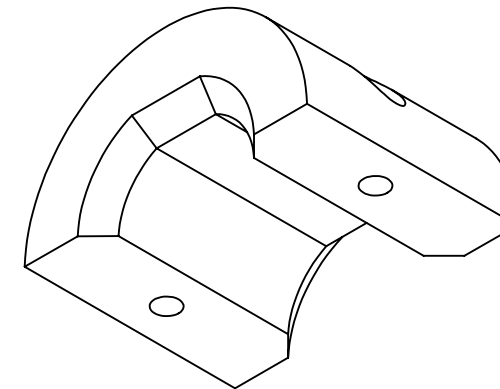
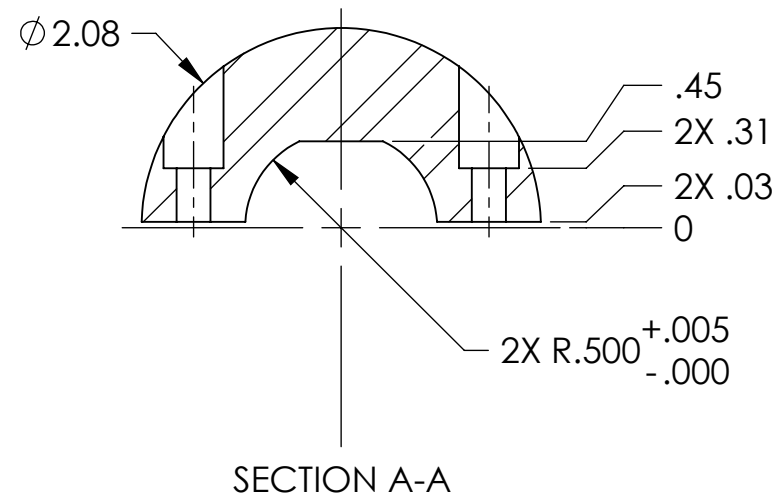
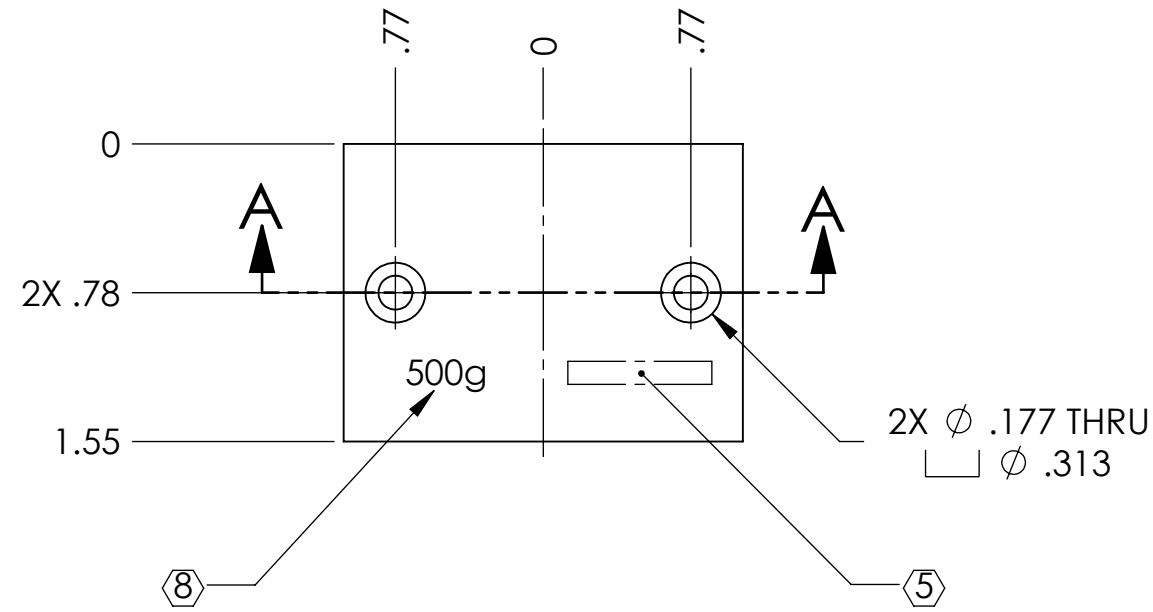


D080225\_Advanced\_LIGO\_SUS\_HLTS\_Collar\_Upper\_500g\_Intermediate\_Mass\_PART PDM REV: V1-001, DRAWING PDM REV: V1-001

**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. 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, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) AS MARKED ON NOTED SURFACE OF PART. USE .12" HIGH CHARACTERS.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 JUN 2009	E0900173	E080191
v2	28 JUN 2010	E1000236	E080191
-	-	-	-



**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX $\pm$ .01 .XXX $\pm$ .005 ANGULAR $\pm$ 0.5°	
MATERIAL	304 SSSL
FINISH	32 $\mu$ inch

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

SYSTEM: ADVANCED LIGO    SUB-SYSTEM: SUS  
 NEXT ASSY: INT. MASS CHANGER

PART NAME			COLLAR, UPPER, 500g		
DESIGNER	D. BRIDGES	28 AUG 2008	SIZE	DWG. NO.	REV.
DRAFTER	R. BIEDENHARN	29 OCT 2010	B	D080225	v2
CHECKER	D. BRIDGES	04 NOV 2010	SCALE: 1:1    PROJECTION:     SHEET 1 OF 1		
APPROVAL					