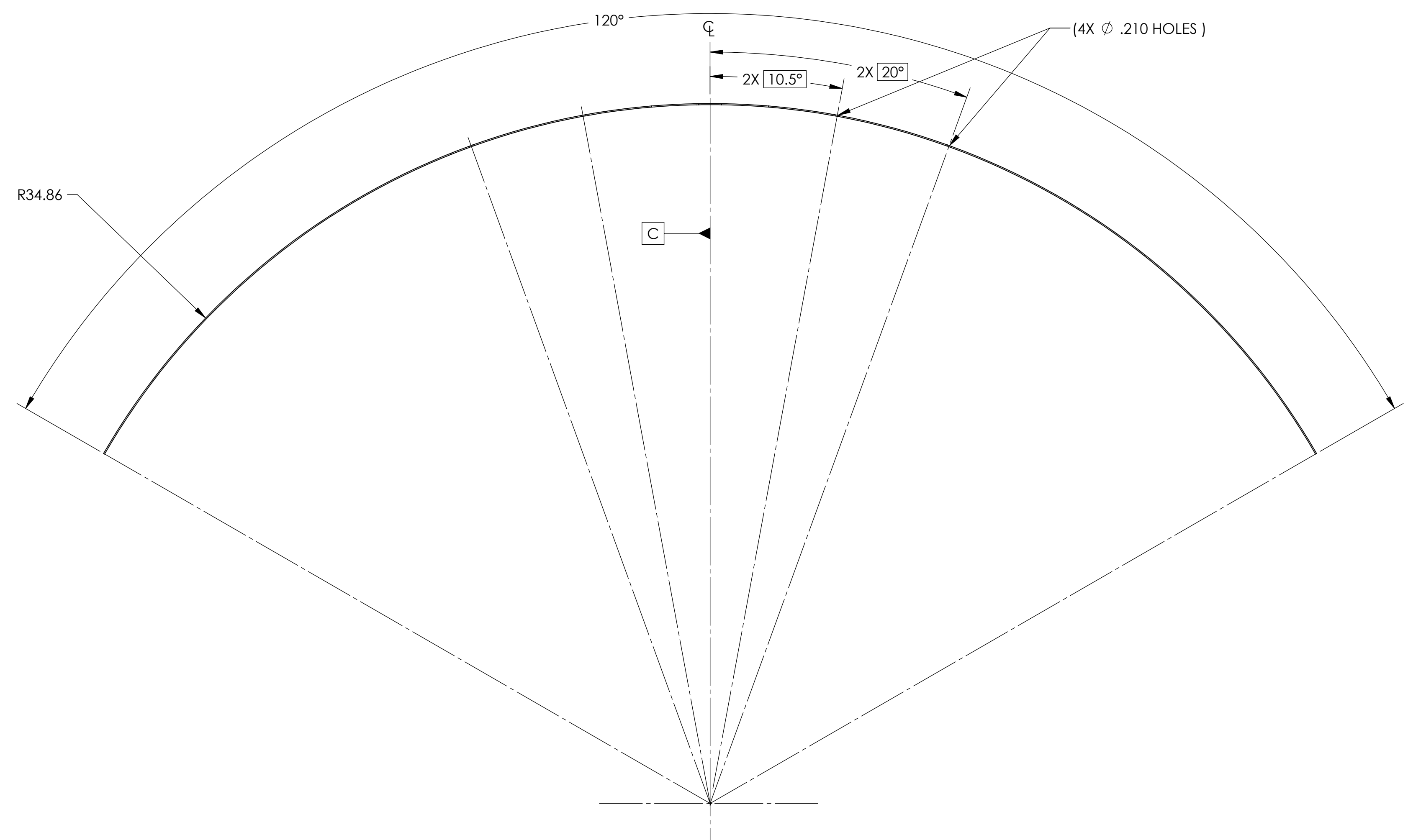
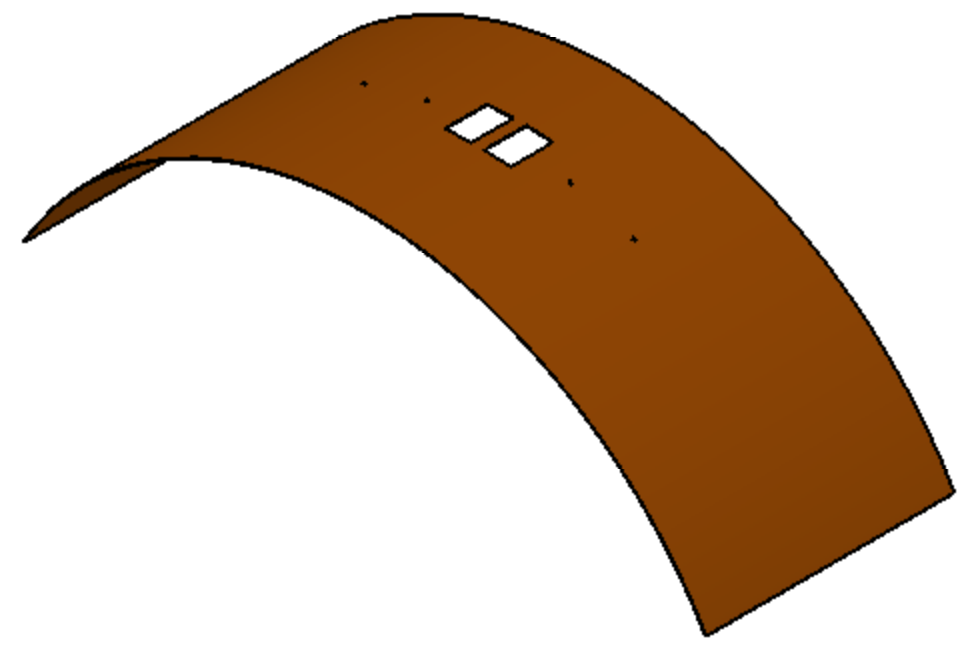
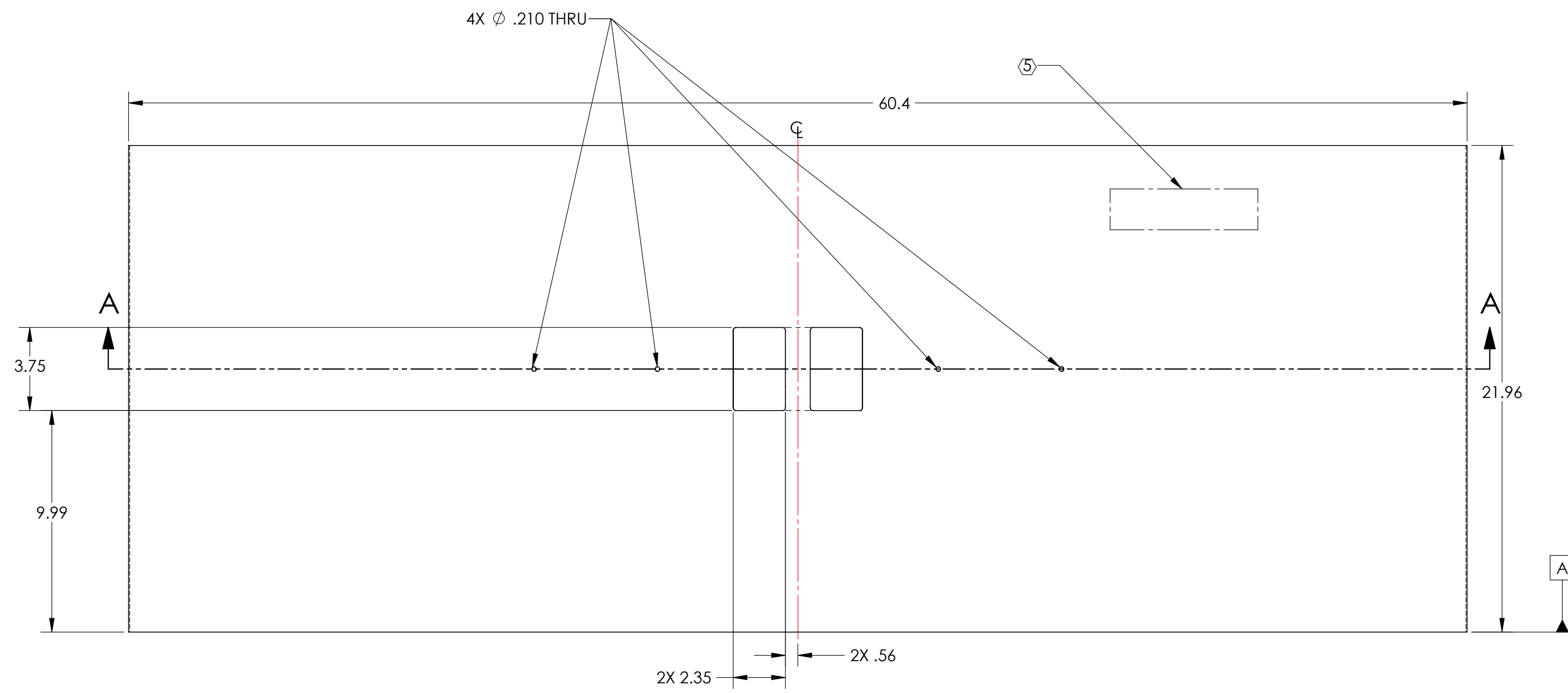


- NOTES CONTINUED:**
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. 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. REFER TO LIGO-E0900364
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
 9. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
 10. PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION. THE INDICATED HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING TO APPROXIMATELY 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF THE HOLE.
 11. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.
 12. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.

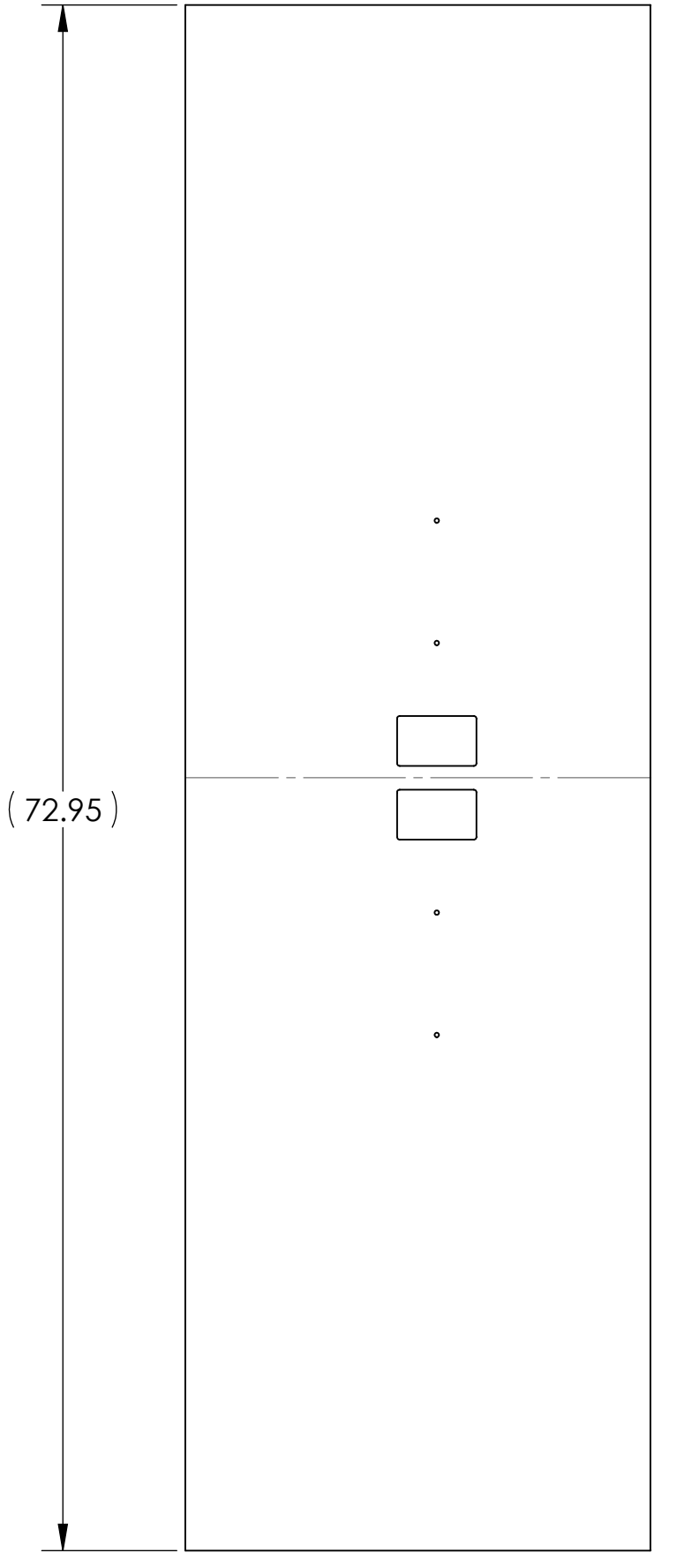
13. MATERIAL RECEIVED AS MACHINE FINISH



SECTION A-A



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



FLAT PATTERN

DIMENSIONS ARE IN INCHES		TOLERANCES: .XX ± .06 .XXX ± .010		ANGULAR ± 0.1°	
MATERIAL 18GA A424 TYPE 1 STEEL		FINISH 13		NEXT ASSY D1002061	

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME RADIAL SEGMENT, BOTTOM	
SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS	DESIGNER H. Kellman	DATE 28 SEPT 2010
DRAFTER TG. NGUYEN		DATE 16 AUG 2010	SIZE D
CHECKER M. SMITH		DWG. NO. D0902620	
APPROVAL D. COYNE		SCALE 1:4	PROJECTION

REV.	DATE	DCN #	DRAWING TREE #
v1	30 SEP 2010	E1000360	E1000085
v2	9 MAY 2011	E1000360-v2	-
-	-	-	-