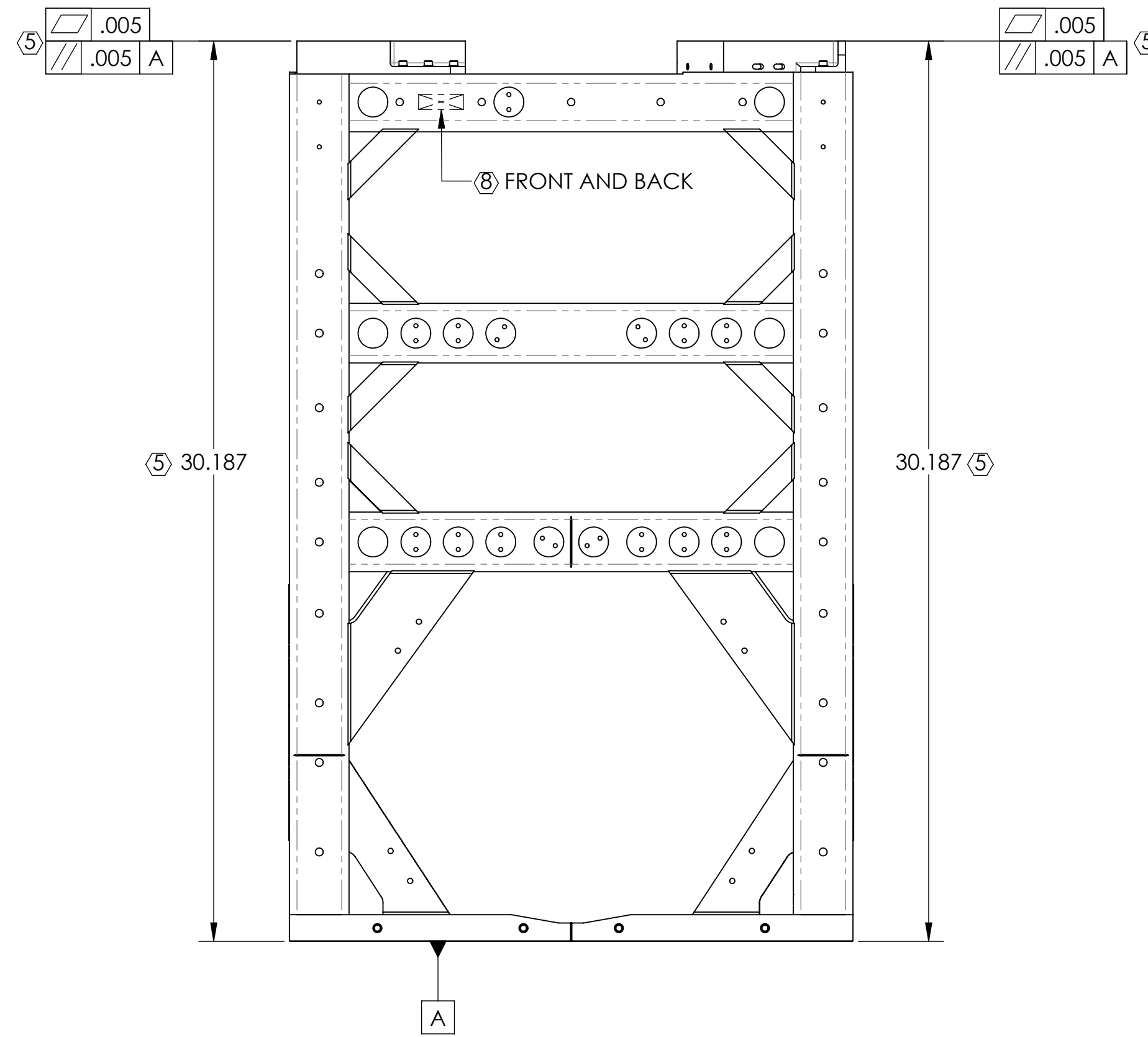
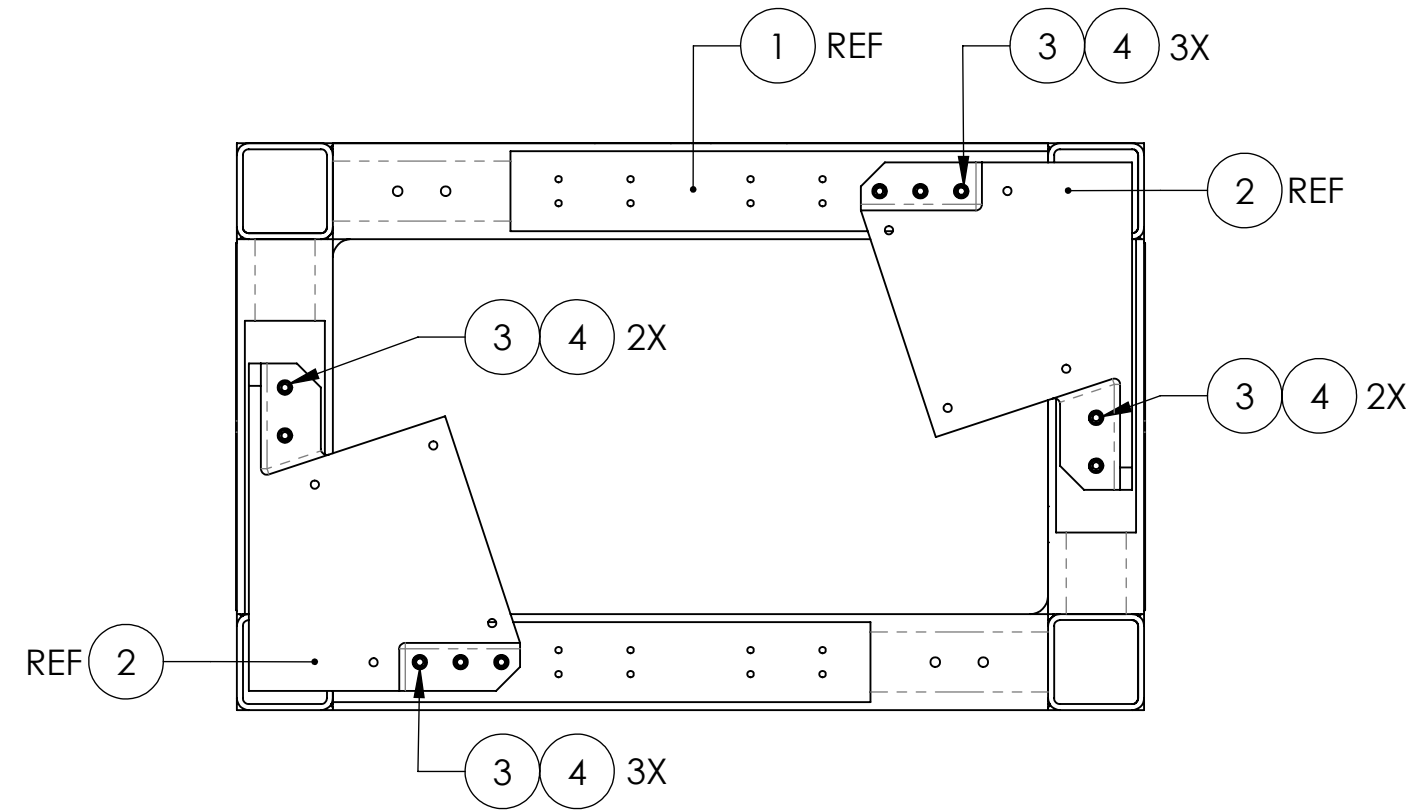
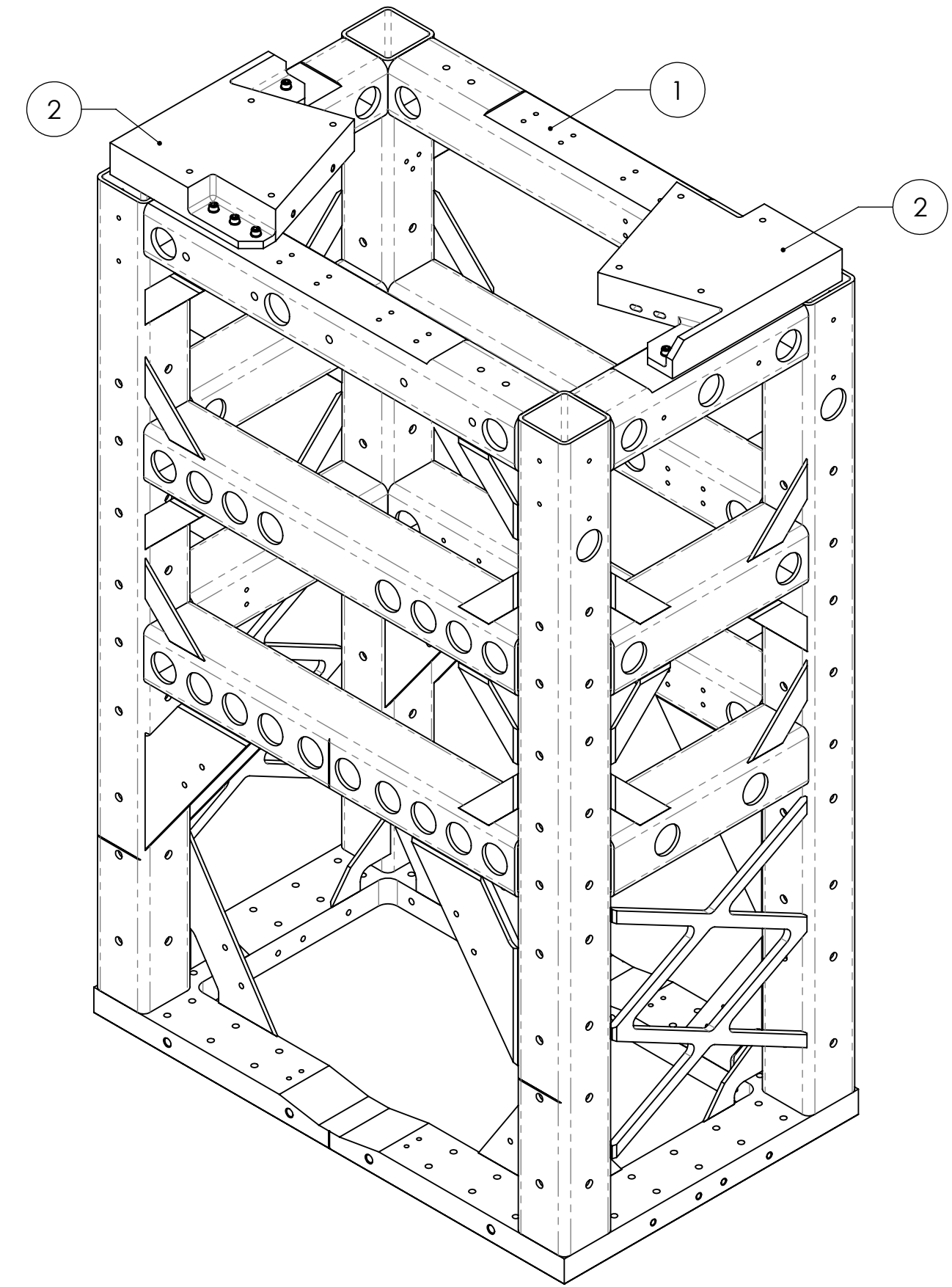


- NOTES CONTINUED:**
- ⑤ FLY CUT INDICATED SURFACES TO ACHIEVE DESIRED DIMENSIONS, PARALLELISM AND FLATNESS.
 - 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 - 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - ⑧ SCRIBE OR ENGRAVE (NO INKS OR DYES) SERIAL NUMBER OF CORRESPONDING MOUNTING PAD BODY (D070374) ON STRUCTURAL WELDMENT (D070442) AFTER MACHINING.



FLY CUTTING LAYOUT

REV.	DATE	DCN #	DRAWING TREE #
v1	03 MAR 2009	E0900066	E080191
v2	29 AUG 2010	E1000371	E080191
-	-	-	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
4	-	WASHER, FLAT, VENTED, #8 (U-C COMPONENTS P/N WFV-08 OR EQUIVALENT)	300 SSTL	10	2	12
3	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 0.5 LONG	Ag-PLATED 300 SSTL	10	2	12
2	D070374	MOUNTING PAD BODY	6061-T6 Al	2	0	0
1	D070442	STRUCTURAL WELDMENT, HLTS	-	1	0	0

PARTS LIST

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, 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.

MATERIAL	N/A	FINISH	63 μinch
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SYSTEM	ADVANCED LIGO	SUB-SYSTEM	SUS
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NEXT ASSY
HLTS OVERALL ASSY

PART NAME

STRUCTURE, HLTS

DESIGNER	D. BRIDGES	27 AUG 2010	SIZE	DWG. NO.	REV.
DRAFTER	D. BRIDGES	29 AUG 2010	c	D070537	v2
CHECKER	M. MEYER	31 AUG 2010	SCALE: 1:4	PROJECTION:	SHEET 1 OF 1
APPROVAL					