NOTES CONTINUED:

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

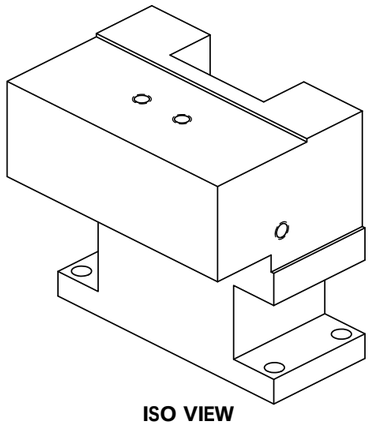
4. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364

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

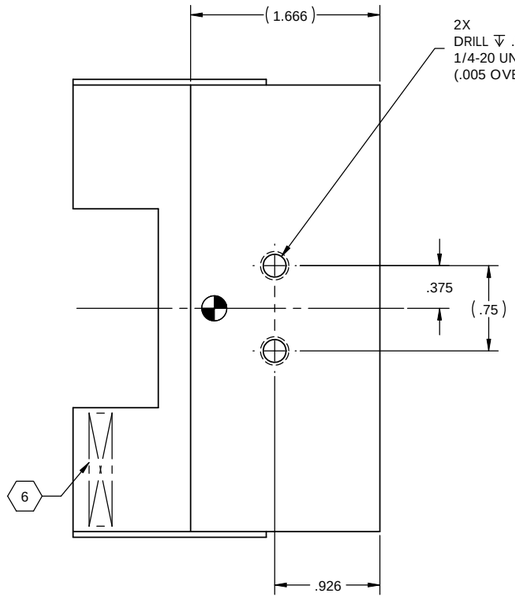
2. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE TECHNIQUES IS NOT ALLOWED.

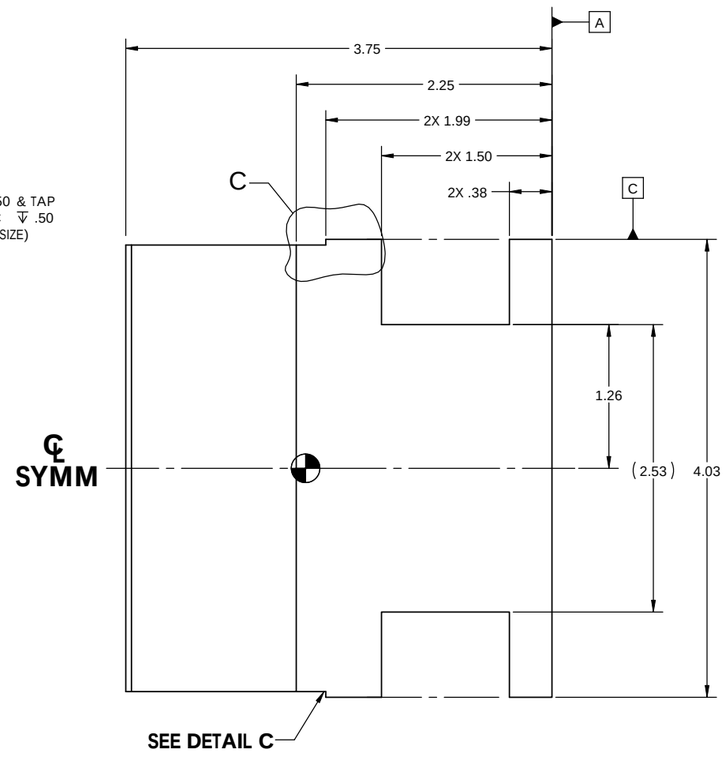
1. CENTER OF GRIVITY (CG) SHOWN FOR INTERNAL REFERENCE ONLY

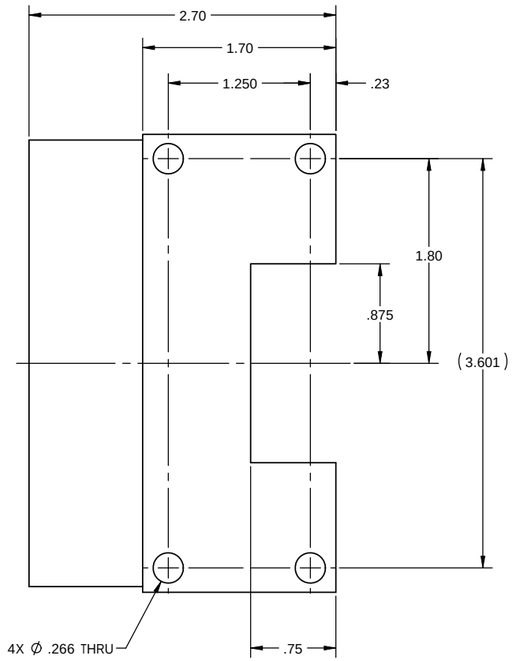
REV.	DATE	DCN #	DRAWING TREE #
v1	JUN-29-2010	E1000234	
v2	SEP-03-2010	E1000388	
v3	27 JUN 2011	E1100351	

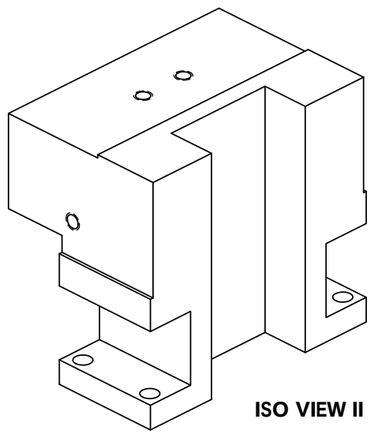


ISO VIEW

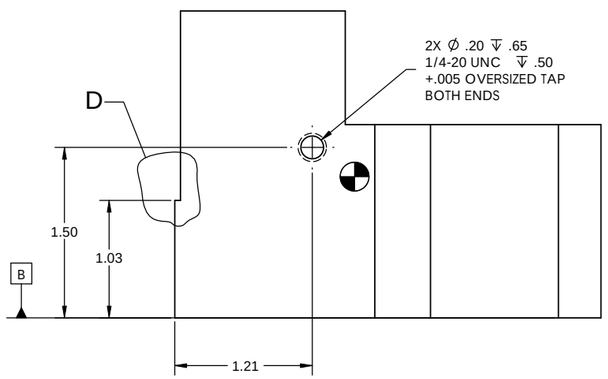


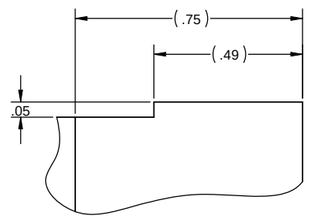




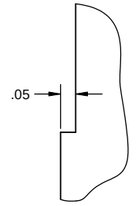


ISO VIEW II





DETAIL C
SCALE 4 : 1



DETAIL D
SCALE 4 : 1

NOTE: WEIGHT 6.6 lbs.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)											
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1.0°	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.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME aLIGO TOP ADD MASS TOWER					
	MATERIAL S. STL. 304	FINISH 63 µinch	SYSTEM aLIGO AOS	SUB-SYSTEM AOS	DESIGNER	K. MAILAND	19 MAR 2010	SIZE D	DWG. NO. D1000631	REV. v3
			NEXT ASSY D1000444		DRAFTER	C Conley	9/2/10			
					CHECKER	K MAILAND	9/2/10			
					APPROVAL	K MAILAND	9/2/10	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1

D1000631 aLIGO TOP ADD MASS TOWER, PART PDM REV: X-019, DRAWING PDM REV: X-012