

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

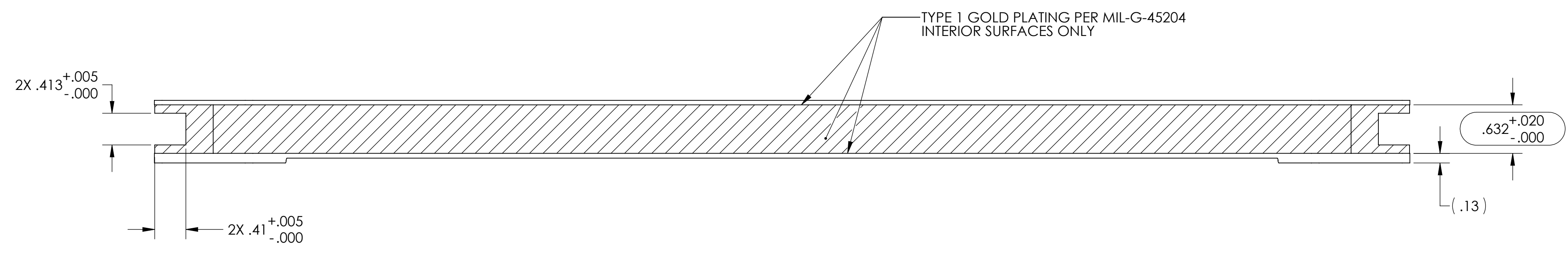
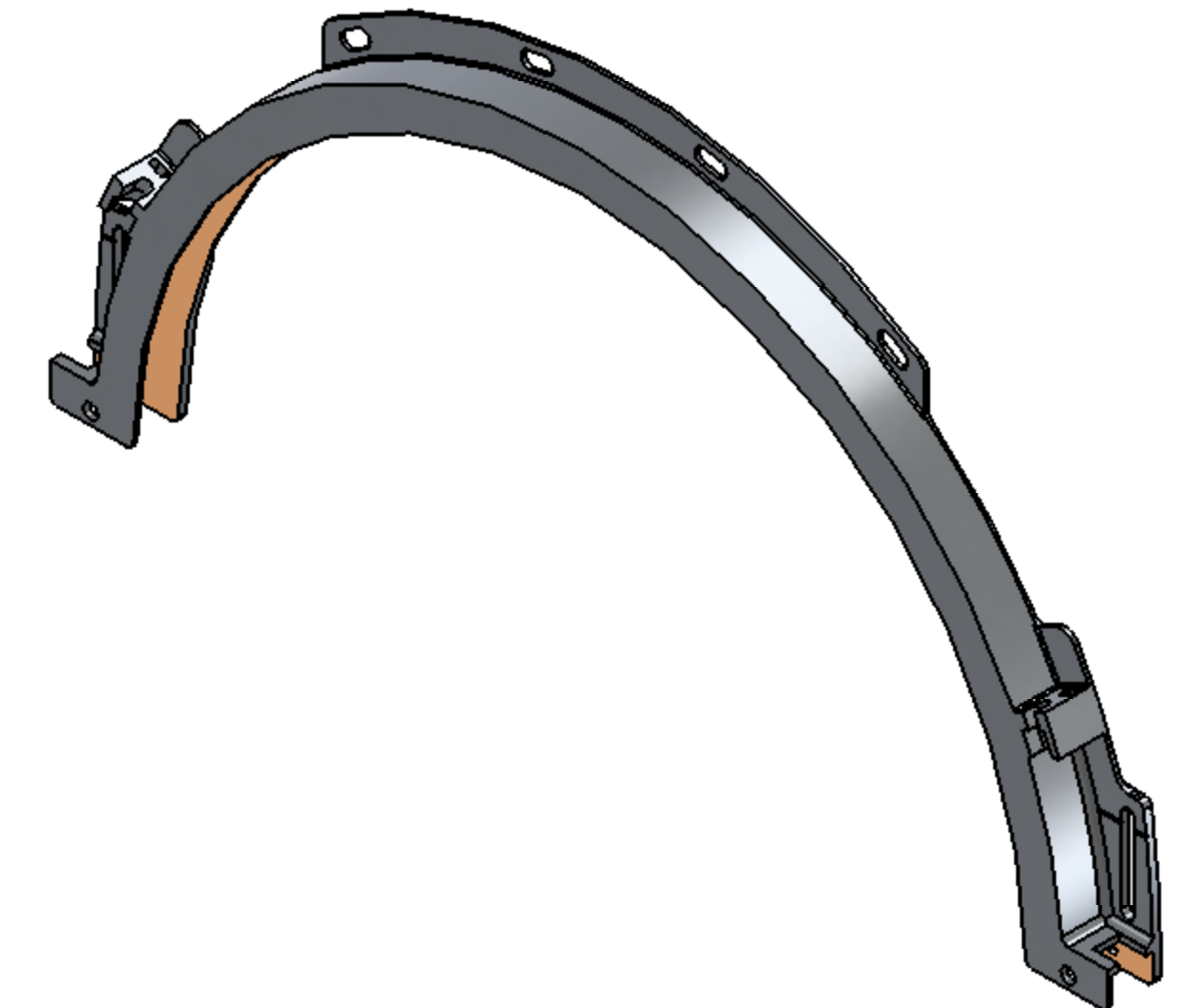
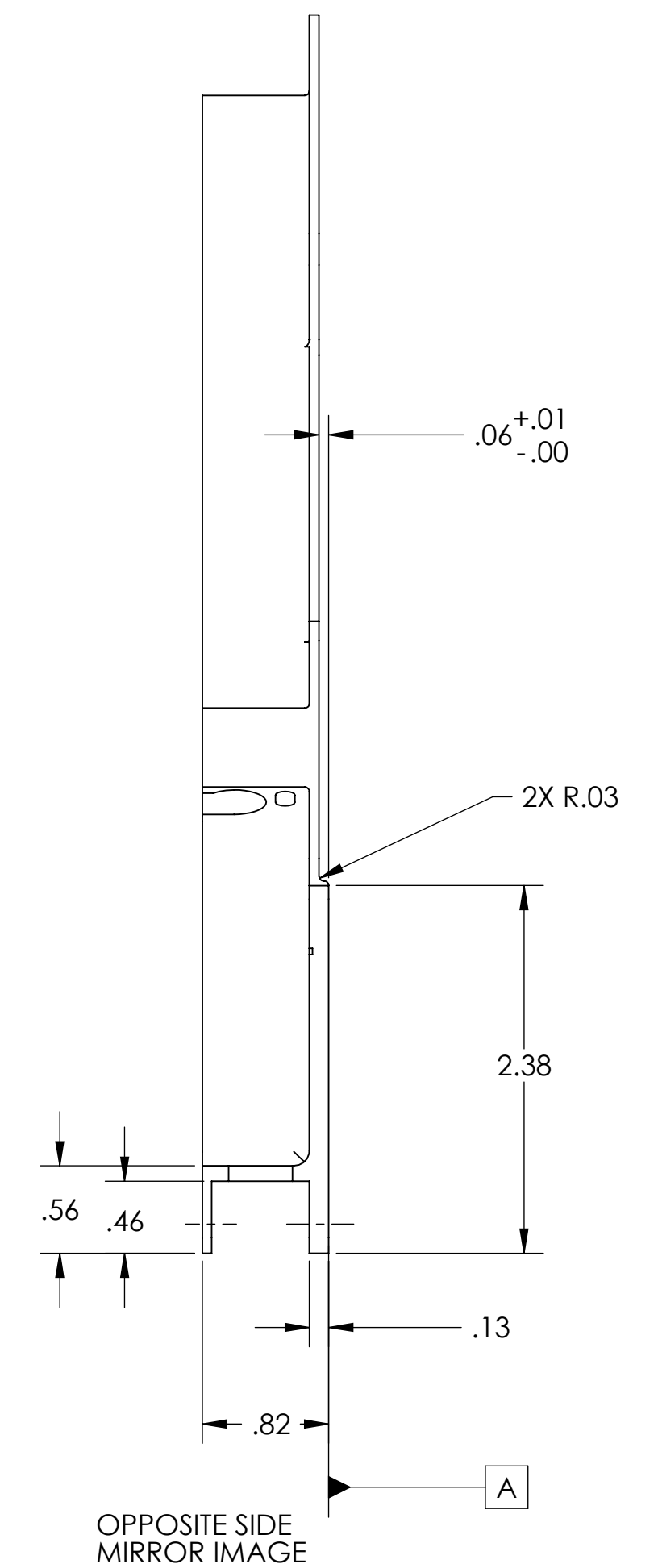
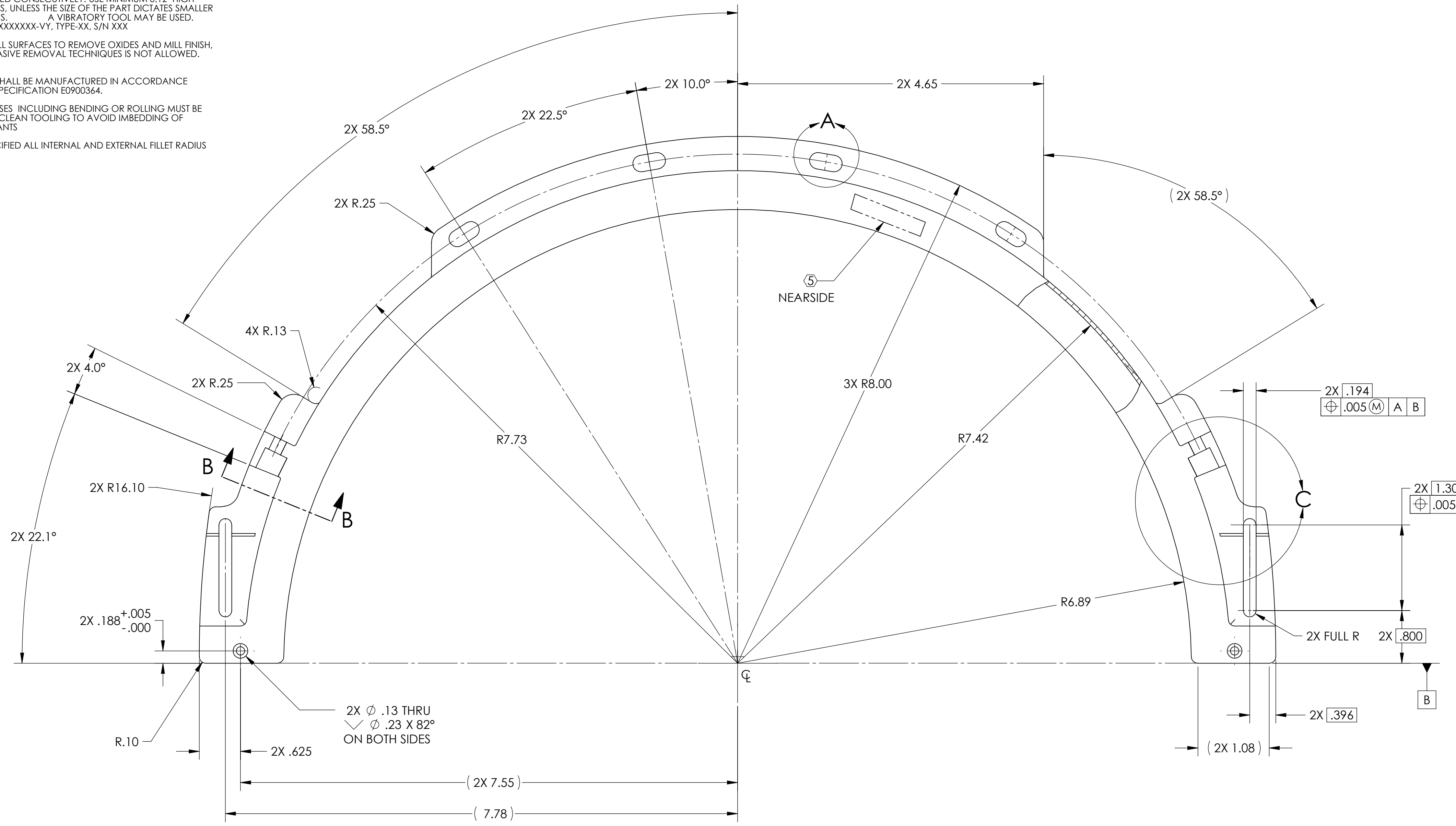
6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

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

8. ALL PROCESSES INCLUDING BENDING OR ROLLING MUST BE DONE WITH CLEAN TOOLING TO AVOID IMBEDDING OF CONTAMINANTS

9. UNLESS SPECIFIED ALL INTERNAL AND EXTERNAL FILLET RADIUS ARE .10IN

REV.	DATE	DCN #	DRAWING TREE #
v1	04-AUG-2010	E1000291	E1000295-v1
-	-	-	-
-	-	-	-



DIMENSIONS ARE IN INCHES	
TOLERANCES:	.XX ± .01
	.XXX ± .005
ANGULAR ±	0.5°

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
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.
MATERIAL	6061 Alloy
FINISH	32 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

NEXT ASSY: D1001895

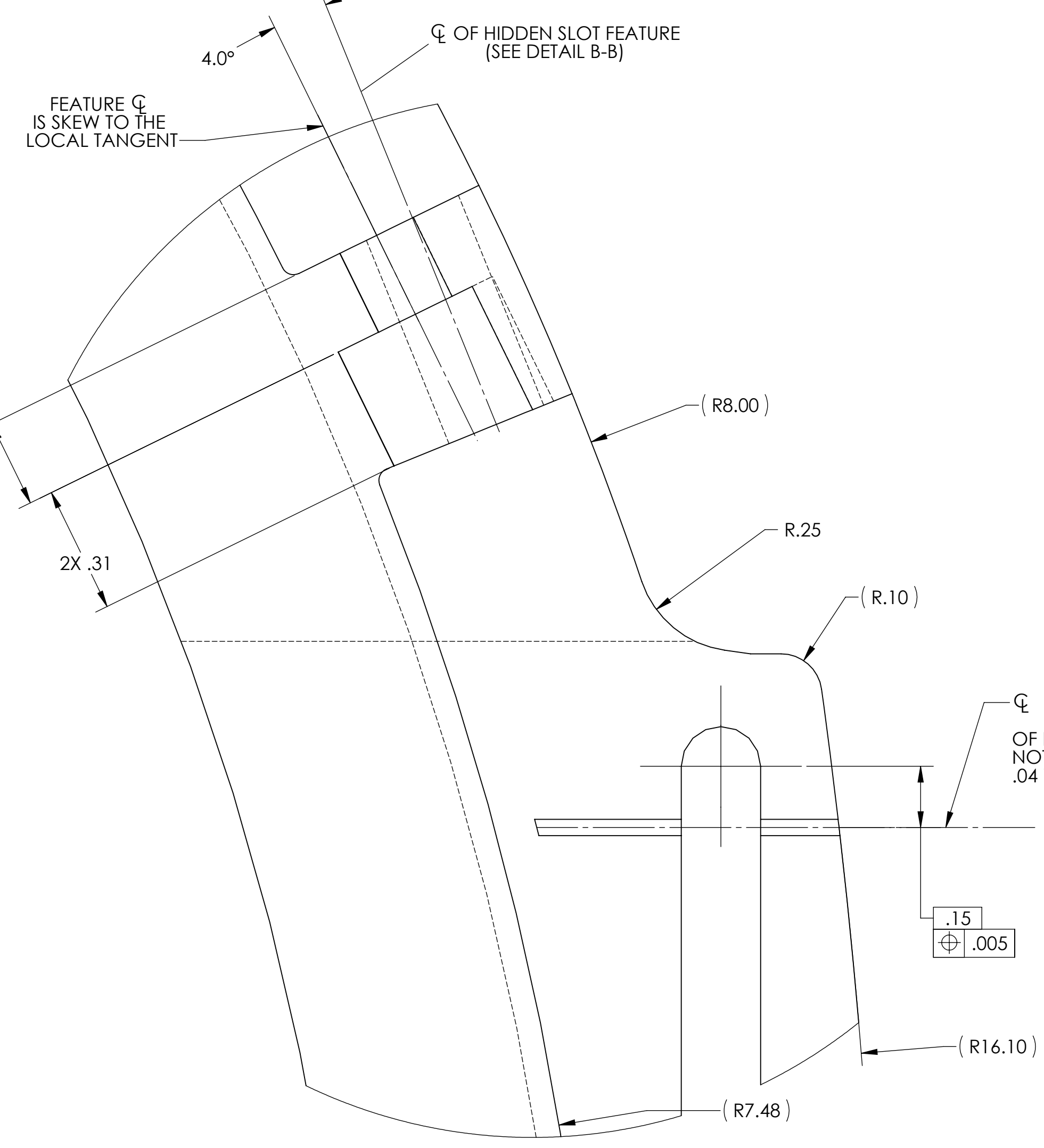
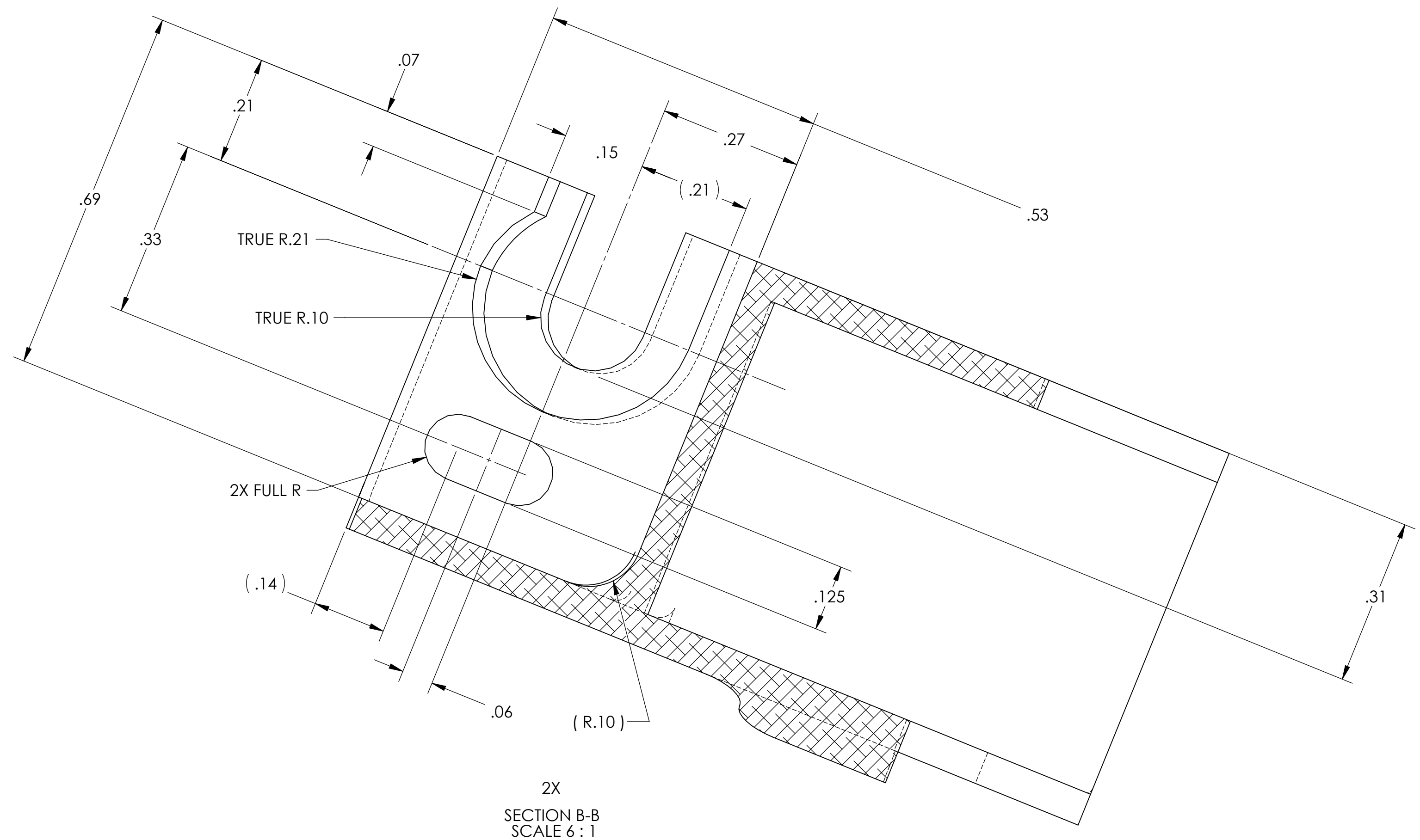
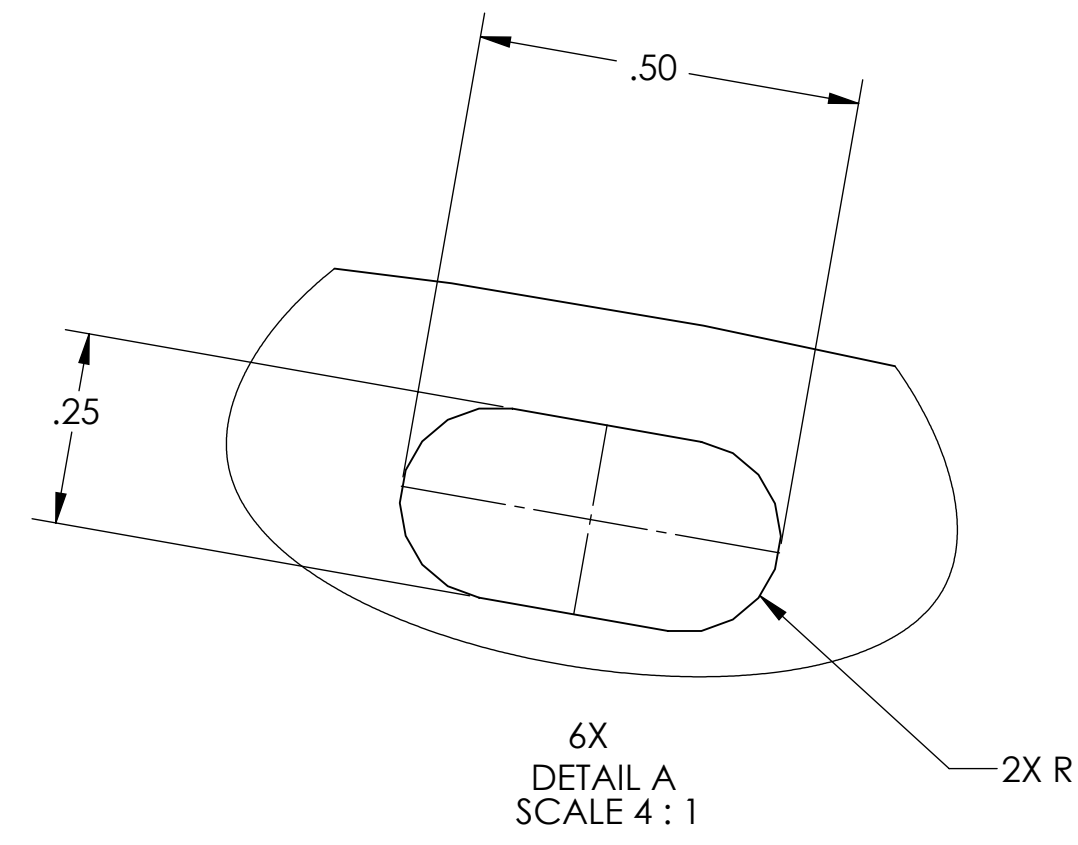
PART NAME		ALIGO TCS LOWER MONOLITHIC RH SHIELD	
DESIGNER	M. JACOBSON	21 APR 2010	SIZE DWG. NO.
DRAFTER	A. COLE	7/13/2010	D
CHECKER	C. TORRIE	7/19/2010	D1001680
APPROVAL	P. WILLEMS	7/13/2010	SCALE: 1:2
			PROJECTION:
			SHEET 1 OF 2

D1001680_ALIGO TCS LOWER MONOLITHIC RH SHIELD PART PDM REV: X-004 DRAWING PDM REV: X-010

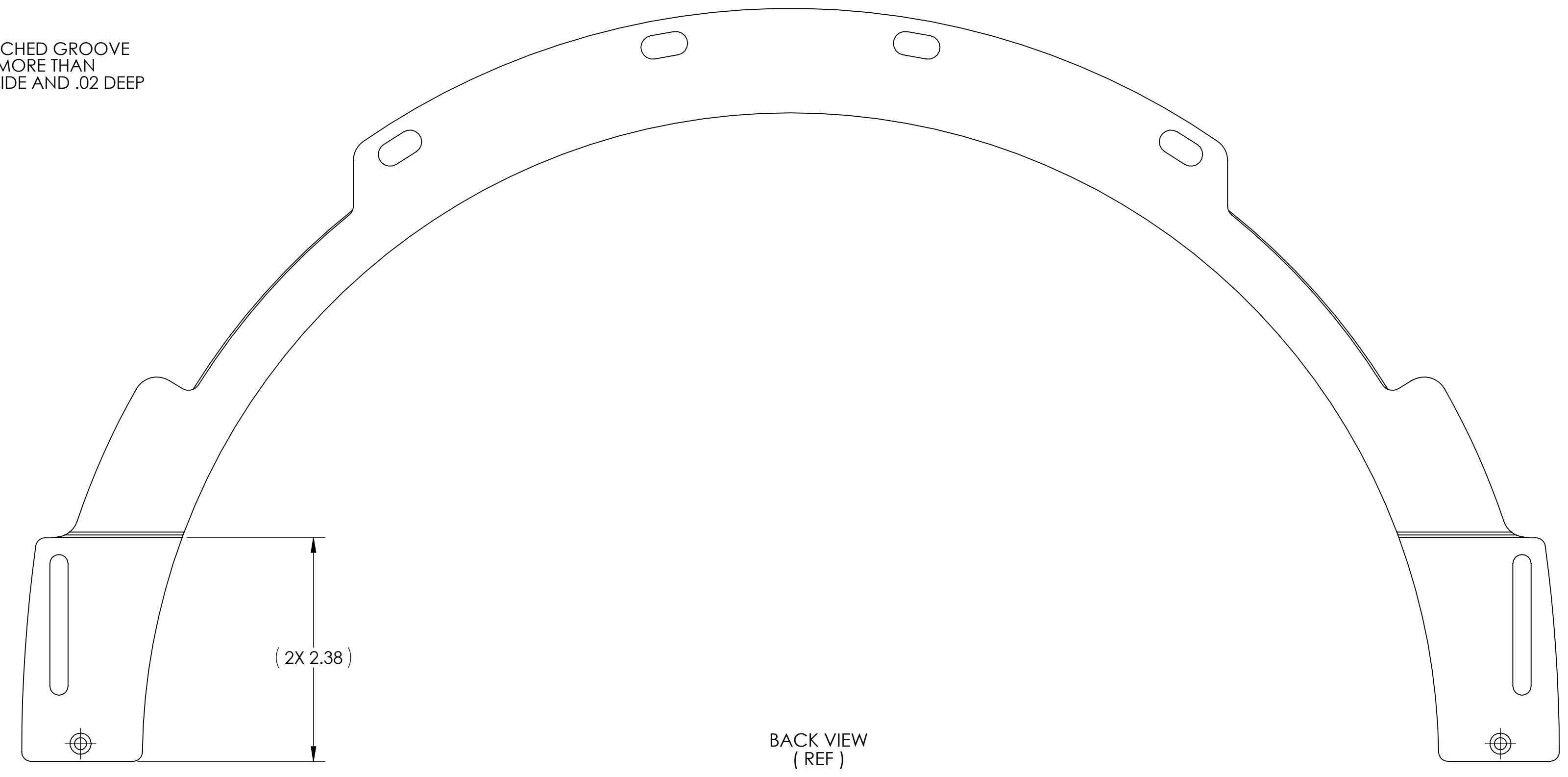
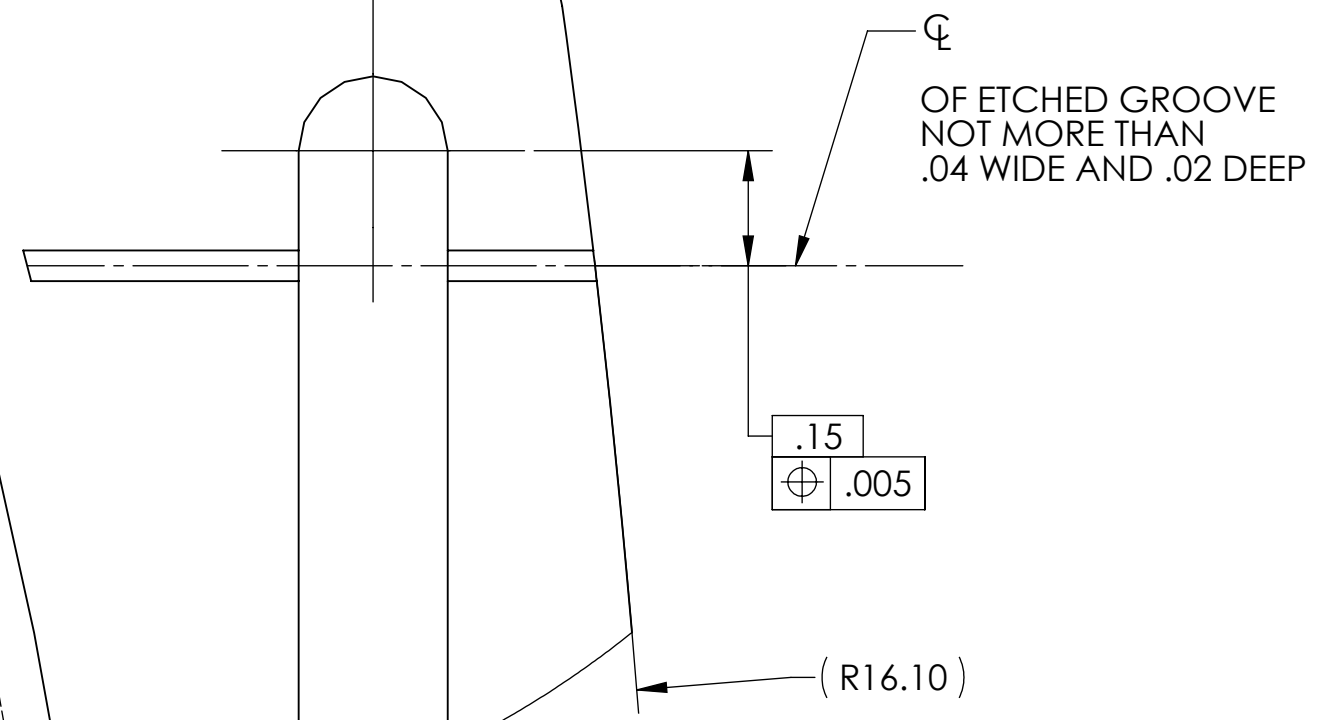
8 7 6 5 4 3 2 1

H
G
F
E
D
C
B
A

H
G
F
E
D
C
B
A



2X
DETAIL C
SCALE 4:1



LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
D	D1001680	v1
SCALE: 1:2	PROJECTION:	SHEET 2 OF 2

D:\001_680_ALUGO_TC3 LOWER MONODIRING HEATER SHIELD PART PDM REV: X-004 DRAWING PDM REV: X-010