

**NOTES CONTINUED:**

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

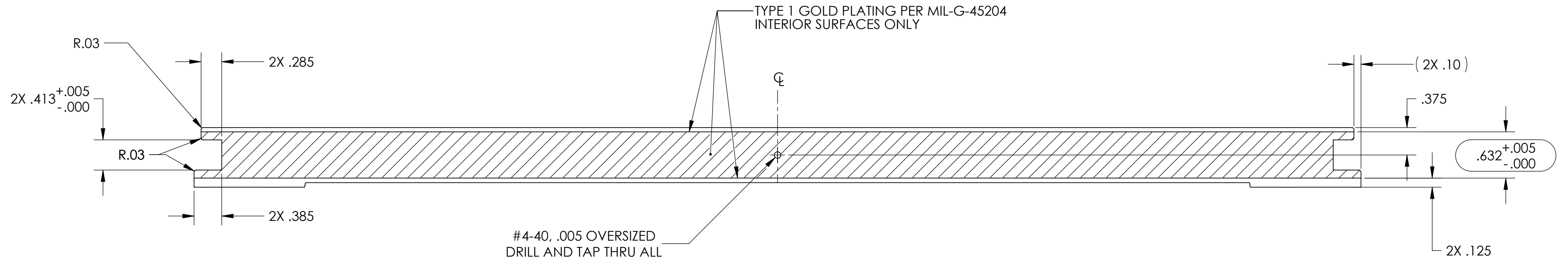
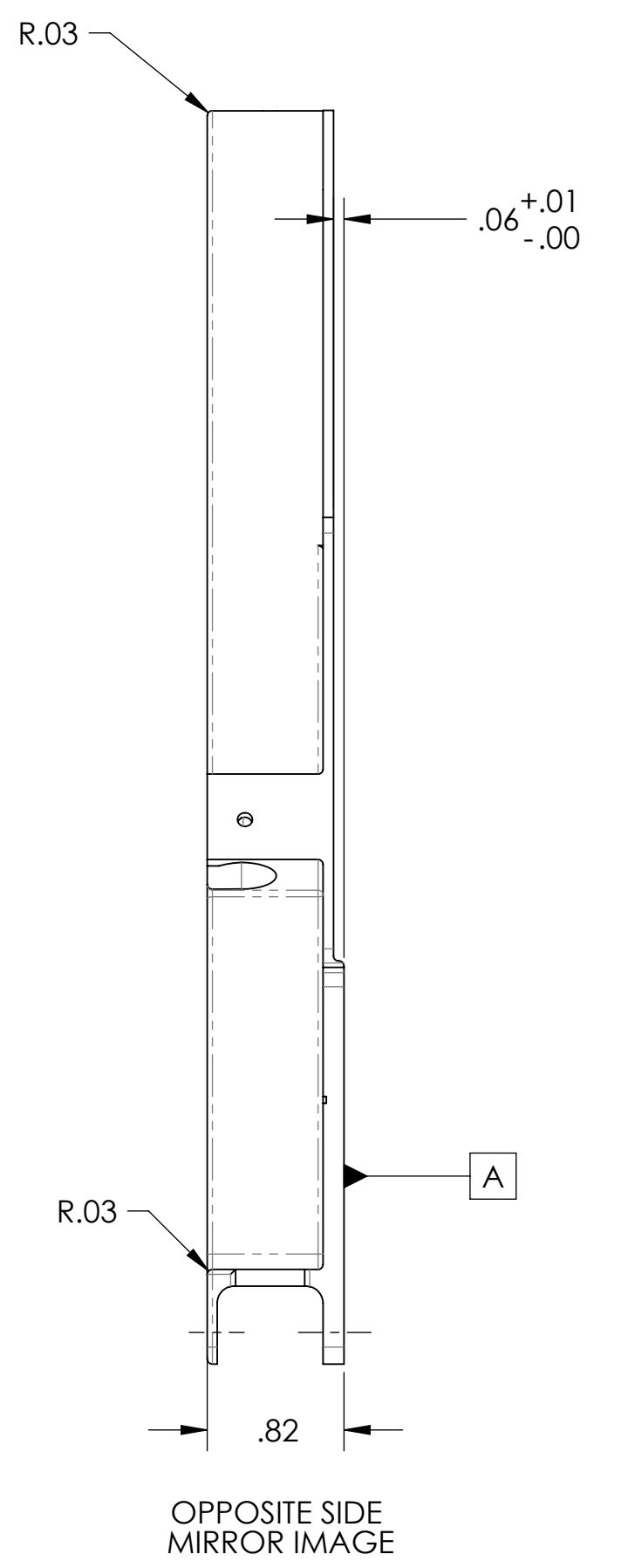
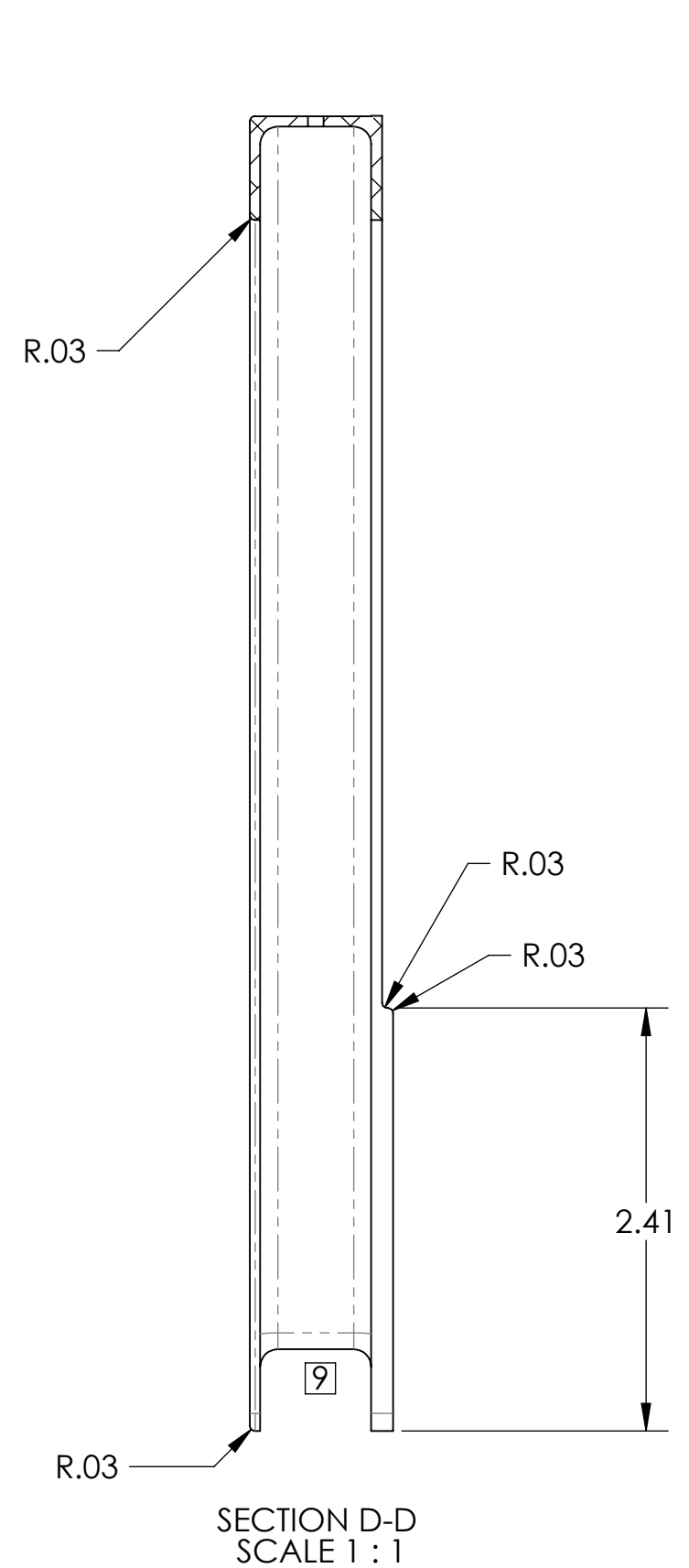
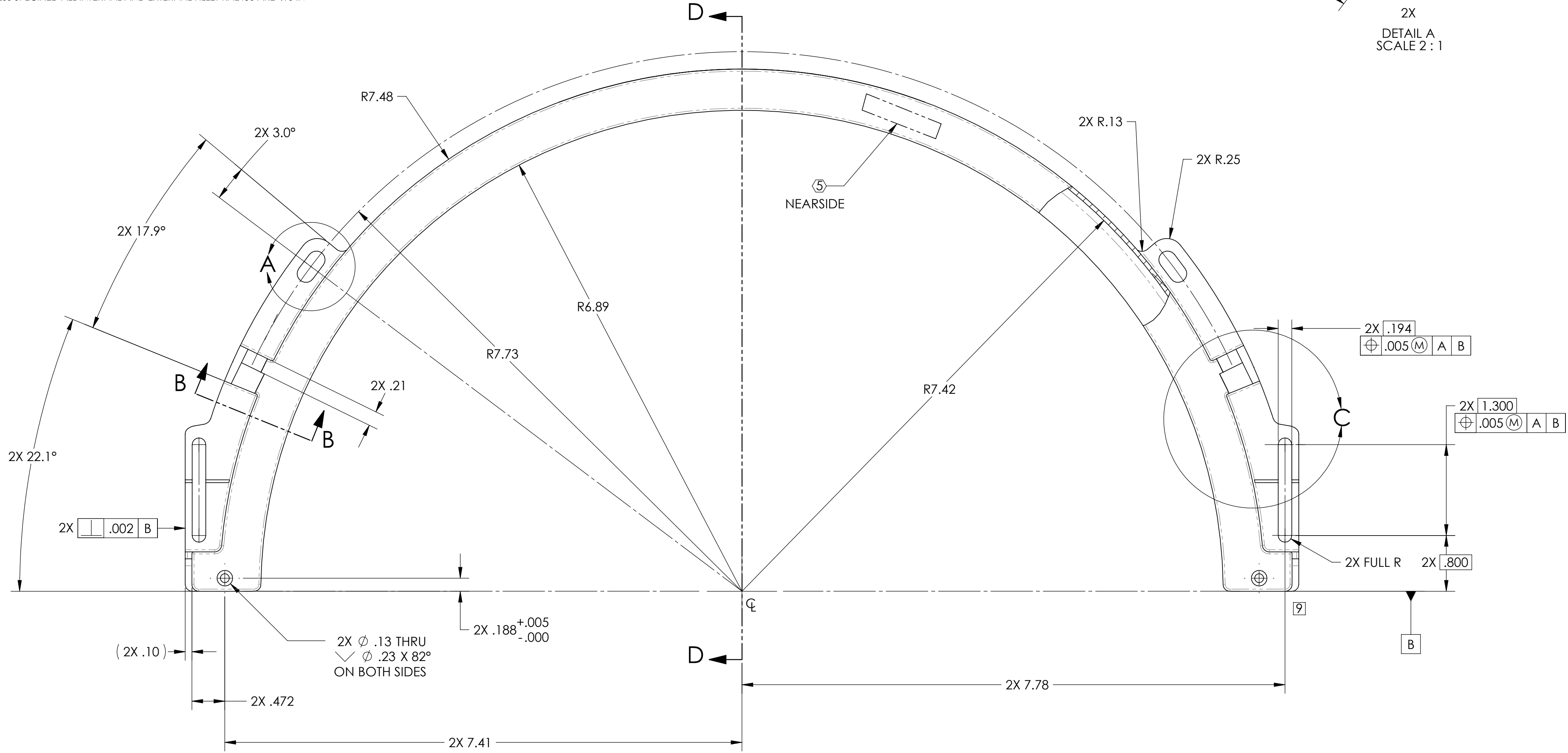
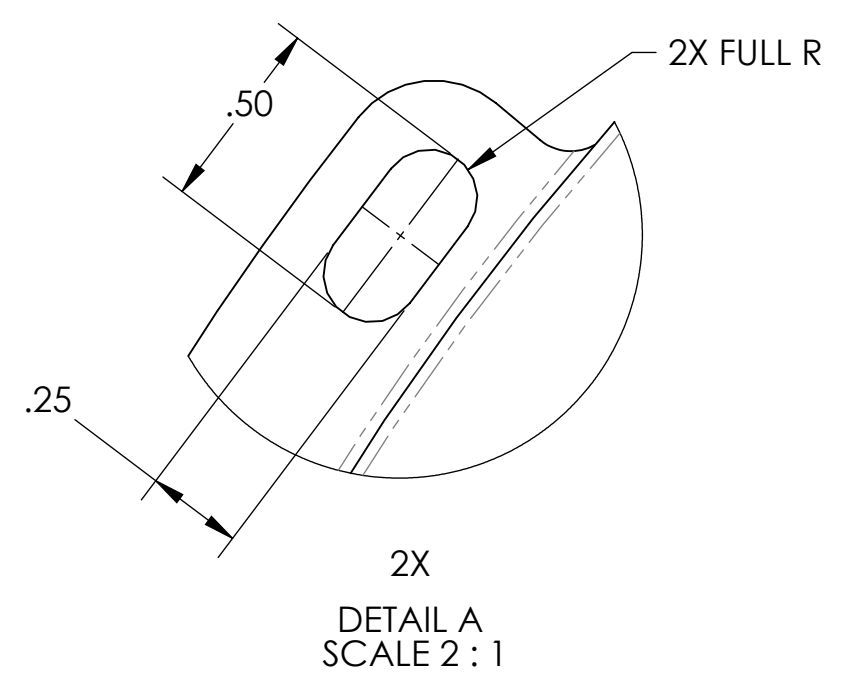
6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

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

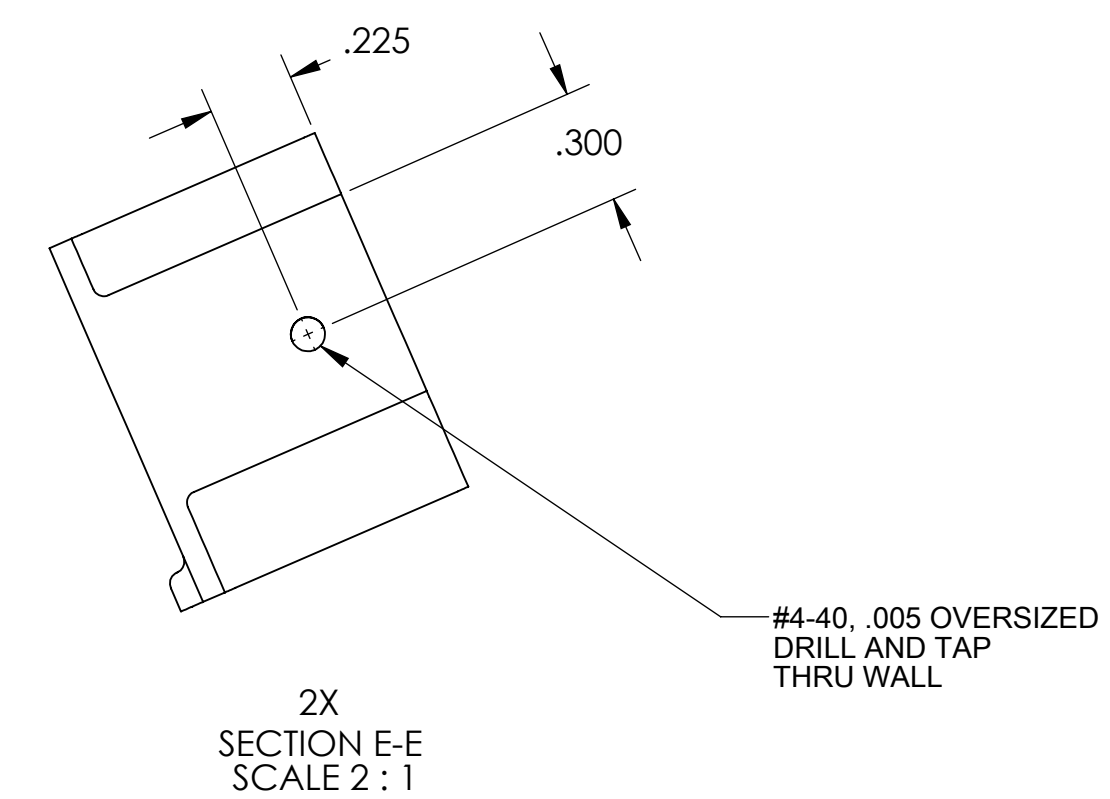
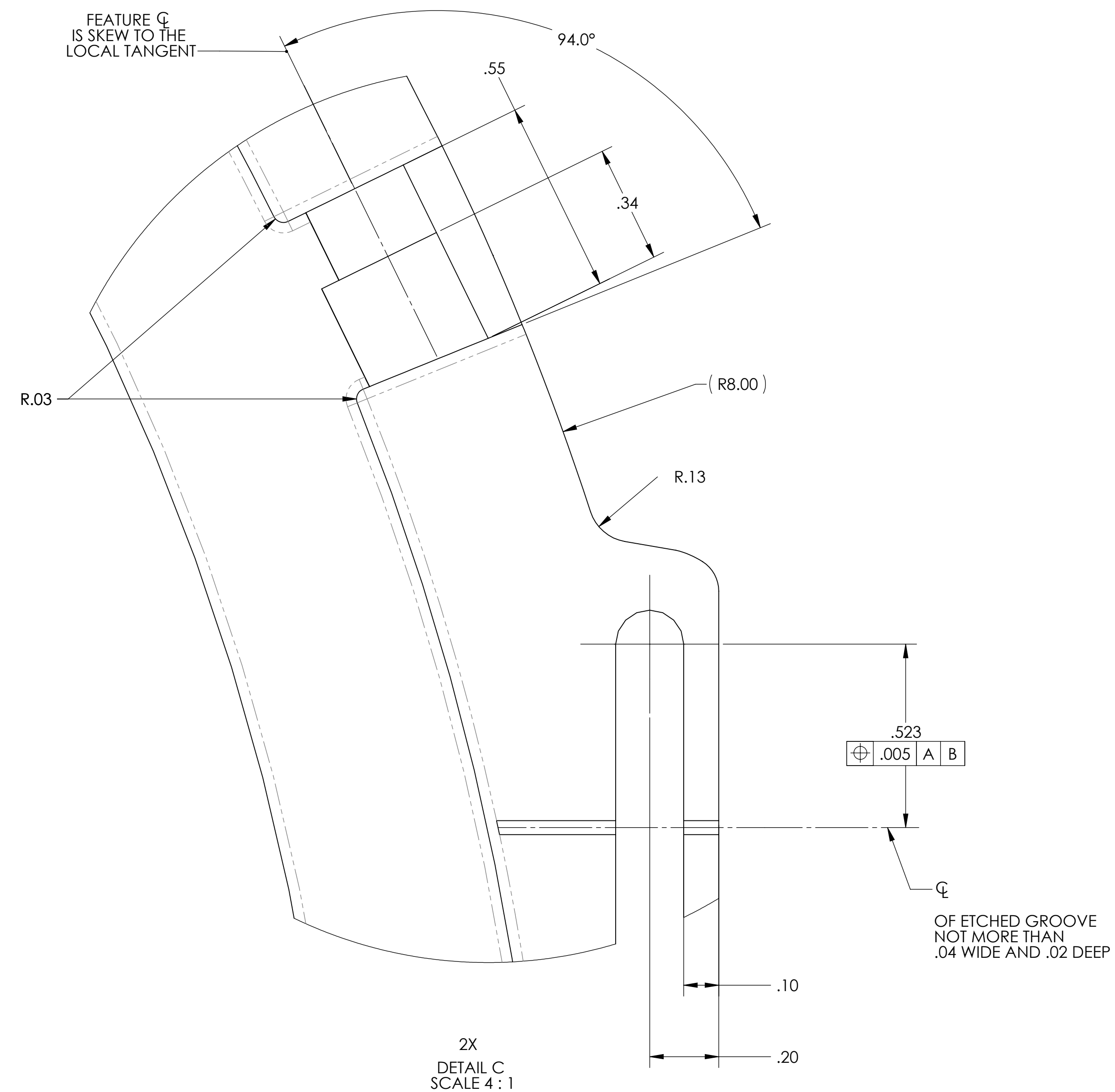
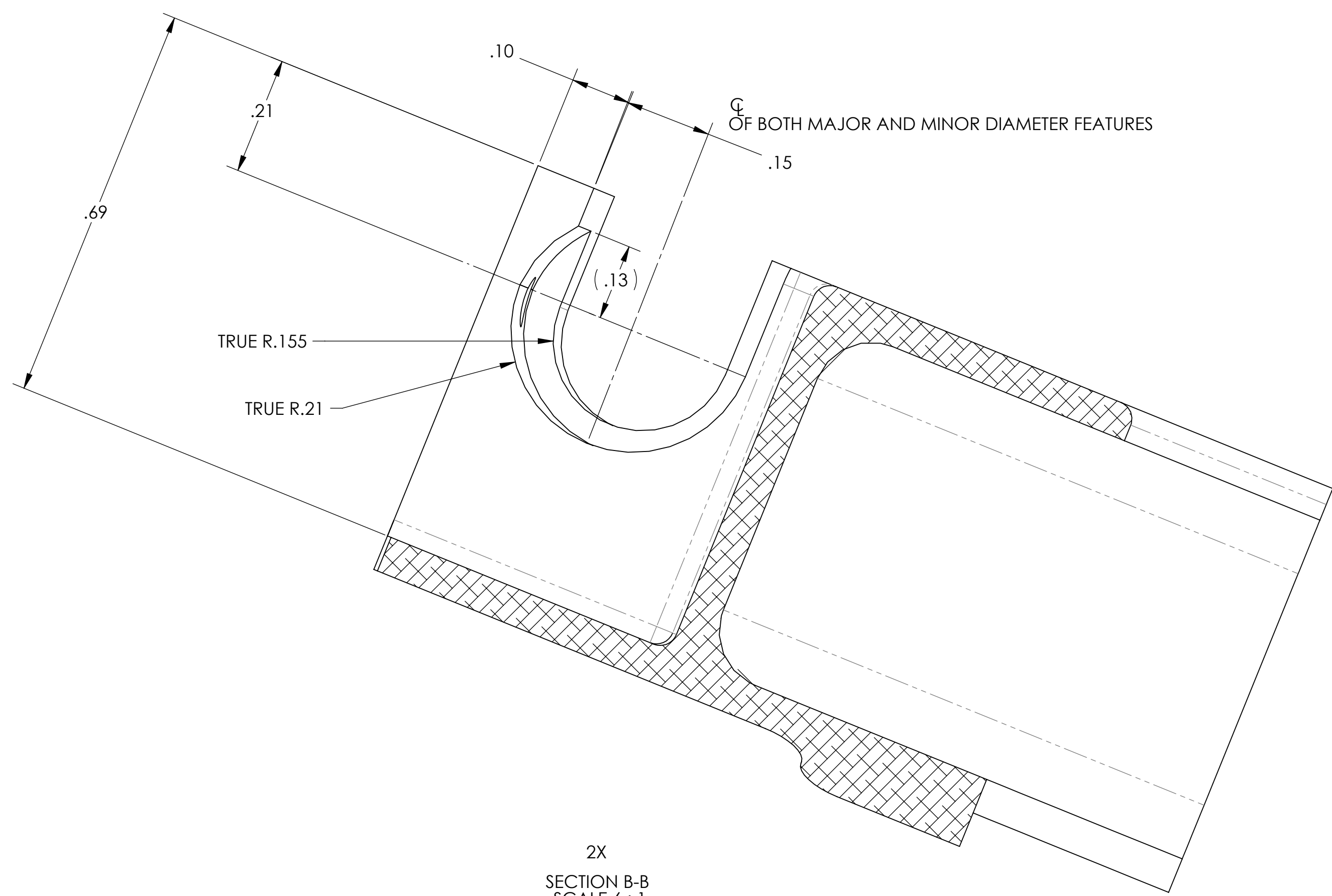
9. UNLESS SPECIFIED ALL INTERNAL AND EXTERNAL FILLET RADIUS ARE .10 IN

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
v5	28-FEB-2010	E1000291-v6	E1000295-v7



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 AOS		<b>alIGO TCS LOWER MONOLITHIC RH SHIELD</b>	
ANGULAR ± 0.5°		MATERIAL 6061 Alloy		FINISH 32 μinch		NEXT ASSY D1001895		DESIGNER M. JACOBSON 21 APR 2010 DRAFTER A. COLE 7/13/2010 CHECKER C. TORRIE 7/19/2010 APPROVAL P. WILLEMS 3/03/2011	
						SIZE DWG. NO. <b>D D1001680</b>		REV. <b>v5</b>	
						SCALE: 1:2 PROJECTION:		SHEET 1 OF 2	

D1001680\_ALIGO TCS LOWER MONOLITHIC RH SHIELD PART FROM REV: X-026 DRAWING FROM REV: X-029



CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE DWG. NO.	D1001680	v5
SCALE: 1:2	PROJECTION:	SHEET 2 OF 2

D1001680\_ALIGOTCS LOWER MONODIRING HEATER SHIELD, PART PDM REV. X-026, DRAWING PDM REV. X-027