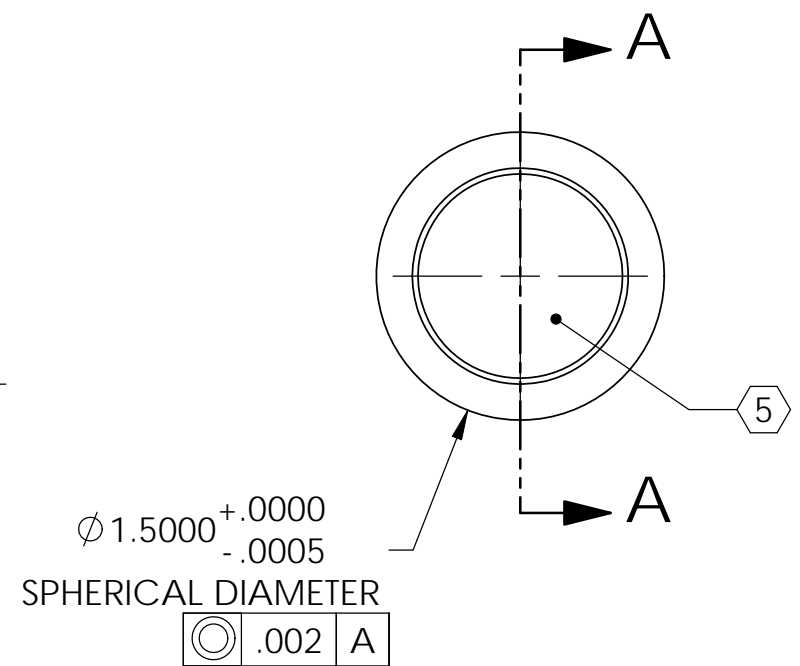
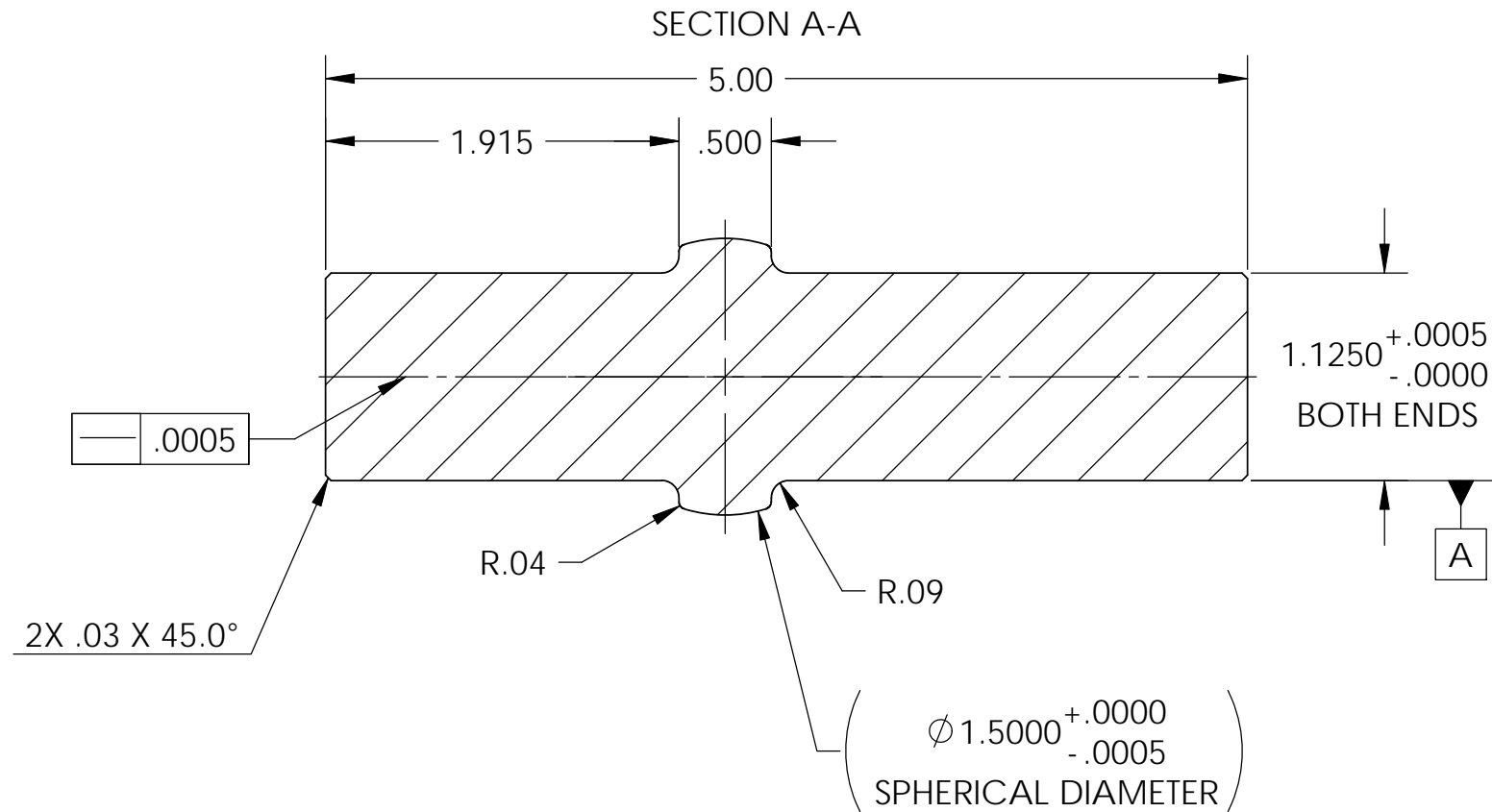


NOTES CONTINUED:
 (5) SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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 = 1.6 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.
 9. HEAT TREAT TO RC57 PER AMS-H-6875A.

REV.	DATE	DCN #	DRAWING TREE #
v1	19 Jul. 2007		
v2	09 Apr. 2009		
v3	01 Mar. 2010	E1000115	E1000025



D047935_Locker_Spherical_Pin, PART PDM REV: V2-001, DRAWING PDM REV: X-004

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM ADVANCED LIGO		SUB-SYSTEM SEI		DESIGNER ASI		LOCKER SPHERICAL PIN	
TOLERANCES: .XX ± .015 .XXX ± .005		MATERIAL AISI 440C PER AMS 5630		FINISH 16 μinch		NEXT ASSY D1000854, D1000855		DRAPER M.HILLARD		DATE 19 Jul. 2007	
ANGULAR ± .5°						CHECKER F.MATICHARD		DWG. NO. D047935		REV. v3	
						APPROVAL K.MASON		SCALE: 1:1		PROJECTION:	
								SHEET 1 OF 1			