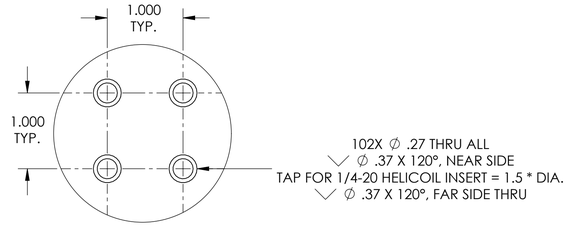
REV.	DATE	DCN #	DRAWING TREE #
v1	14 JAN 2025	E2500006-x0	

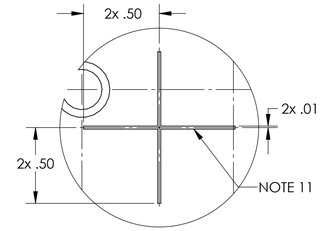
NOTES CONTINUED:

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: DXXXXXXX-VY, TYPE-XX, S/N XXX

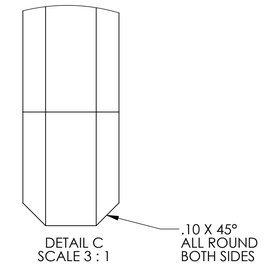
6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
   REFER TO LIGO SPECIFICATION E0900364
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH
   LIGO SPECIFICATION E0900364
8. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL 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 SPECIFICATION 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.



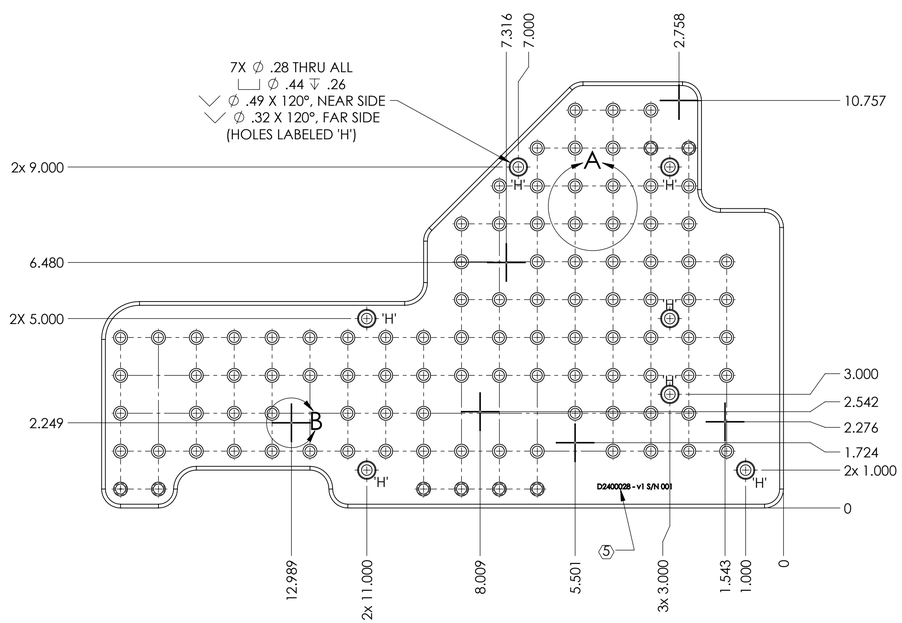
DETAIL A
SCALE 1 : 1

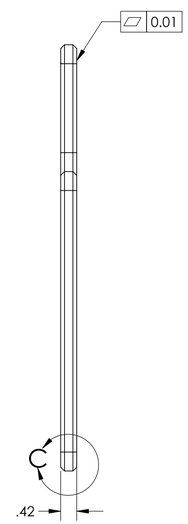


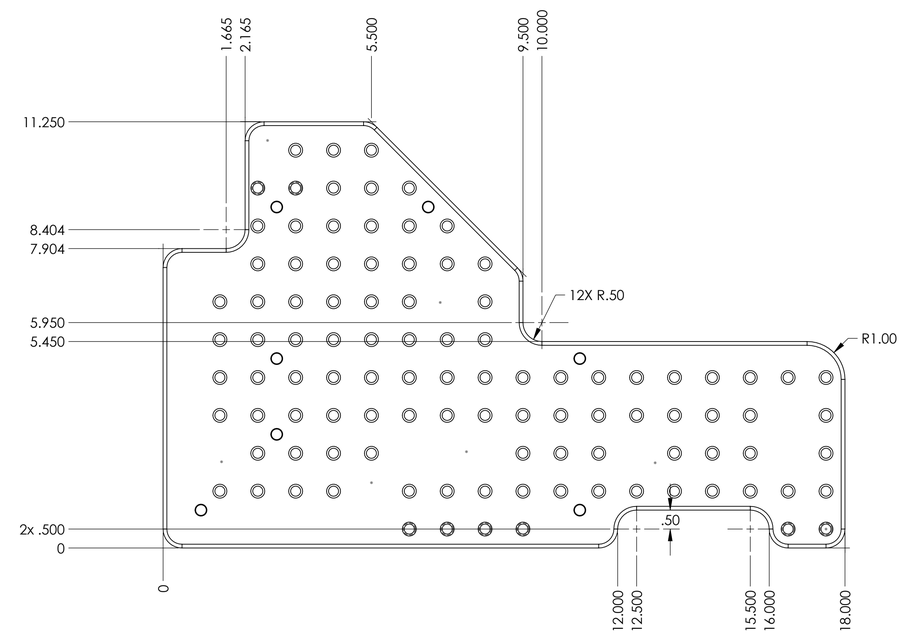
DETAIL B
SCALE 2 : 1



DETAIL C
SCALE 3 : 1







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. ROUND ALL EDGES APPROXIMATLEY R.02 FOR SHEET METAL 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: D2100594

PART NAME: HAM6-H1 LOPO SLED Baseplate

DESIGNER	R.JONES	JUNE 2024	SIZE: D	DWG. NO.: D2400028
DRAFTER	A.LOPEZ	14 JAN 2025		REV.: v1
CHECKER	SEE DCC	SEE DCC		
APPROVAL	SEE DCC	SEE DCC	SCALE: 1:2	PROJECTION:

SHEET 1 OF 1

PART PDM VERSION: y-011
DWG PDM VERSION: y-006
D2400028 A+ SUS HAM6-H1 LOPO SLED Baseplate