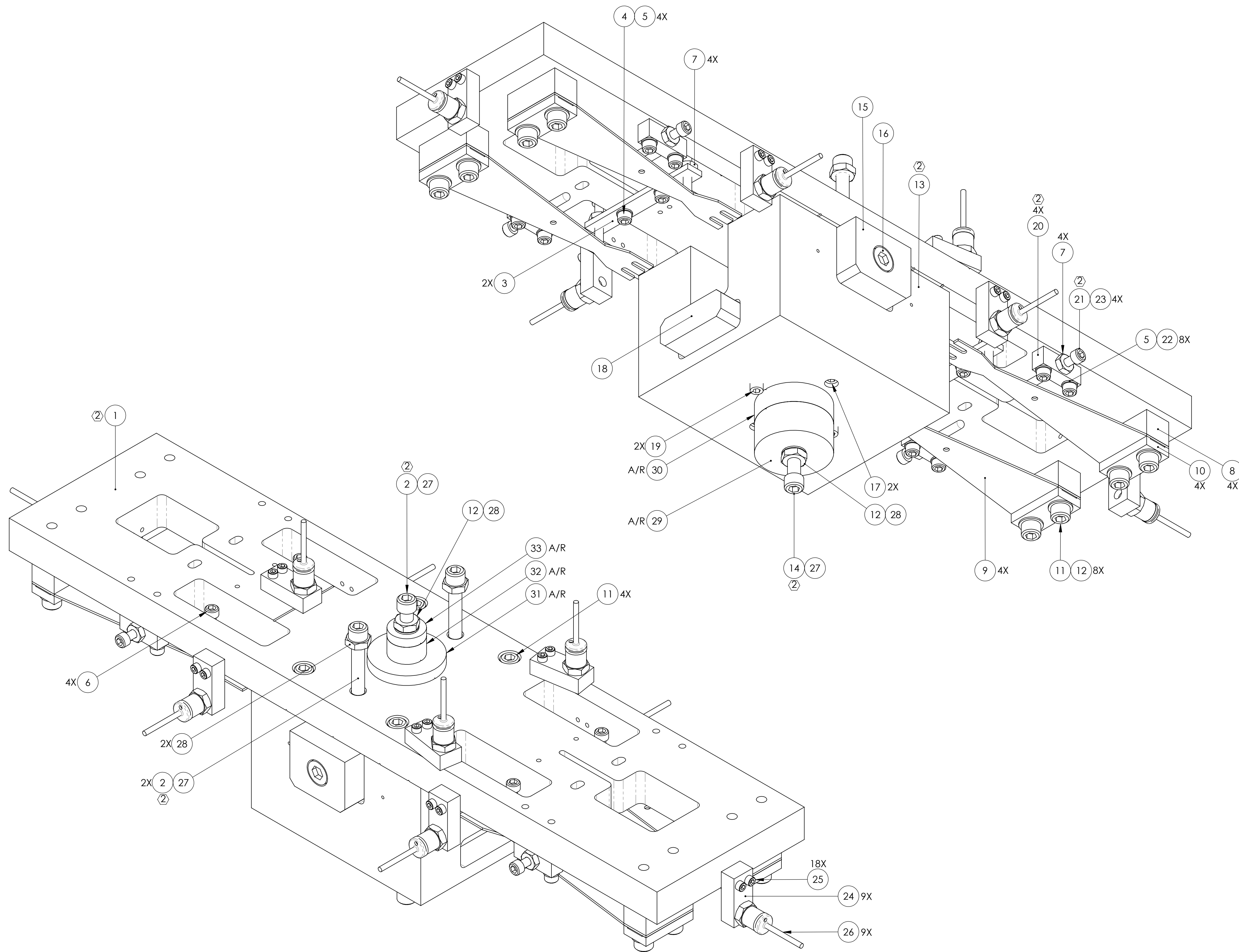


REV.	DATE	DCN #	DRAWING TREE #
v1	24 JUN 2009	E0900176	E080191
v2	02 DEC 2009	E0900446	E080191
v3	18 MAY 2010	E1000166	E080191



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
33	D1001230	ADDITIONAL MASS DISK, 10g	304, 316 OR 302 SSSL	A/R	0	0
32	D1001229	ADDITIONAL MASS DISK, 20g	304, 316 OR 302 SSSL	A/R	0	0
31	D0901405	ADDITIONAL MASS DISK, 50g	304, 316 OR 302 SSSL	A/R	0	0
30	D070333	ADDITIONAL MASS DISK, 100g	304, 316 OR 302 SSSL	A/R	0	0
29	D080263	ADDITIONAL MASS DISK, 150g	304, 316 OR 302 SSSL	A/R	0	0
28	-	JAM NUT, 1/4-20	300 SSSL	4	1	5
27	-	SCREW, SOCKET HEAD CAP, 1/4-20 UNC-2A X 2 LONG, FULLY THREADED	300 SSSL	4	1	5
26	D1001695	MAGNET AND FLAG ASSY, BOSEM	N/A	9	1	10
25	-	SCREW, SOCKET HEAD CAP, #4-40 UNC-2A X 0.625 LONG	Ag-PLATED 300 SSSL	18	6	24
24	D1001699	MAGNET HOLDER, BOSEM, HLTS	6061-T6 Al	9	1	10
23	D0900990	SCREW, SOCKET HEAD CAP, #8-32 UNC-3A X 1.5 LONG, FULLY THREADED, ROUNDED END	300 SSSL	4	2	6
22	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 1 LONG	Ag-PLATED 300 SSSL	8	2	10
21	1185-2EN246	HELICOIL, #8-32 X 0.246 LONG (2)	NITRONIC 60	4	4	8
20	D020653	SCREWDRIVE SYSTEM (2)	6061-T6 Al	4	0	4
19	-	SCREW, SOCKET SET, 1/4-20 UNC-2A X 0.5 LONG	Ag-PLATED 300 SSSL	2	1	3
18	D030139	ROLL OFFSET, T-PIECE	304, 316 OR 302 SSSL	1	0	1
17	-	SCREW, SOCKET SET, 1/4-20 UNC-2A X 1.5 LONG	Ag-PLATED 300 SSSL	2	1	3
16	-	SCREW, SOCKET SET, 1/2-20 UNF-2A X 3.5 LONG	Ag-PLATED 300 SSSL	1	1	2
15	D1001669	PITCH INSERT, T-PIECE	304, 316 OR 302 SSSL	1	0	1
14	3585-4EN250	SCREW-LOCK HELICOIL, 1/4-20 X 0.25 LONG (2)	NITRONIC 60	1	1	2
13	D020607	T-PIECE, UPPER MASS (2)	304, 316 OR 302 SSSL	1	0	1
12	-	WASHER, FLAT, VENTED, 1/4 (U-C COMPONENTS P/N WFV-25 OR EQUIVALENT)	300 SSSL	10	2	12
11	-	SCREW, SOCKET HEAD CAP, 1/4-20 UNC-2A X 1.25 LONG	Ag-PLATED 300 SSSL	12	3	15
10	D020623	BLADE CLAMP (0.0 DEGREE), LOWER BLADE, OUTSIDE	304, 316 OR 302 SSSL	4	0	4
9	D020615	HLTS LOWER BLADE	MARAGING STEEL C250	4	4	8
8	D020602	BLADE CLAMP (0.0 DEGREE), LOWER BLADE, INSIDE	304, 316 OR 302 SSSL	4	0	4
7	-	HEX NUT, #8-32	300 SSSL	8	2	10
6	D030025	SCREW, SOCKET HEAD CAP, #8-32 UNC-3A X 1 LONG, FULLY THREADED, ROUNDED END	Ag-PLATED 300 SSSL	4	2	6
5	-	WASHER, FLAT, VENTED, #8 (U-C COMPONENTS P/N WFV-08 OR EQUIVALENT)	300 SSSL	12	3	15
4	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 0.75 LONG	Ag-PLATED 300 SSSL	4	1	5
3	D080221	GUARD, LOWER BLADE	304, 316 OR 302 SSSL	2	0	2
2	3585-4EN625	SCREW-LOCK HELICOIL, 1/4-20 X 0.625 LONG (2)	NITRONIC 60	3	1	4
1	D020605	MAIN SECTION (2)	304, 316 OR 302 SSSL	1	0	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- 1. PARTS TO BE ASSEMBLED ACCORDING TO E080208 HLTS ASSEMBLY SPECIFICATION.
- 2. HELICOILS TO BE INSTALLED INTO ITEM NO. 1, ITEM NO. 13 AND ITEM NO. 20 BY LIGO PERSONNEL PRIOR TO ASSEMBLY AND AFTER ALL PARTS ARE CLEANED AND BAKED.

MATERIAL	N/A	FINISH	N/A μinch
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LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: SUS

NEXT ASSY: HLTS SUSPENSION ASSY

PART NAME: UPPER MASS ASSY

DESIGNER	D. BRIDGES	27 JUL 2010	SIZE	DWG. NO.	REV.
DRAFTER	D. BRIDGES	29 JUL 2010	D	D070335	v3
CHECKER	M. MEYER	29 JUL 2010	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1
APPROVAL					

D070335-Advanced LIGO_SUS_HLTS_Uppr_Mass_Assembly_PART PDM REV: V2.006, DRAWING PDM REV: V2.003