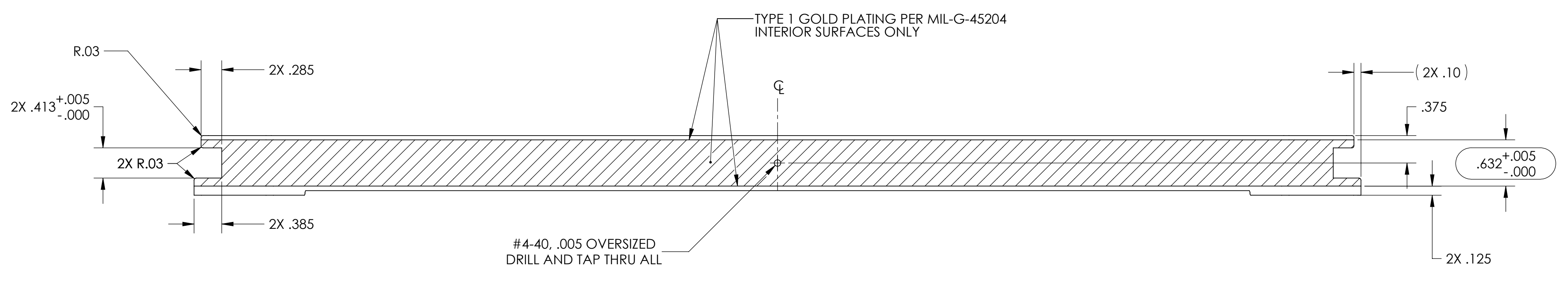
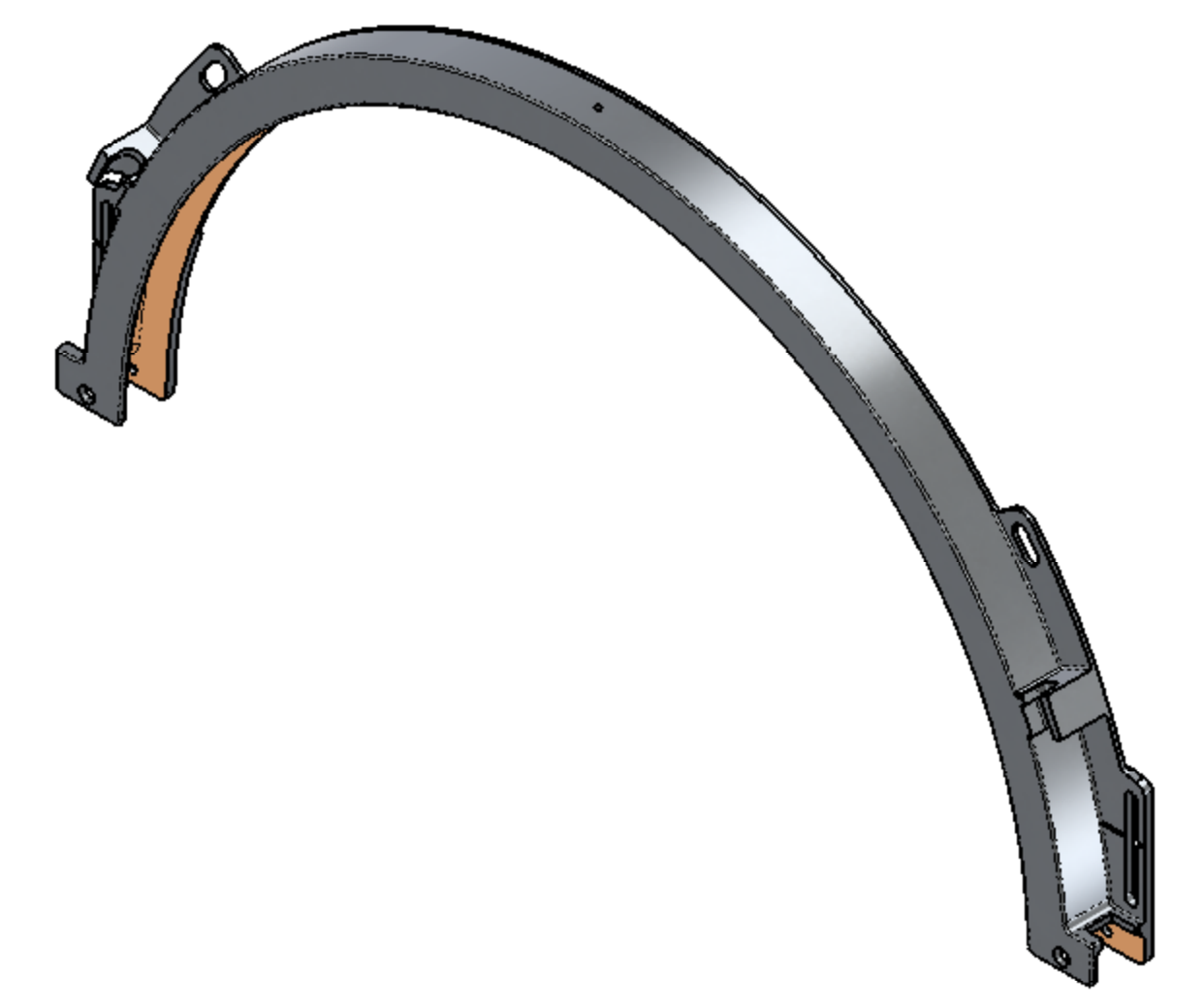
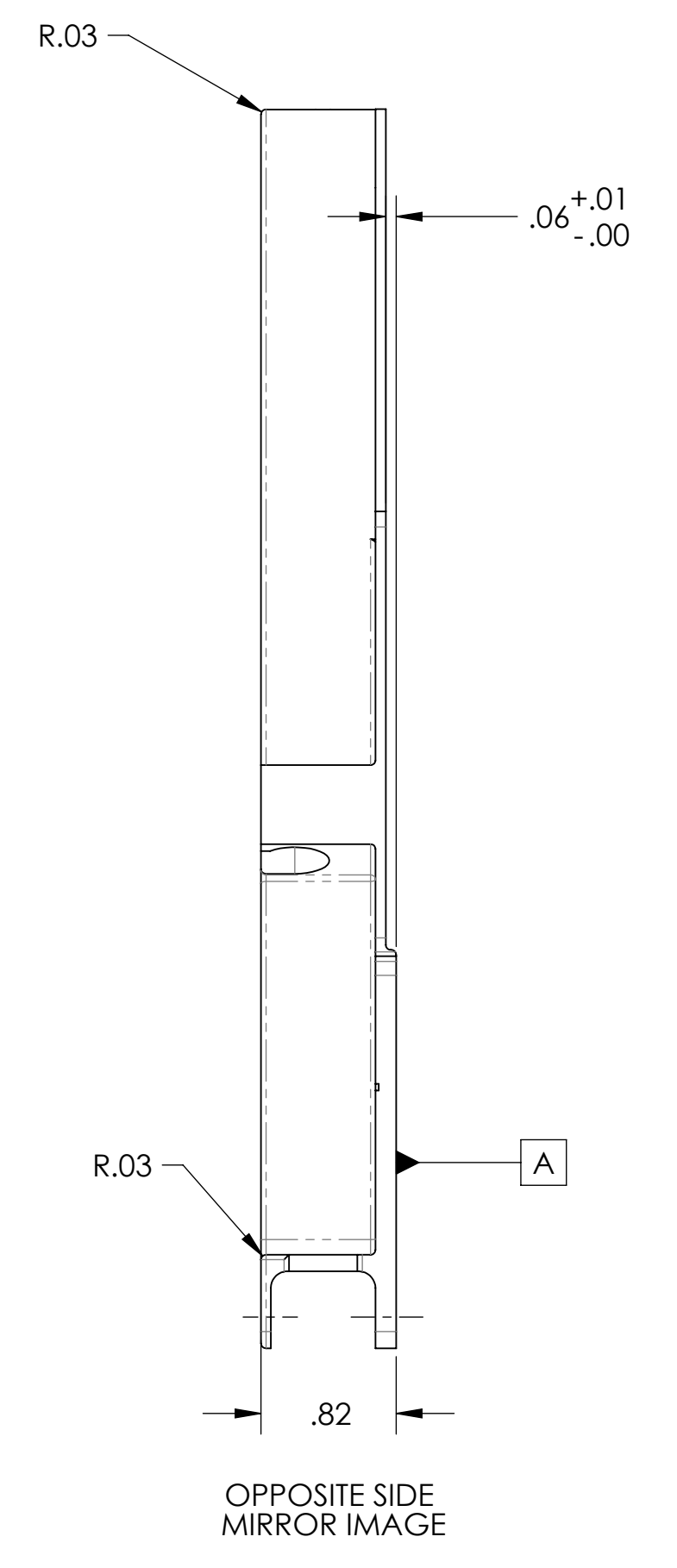
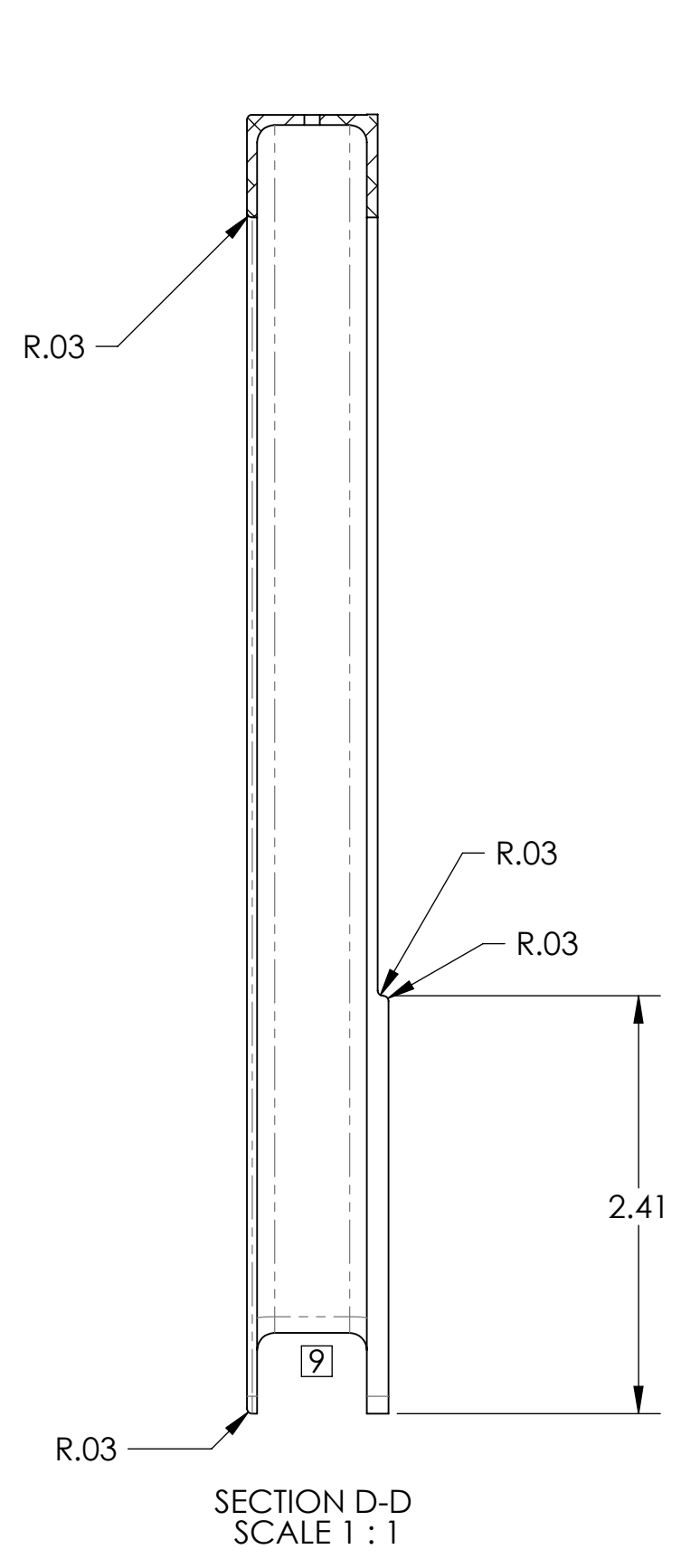
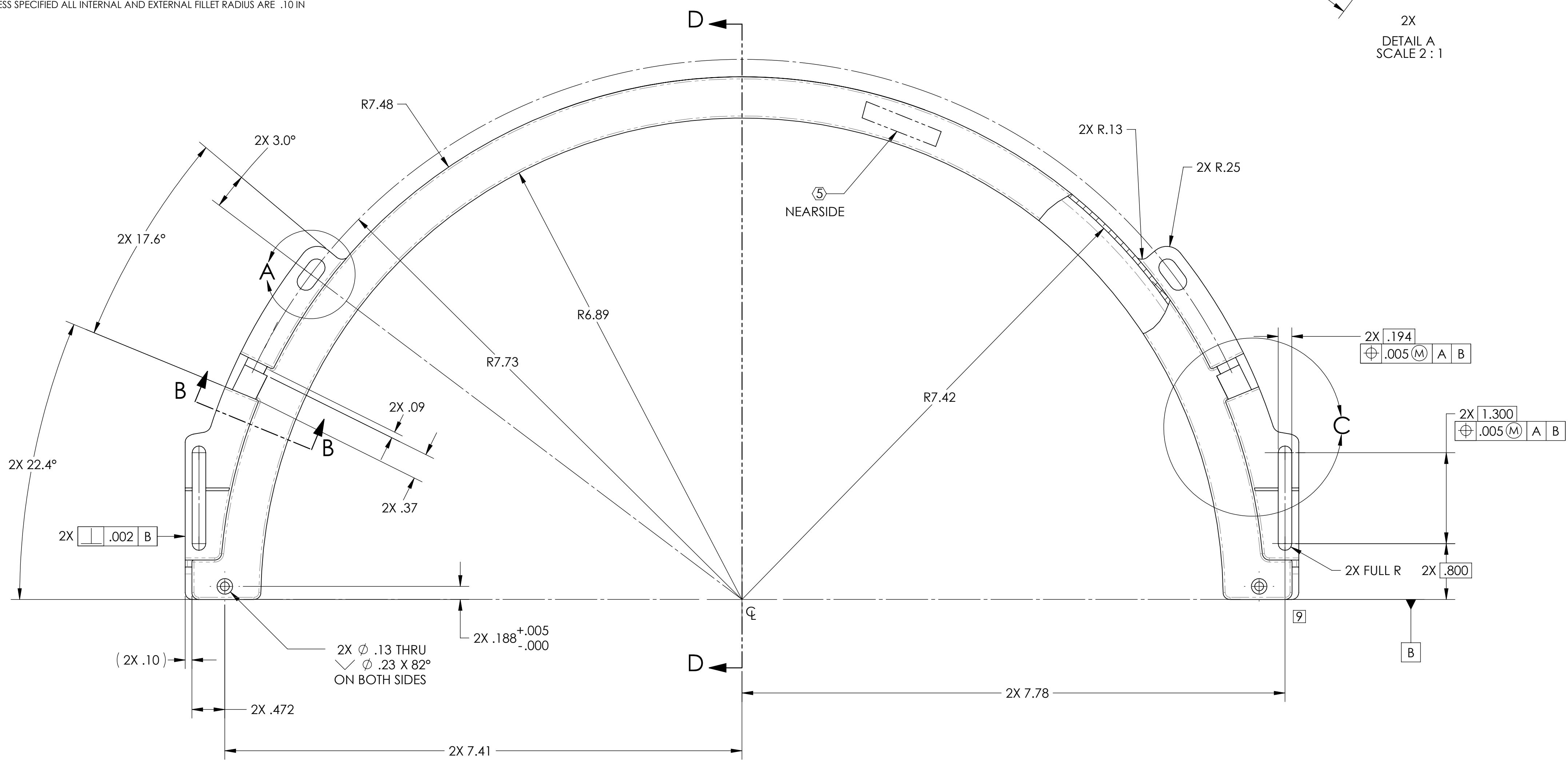
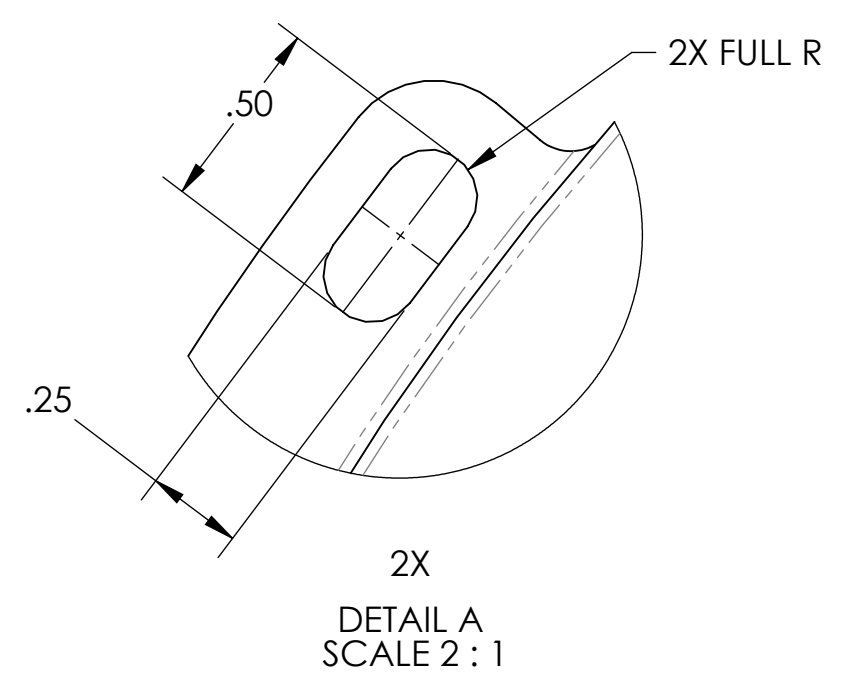


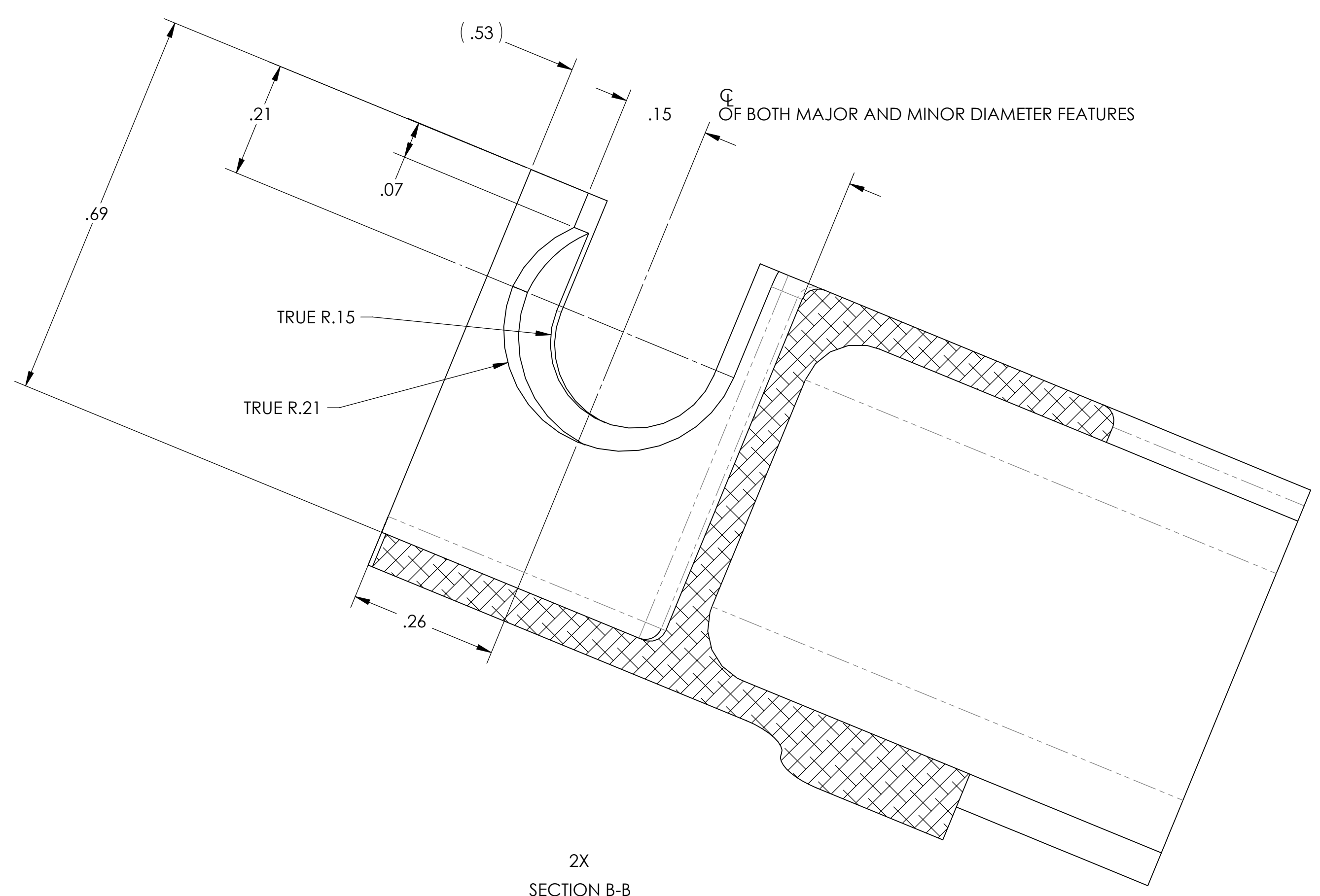
- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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 .10 IN

REV.	DATE	DCN #	DRAWING TREE #
v1	04-AUG-2010	E1000291-v1	E1000295-v1
v2	20-OCT-2010	E1000291-v2	E1000295-v3
v3	16-NOV-2010	E1000291-v3	E1000295-v4
v4	03-DEC-2010	E1000291-v4	E1000295-v5

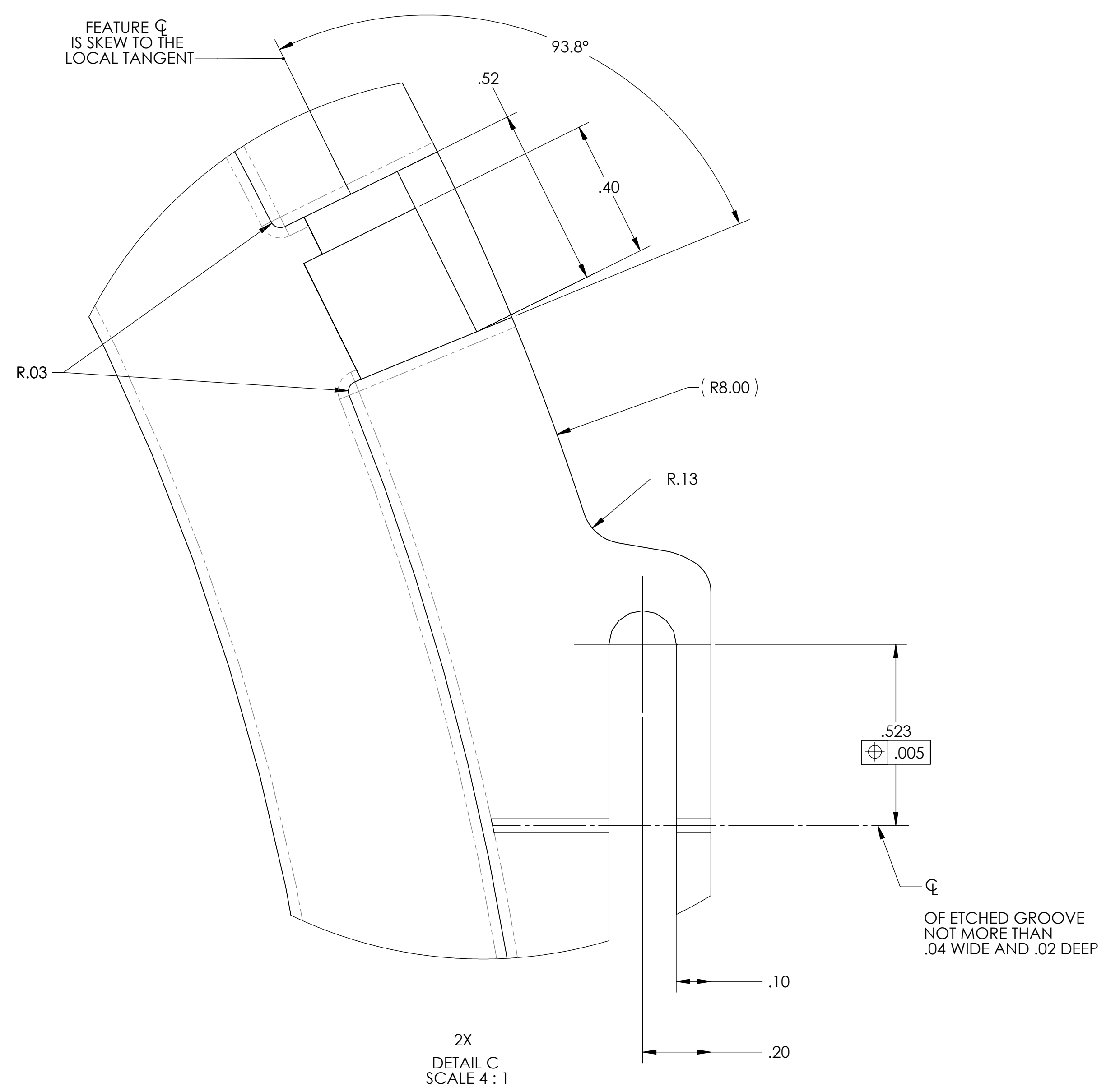


DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± .01 .XXX ± .005		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM ADVANCED LIGO		SUB-SYSTEM	
ANGULAR ± 0.5°		MATERIAL		NEXT ASSY		AOS D1001895	
		FINISH				DESIGNER M. JACOBSON 21 APR 2010	
		6061 Alloy				SIZE DWG. NO. D D1001680	
		32 μinch				CHECKER C. TORRIE 7/19/2010	
						APPROVAL P. WILLEMS 7/13/2010	
						SCALE: 1:2 PROJECTION:	
						SHEET 1 OF 2	
						REV. v4	

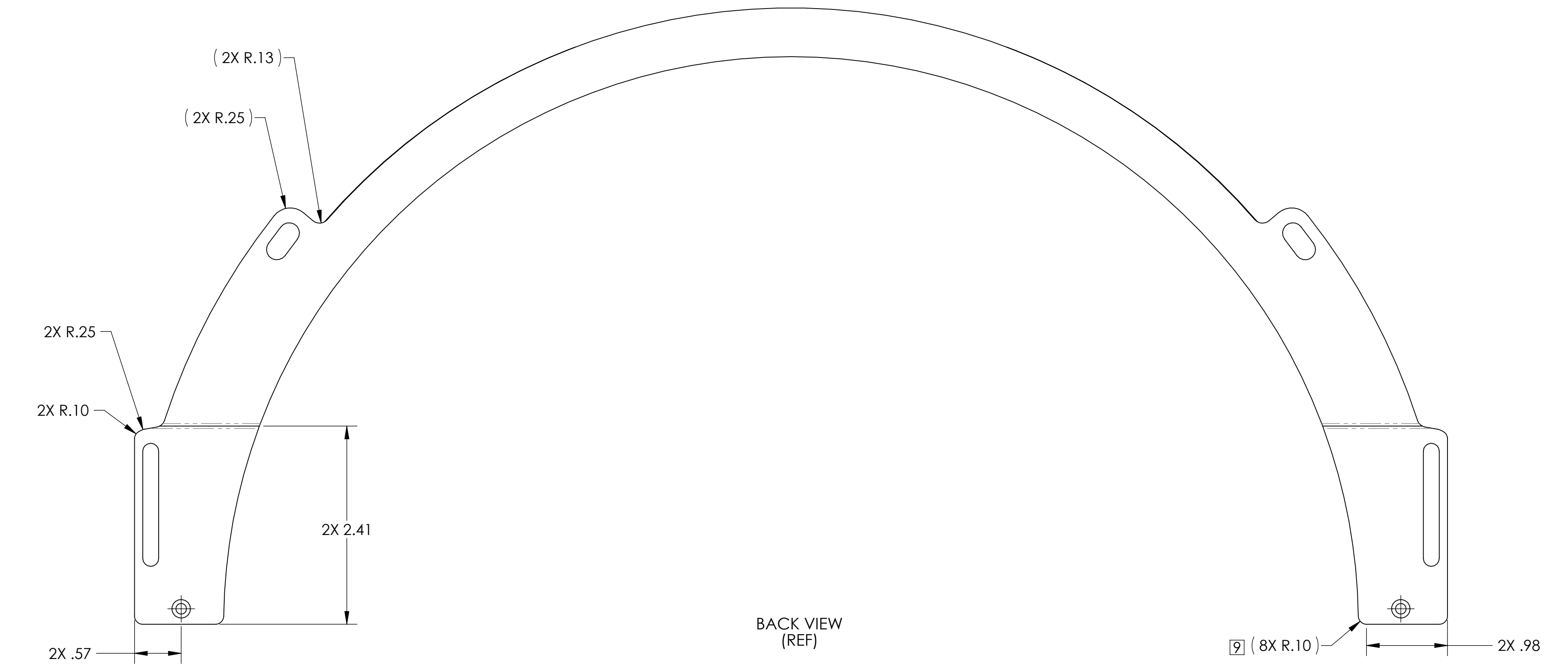
D1001680-4-LALIGO TCS LOWER MONOLITHIC RING HEATER SHIELD PART PDM REV: X-022 DRAWING PDM REV: X-028



2X
SECTION B-B
SCALE 6 : 1



2X
DETAIL C
SCALE 4 : 1



BACK VIEW
(REF)

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
D	D1001680	v4
SCALE: 1:2	PROJECTION:	SHEET 2 OF 2

D1001680-4-LAUGO.TES, LOWER MONOLITHIC RING HEATER SHIELD, PART PDM REV. X:022, DRAWING PDM REV. X:028