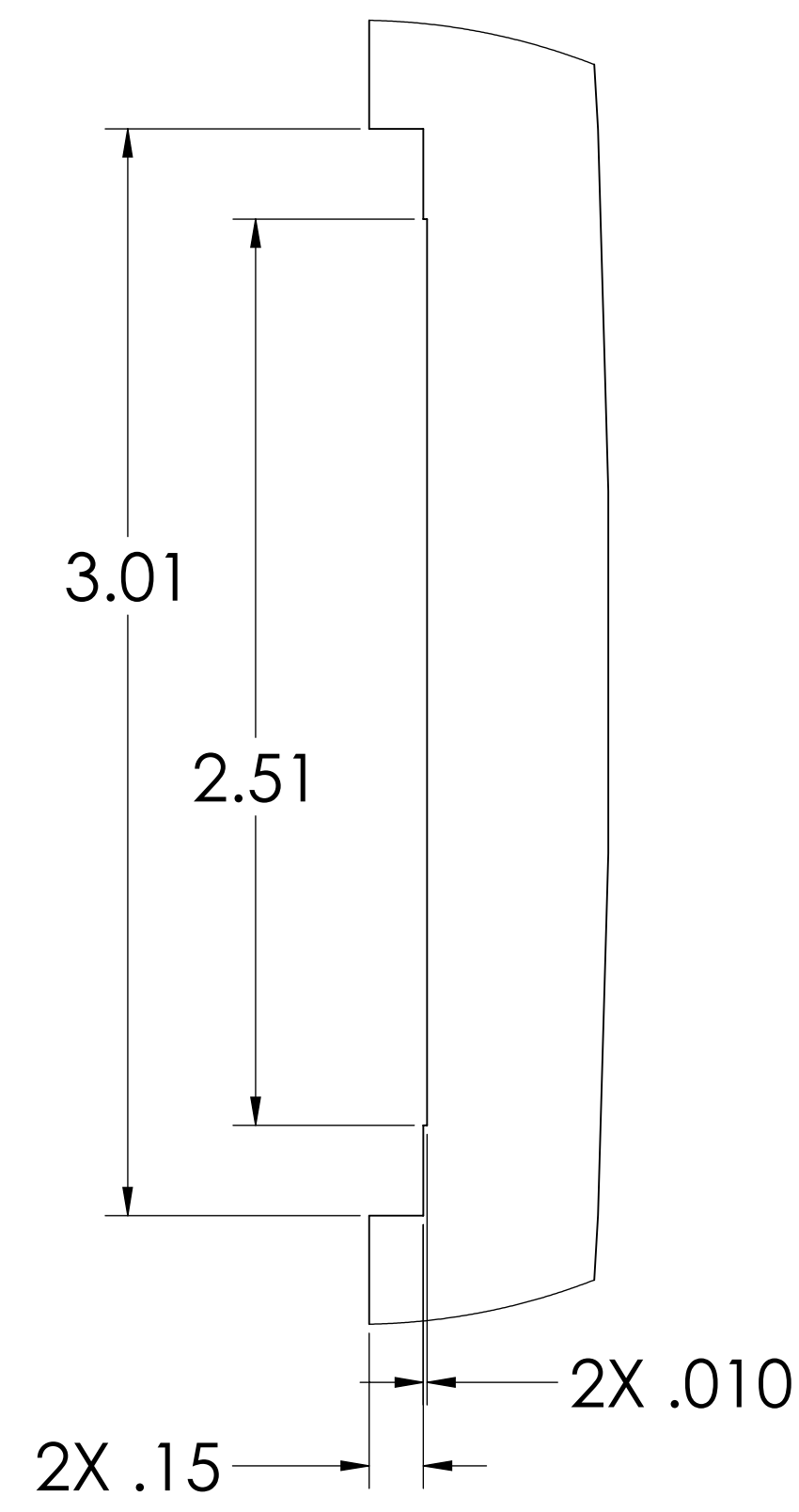
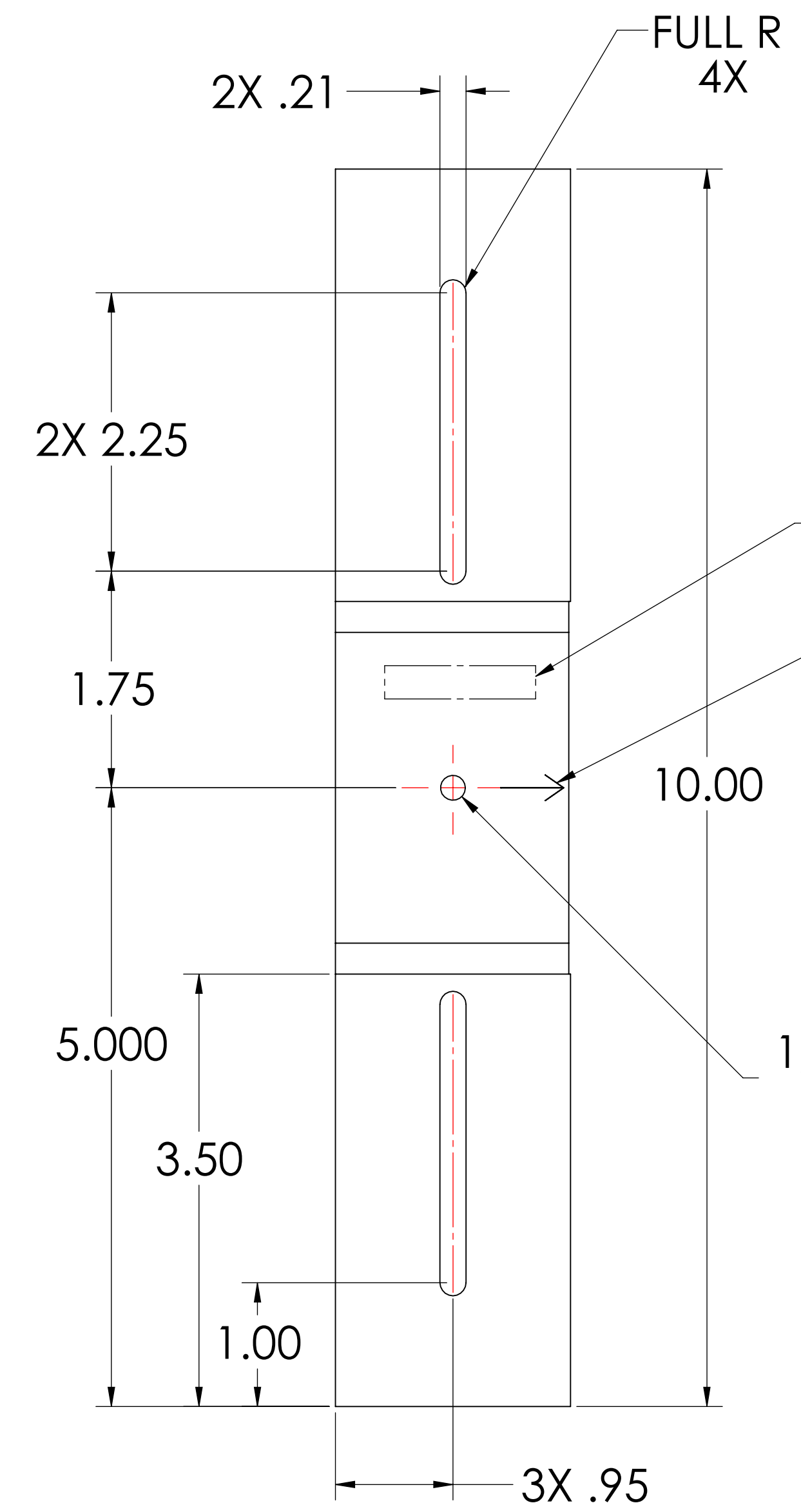


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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. REFER TO LIGO-E0900364
 - 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - 8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL), NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
 - 9. PART TO BE OXIDIZED PER LIGO SPECIFICATION E1100842.

REV.	DATE	DCN #	DRAWING TREE #
v1	5 OCT 2010	E1000185	E1000491
v2	12 MAY 2011	E1000360-v2	-
v3	6 OCT 2011	E1000360-v3	-



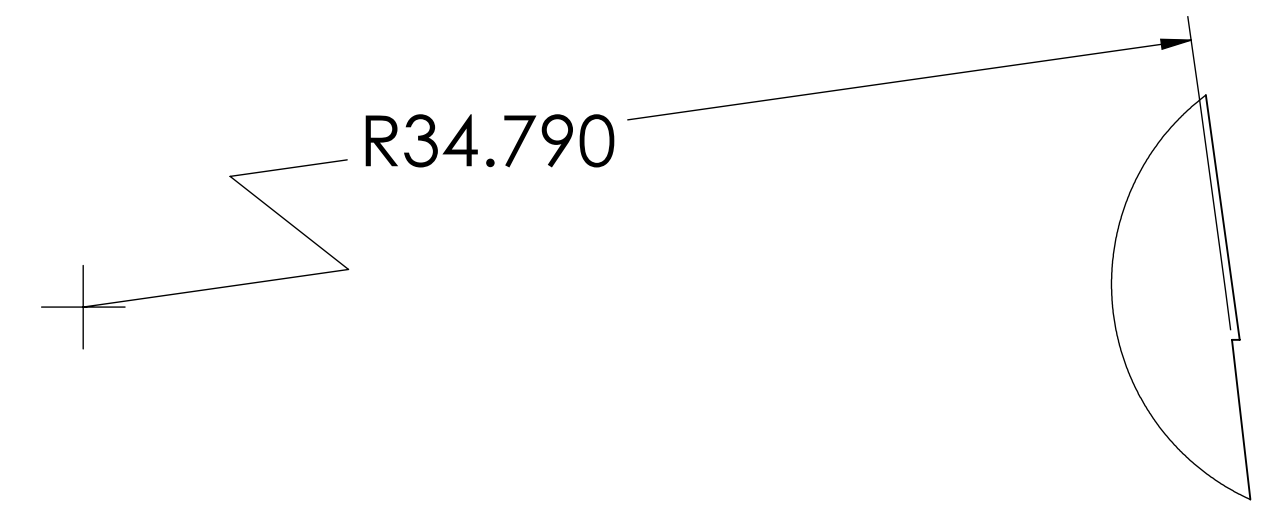
DETAIL A
SCALE 2:1



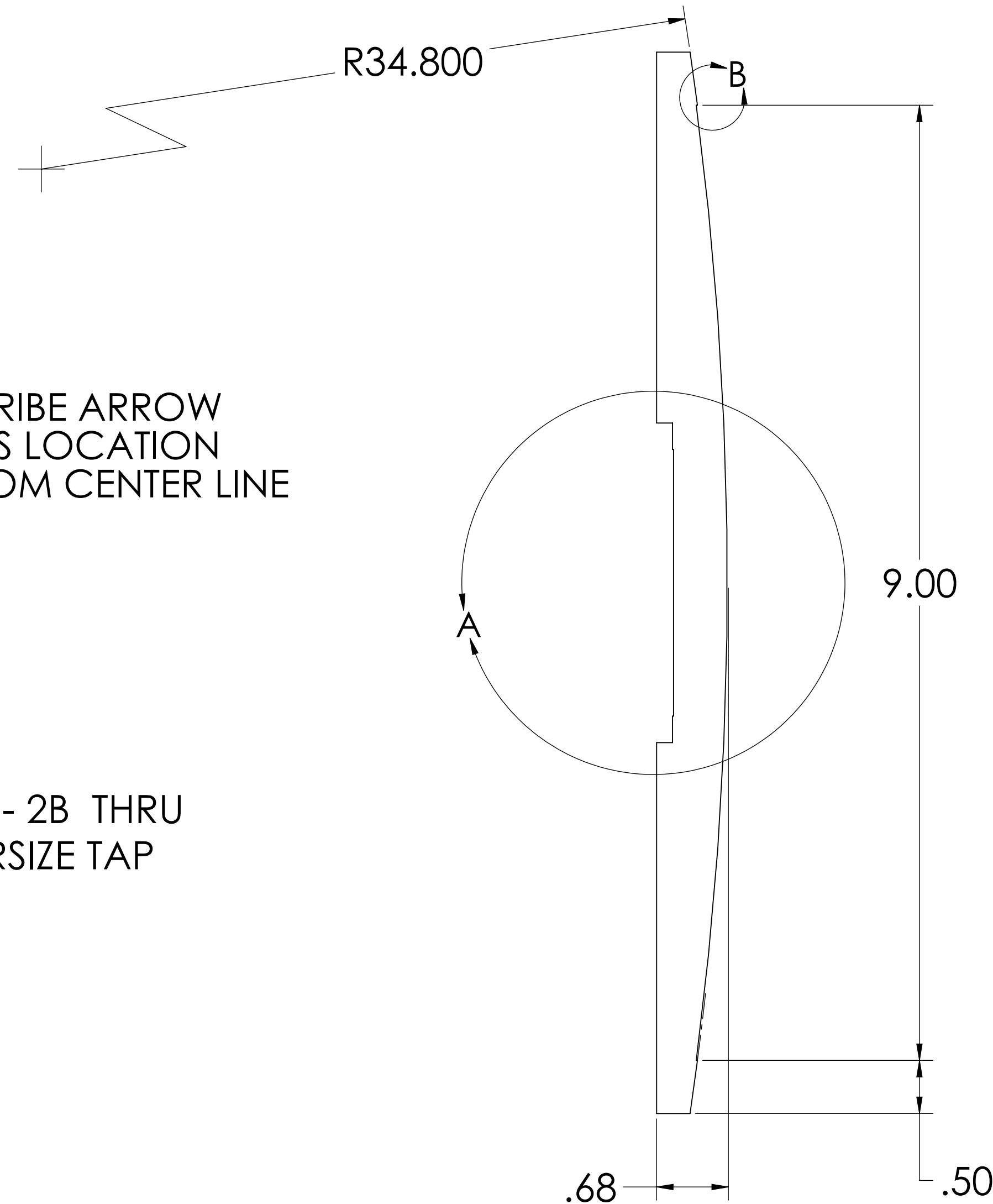
1/4-20 UNC - 2B THRU
+.005 OVERSIZE TAP

SCRIBE ARROW
THIS LOCATION
FROM CENTER LINE

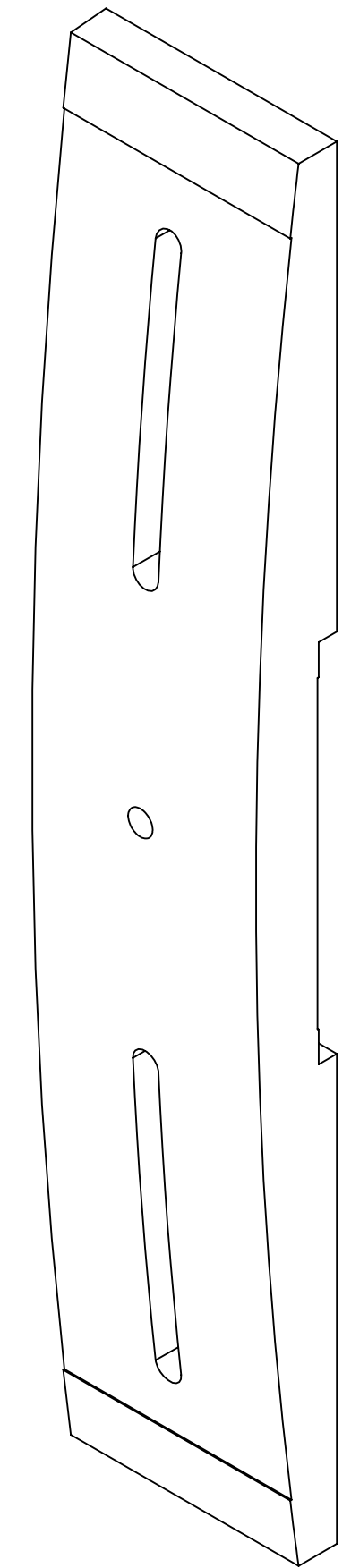
5



DETAIL B
SCALE 4:1



GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015 ON ALL EDGES AND HOLES. 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		VERTICAL WEIGHT	
MATERIAL		FINISH		NEXT ASSY		DESIGNER	TQ. NGUYEN	08 SEPT 2010	SIZE	DWG. NO.	REV.
304, 316 OR 302 SSSL		63 μinch		D1002402		DRAFTER	TQ. NGUYEN	21 SEPT 2010	D	D1002403	v3
						CHECKER	M. SMITH		SCALE: 1:1	PROJECTION:	SHEET 1 OF 1
						APPROVAL	D. COYNE				