

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. REFER TO LIGO E0900364

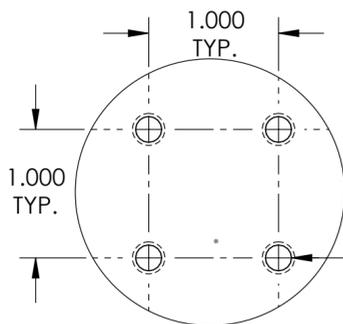
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364

8. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4

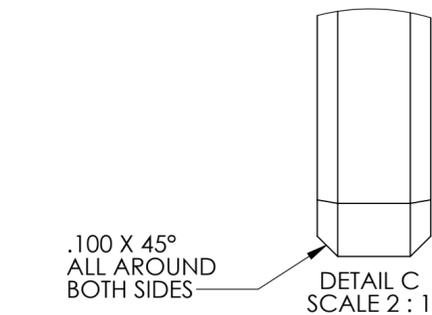
9. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.

10. 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

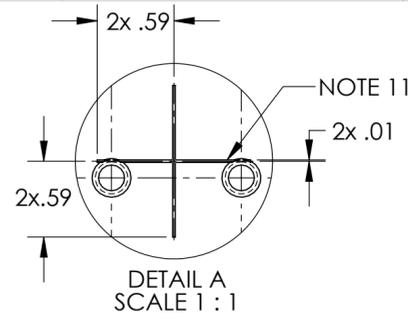
11. YAG LASER ETCH PART WITH ALIGNMENT TARGETS AS SHOWN. MARKING SHALL BE ENGRAVED TO MINIMAL DEPTH, AND WIDTH SHALL NOT EXCEED .010" MAX. MARKING SHALL BE LEGIBLE UNDER CONDITIONS OF NORMAL VISION IN DAYLIGHT.



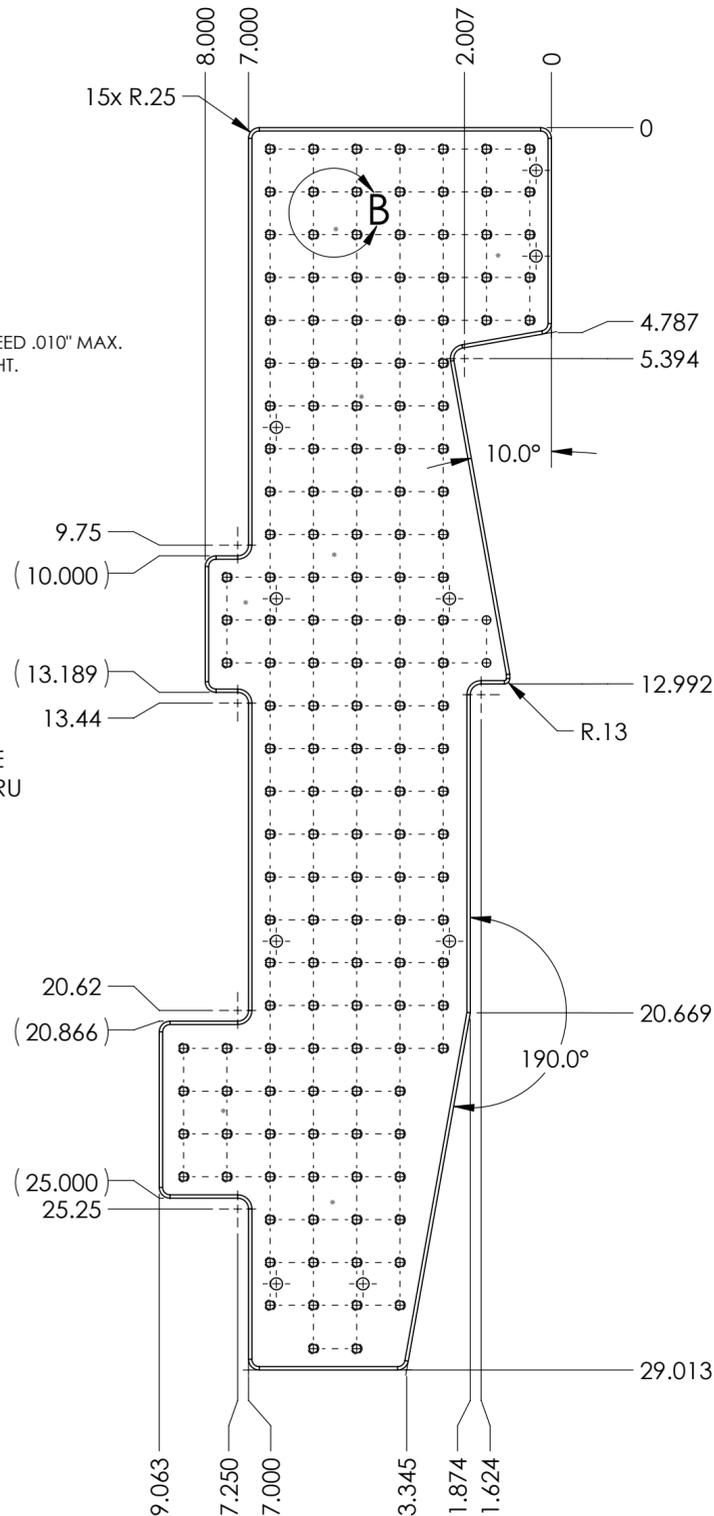
DETAIL B  
SCALE 1 : 1



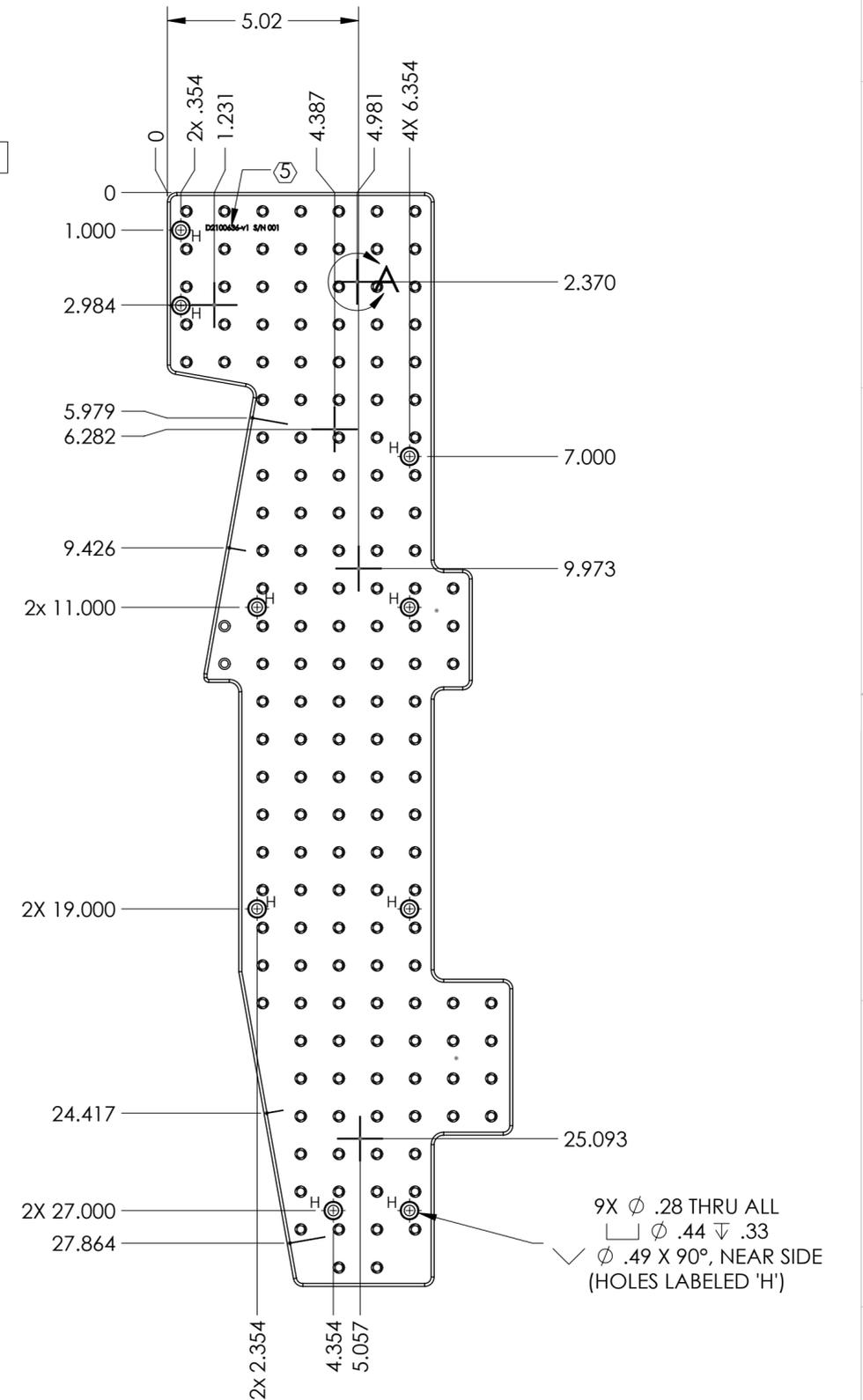
DETAIL C  
SCALE 2 : 1



DETAIL A  
SCALE 1 : 1



REV.	DATE	DCN #	DRAWING TREE #
v1	12 JAN 2025	E2500006-x0	



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES [MM]

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

FINISH

63 μinch

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM

A+

SUB-SYSTEM

SUS

NEXT ASSY

D2100567

PART NAME

HAM6-H1 AS WFS (WFS45) SLED

DESIGNER

R.JONES JUNE 2024

DRAFTER

A.LOPEZ 12 JAN 2025

CHECKER

SEE DCC SEE DCC

APPROVAL

SEE DCC SEE DCC

SIZE

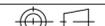
c

DWG. NO.

D2100636

SCALE: 1:4

PROJECTION:



SHEET 1 OF 1

REV.

v1