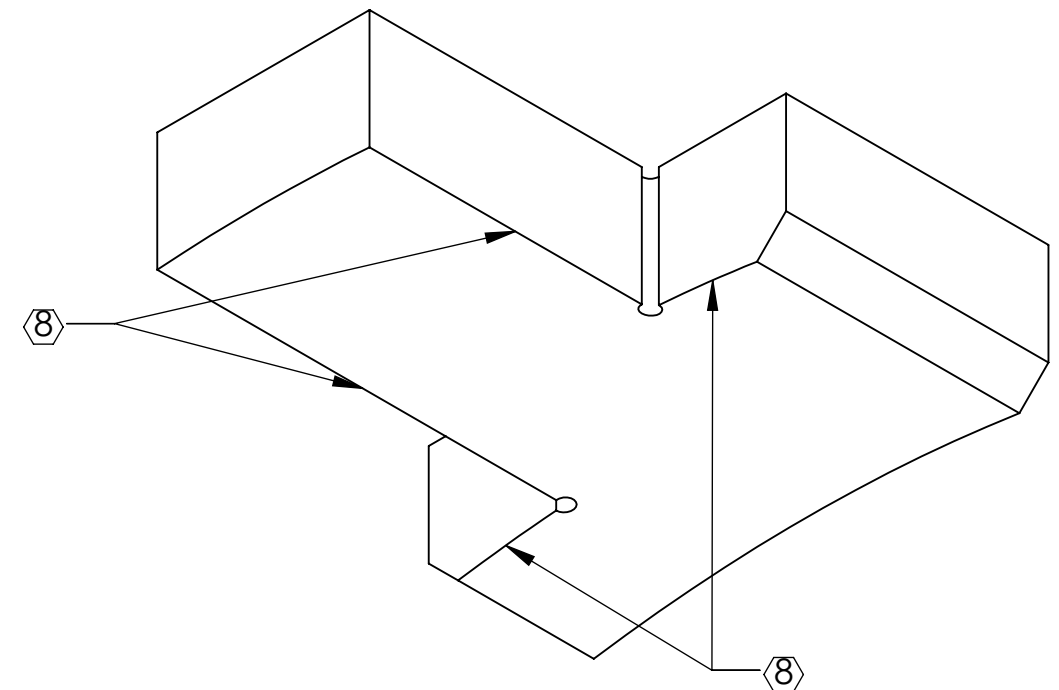
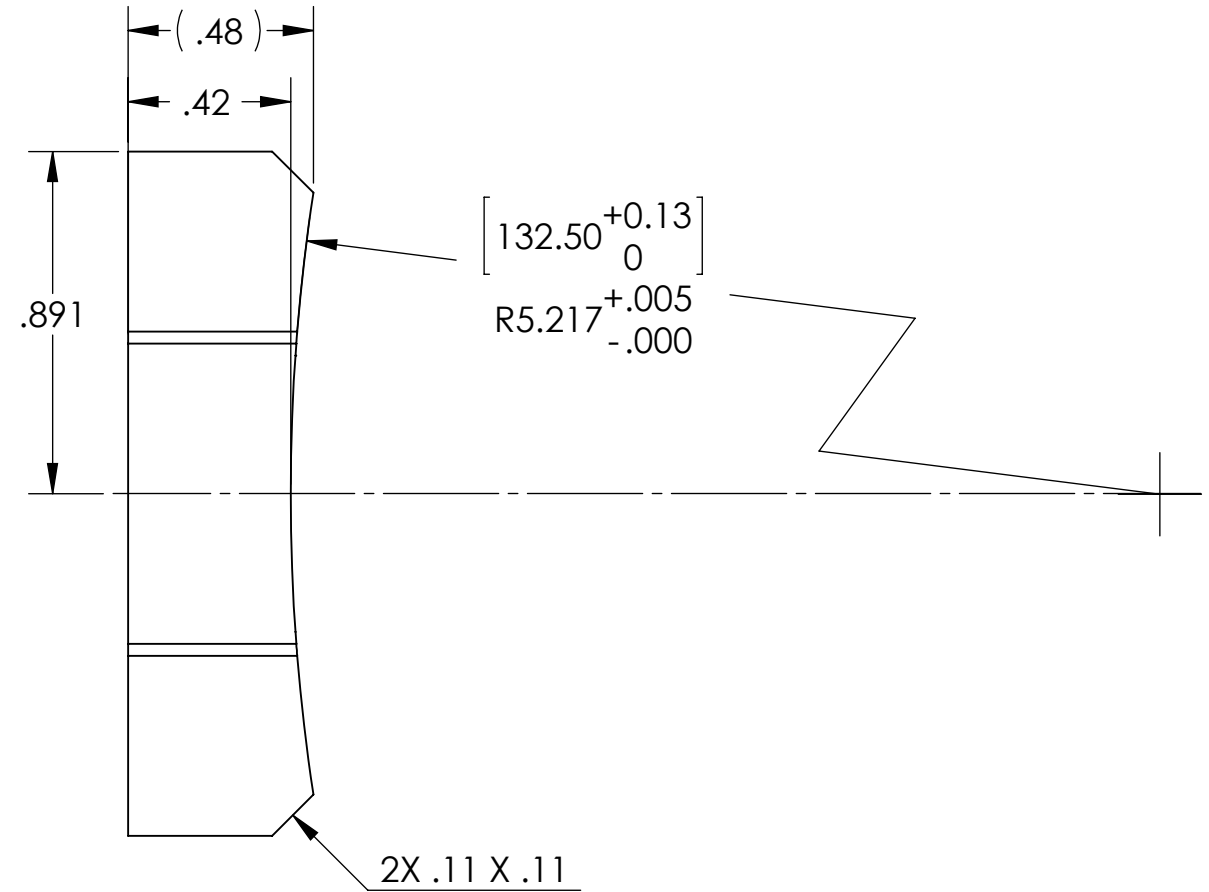
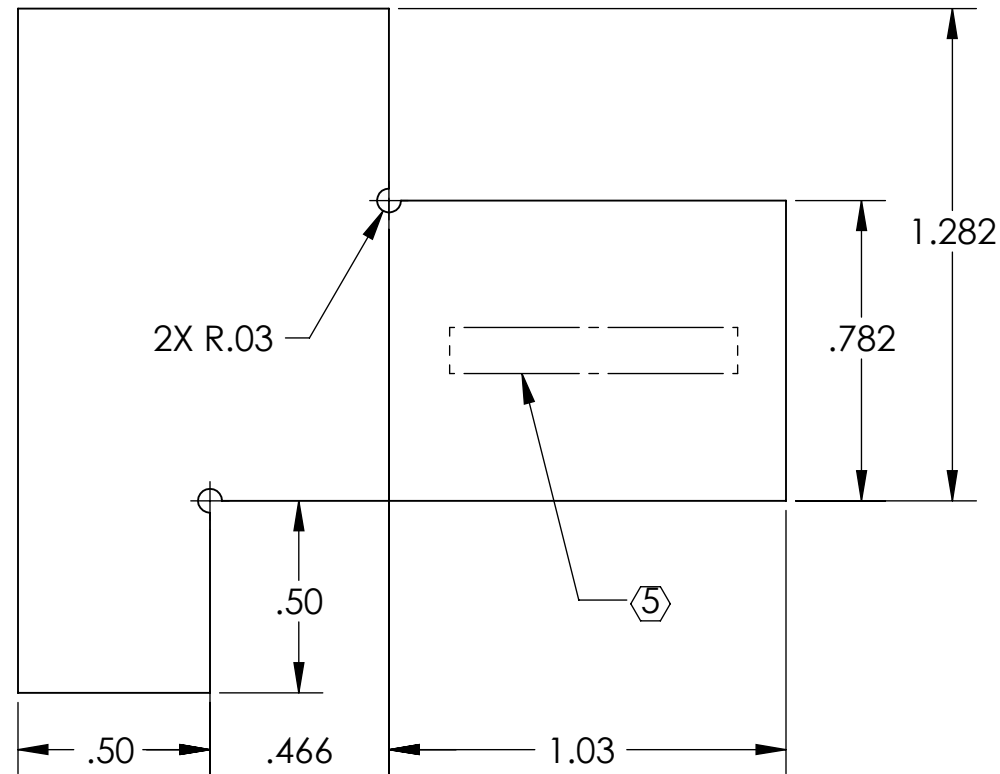


D1101789_Advanced_LIGO_SUS_HLTS_Metal_Bottom_Mass_Secondary_Prism_Placement_Fixture, PART PDM REV: X-000, DRAWING PDM REV:

NOTES CONTINUED:
 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: 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. DO NOT REMOVE SHARP EDGES.

REV.	DATE	DCN #	DRAWING TREE #
v1	11 SEP 2011	E1100838	E080191
-	-	-	-
-	-	-	-



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, 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.		SECONDARY PRISM PLACEMENT FIXTURE, METAL BOTTOM MASS	
MATERIAL		FINISH		SYSTEM		SUB-SYSTEM	
6061-T6 Al		63 μinch		ADVANCED LIGO		SUS	
NEXT ASSY				DESIGNER		DATE	
HLTS OVERALL ASSY AND FIXTURES				D. BRIDGES		10 SEP 2011	
				DRAFTER		14 SEP 2011	
				CHECKER		15 SEP 2011	
				APPROVAL			
				SCALE: 2:1		PROJECTION:	
						SHEET 1 OF 1	

8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

8 7 6 5 4 3 2 1