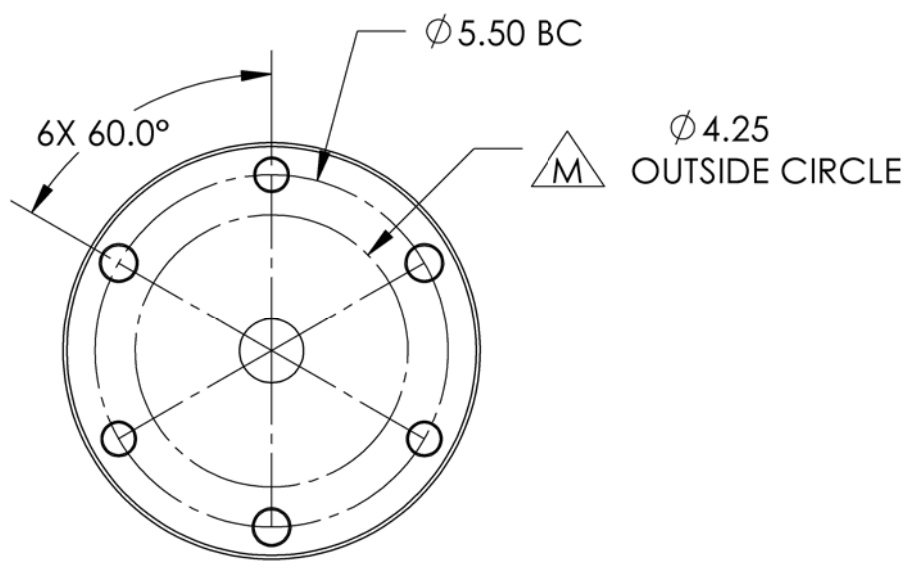
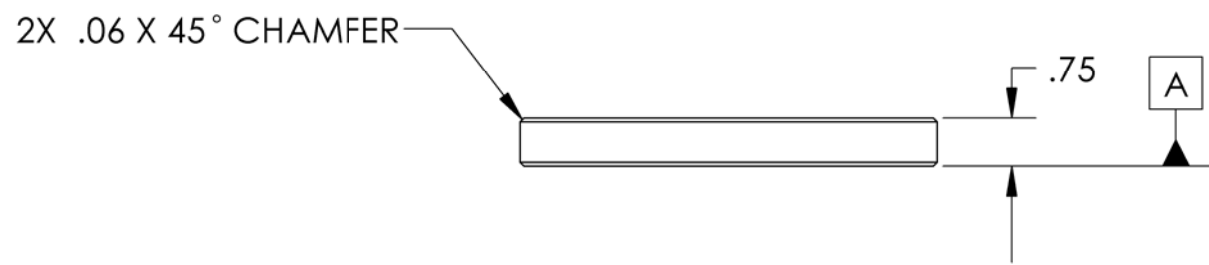
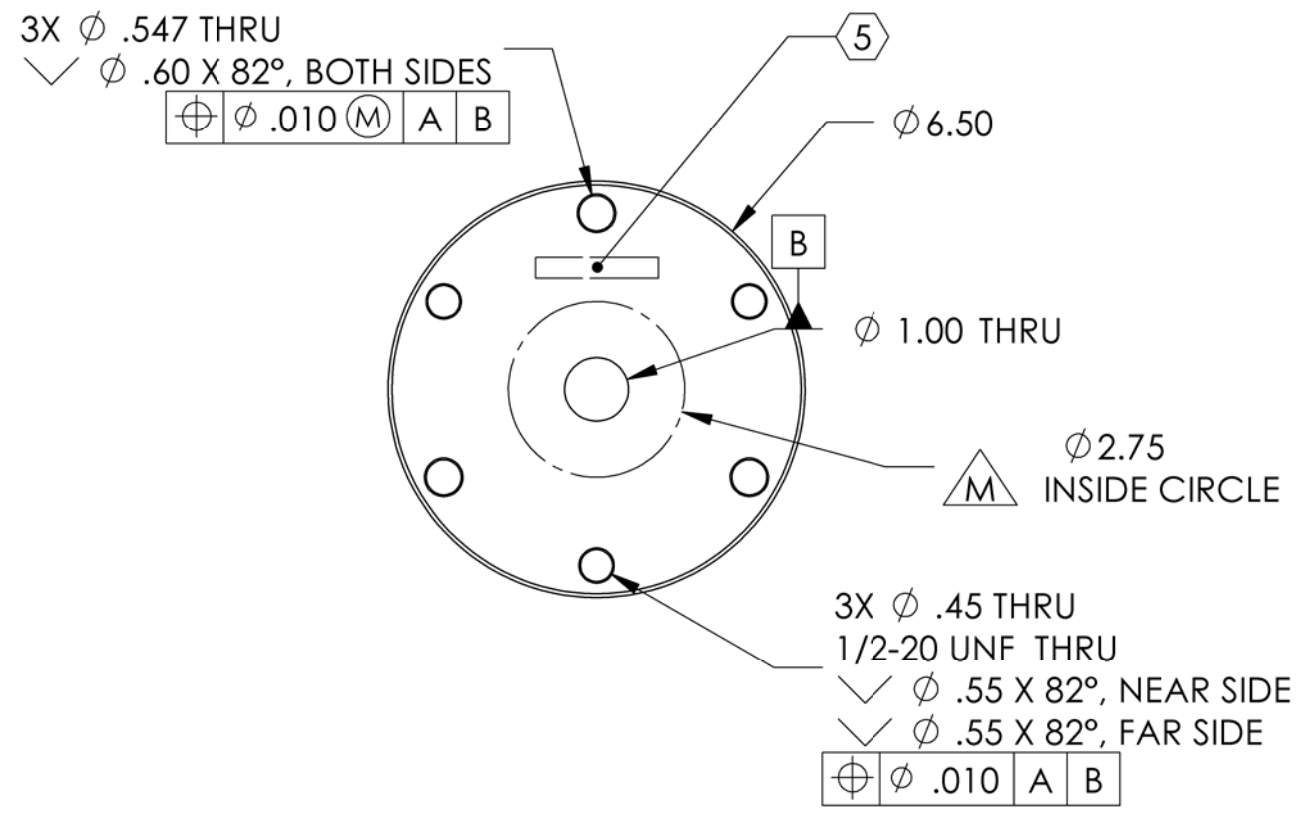


REV.	DATE	DCN #	DRAWING TREE #
v4	22 Mar. 2011	E1100015	E1100016

NOTES CONTINUED:

4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
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 DXXXXXXX-VY, TYPE-XX, S/N XXX.
6. APPROXIMATE WEIGHT = 6.61 LB.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. PAINT: ALL VISIBLE SURFACES (exclude fastening hardware) EXCEPT AREAS IDENTIFIED BY M MEDIUM BLUE SHERWIN WILLIAMS (POLANE (R) T-PLUS POLYURETHANE ENAMEL) #SW-F63TX-L-2822-5864 PRIME WITH SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER P60G2
9. "OXI SOLV RUST INHIBITOR" TO BE APPLIED PER MFG. INSTRUCTIONS TO ALL UNPAINTED SURFACES. BOTH TAPPED AND THRU HOLES WILL BE PLUGGED DURING APPLICATION.



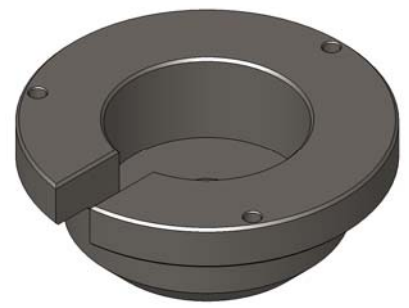
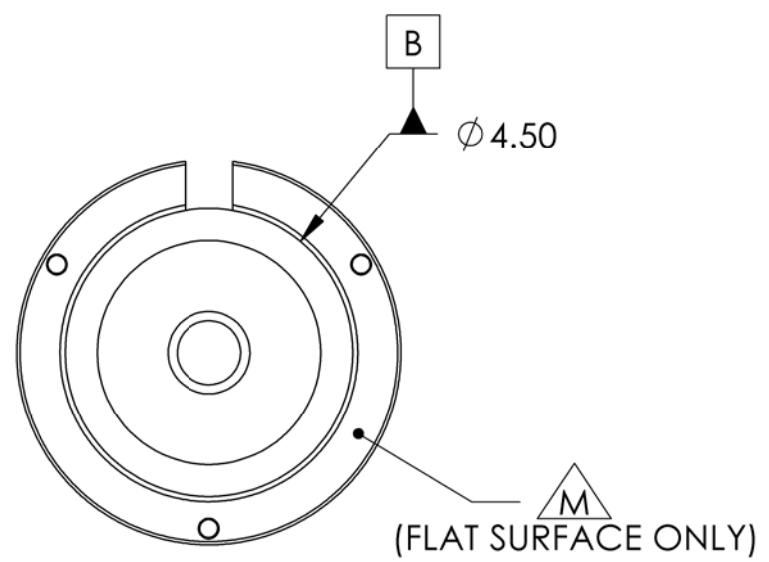
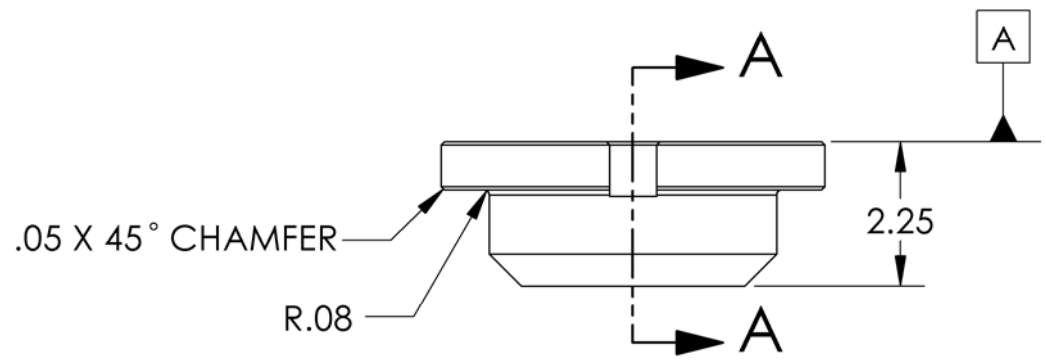
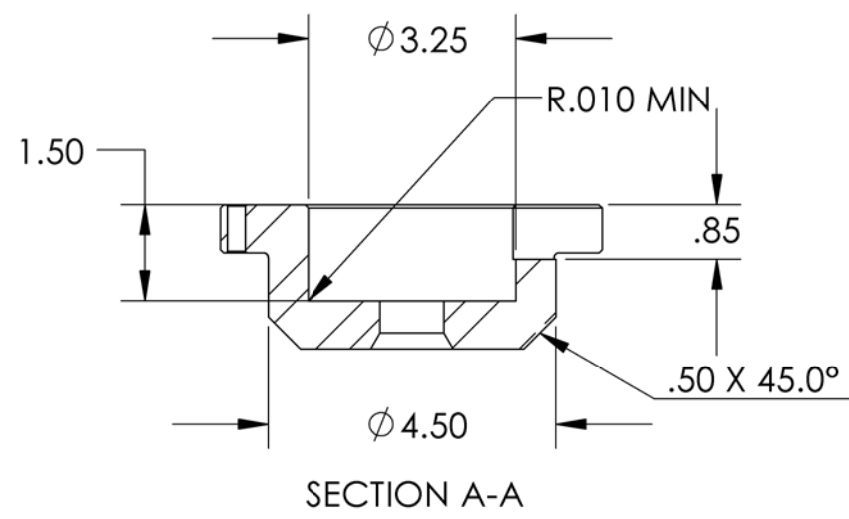
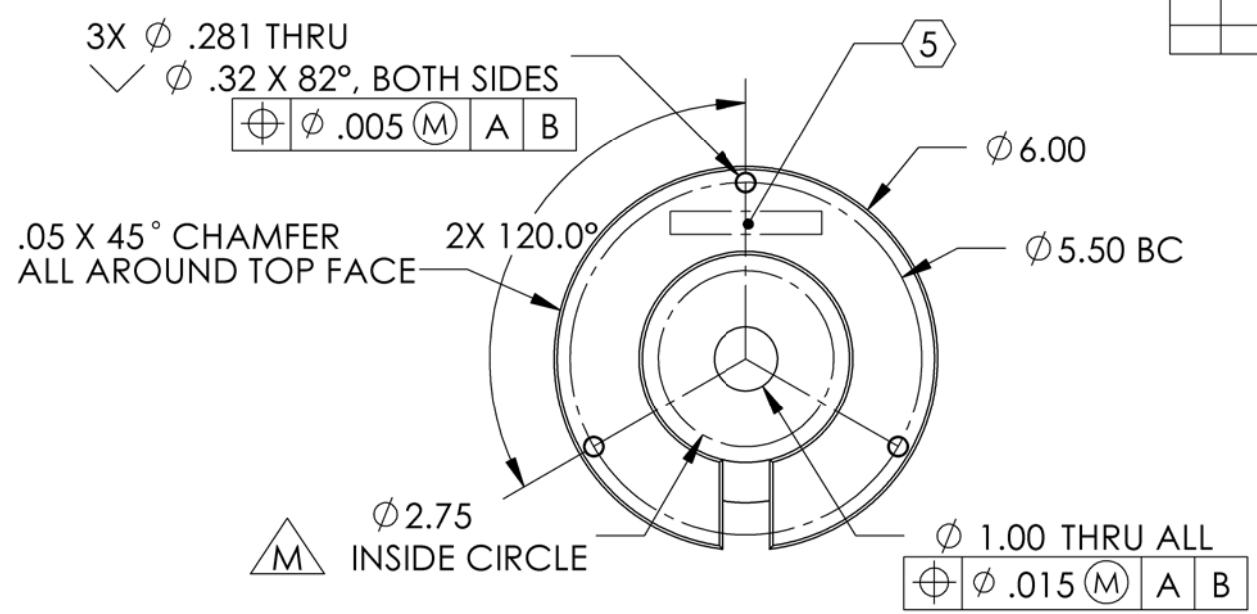
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				PART NAME	
DIMENSIONS ARE IN INCHES		1. INTERPRET DRAWING PER ASME Y14.5-1994.		HEPI Offload Spring Cap	
TOLERANCES: .XX ± .015 .XXX ± .005		2. REMOVE ALL SHARP EDGES, .03 x 45°.		DESIGNER	A. STEIN 07 Oct. 2009
ANGULAR ± .5°		3. DO NOT SCALE FROM DRAWING.		DRAFTER	M. HILLARD 22 Mar. 2011
MATERIAL		FINISH	SYSTEM	CHECKER	K. MASON 22 Mar. 2011
AISI 1020 Steel, Cold Rolled		63 $\mu$ inch	ADVANCED LIGO	APPROVAL	K. MASON 22 Mar. 2011
			SEI	SCALE:	1:3
			PROJECTION:	DWG. NO. D020002-00	
				REV. v4	
				SHEET 1 OF 2	

D020002, PART PDM REV: X-011, DRAWING PDM REV: X-000

REV.	DATE	DCN #	DRAWING TREE #
v4	22 Mar. 2011	E1100015	E1100016

NOTES CONTINUED:

4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
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 DXXXXXXX-VY, TYPE-XX, S/N XXX.
6. APPROXIMATE WEIGHT = 6.61 LB.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. PAINT: ALL VISIBLE SURFACES (exclude fastening hardware) EXCEPT AREAS IDENTIFIED BY  $\Delta$  M MEDIUM BLUE SHERWIN WILLIAMS (POLANE (R) T-PLUS POLYURETHANE ENAMEL) #SW-F63TX-L-2822-5864 PRIME WITH SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER P60G2
9. "OXI SOLV RUST INHIBITOR" TO BE APPLIED PER MFG. INSTRUCTIONS TO ALL UNPAINTED SURFACES. BOTH TAPPED AND THRU HOLES WILL BE PLUGGED DURING APPLICATION.



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.		ADVANCED LIGO		HEPI Offload Spring Cap	
TOLERANCES: .XX ± .015 .XXX ± .005		2. REMOVE ALL SHARP EDGES, .03 x 45°.		SUB-SYSTEM SEI		DESIGNER A. STEIN 07 Oct. 2009	
ANGULAR ± .5°		3. DO NOT SCALE FROM DRAWING.		NEXT ASSY D030320		DRAFTER M. HILLARD 22 Mar. 2011	
MATERIAL AISI 1020 Steel, Cold Rolled		FINISH 63 $\mu$ inch		APPROVAL K. MASON 22 Mar. 2011		CHECKER K. MASON 22 Mar. 2011	
				SCALE: 1:3		DWG. NO. B D020002-01	
				PROJECTION: $\oplus$ $\square$		REV. v4	
						SHEET 2 OF 2	

D020002, PART PDM REV: X-011, DRAWING PDM REV: X-000