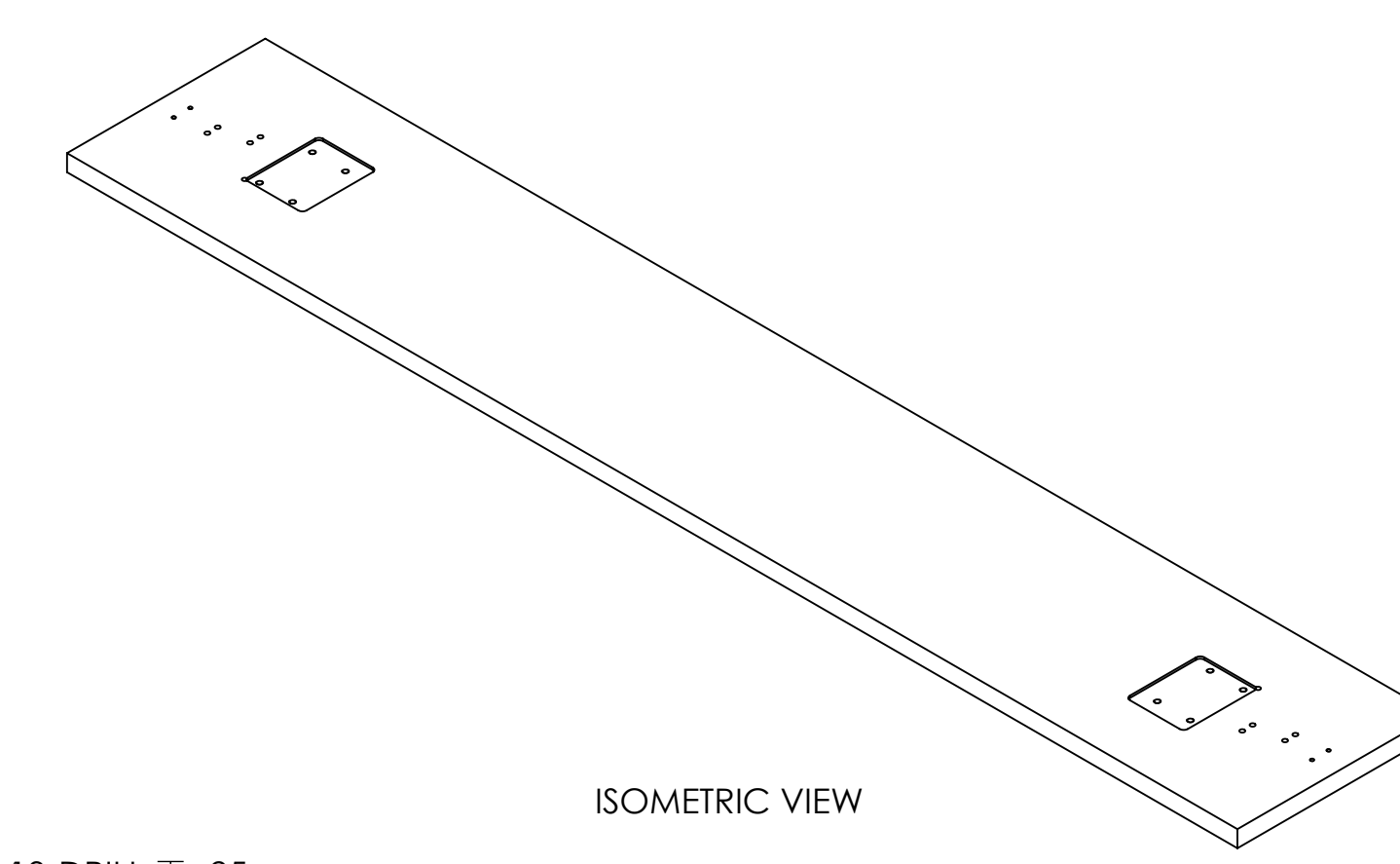
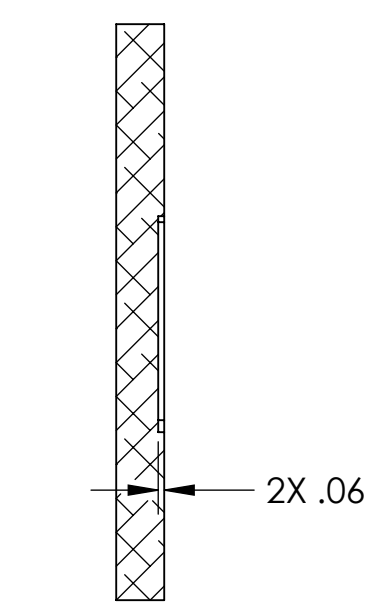
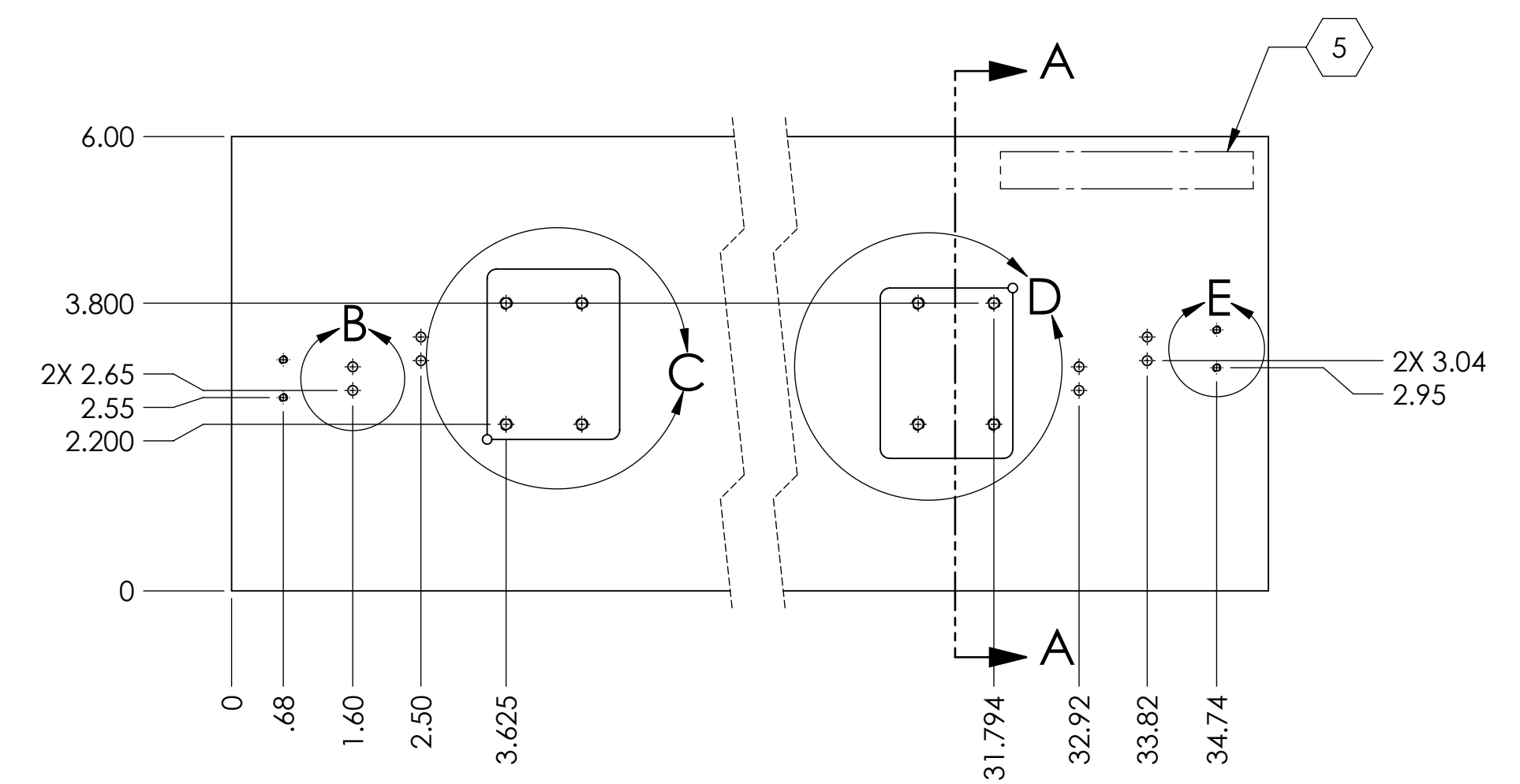


NOTES CONTINUED:  
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 101 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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. APPROXIMATE WEIGHT = 10.298 LB.  
 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.  
 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

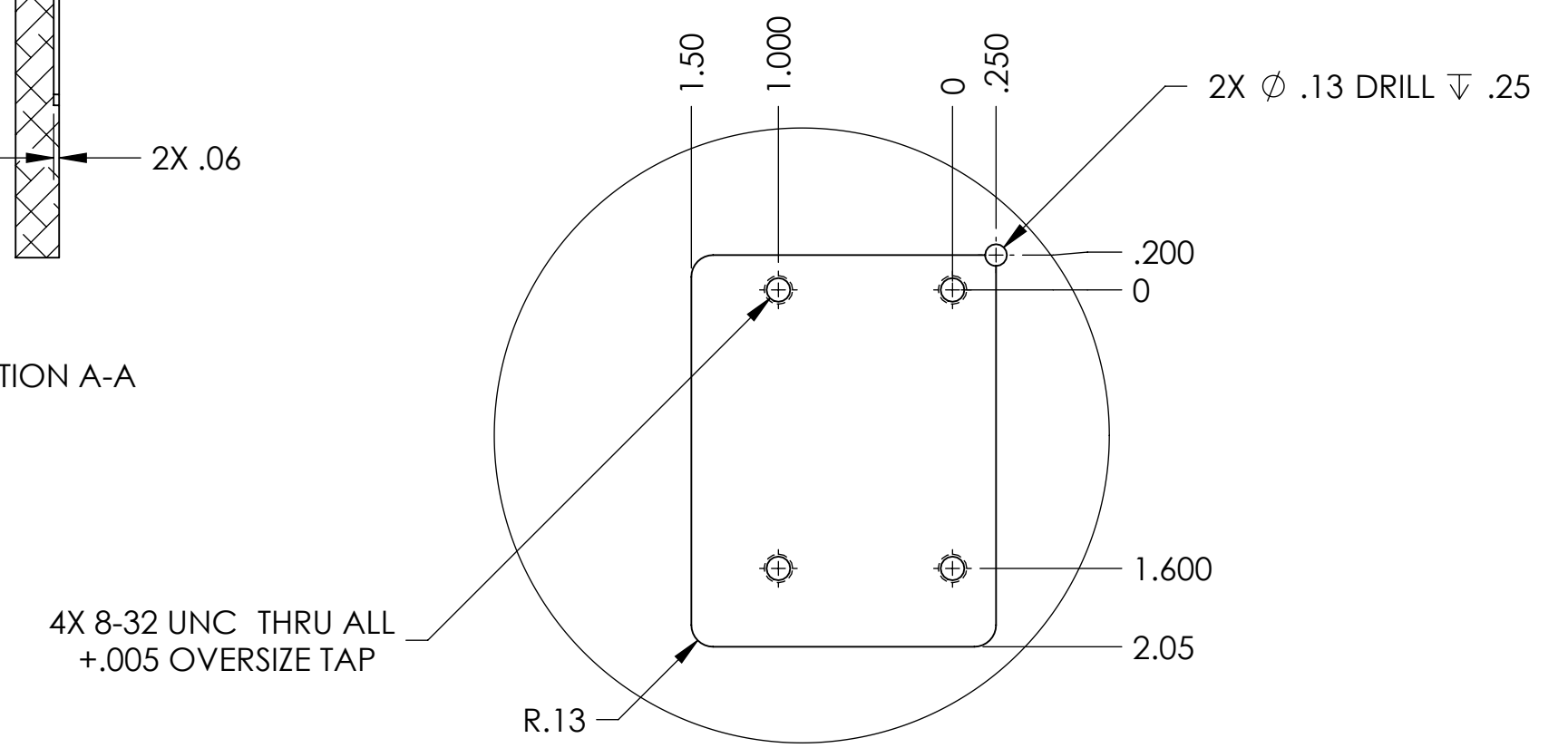
REV.	DATE	DCN #	DRAWING TREE #
v1	09 APR 2010	E0900502	E0900353
v2	02 SEP 2010	E1000347	E0900353
-	-	-	-



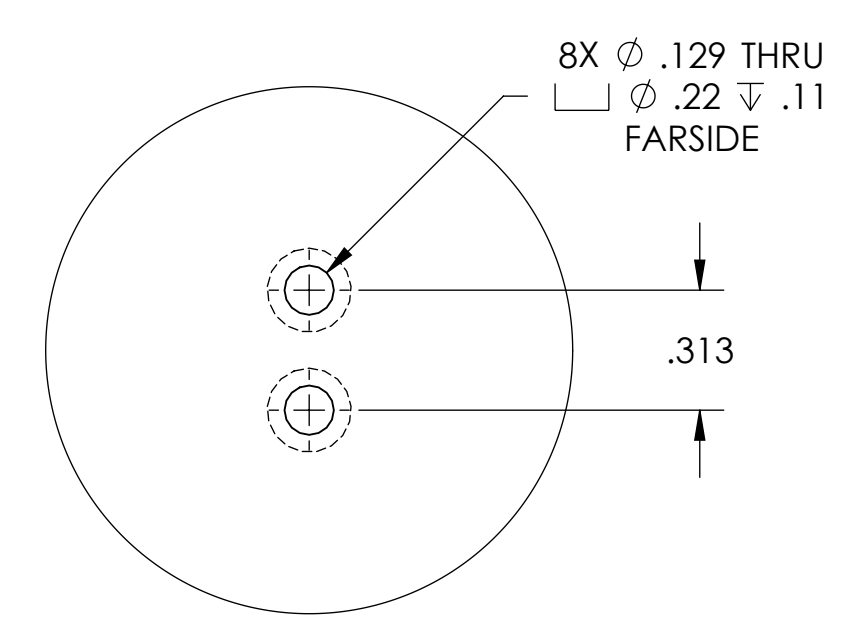
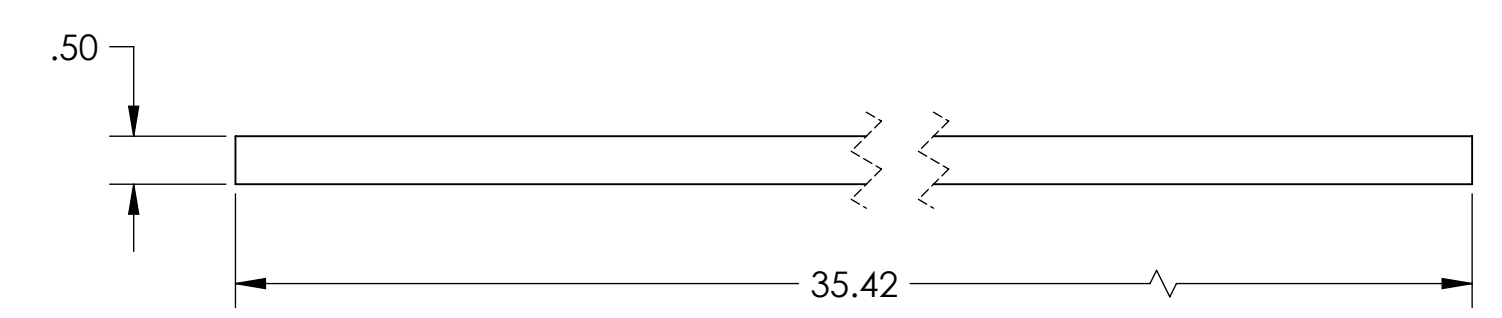
ISOMETRIC VIEW



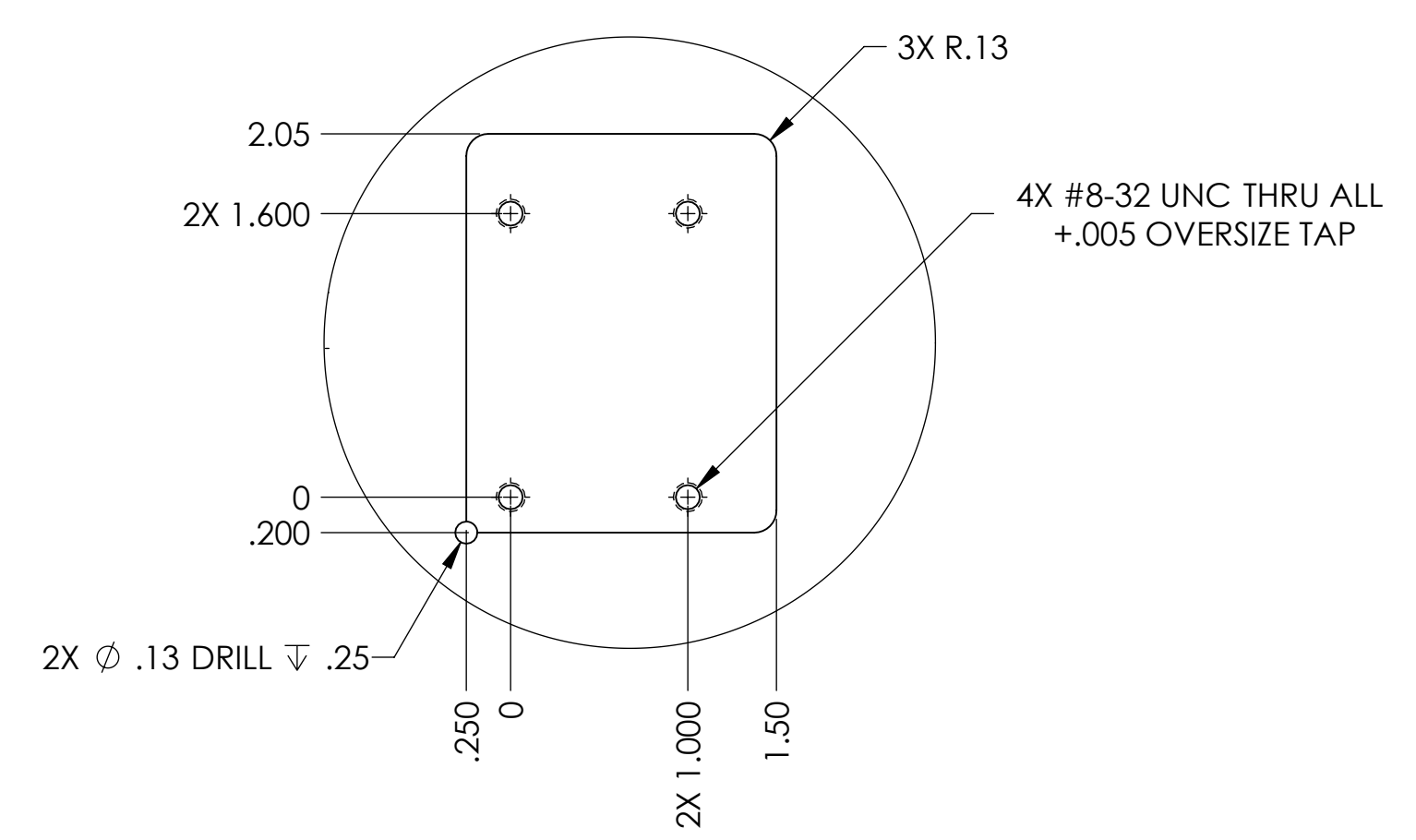
SECTION A-A



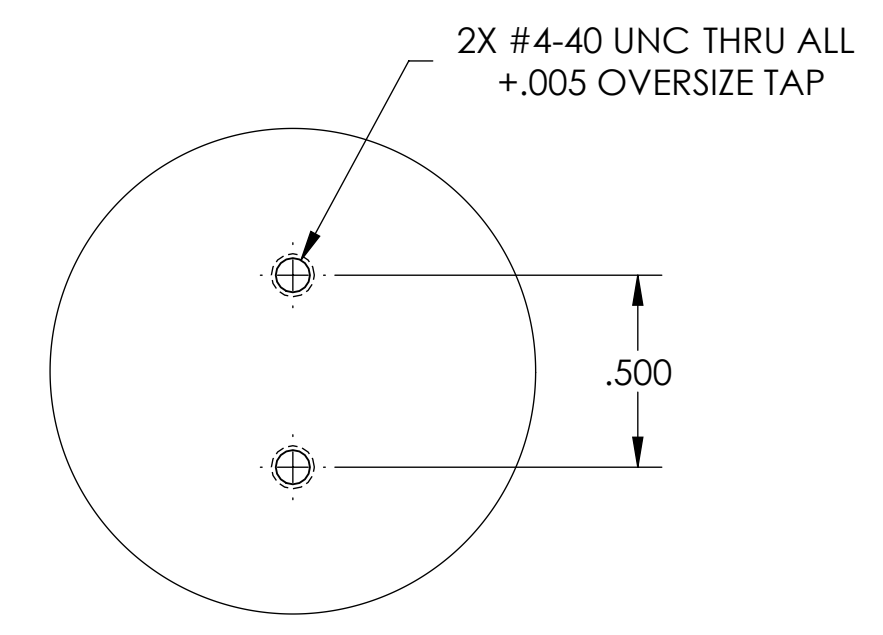
DETAIL D  
SCALE 1 : 1



DETAIL B  
SCALE 2 : 1  
4 PLACES



DETAIL C  
SCALE 1 : 1



DETAIL E  
SCALE 2 : 1  
2 PLACES

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. 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.		BASE PLATE, HSTS LOWER LOOP WIRE JIG			
TOLERANCES: .XX ± .03 .XXX ± .005				DESIGNER	M. MEYER	29 OCT 2009	SIZE
ANGULAR ± 0.5°		DRAFTER	B. MOORE	04 NOV 2009	D	D0902540	v2
MATERIAL	6061-T6 Al	CHECKER	M. MEYER	04 NOV 2009	APPROVAL	SCALE: 1:2	PROJECTION:
FINISH	63 μinch	NEXT ASSY	D0902524	SHEET 1 OF 1			

D0902540\_Advanced LIGO\_SUS\_LSTS\_Base Plate\_lower Wire Jig\_PART PDM REV: X-006\_DRAWING PDM REV: X-007