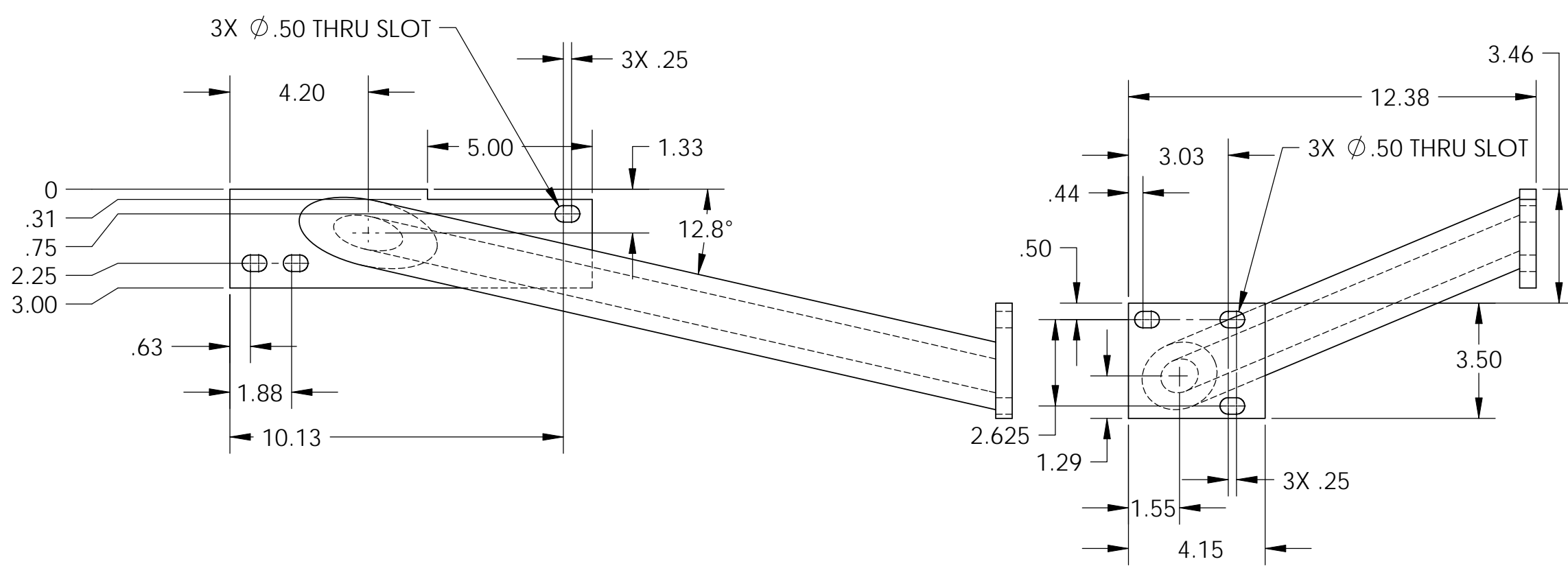
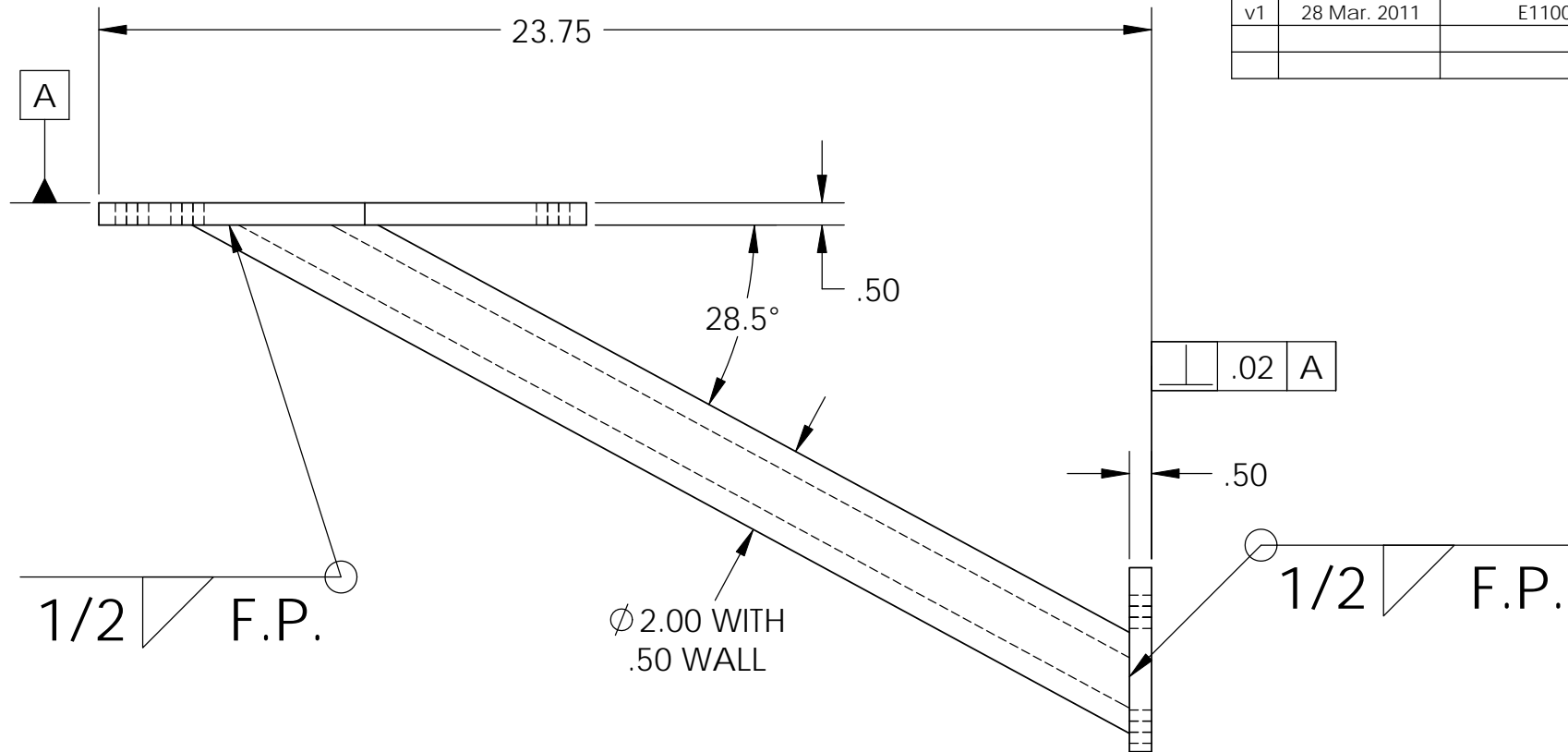


NOTES CONTINUED:

4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
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 DXXXXXXXX-VY, TYPE-XX, S/N XXX.
6. APPROXIMATE WEIGHT = 9.53 LB.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. PAINT: ALL VISIBLE SURFACES MEDIUM BLUE SHERWIN WILLIAMS (POLANE (R) T-PLUS POLYURETHANE ENAMEL) #SW-F63TX-L-2822-5864 PRIME WITH SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER P60G2
9. "OXI SOLV RUST INHIBITOR" TO BE APPLIED PER MFG. INSTRUCTIONS TO ALL UNPAINTED SURFACES. BOTH TAPPED AND THRU HOLES WILL BE PLUGGED DURING APPLICATION.
10. FULL WELDED CONSTRUCTION.
11. STRESS RELIEVE BEFORE FINISH MACHINING.
12. AFTER FINAL MACHINE TO FIT, MARK STIFFENERS AND HOUSING D020004 WITH CORRESPONDING SERIAL NUMBERS

REV.	DATE	DCN #	DRAWING TREE #
v1	28 Mar. 2011	E1100015	E1100016



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		PRE-ISOLATOR ASSEMBLY, HOUSING STIFFENER, LEFT, ACTUATOR					
TOLERANCES: .XX ± .015 .XXX ± .005				SUB-SYSTEM SEI		DESIGNER	K.MASON	20 June 2002	SIZE	DWG. NO.	REV.
ANGULAR ± .5°				MATERIAL		DRAFTER	M.HILLARD	28 Mar. 2011	B	D020331	v1
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .03 x 45°. 3. DO NOT SCALE FROM DRAWING.				FINISH		CHECKER	K.MASON	20 June 2002	SCALE: 1:4		PROJECTION: SHEET 1 OF 1
ASTM A519 Steel				63 μinch		APPROVAL	K.MASON	28 Mar. 2011	NEXT ASSY		
				D1100144, D1100241							

D020331_Housing_Stiffener-Left-Actuator, PART PDM REV: X-006, DRAWING PDM REV: X-003