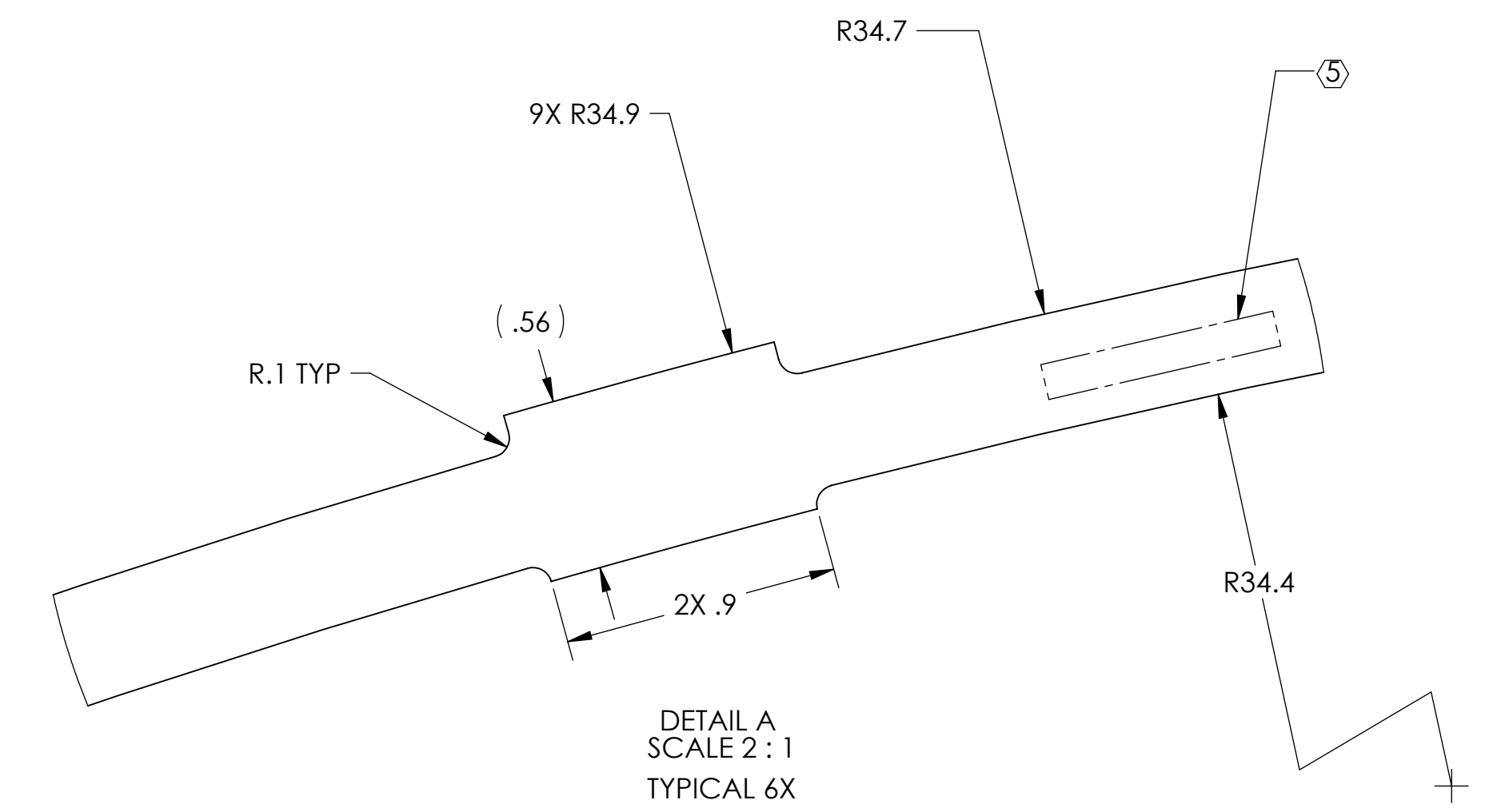
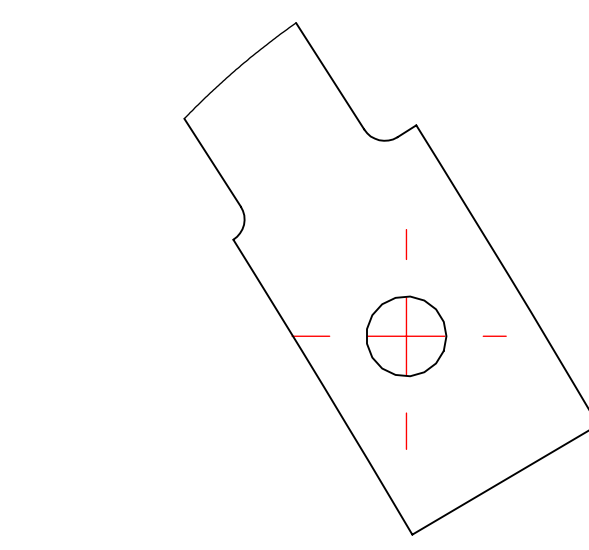
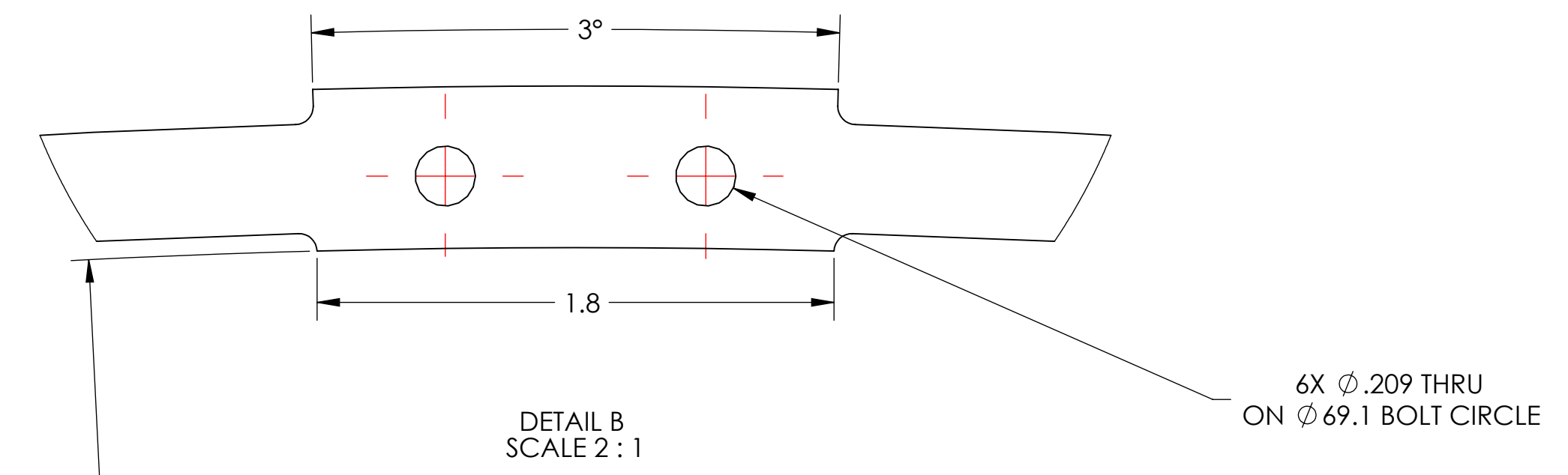
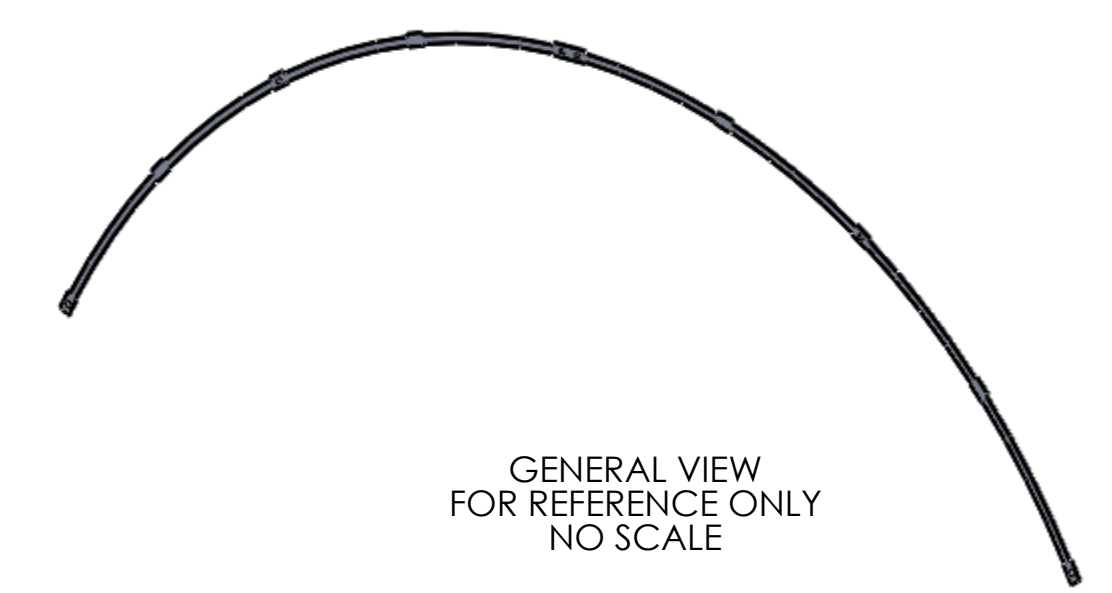
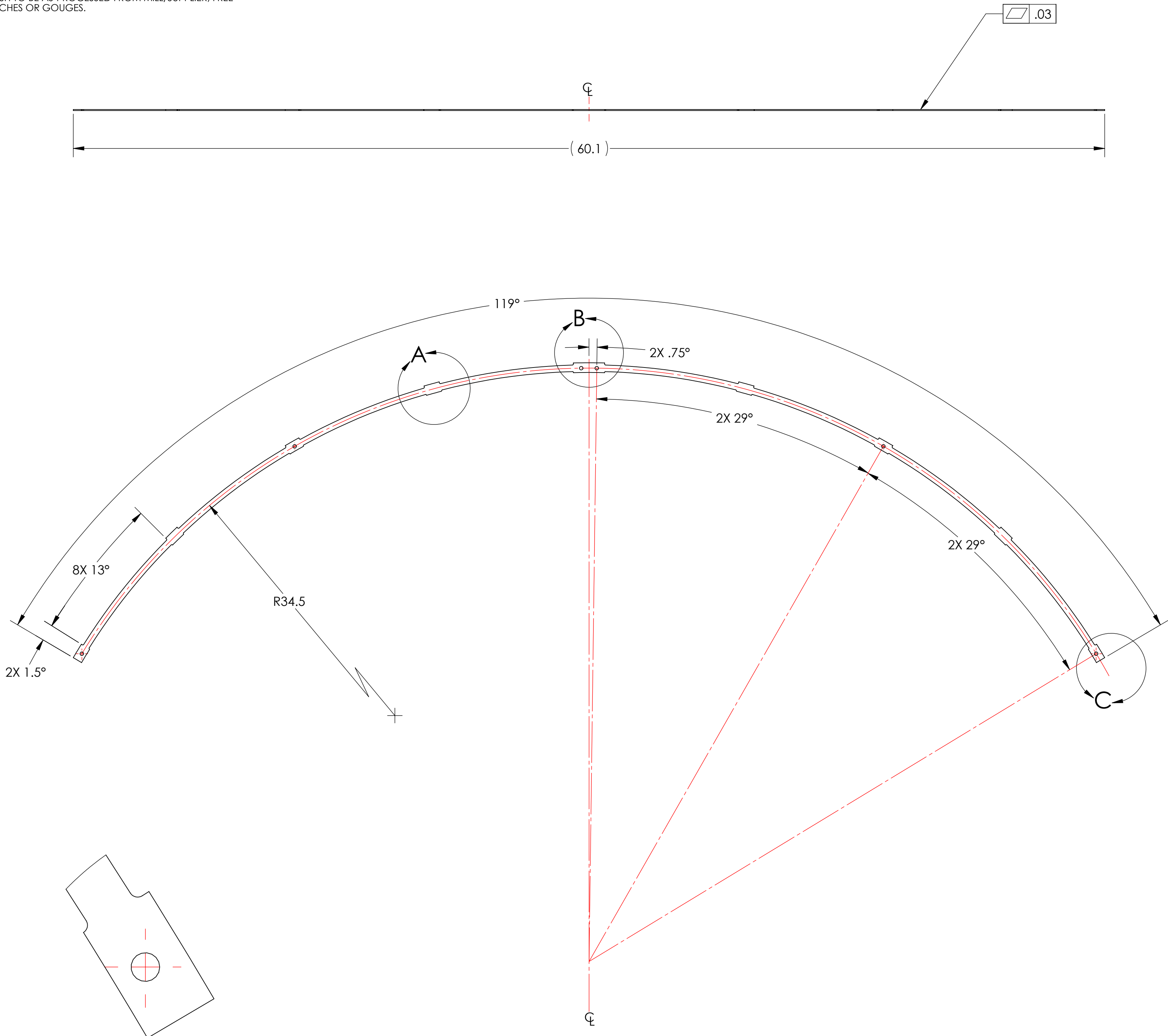


NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND 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 DO NOT APPLY MARK ON SUPER #8 SIDE

6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 7. 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.

8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

REV.	DATE	DCN #	DRAWING TREE #
v1	08 SEP 2010	E1000360	E1000085
v2	12 MAY 2011	E1000360-v2	E1000090
v3	12 SEP 2011	E1000360-v3	E1000091



THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE NEXT ASSEMBLY FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
TOLERANCES:		1. INTERPRET DRAWING PER ASME Y14.5-1994.	
.X	± .1	2. REMOVE ALL SHARP EDGES .005-.015 ON ALL EDGES AND HOLES.	
.XX	± .06	3. DO NOT SCALE FROM DRAWING.	
.XXX	± .010	4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
ANGULAR ± 1.0°		MATERIAL	FINISH
		14 GAUGE 304 SSSL	(8)

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 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

NEXT ASSY: VARIOUS

PART NAME				REV.	
RADIAL ATTACHMENT NUT PLATE				v3	
DESIGNER	H. KELMAN	6 APRIL 2010	SIZE	DWG. NO.	
DRAFTER	TQ. NGUYEN	17 AUG 2010	D	D1001073	
CHECKER	M. SMITH	27 SEP 2011	SCALE: 1:4	PROJECTION:	
APPROVAL	D. COYNE			SHEET 1 OF 1	

D1001073.dwg; Weld; Nut; Plate; PART FDM; REV: X-025; DRAWING FDM; REV: X-019