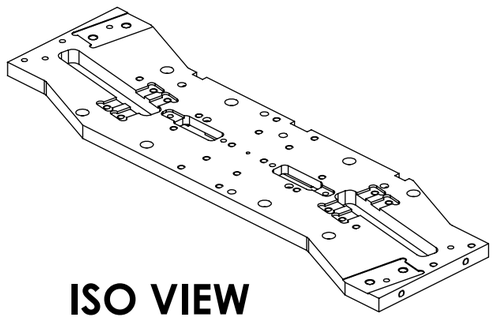
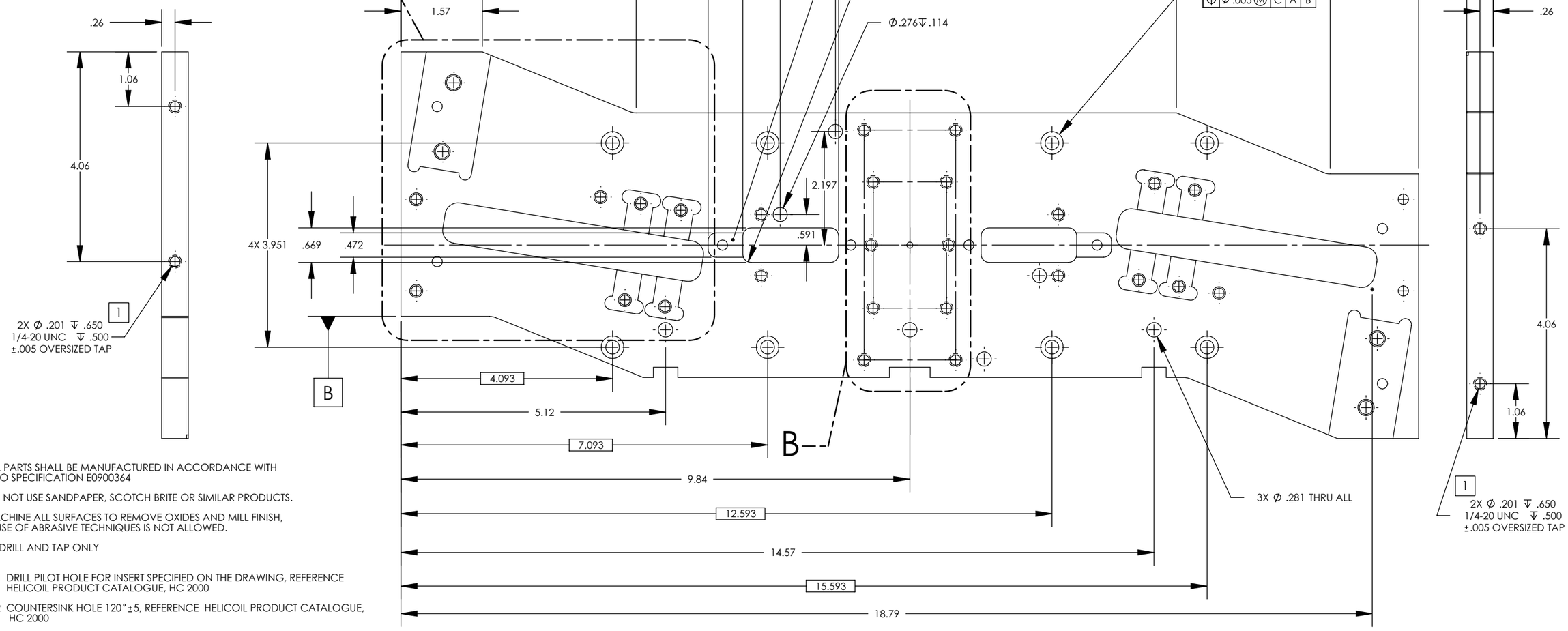
NOTES CONTINUED:

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: DXXXXXXX-VY, TYPE-XX, S/N XXX

REV.	DATE	DCN #	DRAWING TREE #
v1	JUN-29-2010	E1000234	



ISO VIEW



4. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364

3. DO NOT USE SANDPAPER, SCOTCH BRITE OR SIMILAR PRODUCTS.

2. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE TECHNIQUES IS NOT ALLOWED.

[1] DRILL AND TAP ONLY

1.1 DRILL PILOT HOLE FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELICOIL PRODUCT CATALOGUE, HC 2000

1.2 COUNTERSINK HOLE 120°±5, REFERENCE HELICOIL PRODUCT CATALOGUE, HC 2000

1.3 TAP HOLES FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELICOIL PRODUCT CATALOGUE, HC 2000

1.4 REMOVE ALL CHIPS

1.5 GAGE THREADS WITH GAGE TOOL FOR INSERT SPECIFIED IN DRAWING, REFERENCE HELICOIL PRODUCT CATALOGUE, HC 2000 AND AS PER AGREED INSPECTION

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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 SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.

MATERIAL ST STL 304 **FINISH** 32 µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM aLIGO AOS **SUB-SYSTEM** TRANSMON

NEXT ASSY D1000442

PART NAME aLIGO INTERMEDIATE MASS BOTTOM PLATE

DESIGNER		
DRAFTER	I ROMERO	4/14/10
CHECKER	KMAILAMD	4/14/10
APPROVAL	KMAILAND	4/14/10

SIZE B **DWG. NO.** D1000394 **REV.** v1

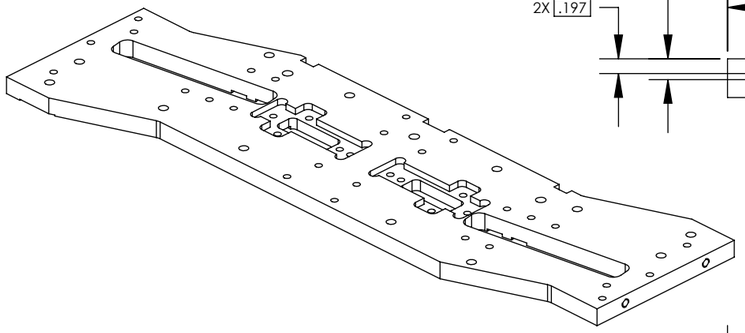
SCALE: 1:2 **PROJECTION:** SHEET 1 OF 3

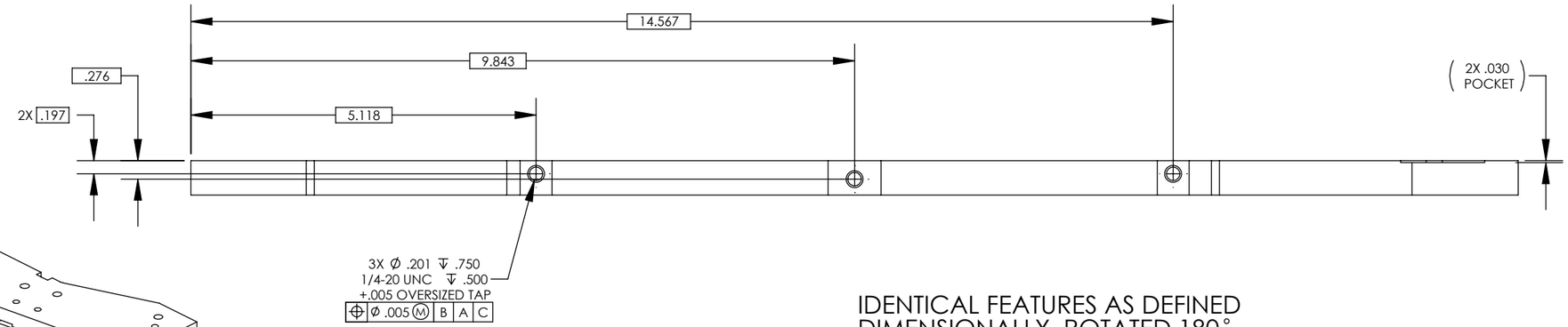
D1000394 aLIGO INTERMEDIATE MASS BOTTOM PLATE, PART PDM REV: X-019, DRAWING PDM REV: X-006

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: DXXXXXXX-VY, TYPE-XX, S/N XXX

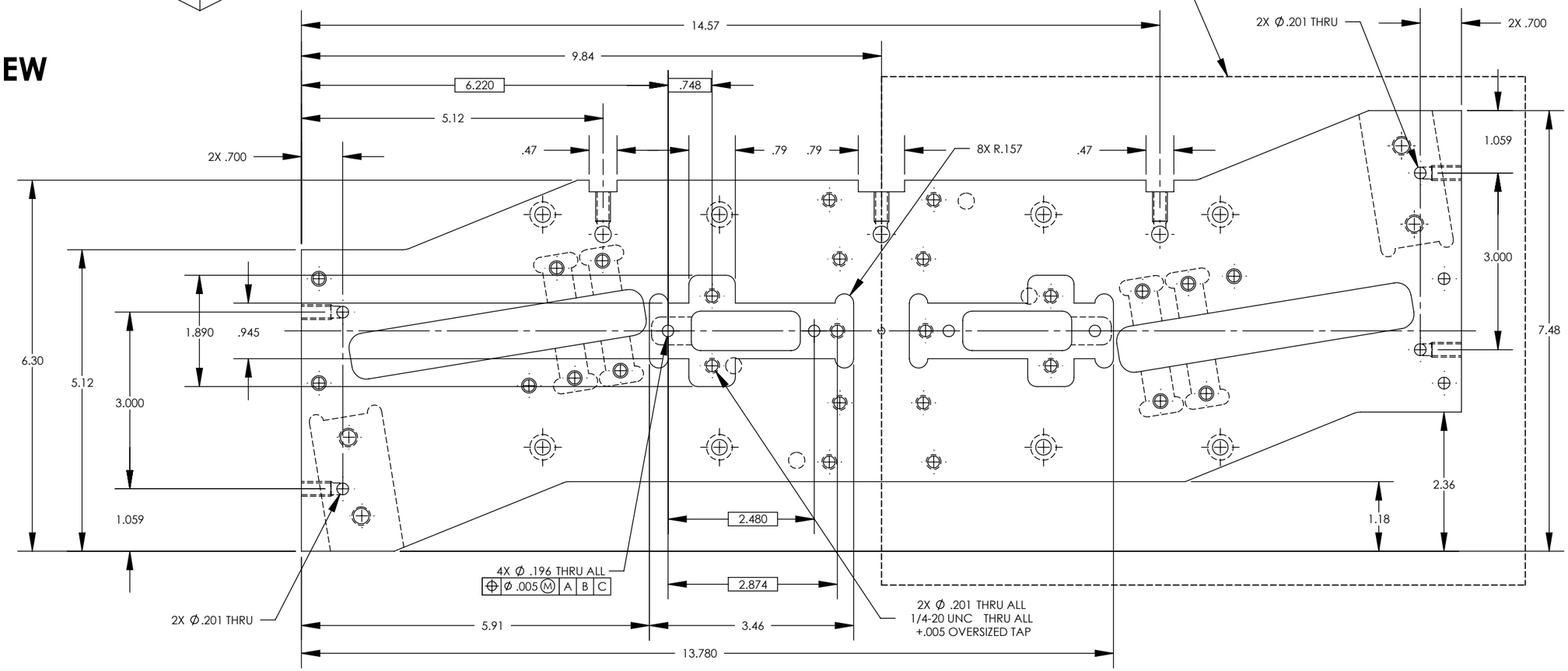
REV.	DATE	DCN #	DRAWING TREE #
v1	JUN-29-2010	E1000234	





ISO VIEW

IDENTICAL FEATURES AS DEFINED DIMENSIONALLY, ROTATED 180° EXCEPT FOR NOTCH OUTS



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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.XXX ± .005

ANGULAR ± 0.1°

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4. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.

MATERIAL: ST STL 304 **FINISH:** 32 µinch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: aLIGO AOS **SUB-SYSTEM:** TRANSMON

NEXT ASSY: D1000442

PART NAME: aLIGO INTERMEDIATE MASS BOTTOM PLATE

DESIGNER			
DRAFTER	I ROMERO	4/14/10	
CHECKER	KMAILAND	4/14/10	
APPROVAL	KMAILAND	4/14/10	

SIZE: B DWG. NO.: D1000394 REV.: v1

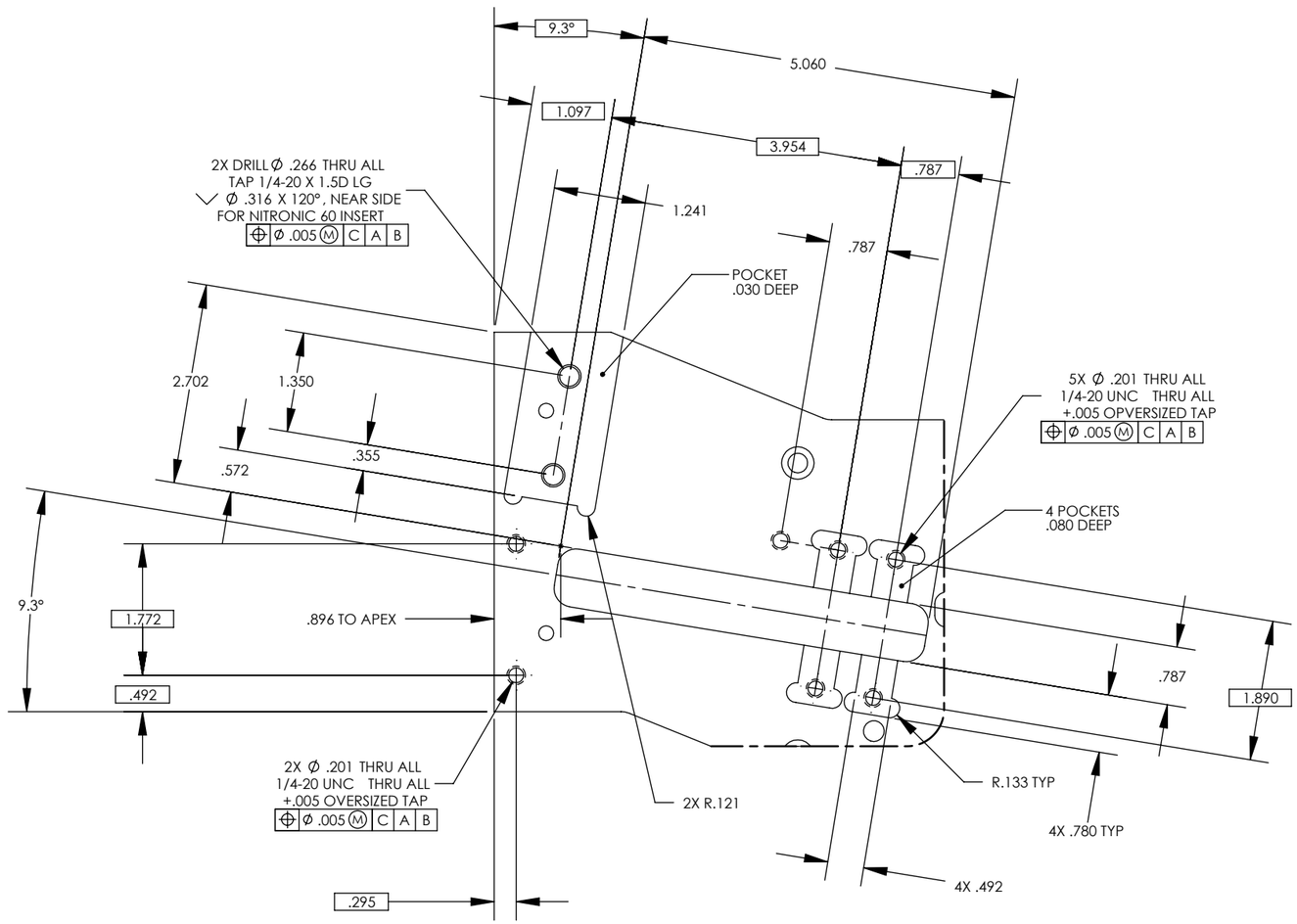
SCALE: 1:2 PROJECTION: SHEET 2 OF 3

D1000394 aLIGO INTERMEDIATE MASS BOTTOM PLATE, PART PDM REV: X-019, DRAWING PDM REV: X-006

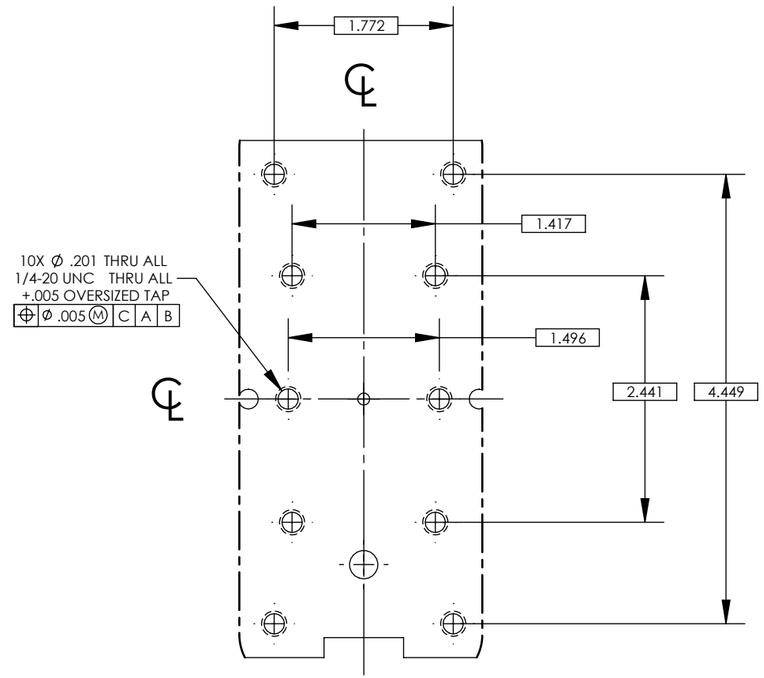
NOTES CONTINUED:

(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: DXXXXXXX-VY, TYPE-XX, S/N XXX

REV.	DATE	DCN #	DRAWING TREE #
v1	JUN-29-2010	E1000234	



DETAIL A



DETAIL B
SCALE 1 : 1.5

D1000394 aLIGO INTERMEDIATE MASS BOTTOM PLATE, PART PDM REV: X-019, DRAWING PDM REV: X-006

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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ANGULAR ± 0.1°

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MATERIAL ST STL 304

FINISH 32 µinch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM aLIGO AOS

SUB-SYSTEM TRANSMON

NEXT ASSY D1000442

PART NAME aLIGO INTERMEDIATE MASS BOTTOM PLATE

DESIGNER			
DRAFTER	I ROMERO	4/14/10	
CHECKER	KMAILAMD	4/14/10	
APPROVAL	KMAILAND	4/14/10	

SIZE B | **DWG. NO.** D1000394 | **REV.** v1

SCALE: 1:2 | **PROJECTION:** | SHEET 3 OF 3