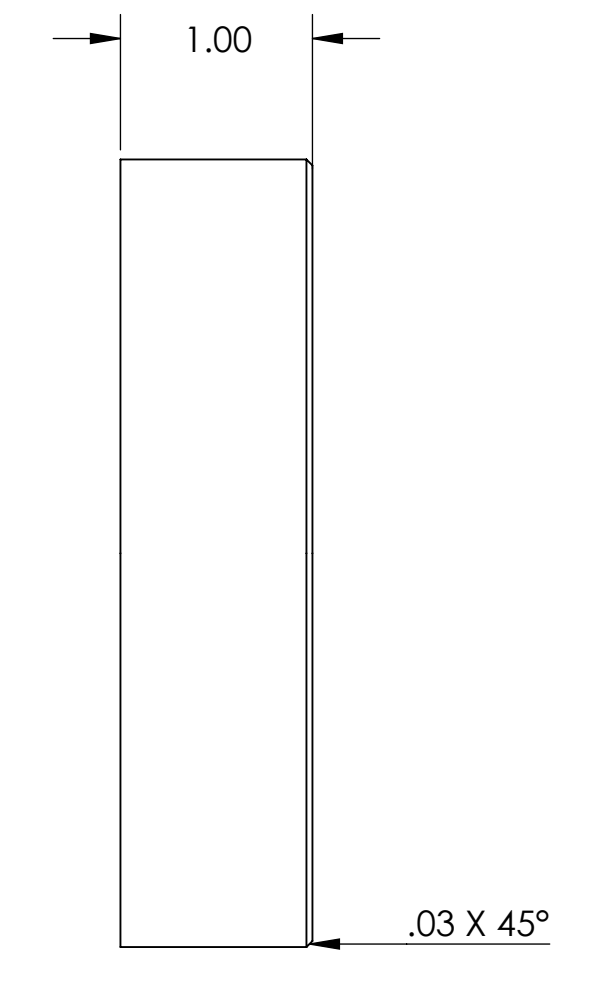
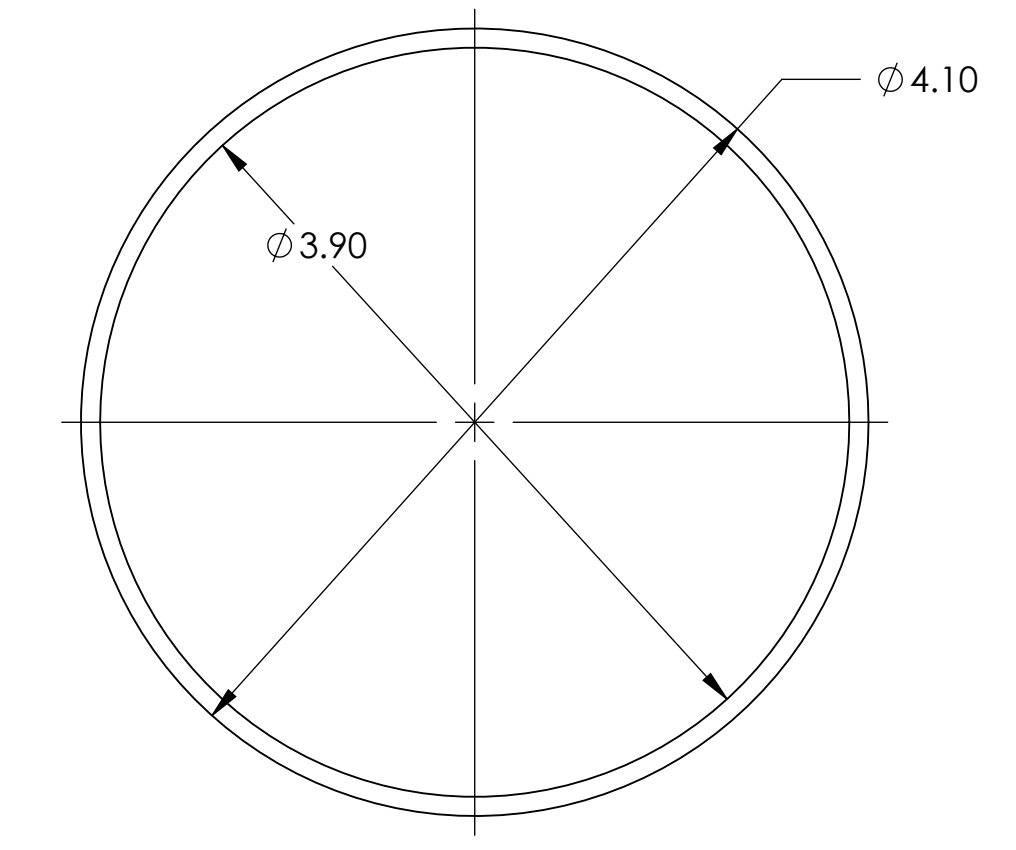
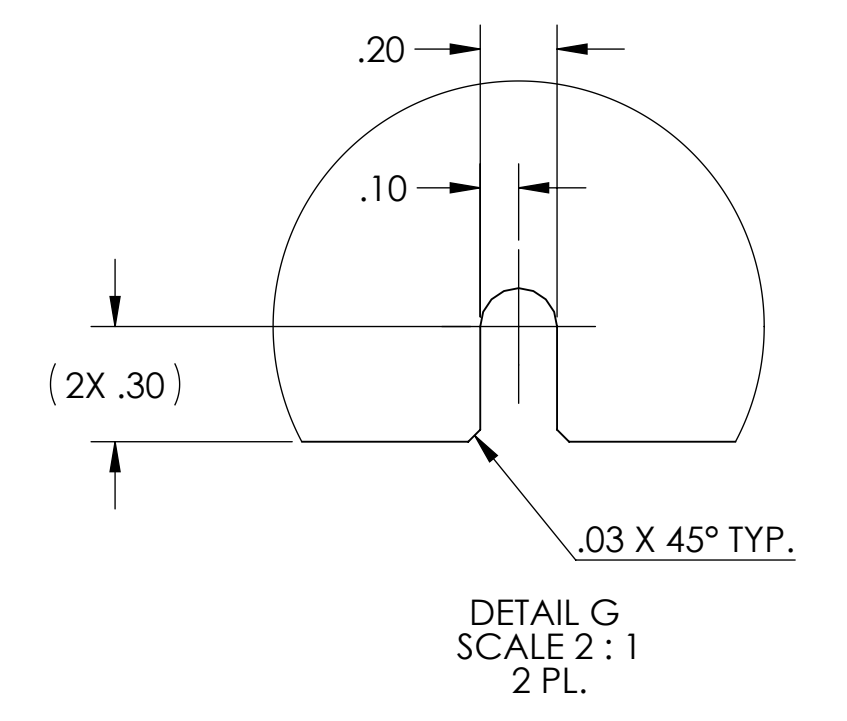
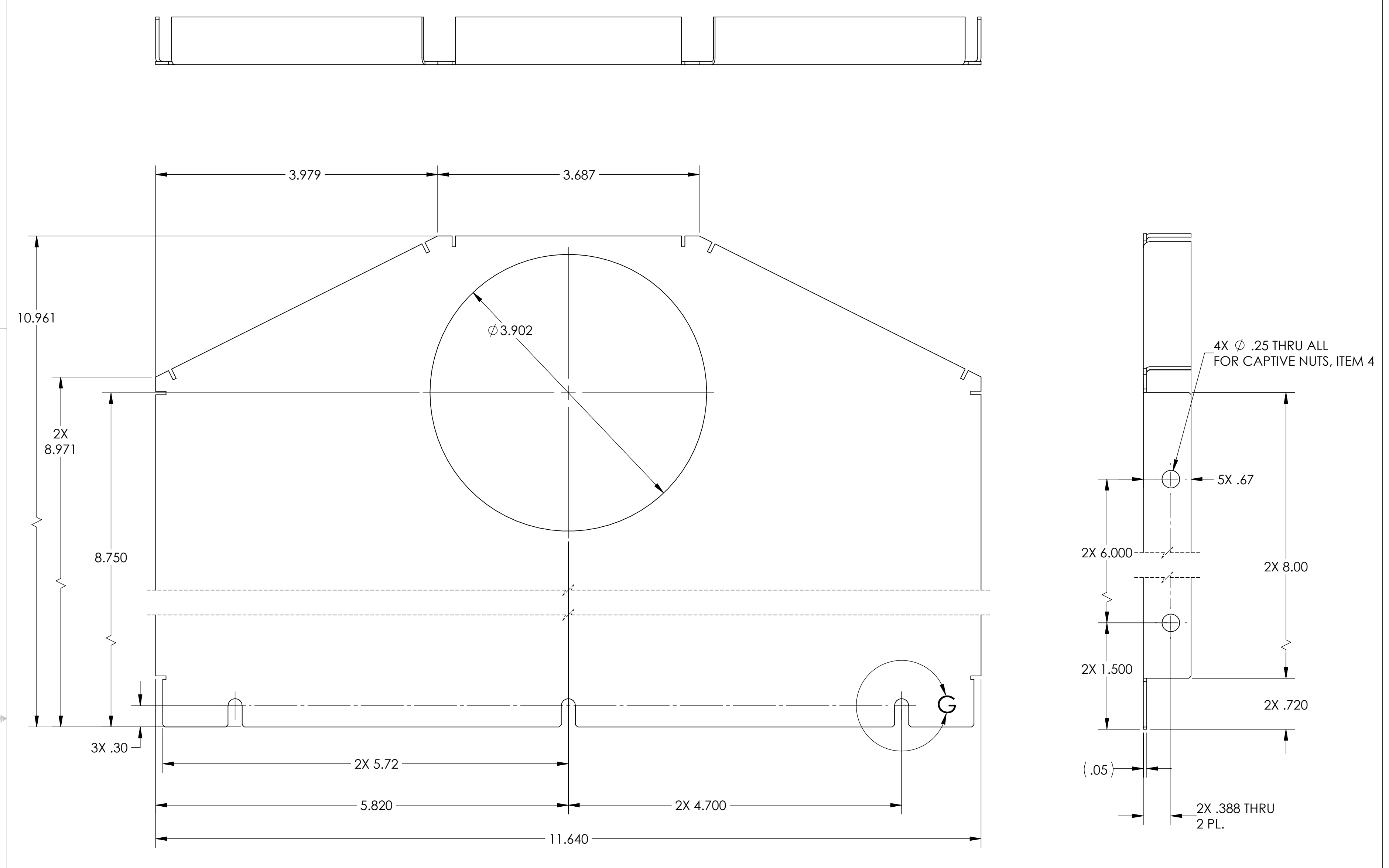


NOTES CONTINUED:  
 3. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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

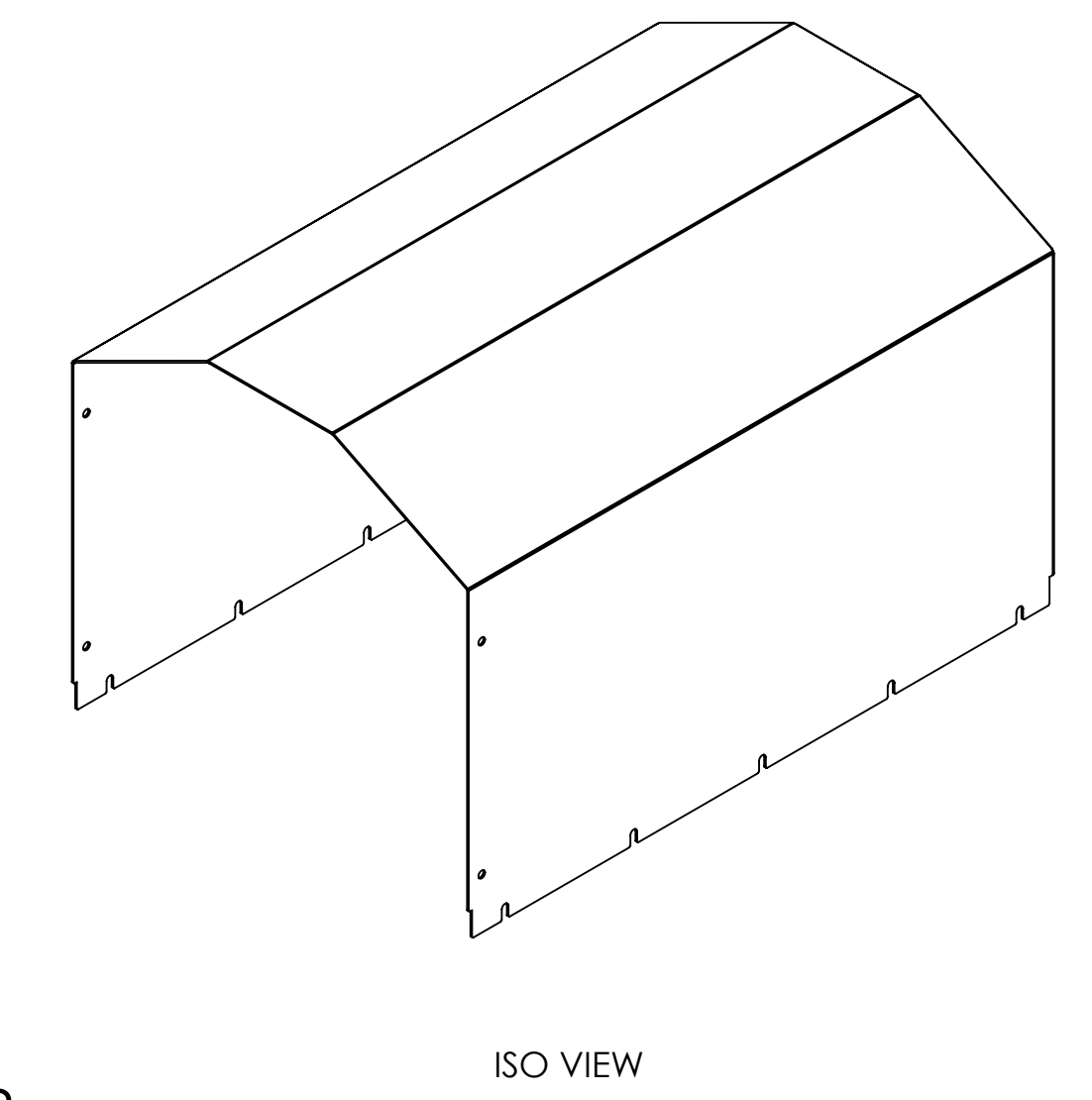
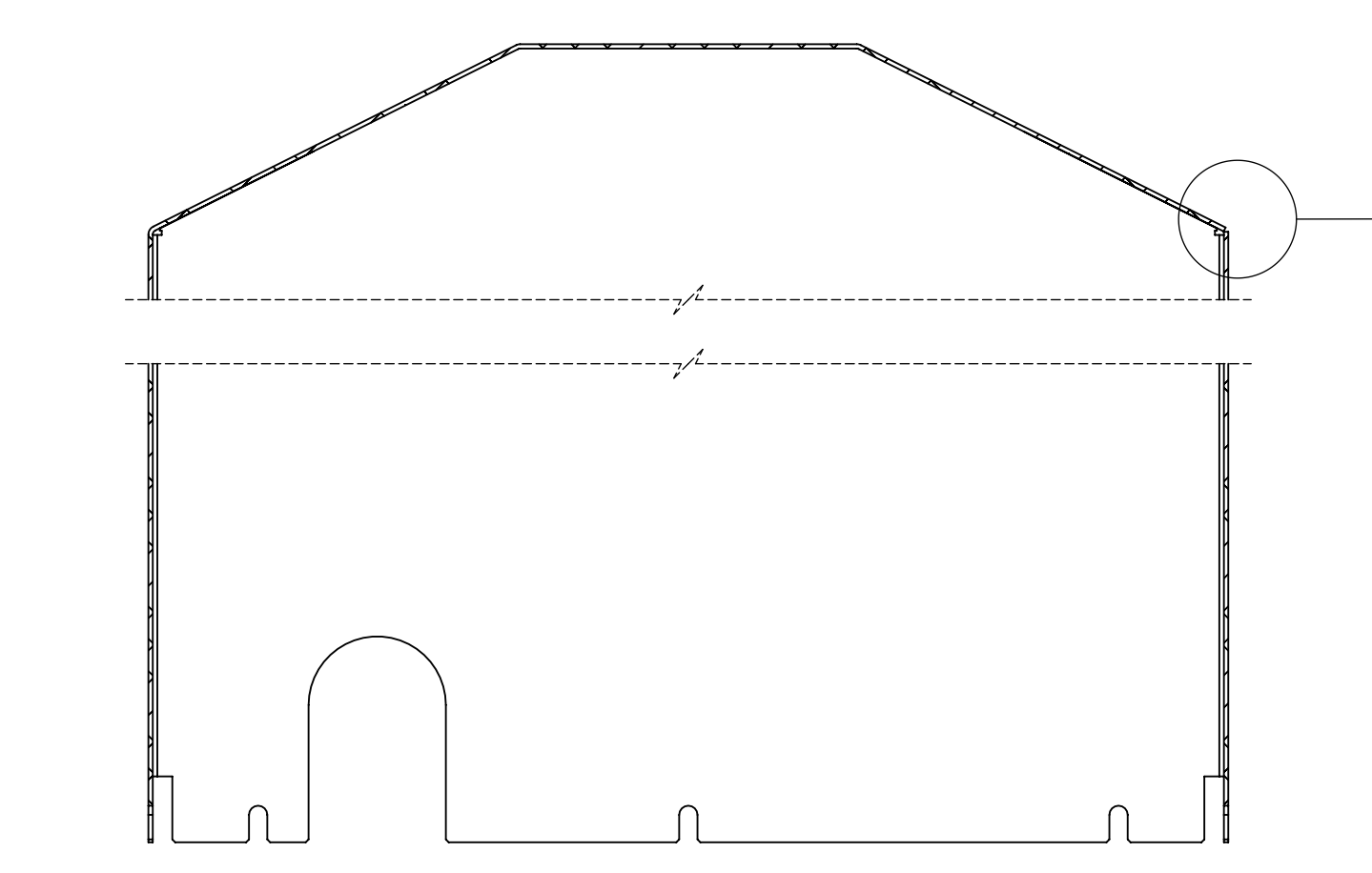
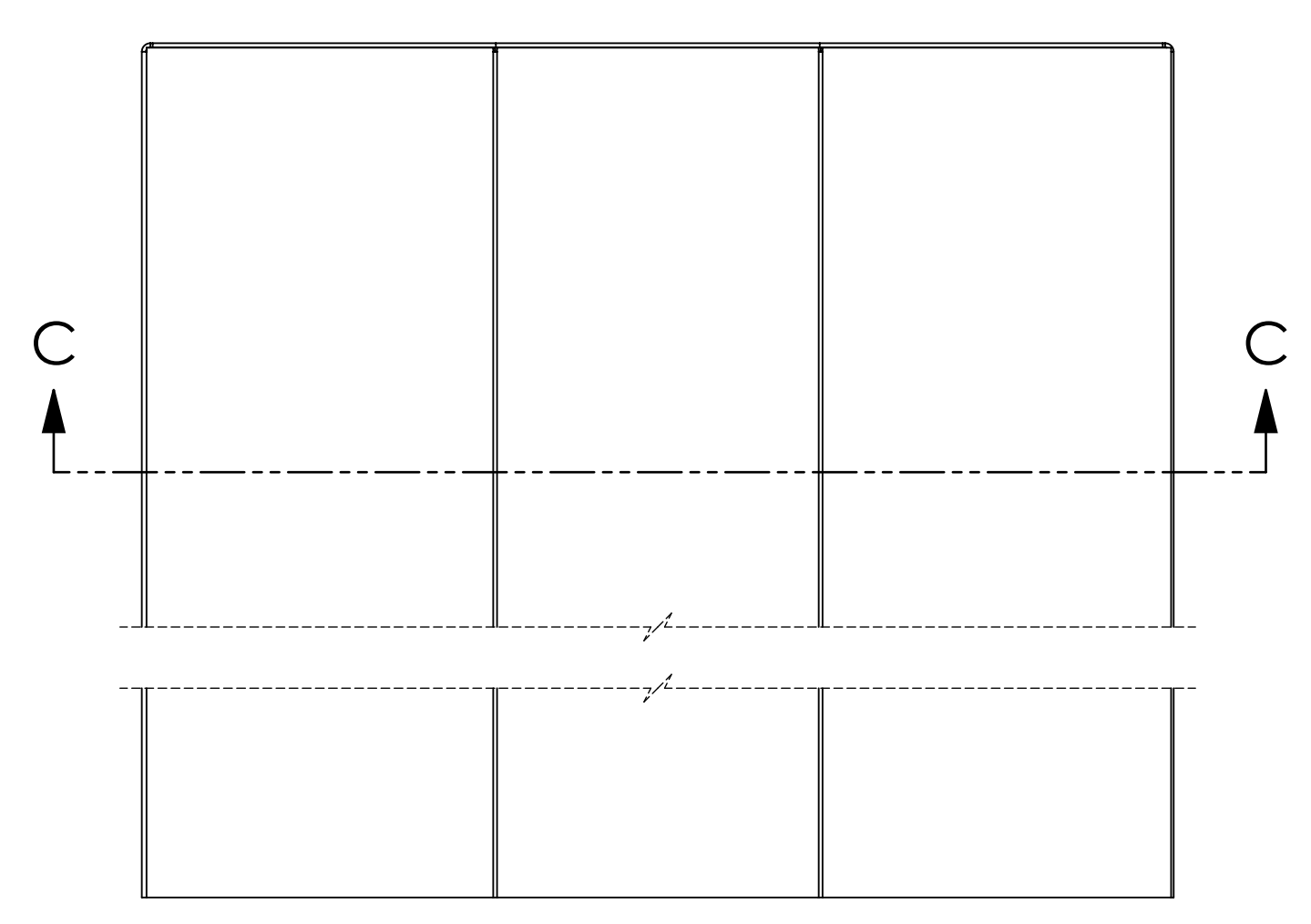
- 6. APPROXIMATE WEIGHT = 11.08 LB.
- 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION ED000364.
- 8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-ED000364.
- 9. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- 10. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.



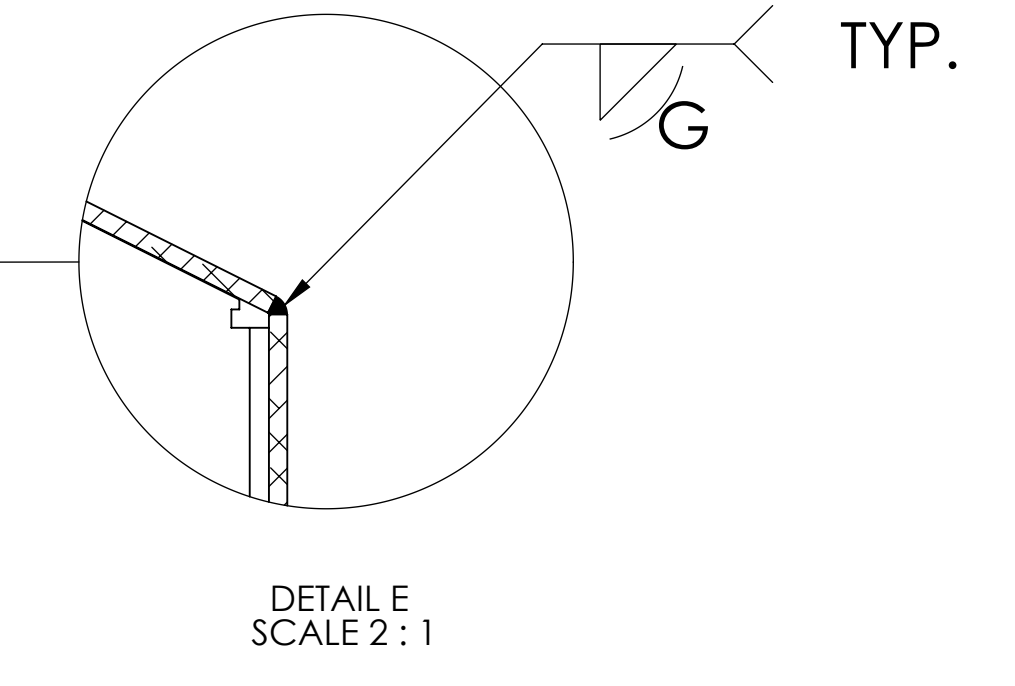
-101 DETAIL



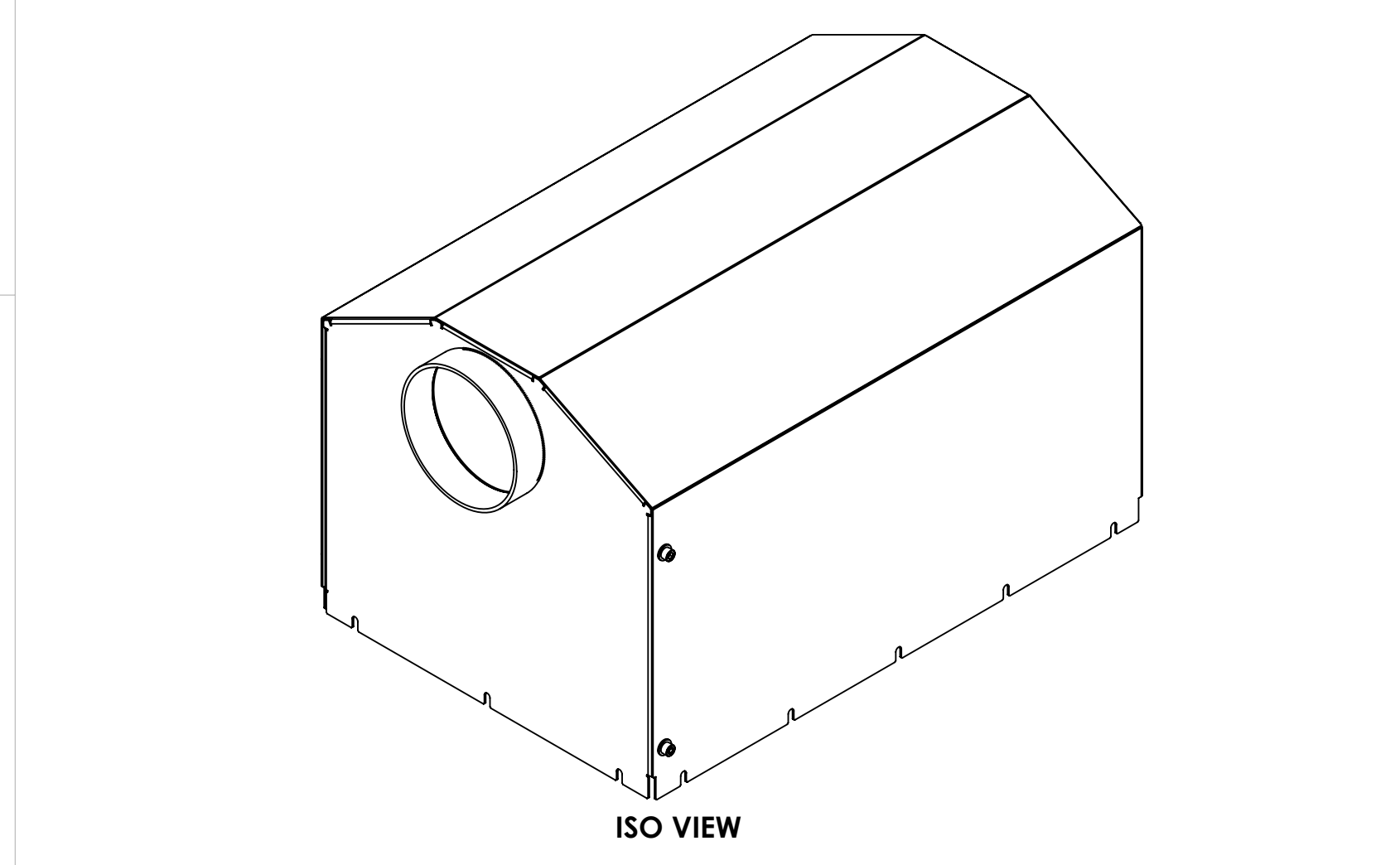
-103 DETAIL



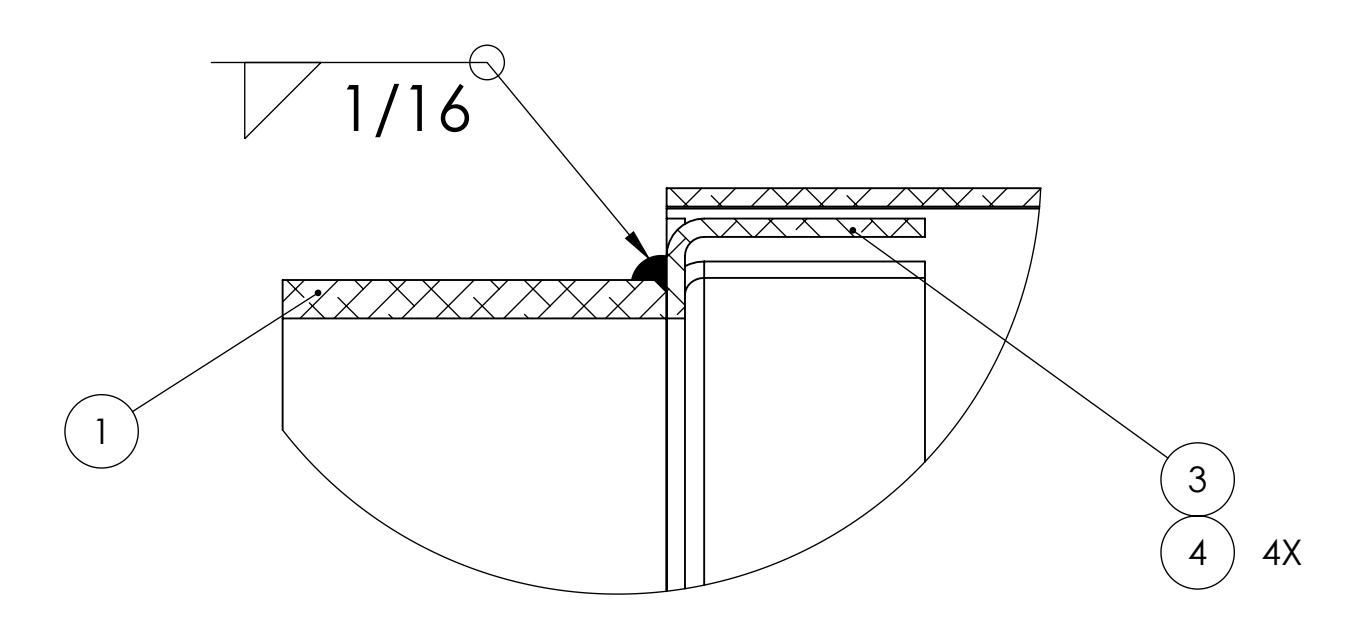
ISO VIEW



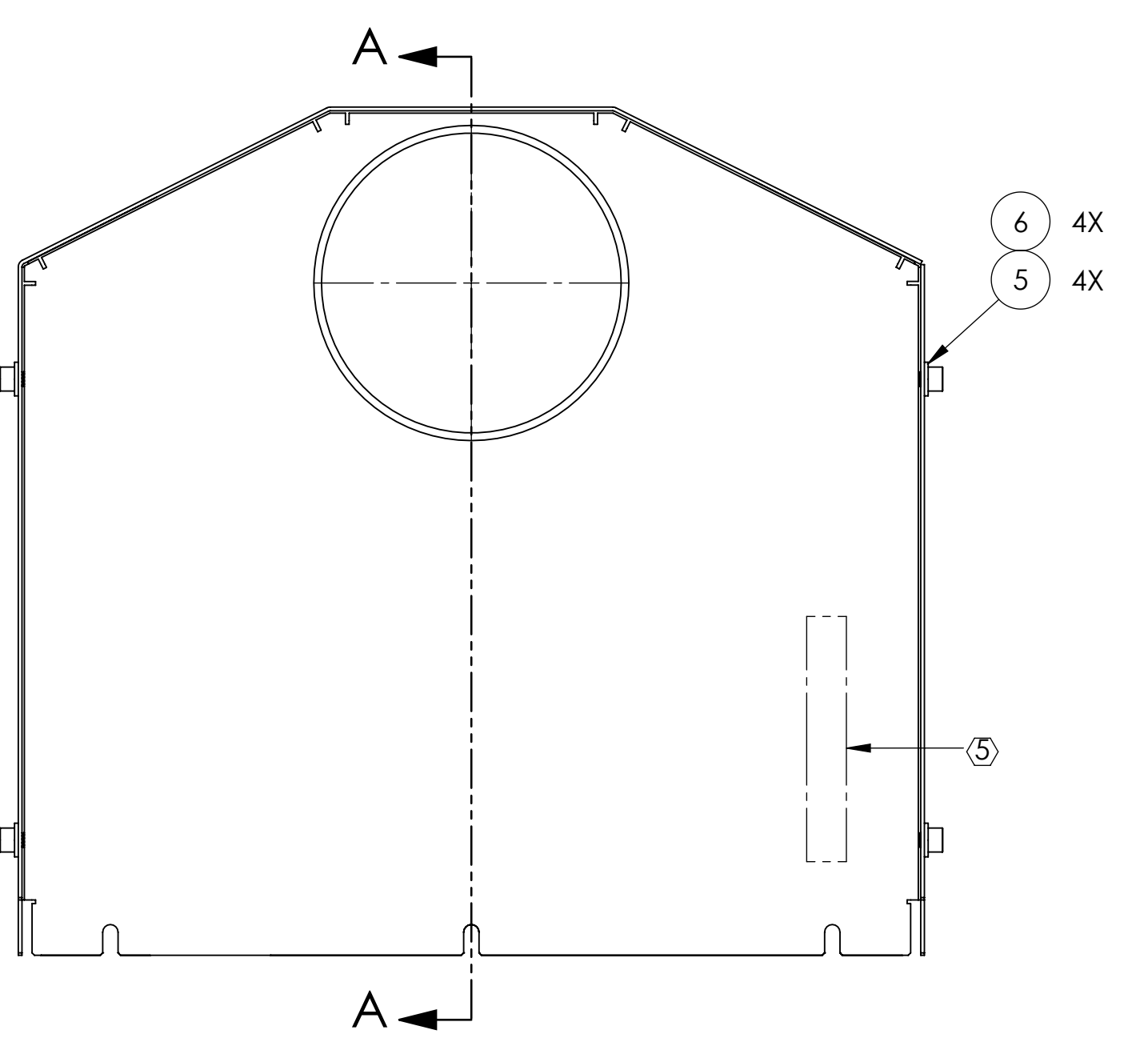
DETAIL E SCALE 2:1



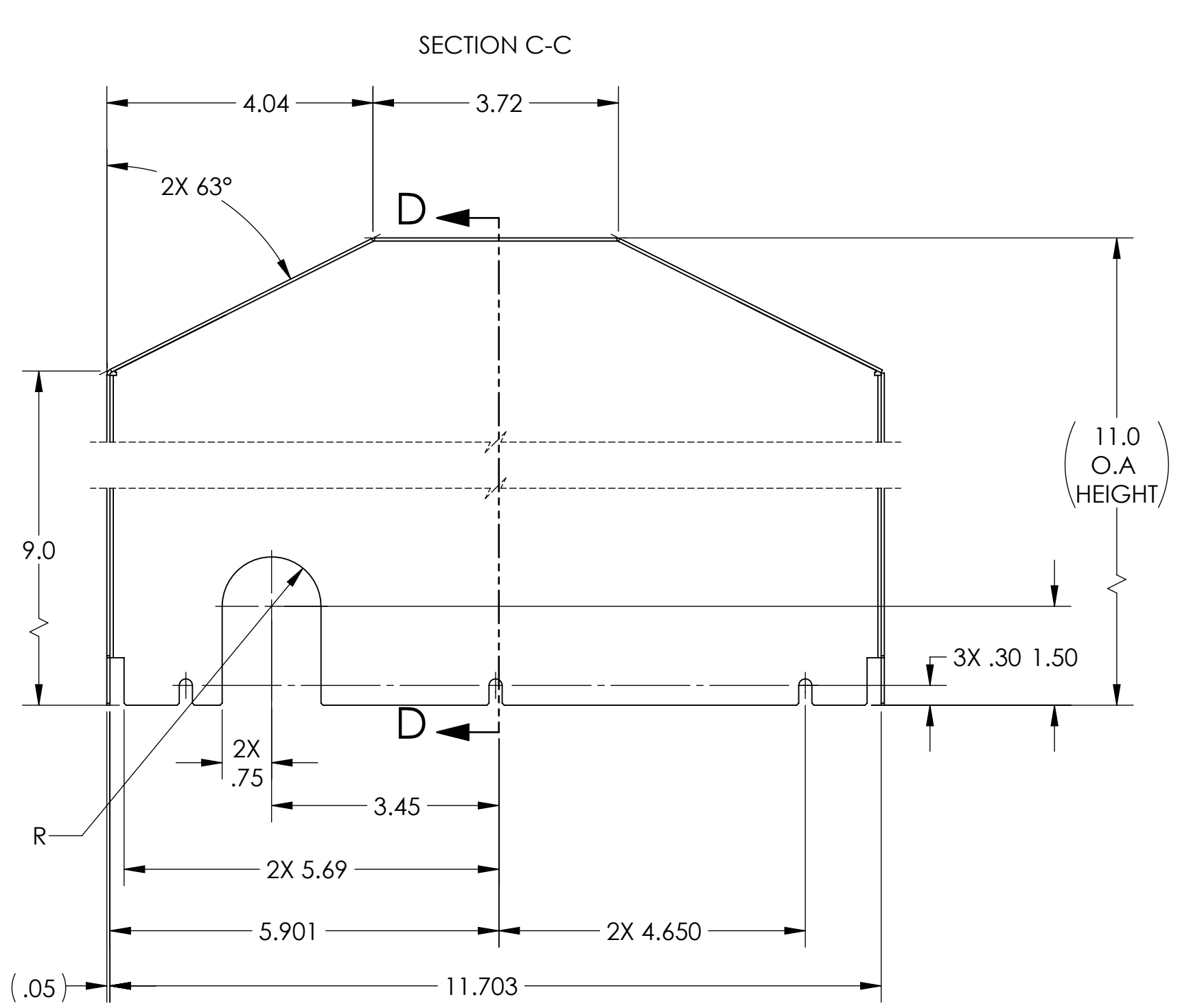
ISO VIEW



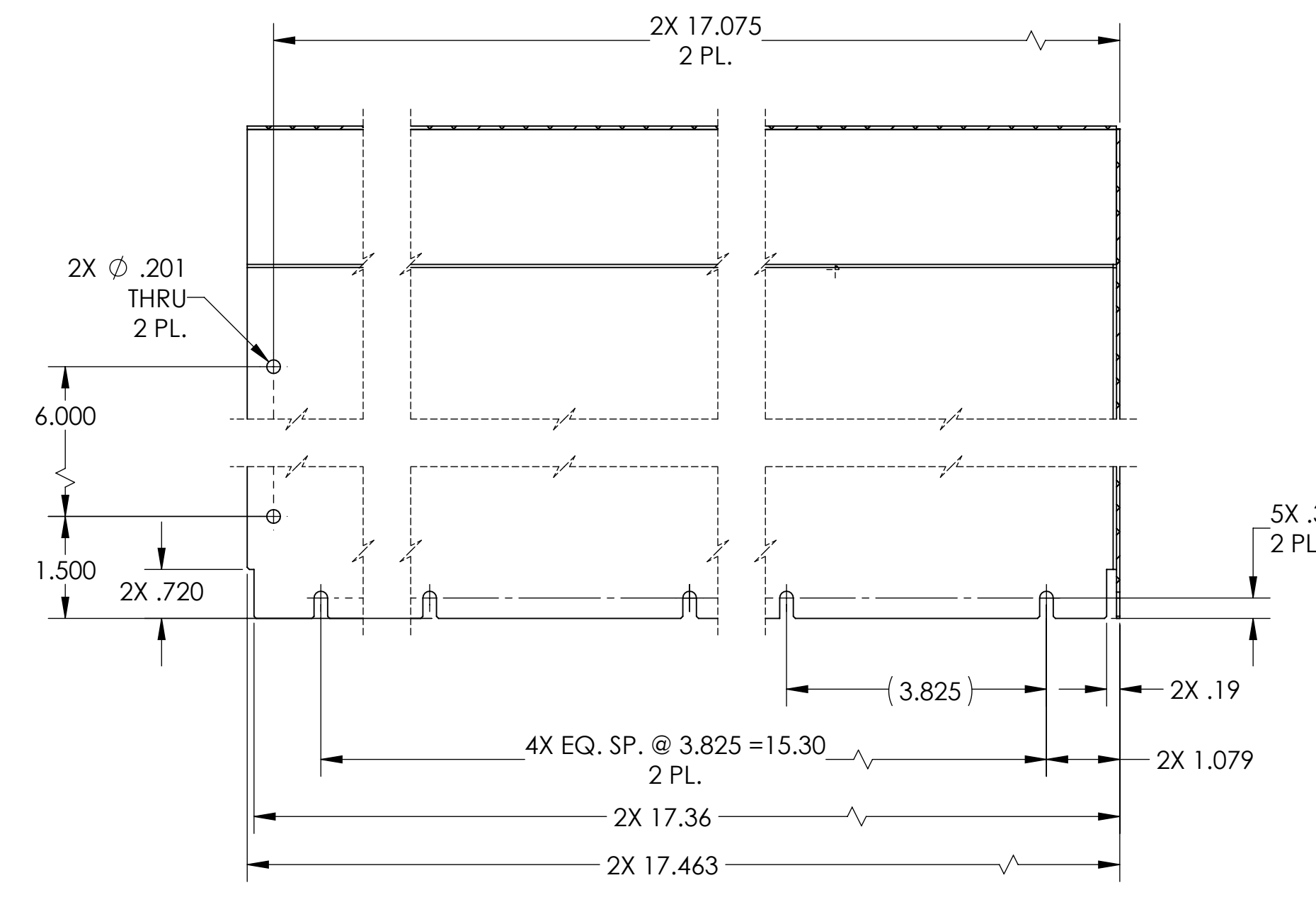
DETAIL B SCALE 2:1



SECTION A-A



SECTION C-C



SECTION D-D

-102 DETAIL

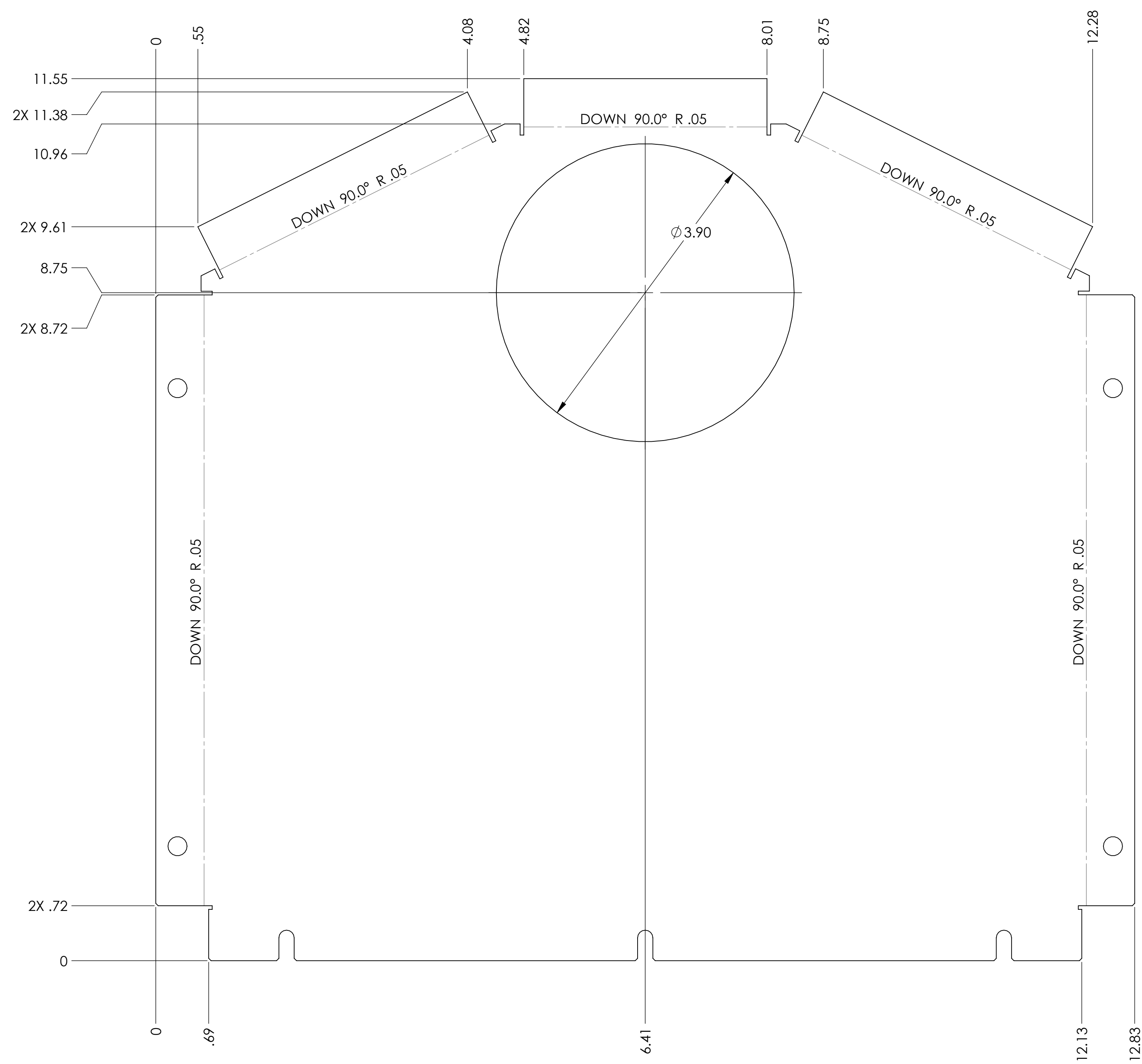
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.
6	MS16996-9 OR EQ.	SCREW, SHC, 10-32 X .38 LG.		4
5	MS15995-808	WASHER, FLAT, 1/4	300 SSSL	4
4	96439A20 MCMMASTER-CARR	CAPTIVE NUT, 10-32	18-8 SSSL	4
3	D1100209-103	ALIGO, AOS, OPLEV XMTR PYLON ENCLOSURE ASSY, FRONT COVER	304 SSSL 18 GA.	1
2	D1100209-102	ALIGO, AOS, OPLEV XMTR PYLON ENCLOSURE ASSY, HOUSING	304 SSSL 18 GA.	1
1	D1100209-101	ALIGO, AOS, OPLEV XMTR PYLON ENCLOSURE ASSY, BELLOW MT. RING	304 SSSL	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)  
 1. INTERPRET DRAWING PER ASME Y14.5-1994  
 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.  
 3. DO NOT SCALE FROM DRAWING.  
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

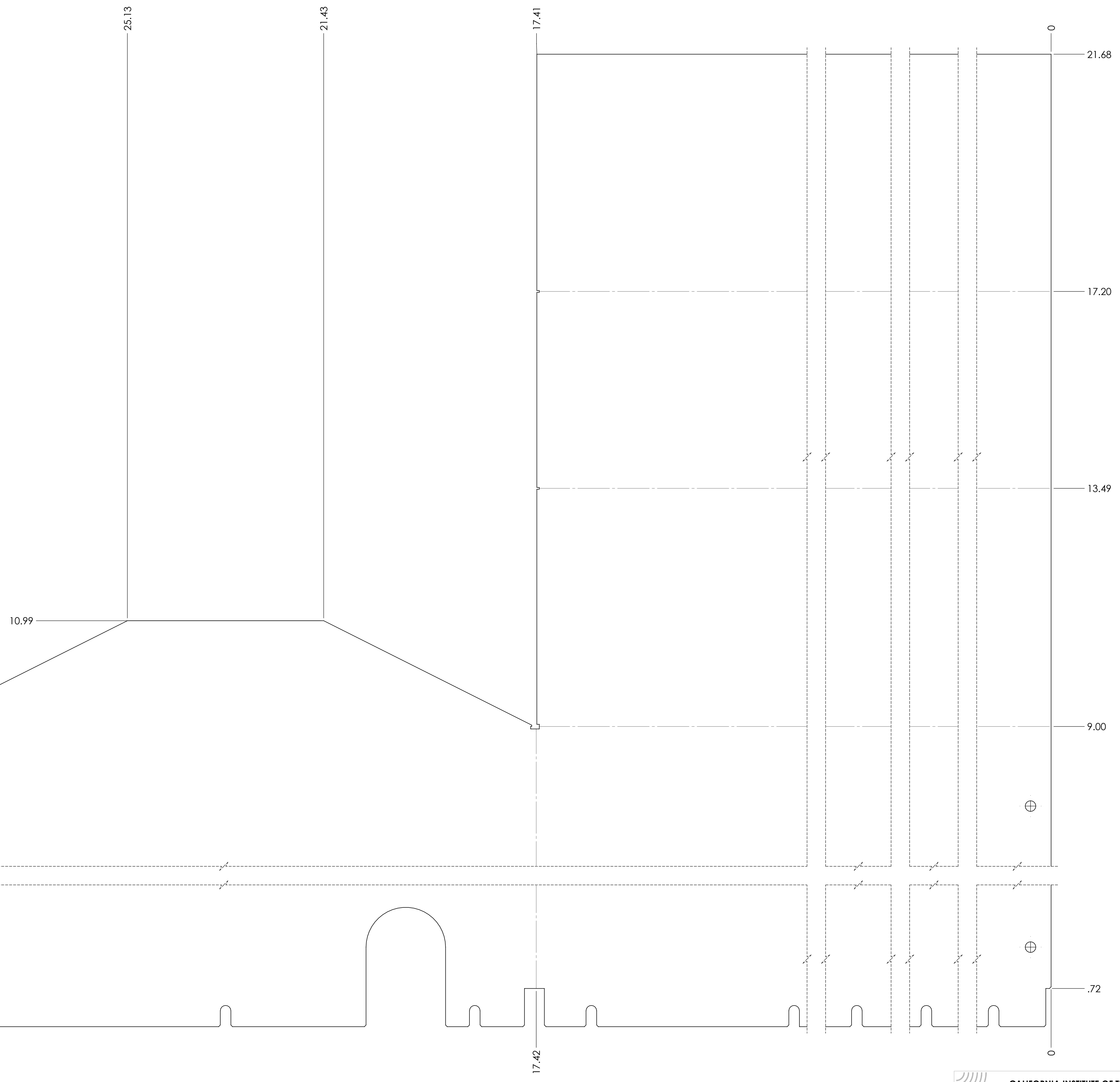
DIMENSIONS ARE IN INCHES  
 TOLERANCES:  
 .XX ± .01  
 .XXX ± .005  
 ANGULAR ± 0.5°

MATERIAL: SEE PARTS LIST  
 FINISH: N/A  
 PROJECTION: 1st Angle

CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY  
 ADVANCED LIGO  
 SUB-SYSTEM: AOS  
 PART NAME: ALIGO, AOS, OPLEV XMTR PYLON ENCLOSURE ASSY.  
 DESIGNER: C. WILKERSON  
 DRAFTER: E. SANCHEZ  
 CHECKER: SEE DCC  
 APPROVAL: SEE DCC  
 DATE: 11 FEB 2011  
 DATE: 18 MAY 2011  
 DATE: SEE DCC  
 DATE: SEE DCC  
 SIZE: DWG. NO. E  
 DWG. NO. D1100209  
 REV. v2  
 SCALE: 1:2  
 SHEET 1 OF 2



**-103 FLAT STATE**  
(ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY)



**-101 FLAT STATE**  
(ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY)