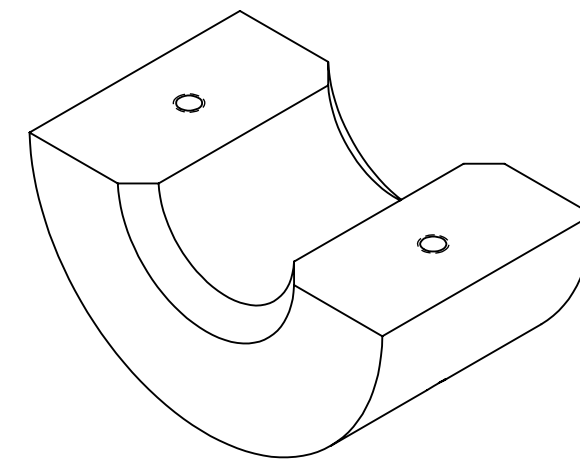
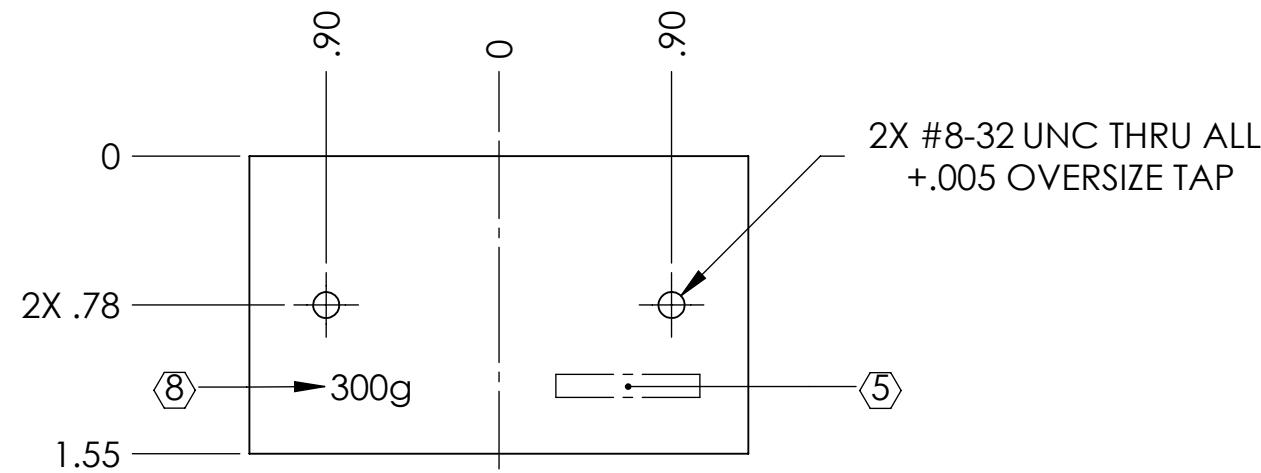
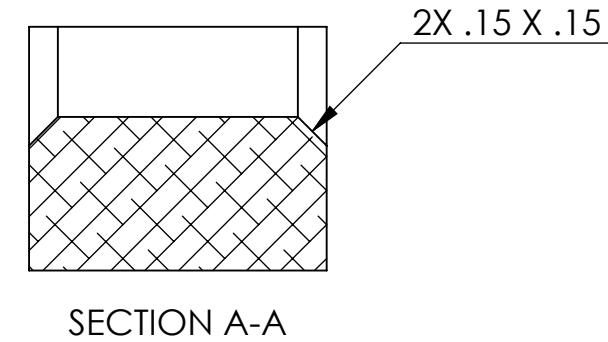
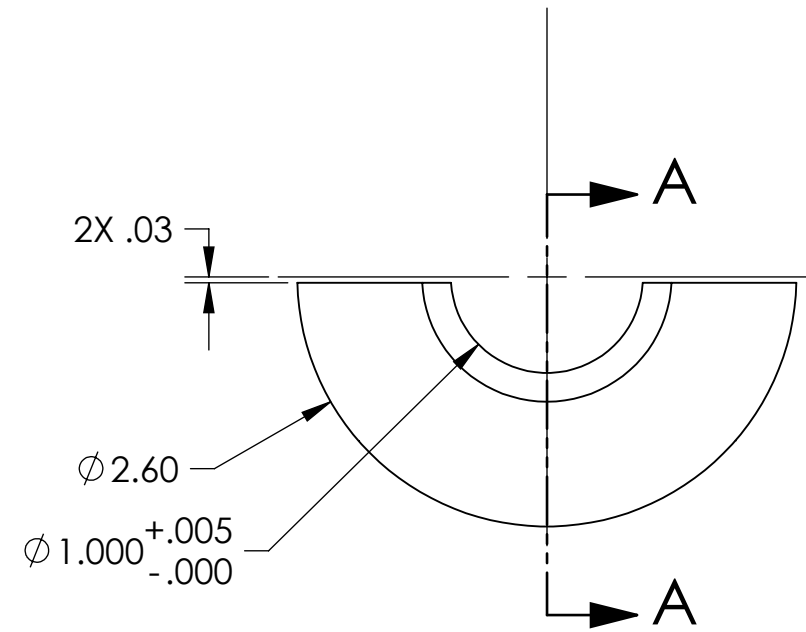


D080232\_Advanced\_LIGO\_SUS\_HLTS\_Collar\_Lower\_300g\_Intermediate\_Mass\_PART PDM REV: V1, DRAWING PDM REV: V1-001

- 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)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.1°				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.		<b>COLLAR, LOWER, 300g</b>	
<b>MATERIAL</b> 6061-T6 Al		<b>FINISH</b> 32 μinch		<b>SYSTEM</b> ADVANCED LIGO		<b>SUB-SYSTEM</b> SUS	
<b>NEXT ASSY</b> INT. MASS CHANGER				<b>DESIGNER</b> D. BRIDGES		<b>DATE</b> 29 AUG 2008	
				<b>DRAFTER</b> R. BIEDENHARN		<b>DATE</b> 29 OCT 2010	
				<b>CHECKER</b> D. BRIDGES		<b>DATE</b> 04 NOV 2010	
				<b>APPROVAL</b>		<b>SCALE</b> : 1:1	
				<b>SIZE</b> : B		<b>DWG. NO.</b> D080232	
				<b>PROJECTION</b> :		<b>REV.</b> v2	
				<b>SHEET</b> 1 OF 1			