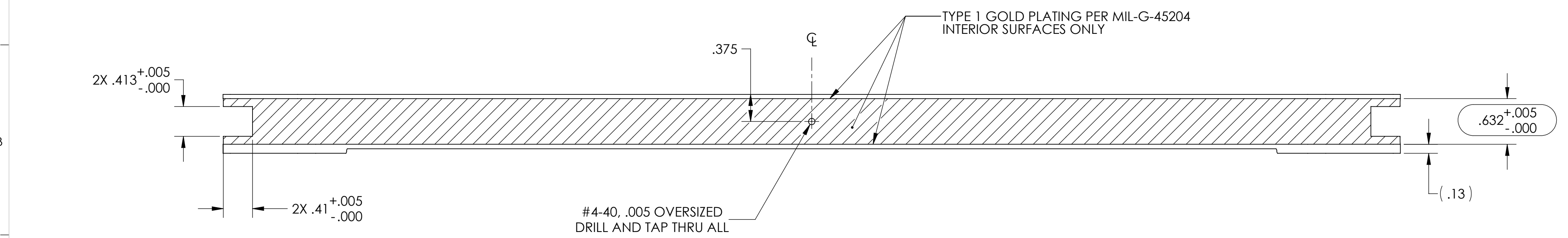
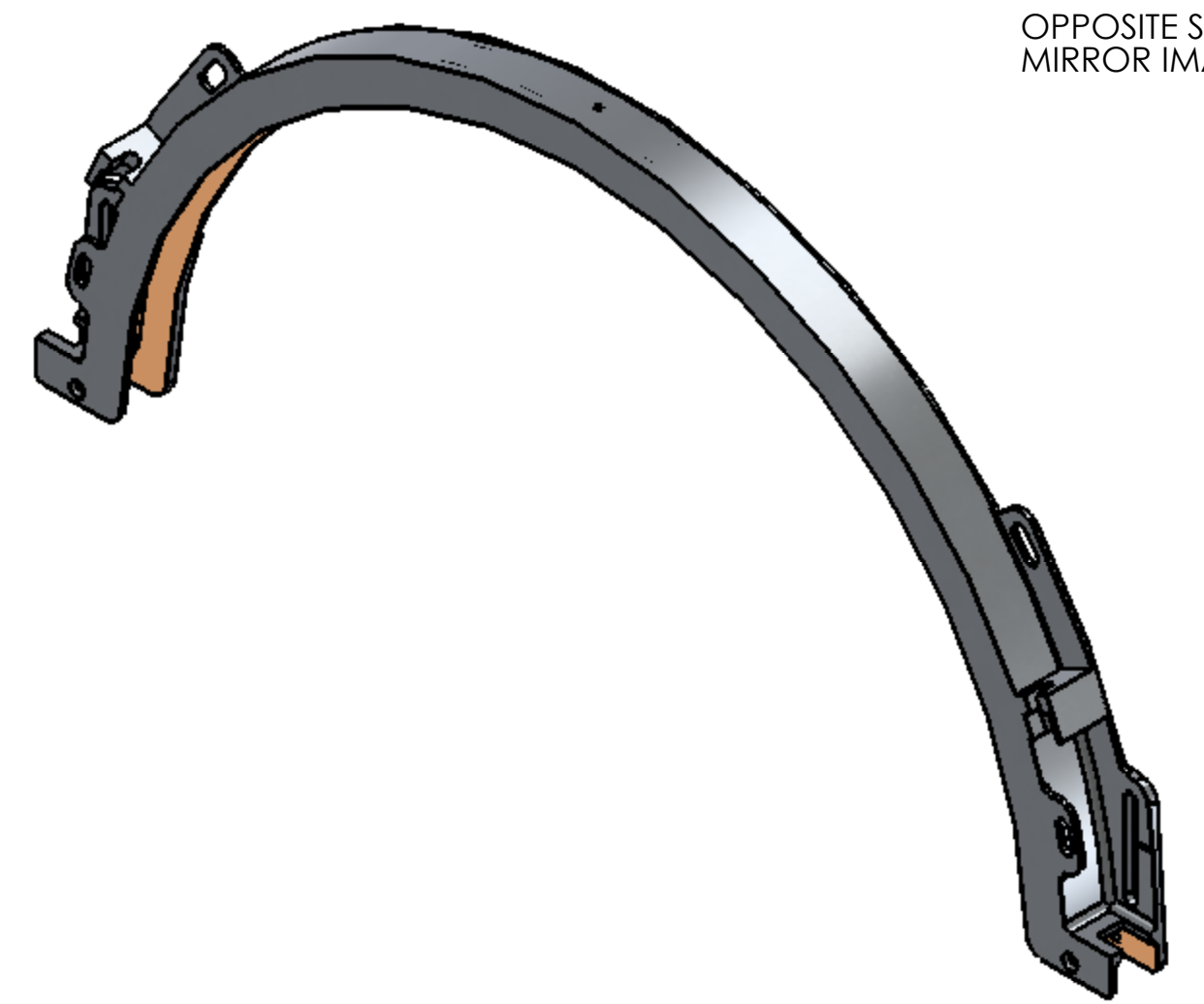
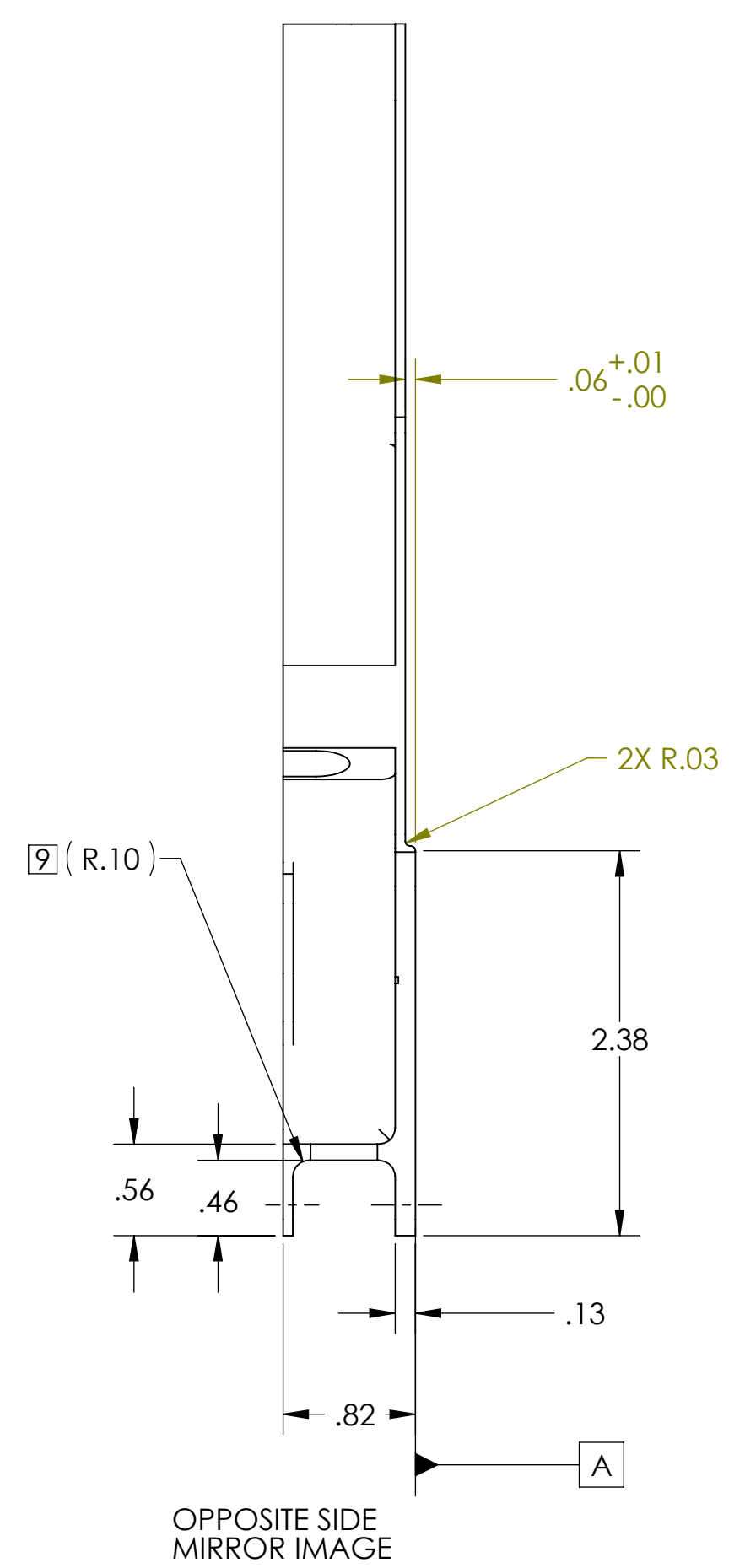
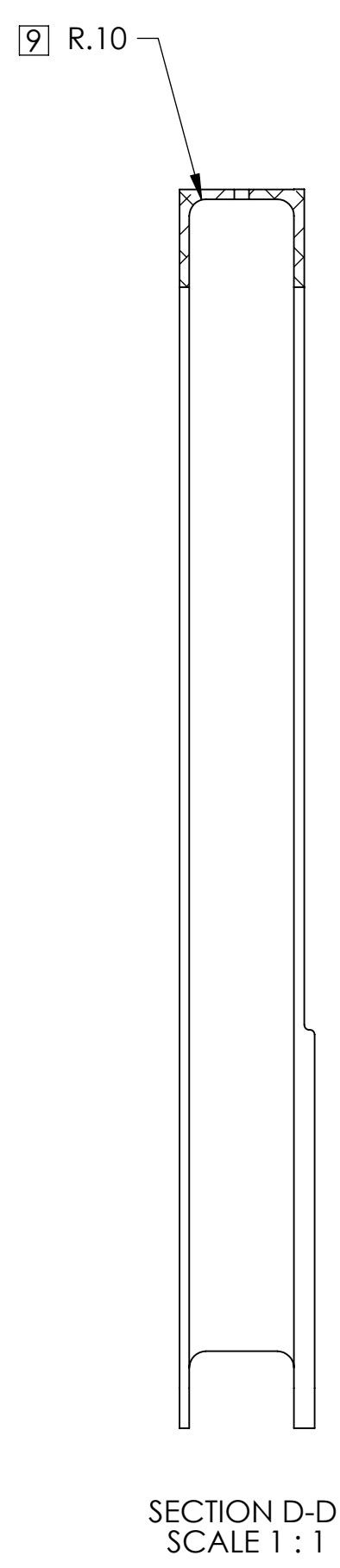
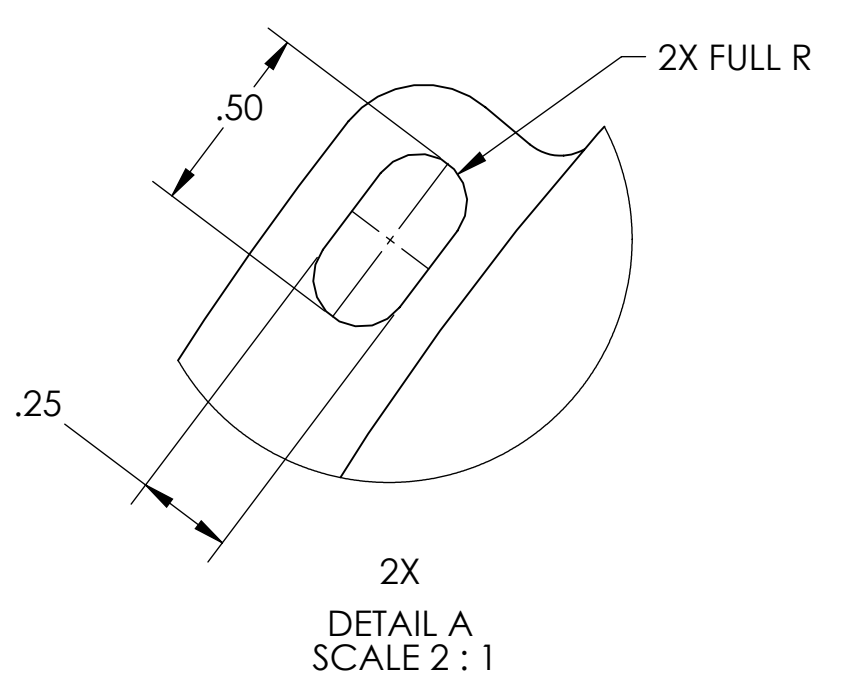
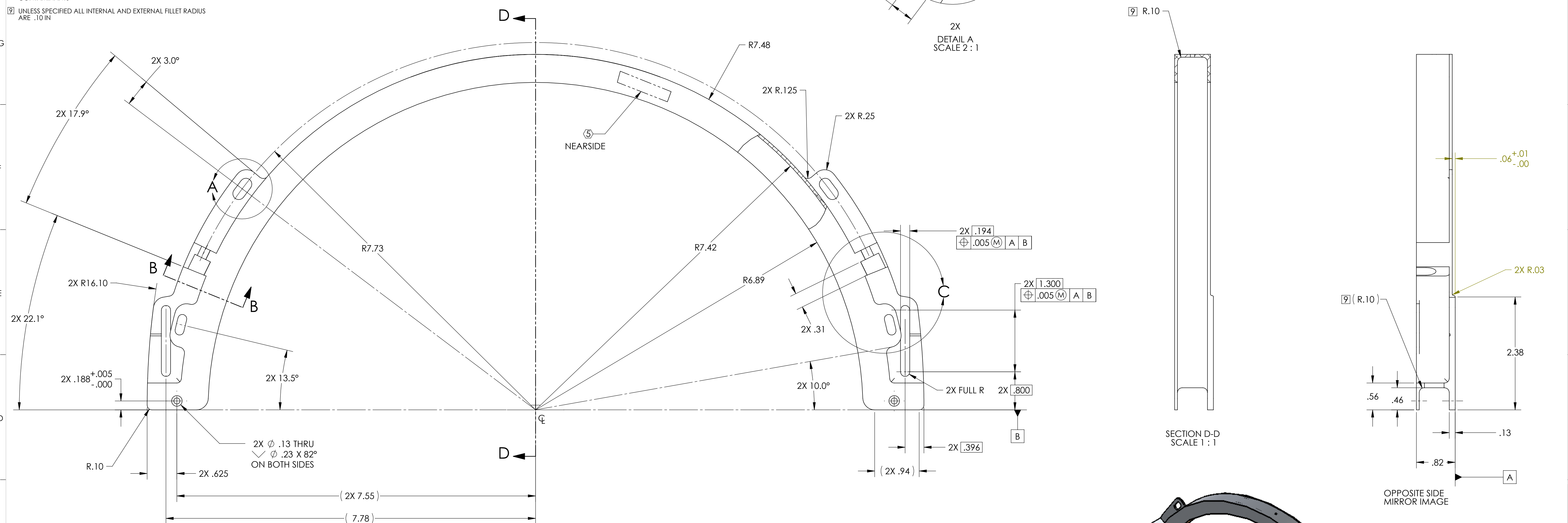


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION [AND VARIANT OR TYPE IF APPLICABLE] ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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
v2	20-OCT-2010	E1000291	E1000295-v3
v3	16-NOV-2010	E1000291	E1000295-v4



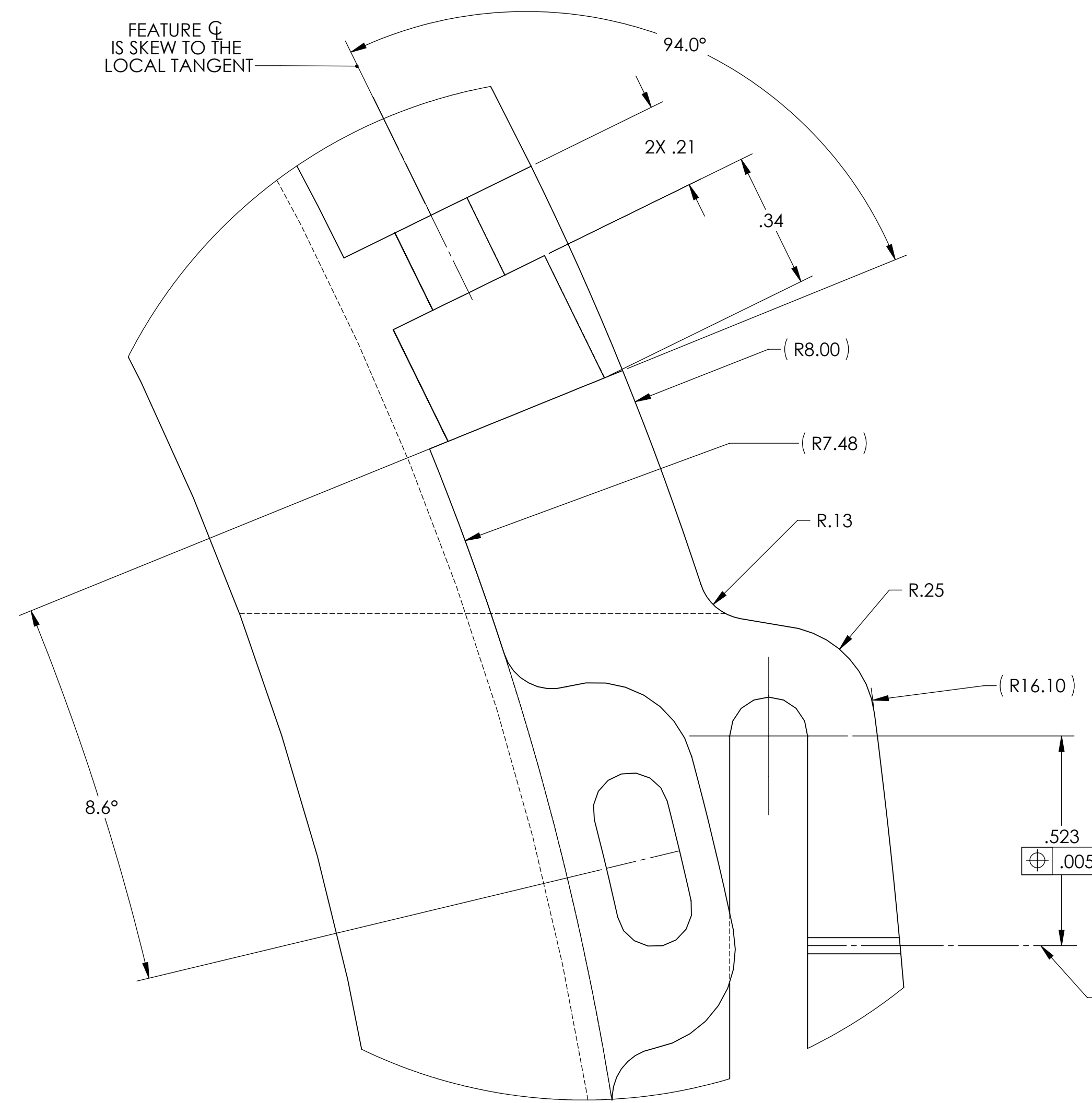
DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME ALIGO TCS LOWER MONOLITHIC RH SHIELD	
TOLERANCES: .XX ± .01 .XXX ± .005		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP 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.		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
ANGULAR ± 0.5°		MATERIAL 6061 Alloy		FINISH 32 μinch		NEXT ASSY D1001895	
				DESIGNER M. JACOBSON 21 APR 2010		SIZE DWG. NO. D D1001680	
				DRAFTER A. COLE 7/13/2010		REV. v3	
				CHECKER C. TORRIE 7/19/2010		SCALE: 1:2 PROJECTION:	
				APPROVAL P. WILLEMS 7/13/2010		SHEET 1 OF 2	

D1001680_ALIGO TCS LOWER MONOLITHIC RH SHIELD PART PDM REV: X-013 DRAWING PDM REV: X-023

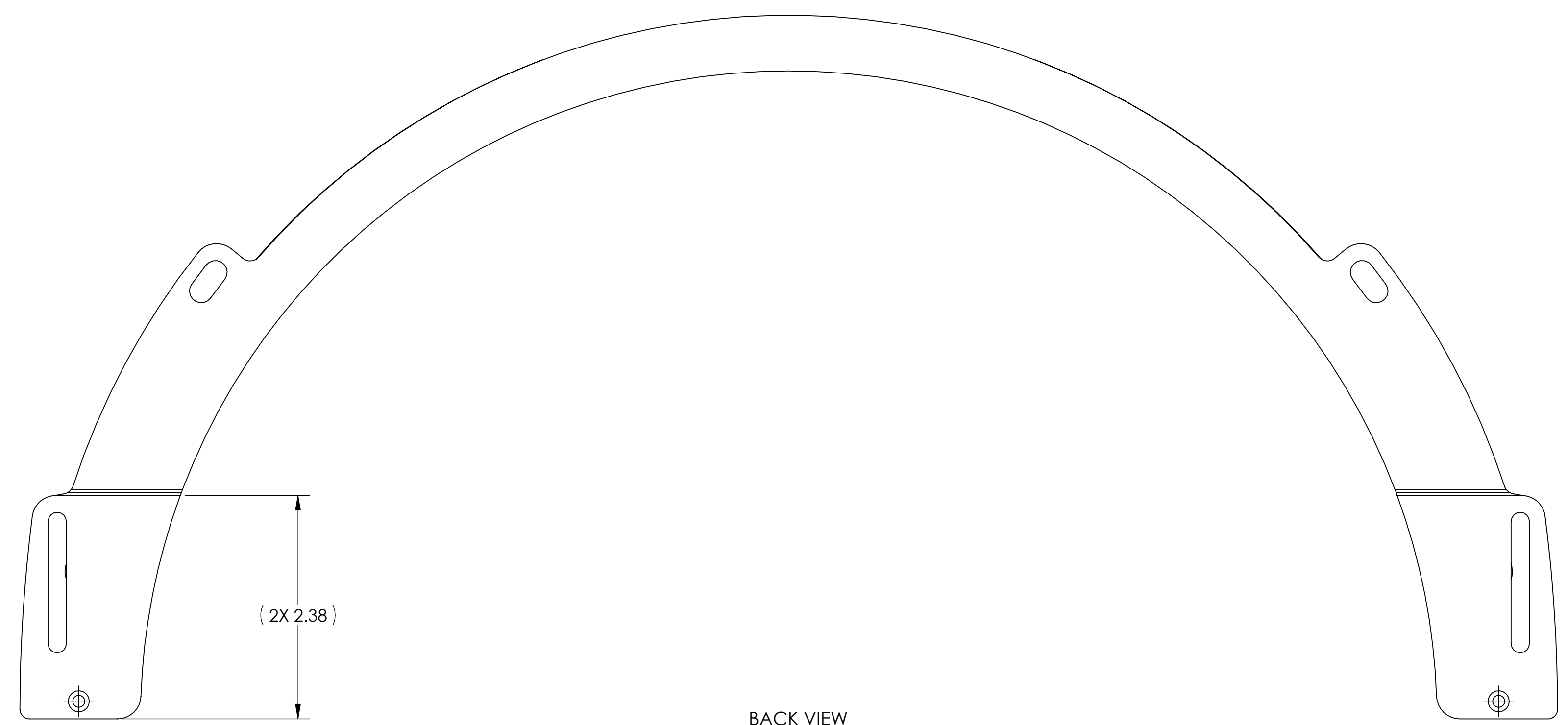
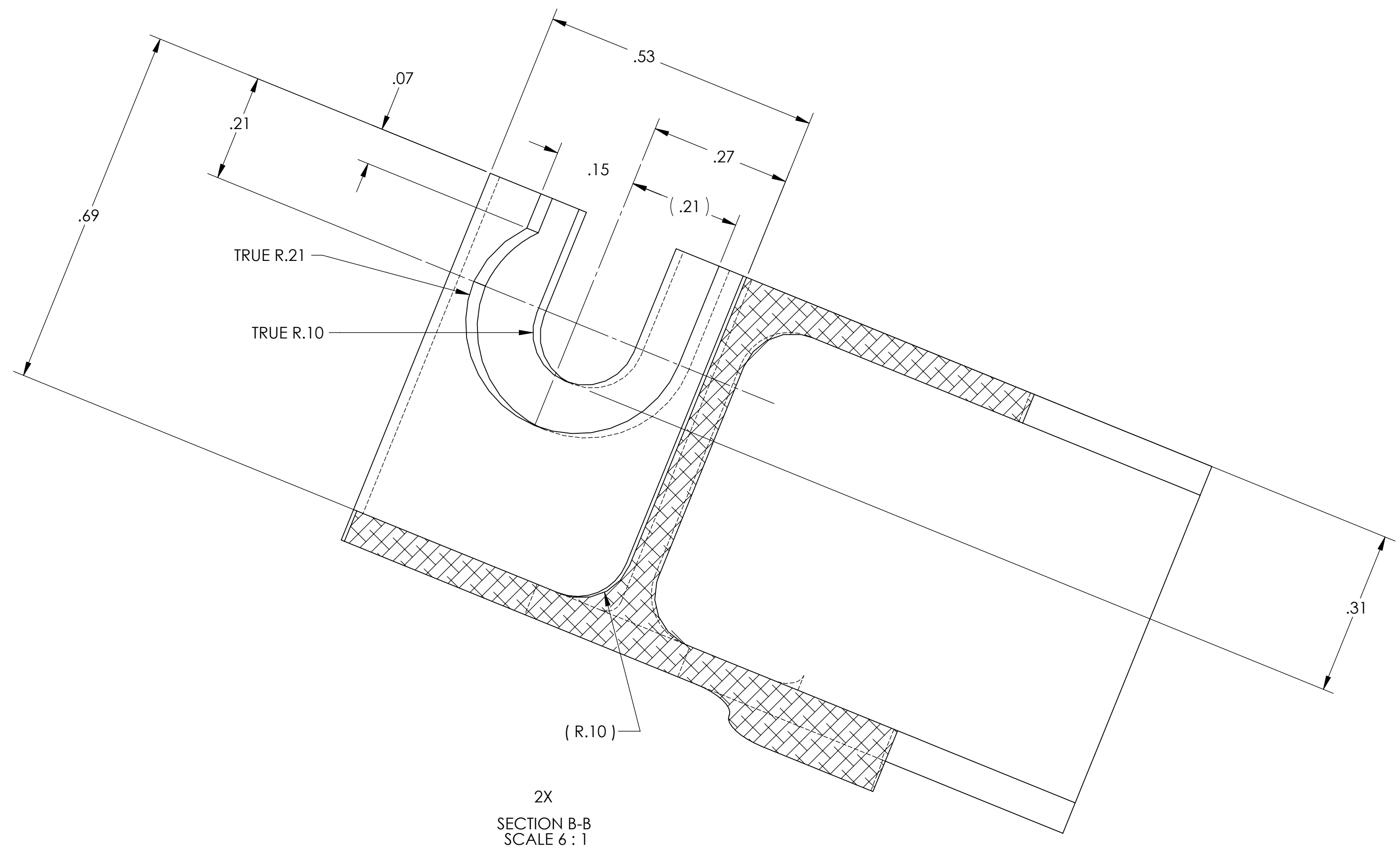
8 7 6 5 4 3 2 1

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E
D
C
B
A

FEATURE C IS SKEW TO THE LOCAL TANGENT



2X
DETAIL C
SCALE 4 : 1



LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE	DWG. NO.	REV.
D	D1001680	v3
SCALE: 1:2	PROJECTION:	SHEET 2 OF 2

8 7 6 5 4 3 2 1

H
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D
C
B
A

D:\001_680_ALIGO_TC3 LOWER MONODIRING HEATER SHIELD PART PDM REV: X-013 DRAWING PDM REV: X-023