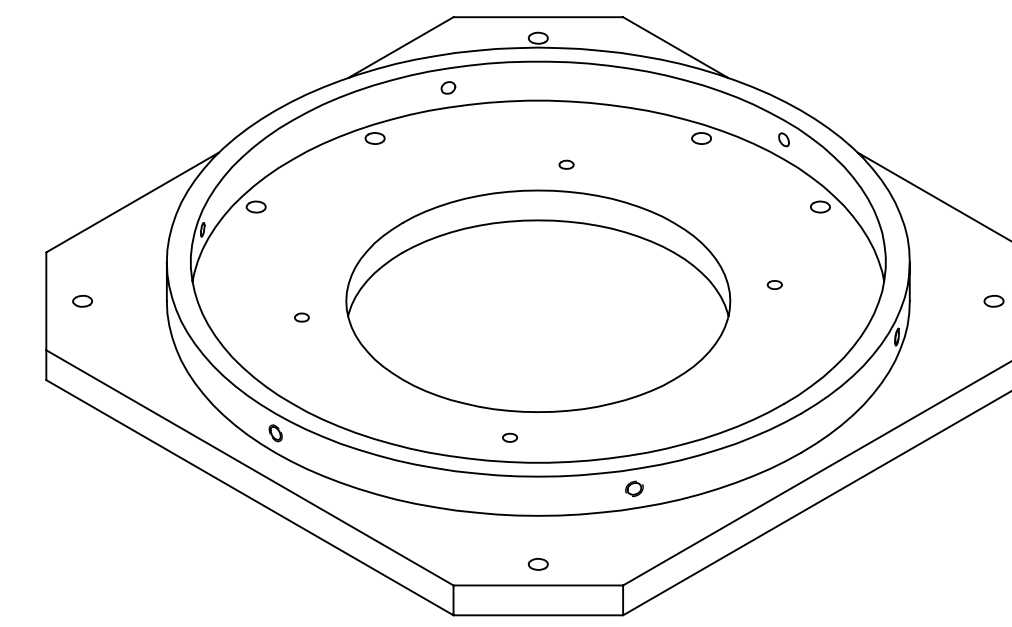
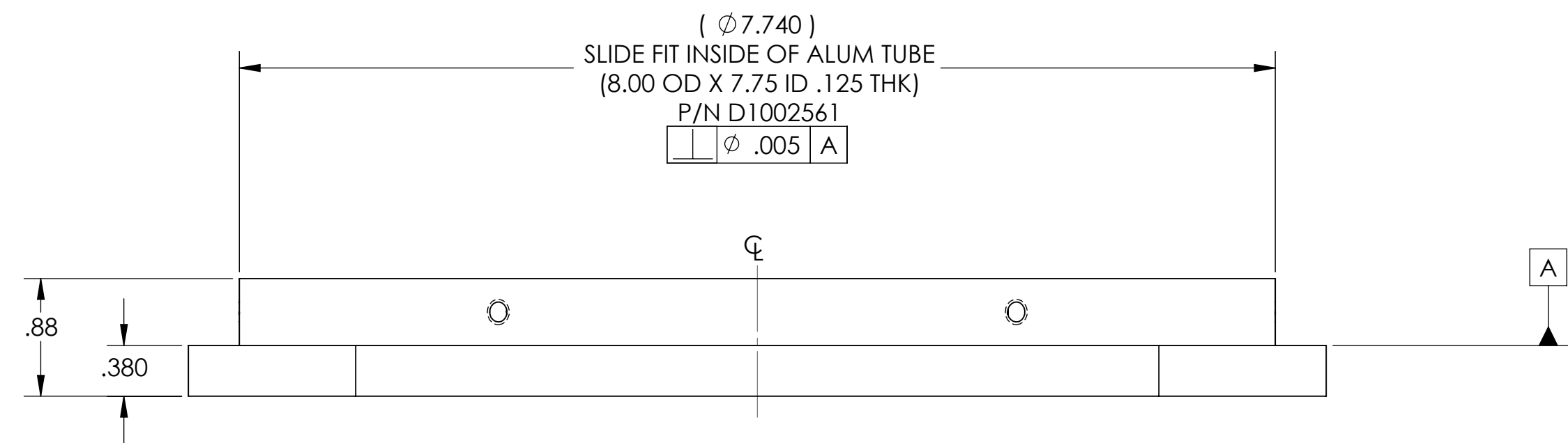
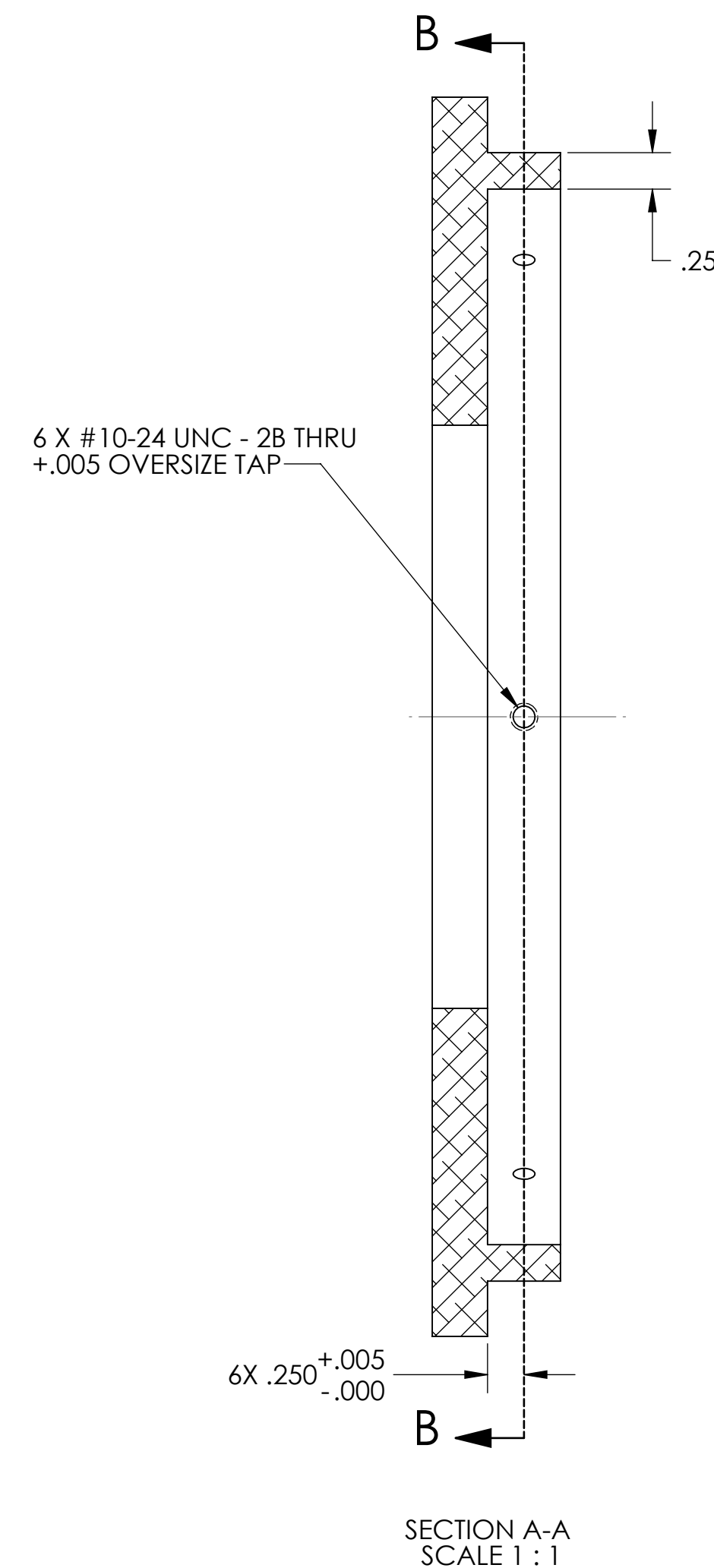
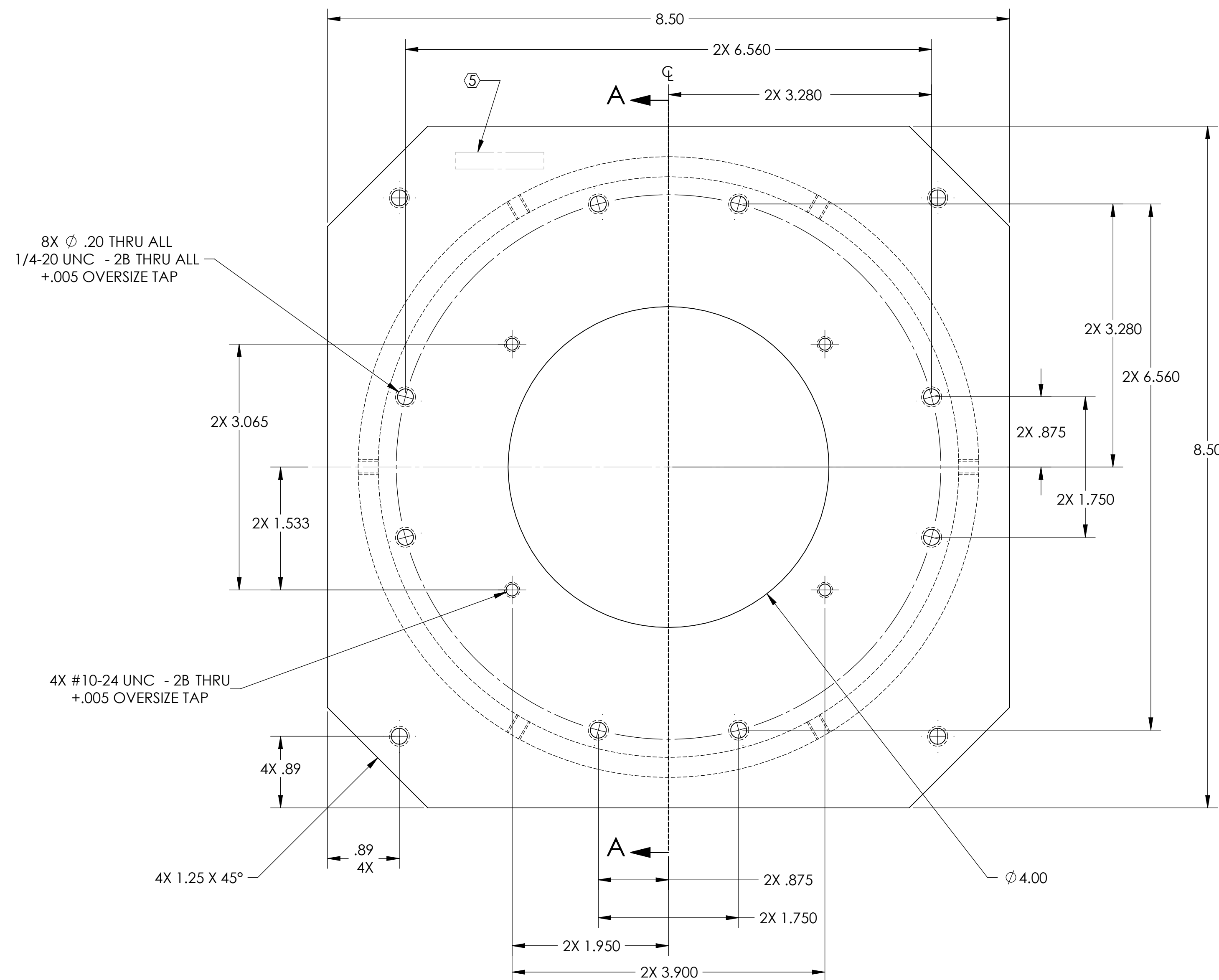


- NOTES CONTINUED:**
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS.
EXAMPLE: DXXXXX-VY, TYPE-XX, S/N XXX
 6. APPROXIMATE WEIGHT=2.363 LB.
 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 9. 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.

REV.	DATE	DCN #	DRAWING TREE #
v1	03 JUN 2010	E1000285	
v2	04 APR 2011	E1100216	



NO SCALE
FOR REFERENCE ONLY



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
1. INTERPRET DRAWING PER ASME Y14.5-1994.	
2. REMOVE ALL SHARP EDGES 0.005" TO 0.015".	
3. DO NOT SCALE FROM DRAWING.	
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. REFER TO LIGO E0900237 FOR LIST OF APPROVED COOLANTS.	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX $\pm .01$.XXX $\pm .005$	
ANGULAR $\pm 1.0^\circ$	
MATERIAL	FINISH
6061-T6 Al	63 μ inch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	PART NAME	
	SLC DAMPING TUBE LOWER PLATE	
SYSTEM	SUB-SYSTEM	DESIGNER
ADVANCED LIGO	AOS	N.Nguyen
NEXT ASSY		DRAFTER
D1002563		TG. NGUYEN
		CHECKER
		M. SMITH
		APPROVAL
		D. COYNE

DATE	SIZE	DWG. NO.	REV.
01 Jun 2010	D	D1002617	v2
15 Jul 2010			
01 Nov 2010			
10 Nov 2010	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1