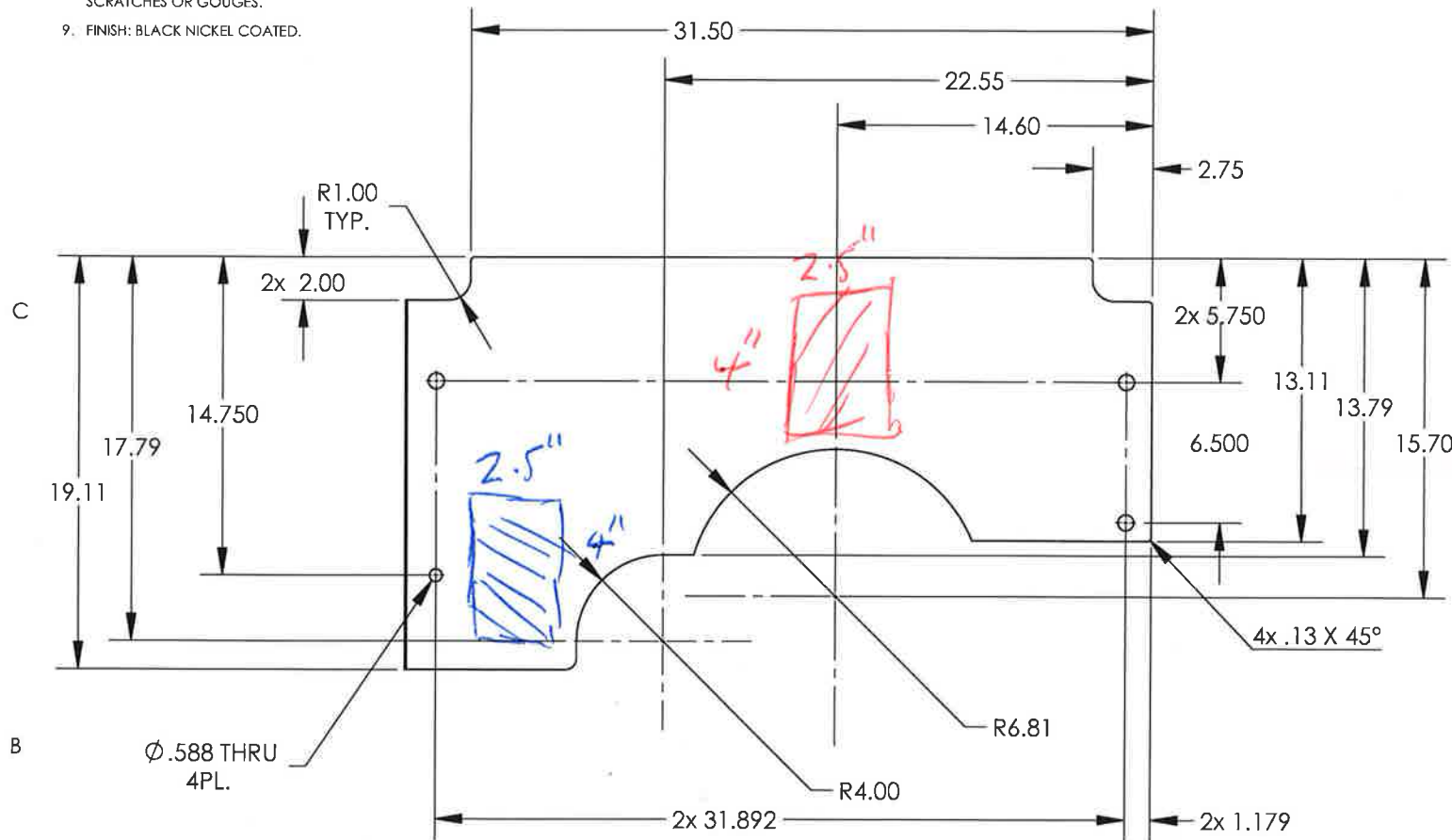


NOTES CONTINUED:

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

Sample 1
Sample 2

- 6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH REFER TO 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. LIGO SPECIFICATION E0900364
- 8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- 9. FINISH: BLACK NICKEL COATED.



FLAT STATE
(ALL DIMENSIONS SHOWN ONLY FOR REFERENCE)

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
TOLERANCES:
.XX ±.03
.XXX ±.010
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
FINISH AS NOTED μinch
NEXT ASSY

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY
aLIGO
D1900262

PART NAME aLIGO, SLIC, TMS SHROUD ASSY., ROOF PANEL
DESIGNER E.SANCHEZ 15 AUG 2019
DRAFTER E.SANCHEZ 27 AUG 2019
CHECKER SEE DCC
APPROVAL SEE DCC
SUB-SYSTEM AOS
SIZE DWG. NO. B D1900260
SCALE: 1:8
PROJECTION:
REV. v1
SHEET 1 OF 2

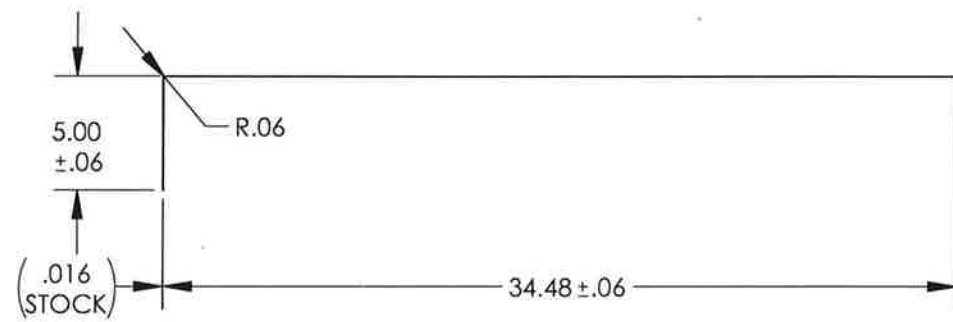
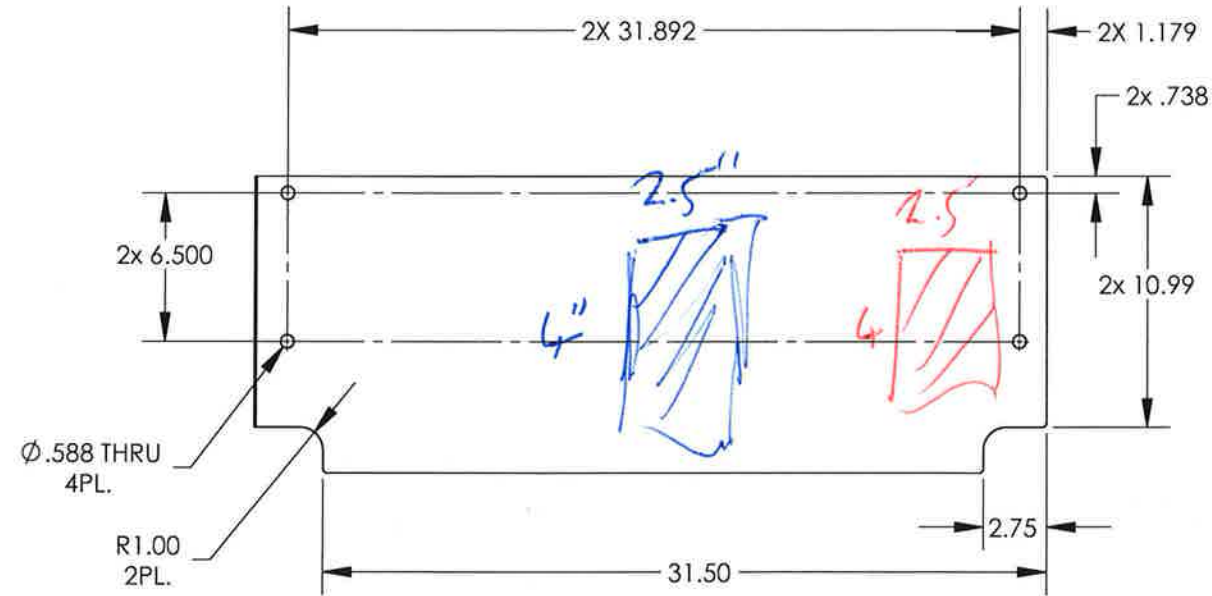
D1900260-02

D

C

B

A

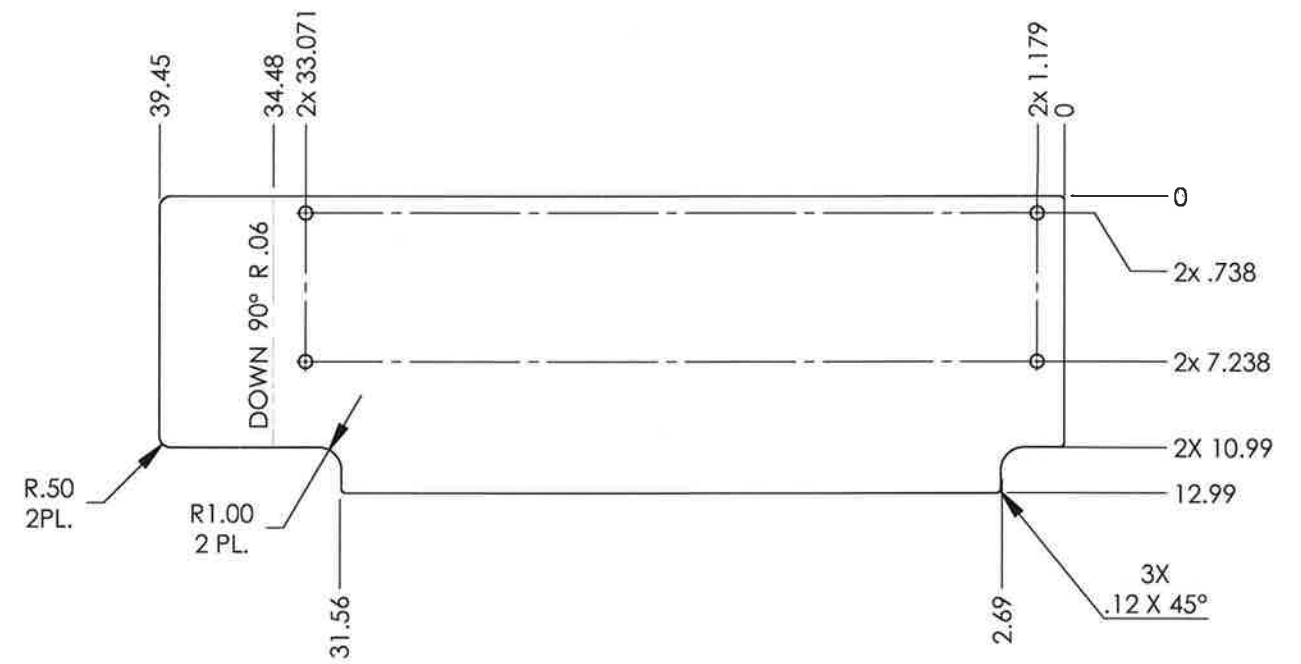


D

C

B

A



FLAT STATE
(ALL DIMENSIONS SHOWN ONLY FOR REFERENCE)

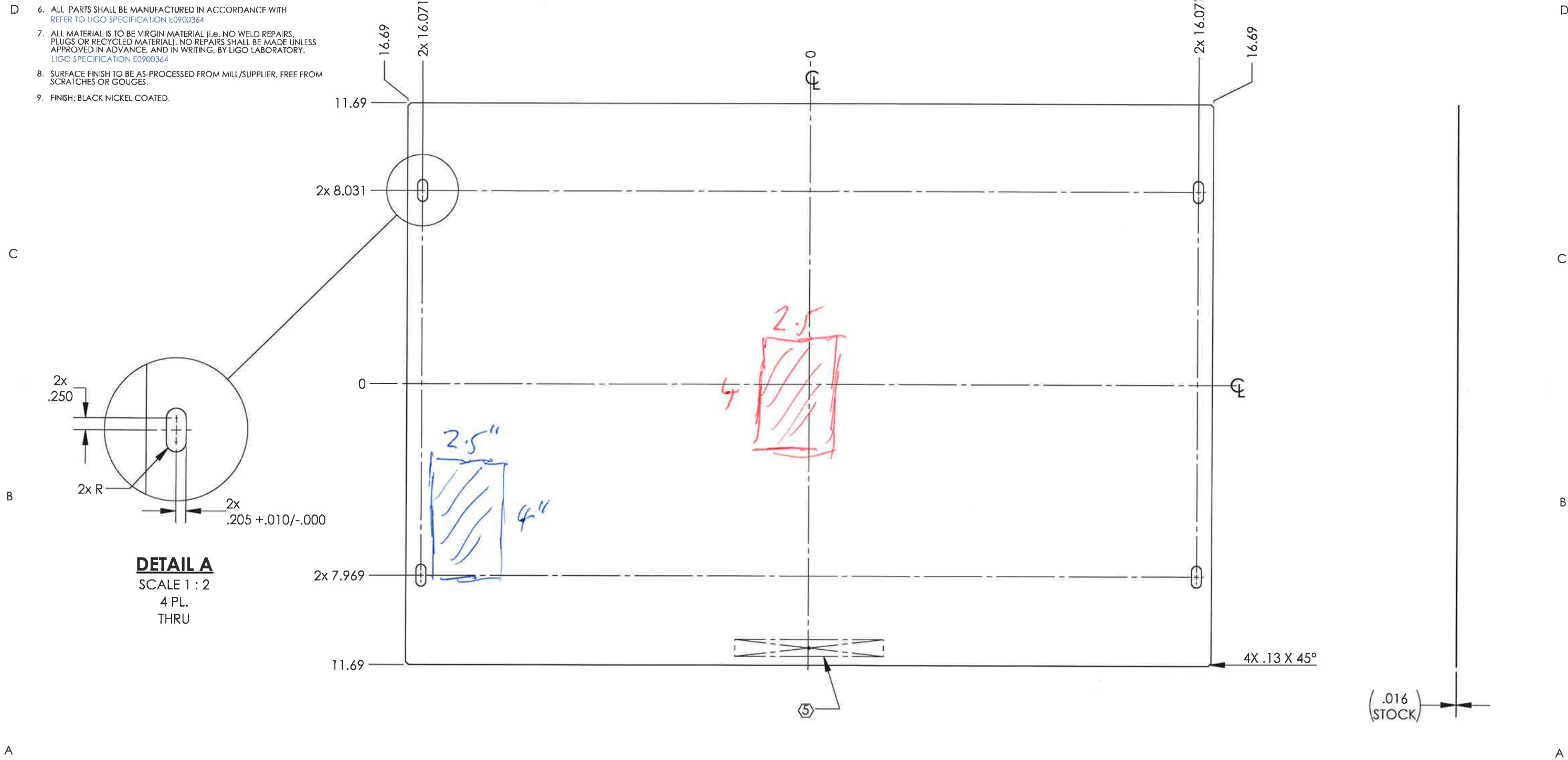
NOTES CONTINUED:

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

- D 6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH REFER TO 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. LIGO SPECIFICATION E0900364
- 8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- 9. FINISH: BLACK NICKEL COATED.

| REV. | DATE | DCN # | DRAWING TREE # |
|------|-------------|-------------|----------------|
| v1 | 27 AUG 2019 | E1900196-x0 | - |
| - | - | - | - |

Sample 1
Sample 2



DETAIL A
SCALE 1 : 2
4 PL.
THRU

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
TOLERANCES:
XX ±.03
.XXX ±.010
ANGULAR ± 0.5°

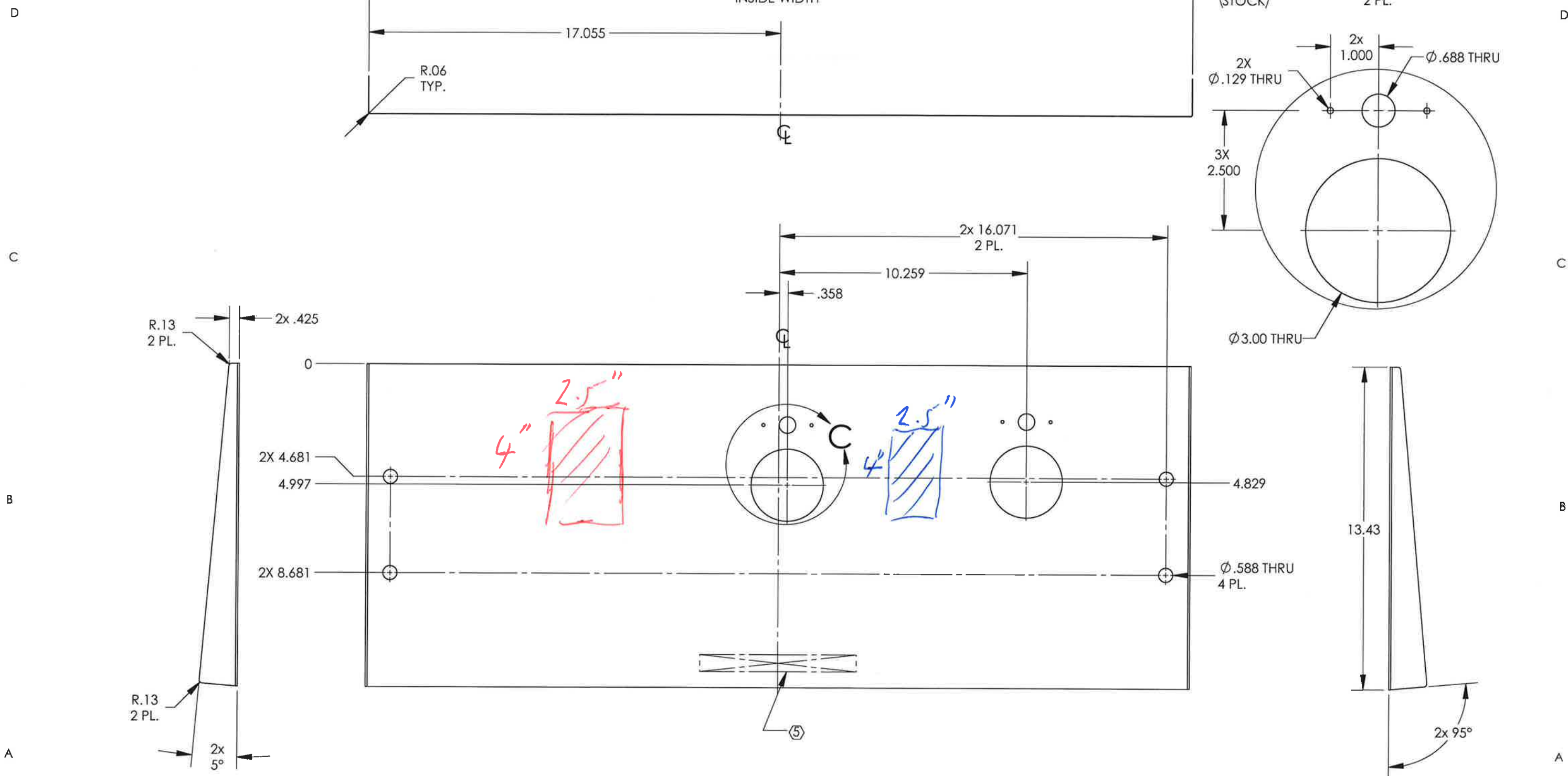
1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.
MATERIAL 6061-T6 Al
FINISH AS NOTED μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
SYSTEM aLIGO
SUB-SYSTEM AOS
NEXT ASSY D1900262

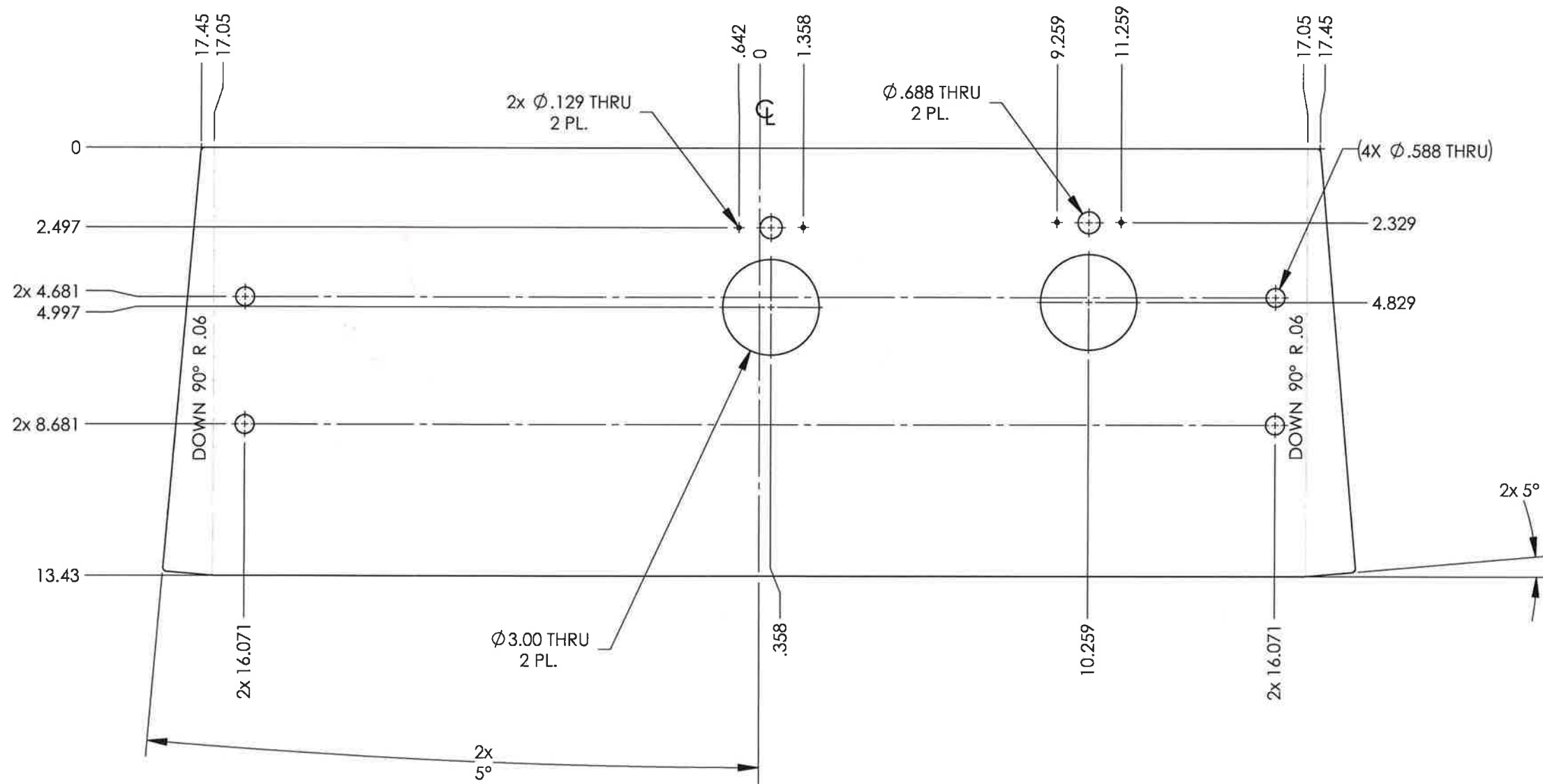
PART NAME aLIGO, SLIC, TMS SHROUD ASSY., SIDE PANEL
DESIGNER E.SANCHEZ 15 AUG 2019 SIZE DWG. NO. B D1900259
DRAFTER E.SANCHEZ 27 AUG 2019
CHECKER SEE DCC SEE DCC
APPROVAL SEE DCC SEE DCC SCALE: 1:4 PROJECTION: SHEET 1 OF 1

D1900391-02 DETAIL (USED ON Yarm)

Sample 1
Sample 2



D1900391-02 DETAIL (USED ON Yarm)



FLAT STATE
(ALL DIMENSIONS SHOWN ONLY FOR REFERENCE)

NOTES CONTINUED:

Ⓢ 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

- D 6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH REFER TO 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. LIGO SPECIFICATION E0900364
- 8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- 9. FINISH: BLACK NICKEL COATED.

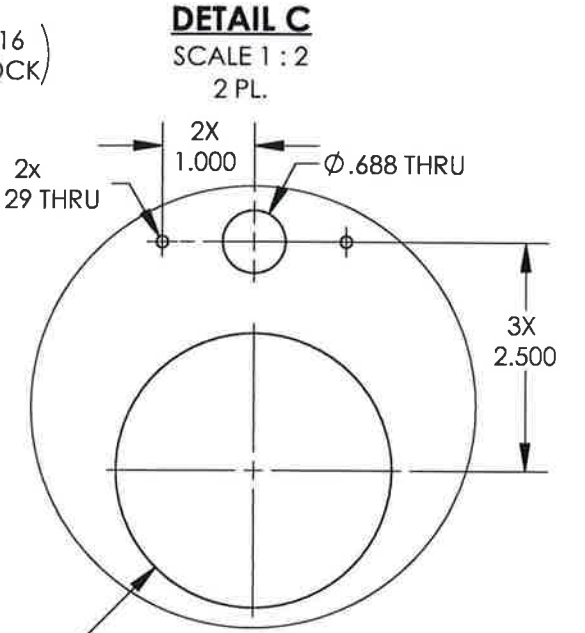
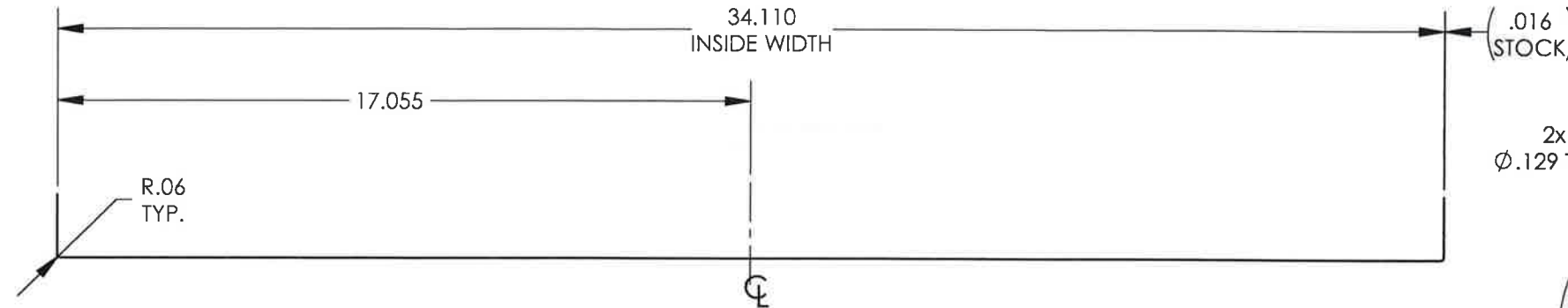
Sample 1
Sample 2

D1900391-01 DETAIL (USED ON Xarm)

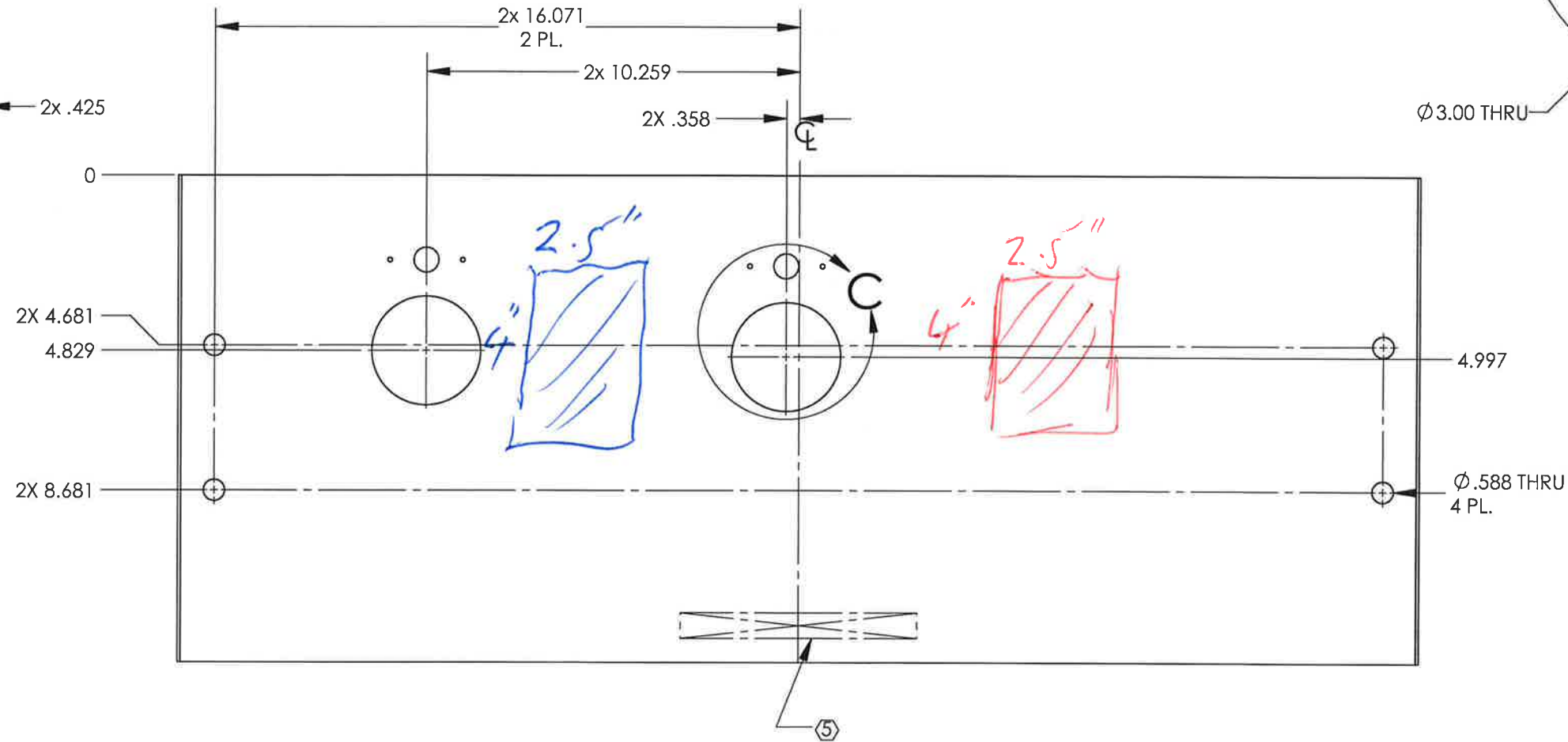
REV. DATE
v1 28 AUG 2019
v2 03 SEP 2019

DCN #
E1900196-x0

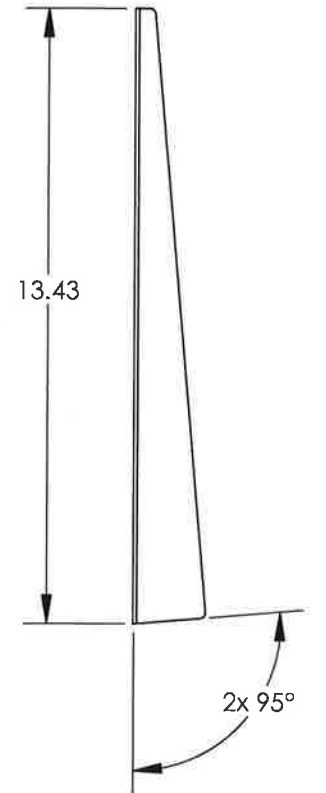
DRAWING TREE #
-



C



Handwritten notes: 2.5" (blue), 4" (blue), 2.5" (red), 4" (red)



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
TOLERANCES:
.XX ± .03
.XXX ± .010
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

FINISH AS NOTED μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY
aLIGO D1900262

PART NAME aLIGO, SLIC, TMS SHROUD ASSY., ALS PANEL
DESIGNER E.SANCHEZ 15 AUG 2019
DRAFTER E.SANCHEZ 27 AUG 2019
CHECKER SEE DCC
APPROVAL SEE DCC
SIZE DWG. NO. B D1900391
SCALE: 1:4 PROJECTION: 1

REV. v2

8

7

6

5

4

3

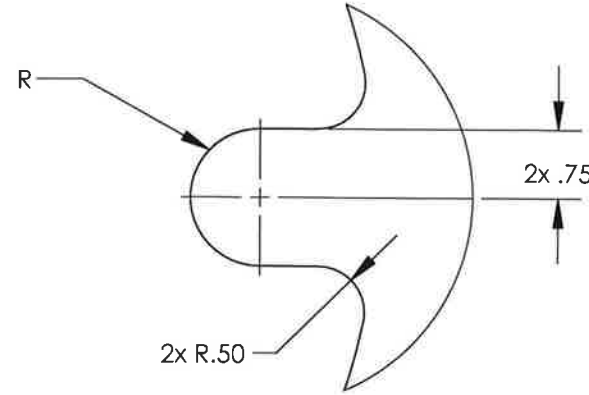
2

1

NOTES CONTINUED:

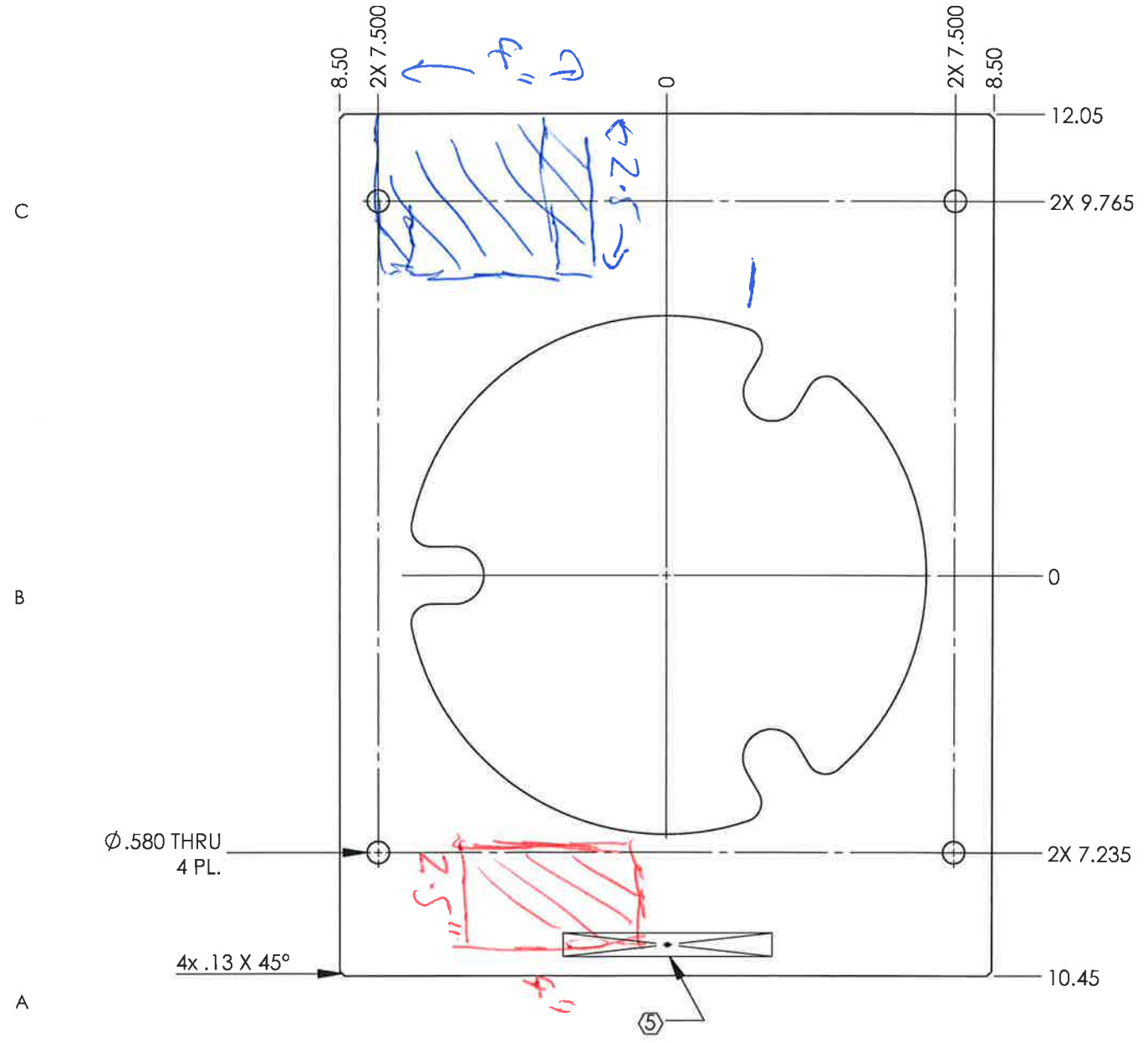
⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-VV, TYPE-XX, S/N XXX

Sample 1
Sample 2



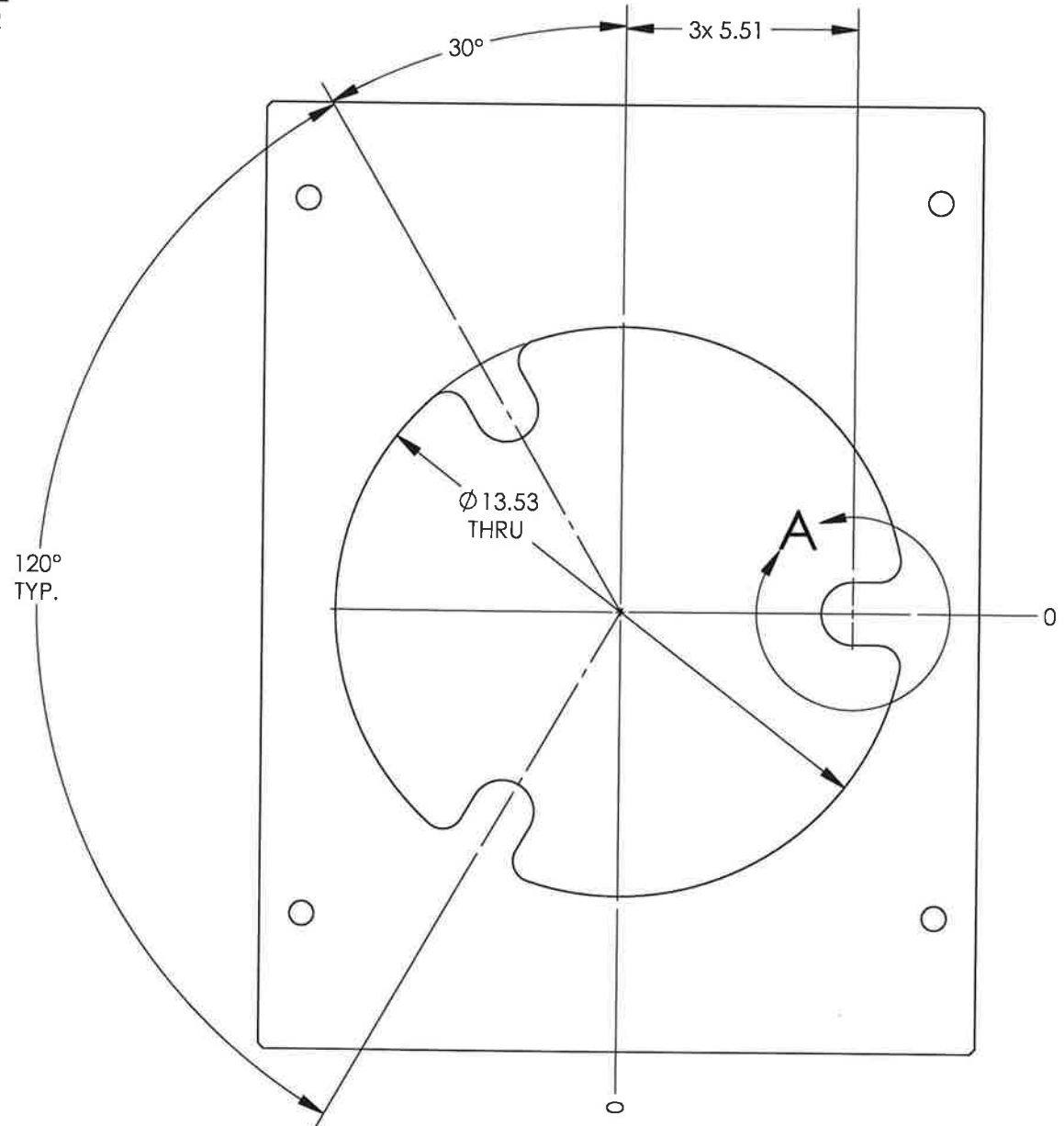
| REV. | DATE | DCN # | DRAWING TREE # |
|------|-------------|-------------|----------------|
| v1 | 27 AUG 2019 | E1900196-x0 | - |
| - | - | - | - |
| - | - | - | - |

- 6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH REFER TO 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. LIGO SPECIFICATION E0900364
- 8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- 9. FINISH: BLACK NICKEL COATED.



DETAIL A
SCALE 1 : 2
3 PL.

(.016 STOCK)



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
TOLERANCES:
.XX ±.03
.XXX ±.010
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
FINISH AS NOTED μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY
SUB-SYSTEM AOS
NEXT ASSY D1900262

PART NAME aLIGO, SLIC, TMS SHROUD ASSY., FRONT PANEL
DESIGNER E.SANCHEZ 15 AUG 2019
DRAFTER E.SANCHEZ 27 AUG 2019
CHECKER SEE DCC
APPROVAL SEE DCC
SIZE DWG. NO. B D1900257
SCALE: 1:4 PROJECTION: SHEET 1 OF 1

8

7

6

5

4

3

2

1

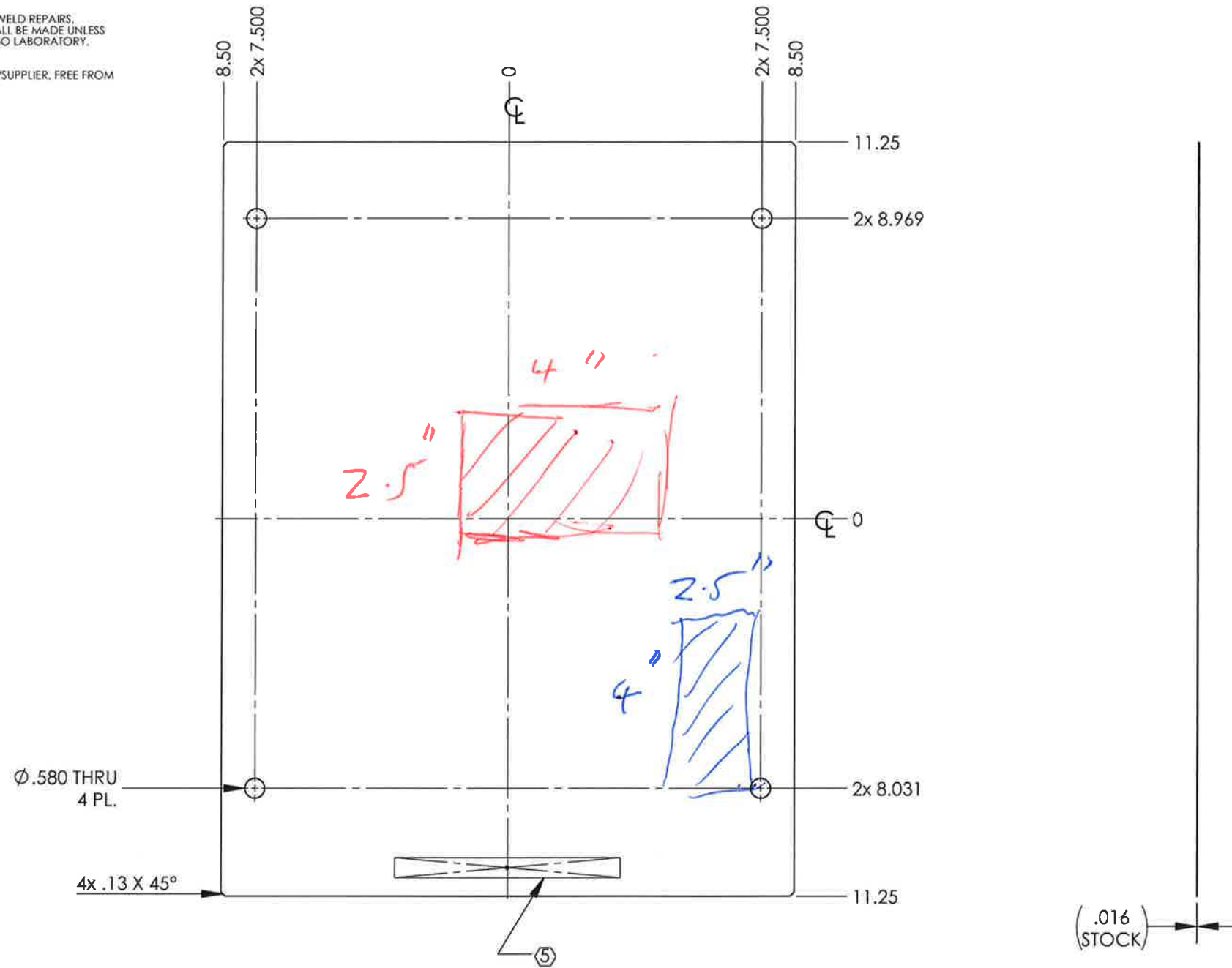
NOTES CONTINUED:

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

- D 6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH REFER TO 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. LIGO SPECIFICATION E0900364
- 8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- 9. FINISH: BLACK NICKEL COATED.

Sample 1
Sample 2

| REV. | DATE | DCN # | DRAWING TREE # |
|------|-------------|-------------|----------------|
| v1 | 27 AUG 2019 | E1900196-x0 | - |
| - | - | - | - |
| - | - | - | - |



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES:

TOLERANCES:
.XX ± .03
.XXX ± .010

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

FINISH
AS NOTED μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
SYSTEM
aLIGO
D1900262

SUB-SYSTEM
AOS

PART NAME
aLIGO, SLIC, TMS SHROUD ASSY., REAR PANEL
DESIGNER E.SANCHEZ 15 AUG 2019 SIZE DWG. NO. D190058
DRAFTER E.SANCHEZ 27 AUG 2019 B
CHECKER SEE DCC: SEE DCC
APPROVAL SEE DCC: SEE DCC SCALE: 1:4 PROJECTION: SHEET 1 OF 1

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

- D 6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH REFER TO 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. LIGO SPECIFICATION E0900364
- 8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- 9. FINISH: BLACK NICKEL COATED.

Handwritten: Sample 1
Sample 2

2x .205+.010/-0.000

2x .25

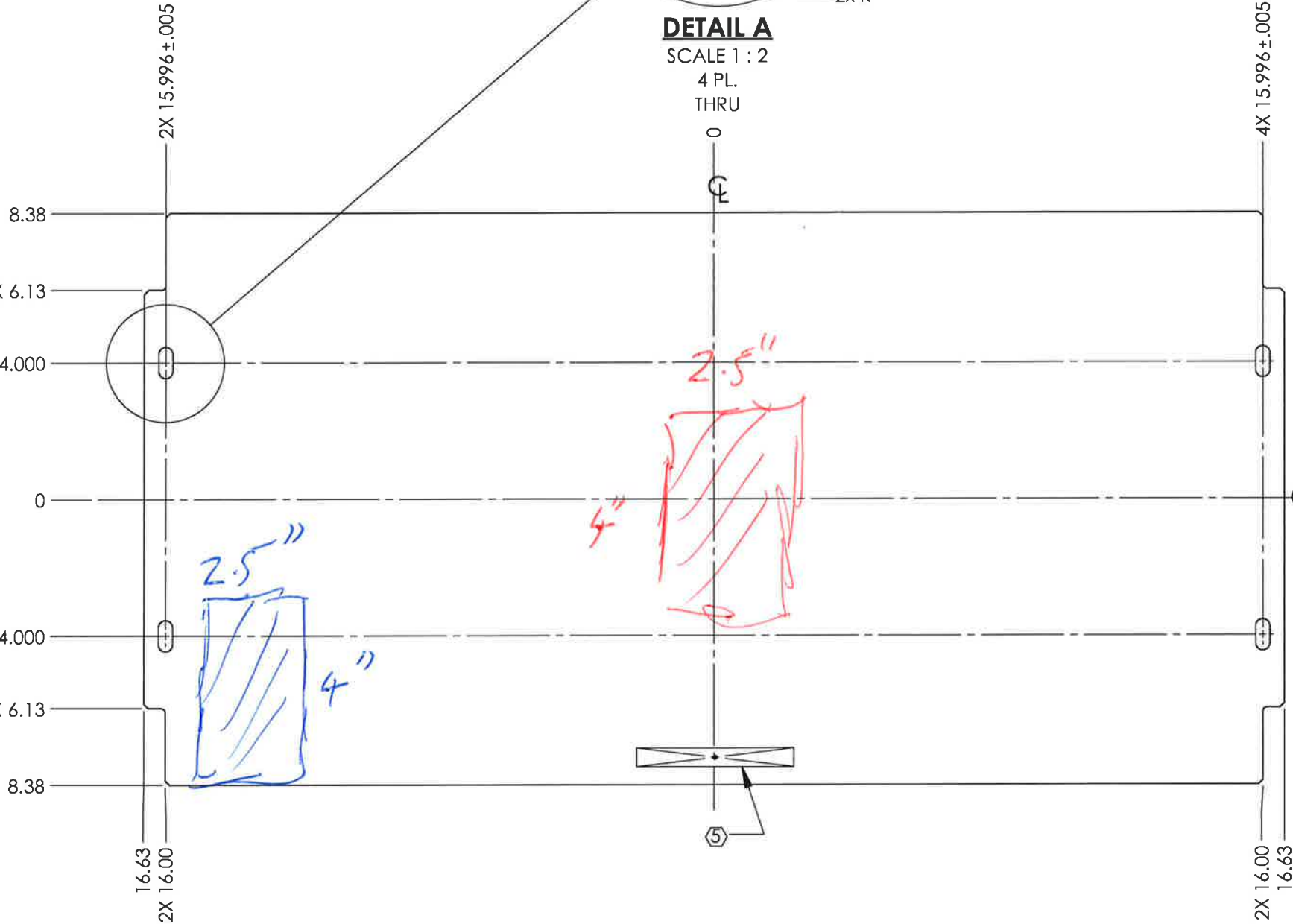
2x R

DETAIL A

SCALE 1 : 2

4 PL.
THRU

C



(.016)
(STOCK)

B

A

C

B

A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .03
.XXX ± .010

ANGULAR ± 0.5°

MATERIAL
6061-T6 Al

FINISH
AS NOTED μinch

SYSTEM

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

aLIGO
D1900262

SUB-SYSTEM
AOS

PART NAME
aLIGO, SLIC, TMS SHROUD ASSY., BOTTOM PANEL

DESIGNER E.SANCHEZ 15 AUG 2019 SIZE DWG. NO. D1900261 REV. v1
DRAFTER E.SANCHEZ 27 AUG 2019
CHECKER SEE DCC SEE DCC
APPROVAL SEE DCC SEE DCC SCALE: 1:4 PROJECTION: SHEET 1 OF 1

8

7

6

5

4

3

2

1

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

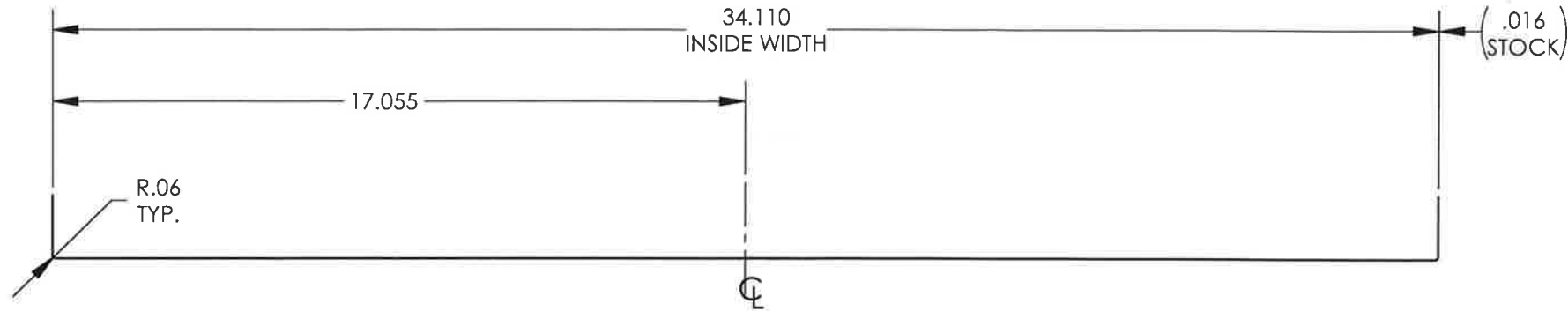
Sample 1
Sample 2

REV. v1 DATE 27 AUG 2019

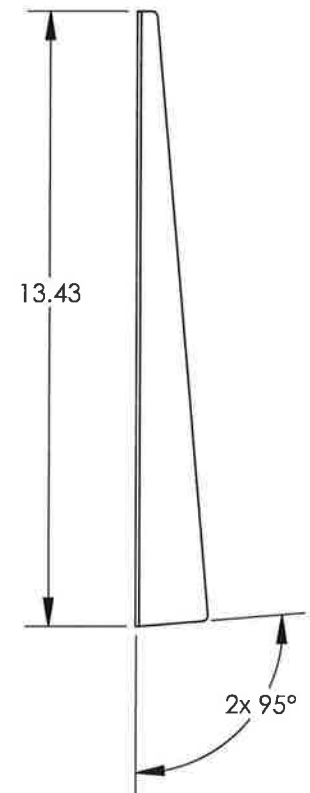
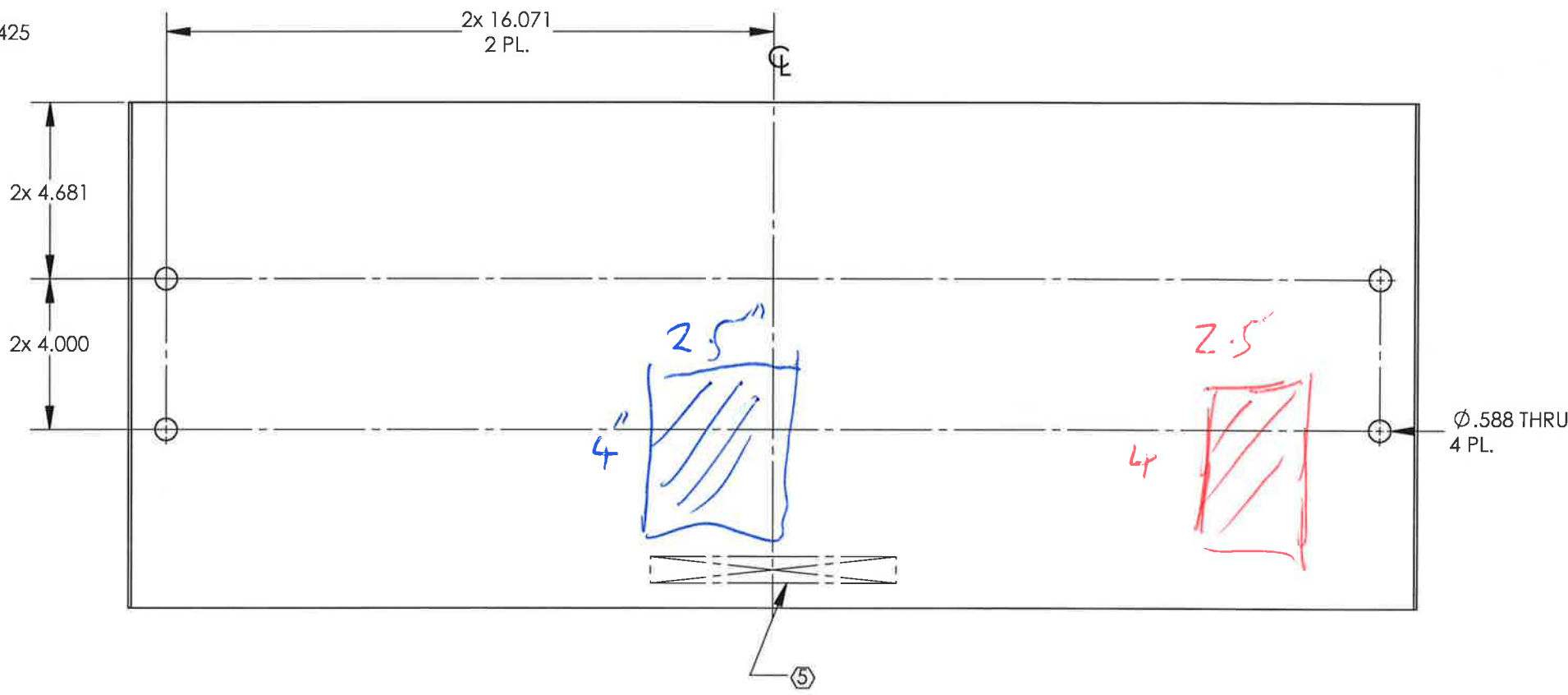
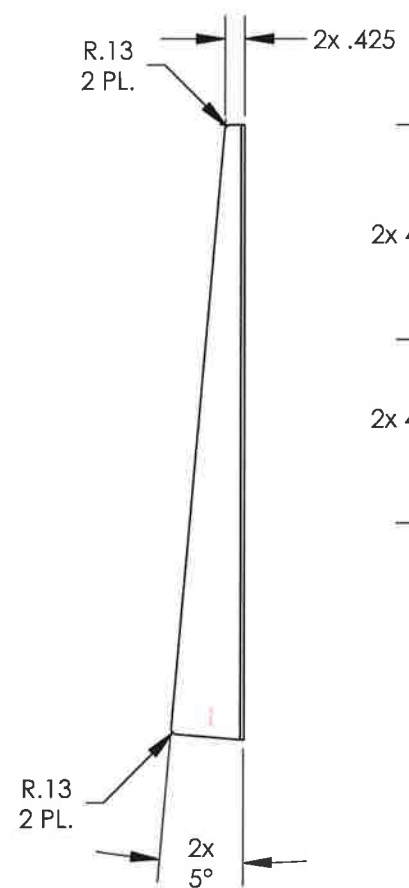
DCN # E1900196-x0

DRAWING TREE #

- 6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH REFER TO 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. LIGO SPECIFICATION E0900364
- 8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- 9. FINISH: BLACK NICKEL COATED.



C



B

A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
TOLERANCES:
.XX ± .03
.XXX ± .010
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
FINISH AS NOTED μinch
NEXT ASSY D1900262

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY
aLIGO
SYSTEM AOS
SUB-SYSTEM AOS

PART NAME aLIGO, SLIC, TMS SHROUD ASSY., SIDE PANEL (UPPER)
DESIGNER E.SANCHEZ 15 AUG 2019
DRAFTER E.SANCHEZ 27 AUG 2019
CHECKER SEE DCC
APPROVAL SEE DCC
SIZE DWG. NO. B D1900390
SCALE: 1:4
PROJECTION:
REV. v1
SHEET 1 OF 2

8

7

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5

4

3

2

1

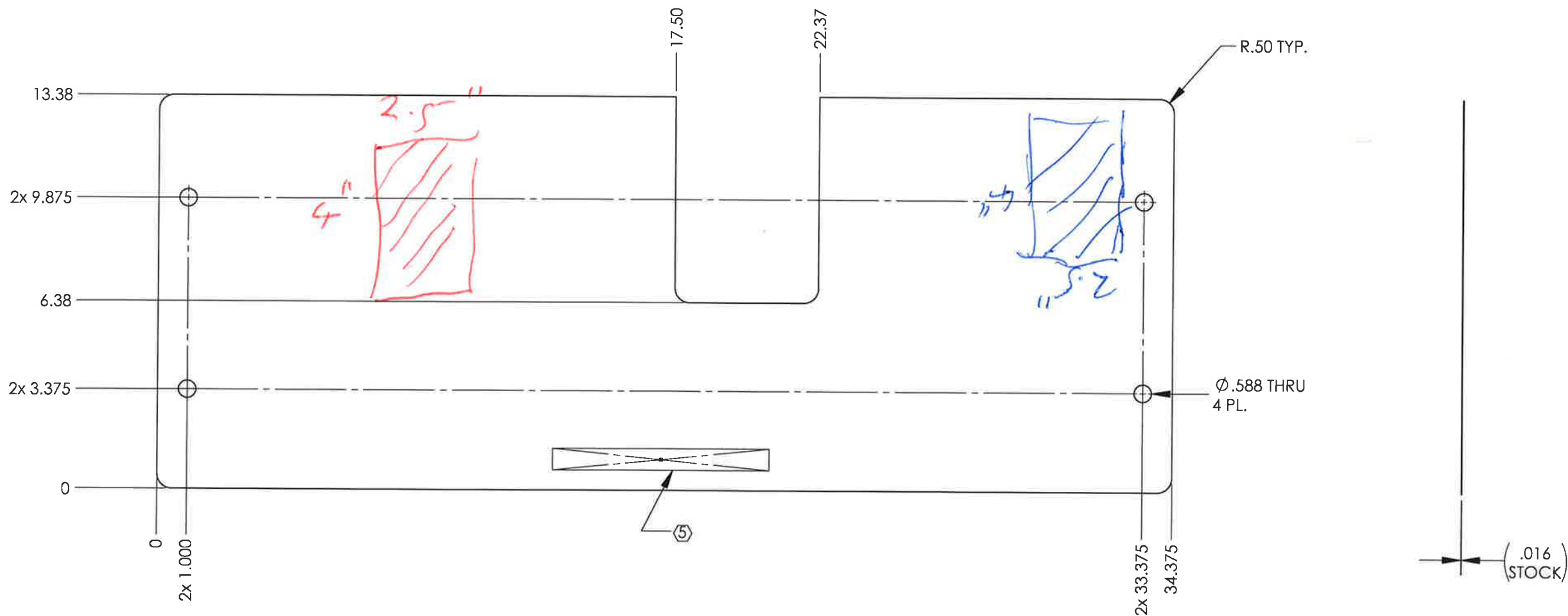
NOTES CONTINUED:

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

Sample 1
Sample 2

| REV. | DATE | DCN # | DRAWING TREE # |
|------|-------------|-------------|----------------|
| v1 | 27 AUG 2019 | E1900196-x0 | - |
| - | - | - | - |
| - | - | - | - |

- 6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH REFER TO 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. LIGO SPECIFICATION E0900364
- 8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- 9. FINISH: BLACK NICKEL COATED.



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
TOLERANCES:
.XX ± .03
.XXX ± .010
ANGULAR ± 0.5°

MATERIAL 6061-T6 Al
FINISH AS NOTED μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY
aLIGO
D1900262

PART NAME aLIGO, SLIC, TMS SHROUD, FRONT PANEL
DESIGNER E.SANCHEZ 15 AUG 2019
DRAFTER E.SANCHEZ 27 AUG 2019
CHECKER SEE DCC
APPROVAL SEE DCC
SUB-SYSTEM AOS
SIZE DWG. NO. B D1900389
SCALE: 1:4 PROJECTION:

REV. v1
SHEET 1 OF 1

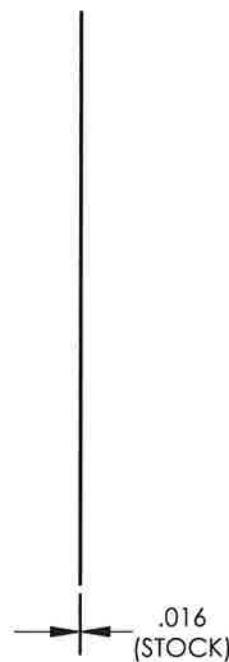
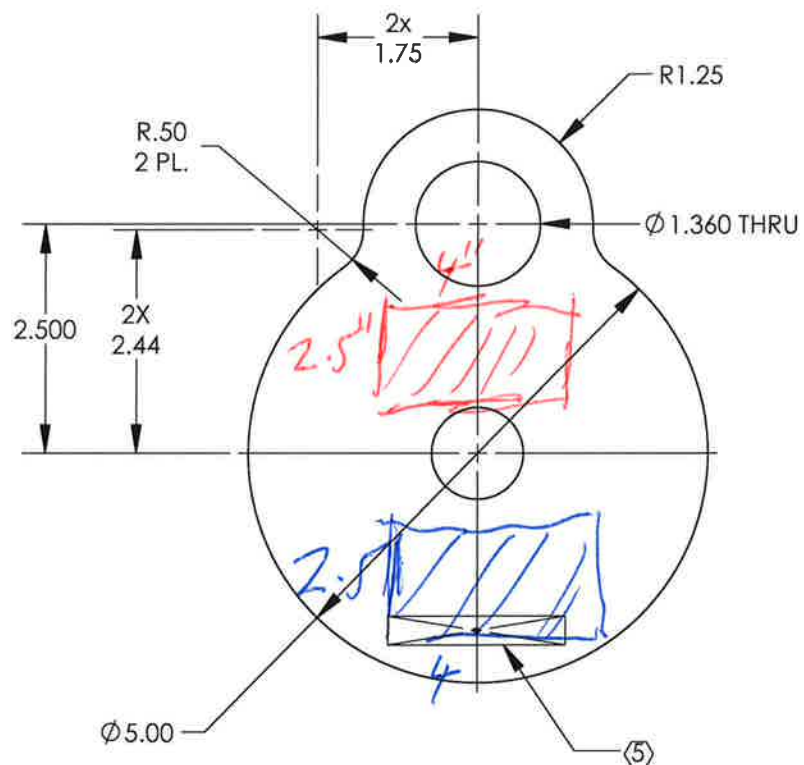
NOTES CONTINUED:

⊕ 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

- D 6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH REFER TO 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. LIGO SPECIFICATION E0900364
- 8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- 9. FINISH: BLACK NICKEL COATED.

Sample 1
Sample 2

| REV. | DATE | DCN # | DRAWING TREE # |
|------|-------------|-------------|----------------|
| v1 | 28 AUG 2019 | E1900196-x0 | - |
| - | - | - | - |
| - | - | - | - |



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .03
 .XXX ± .010

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

FINISH AS NOTED μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM aLIGO NEXT ASSY D1900262

PART NAME aLIGO, SLIC, TMS SHROUD ASSY., ALS WINDOW COVER

DESIGNER E.SANCHEZ 15 AUG 2019 SIZE DWG. NO. B D1900392 REV. v1
 DRAFTER E.SANCHEZ 27 AUG 2019
 CHECKER SEE DCC SEE DCC
 APPROVAL SEE DCC SEE DCC SCALE: 1:2 PROJECTION: SHEET 1 OF 1