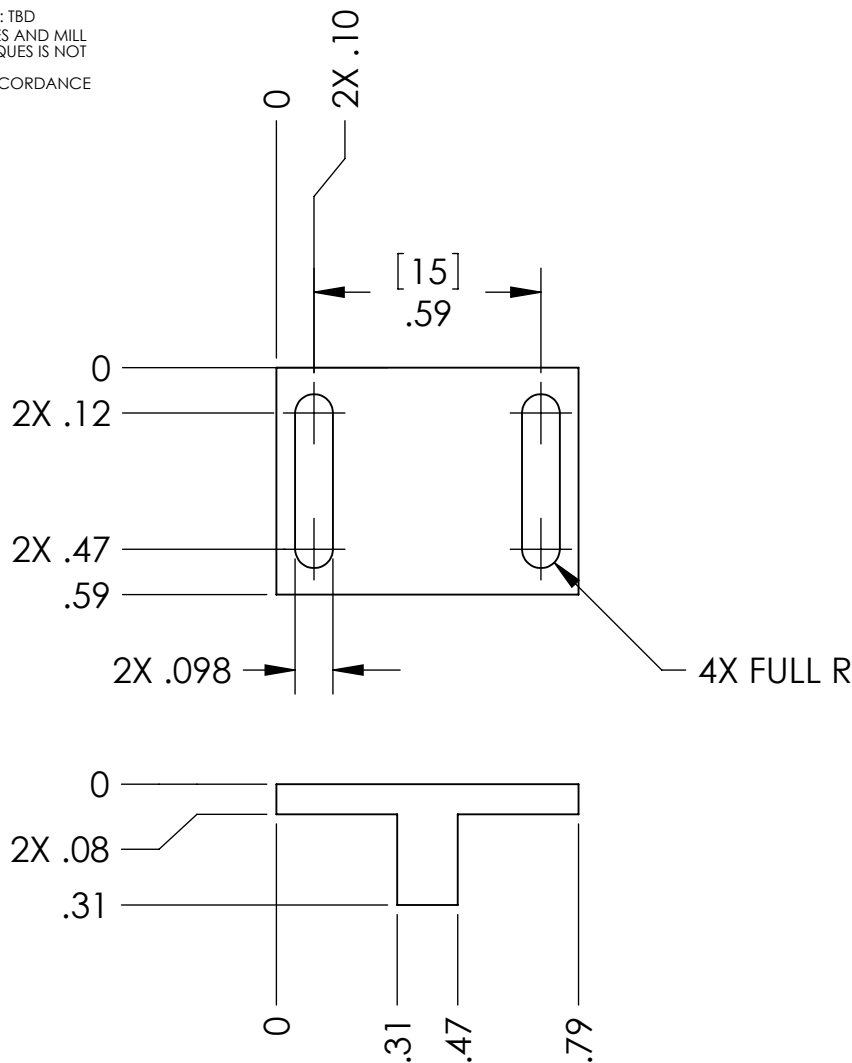


NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS & REVISION NUMBER START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.  
EXAMPLE (PART): 001-v1  
EXAMPLE (TAG): DXXXXXX-YY, TYPE-XX, QTY: TBD
- 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.

REV.	DATE	DCN #	DRAWING TREE #
A	12 AUG 2008	E080415	-
v2	02 SEP 2011	E1100826	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES [MM]  
 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.

MATERIAL 6061-T6 Al  
 FINISH 63 μinch

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM SUS  
 NEXT ASSY MULTIPLE ASSYS

PART NAME				SIZE		DWG. NO.		REV.
ALIGNMENT GUIDE				A		D080409		v2
DESIGNER	D. BRIDGES	02 SEP 2011						
DRAFTER	B. MOORE	06 SEP 2011						
CHECKER								
APPROVAL								
				SCALE: 2:1		PROJECTION:		SHEET 1 OF 1

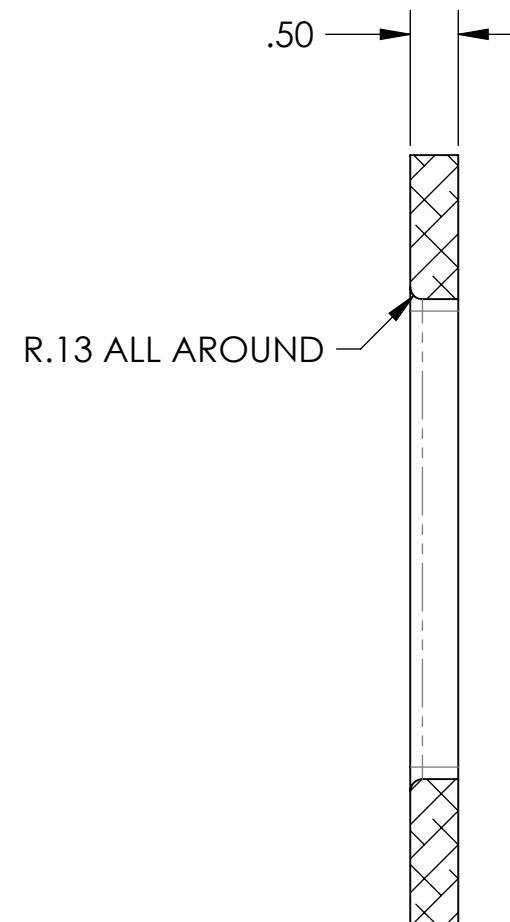
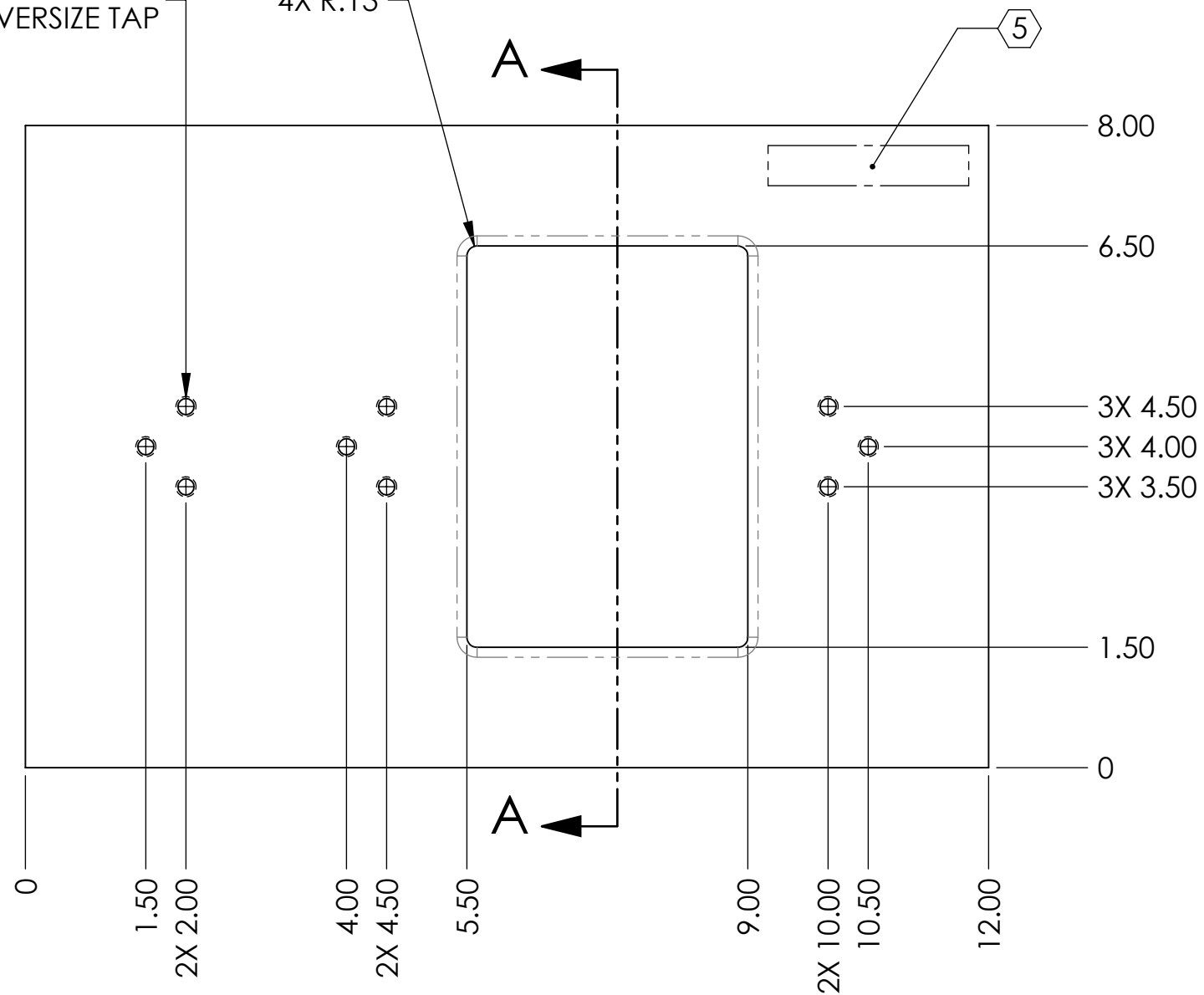
D0902460\_Advanced\_LIGO\_SUS\_HLTS\_Base\_Plate,\_Sapphire\_Prism\_Placement\_Fixture, PART PDM REV: V1-001, DRAWING PDM REV: V1-002

**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.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 OCT 2009	E0900369	-
v2	02 SEP 2011	E1100826	-
-	-	-	-

9X 1/4-20 UNC THRU  
 +.005 OVERSIZE TAP

4X R.13



SECTION A-A

**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

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.

MATERIAL: 6061-T6 Al  
 FINISH: 63 μinch

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO  
 SUB-SYSTEM: SUS  
 NEXT ASSY: OPTIC HOLDER, HAM TRIPLE SUS.

PART NAME			BASE PLATE		
DESIGNER	D. BRIDGES	09 SEP 2011	SIZE	DWG. NO. <b>D0902460</b>	
DRAFTER	D. BRIDGES	09 SEP 2011	REV.	v2	
CHECKER	B. MOORE	09 SEP 2011	SCALE	1:2	
APPROVAL			PROJECTION	SHEET 1 OF 1	

D0902461\_Advanced\_LIGO\_SUS\_HLTS\_Optic\_Rest\_Wedge\_Sapphire\_Prism\_Placement\_Fixture\_PART PDM REV: V1\_DRAWING PDM REV: V1-000

**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.

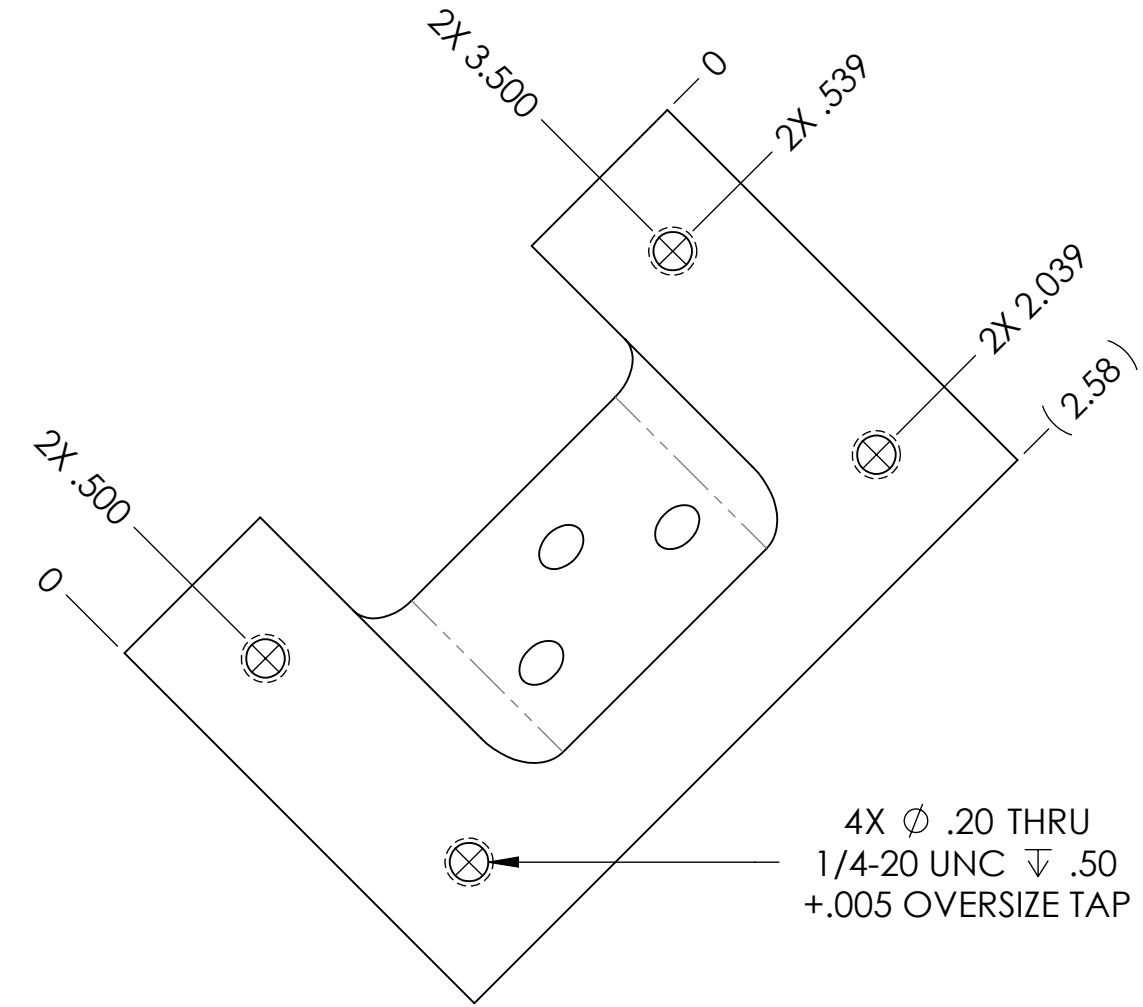
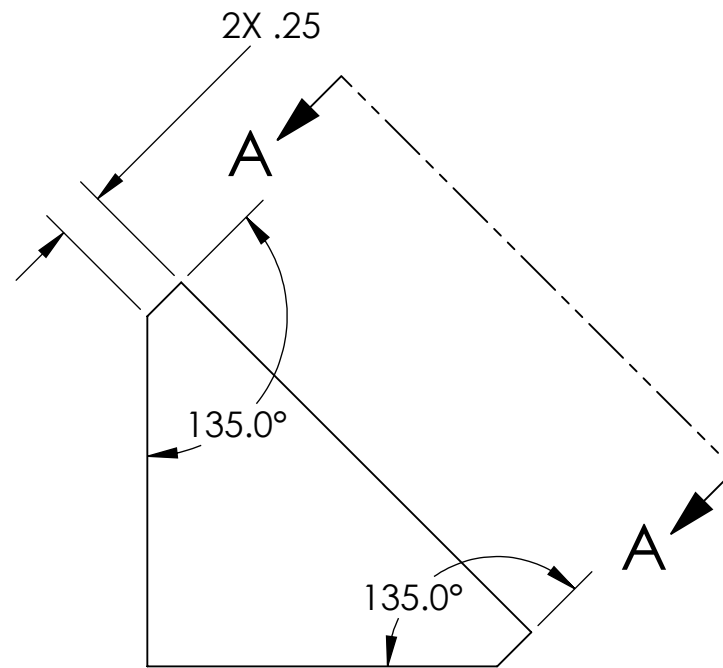
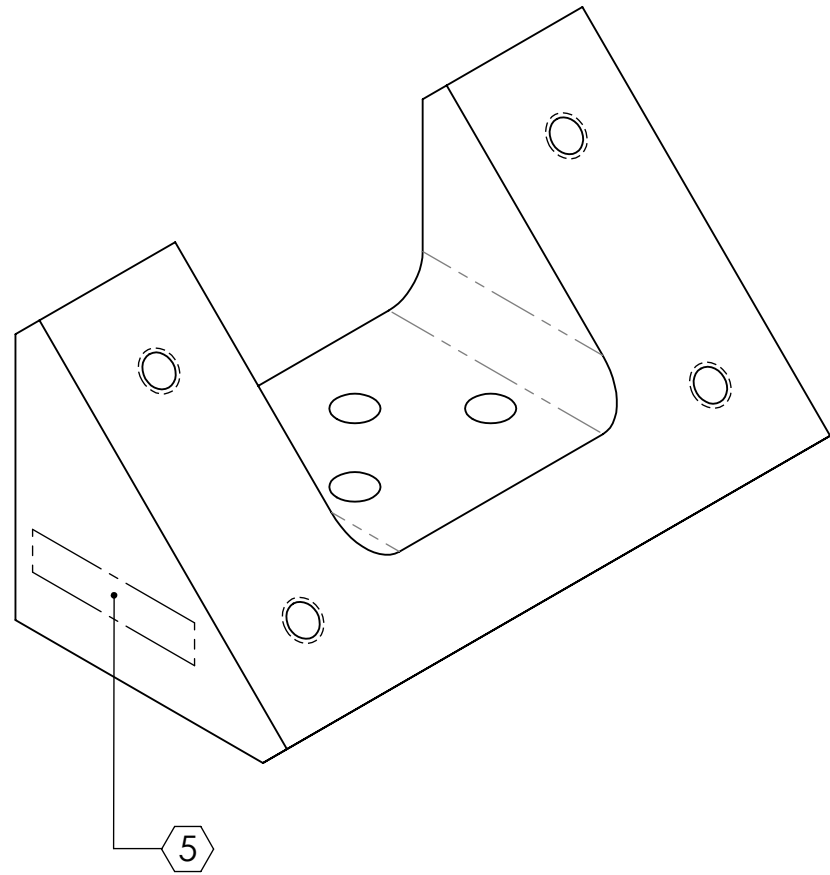
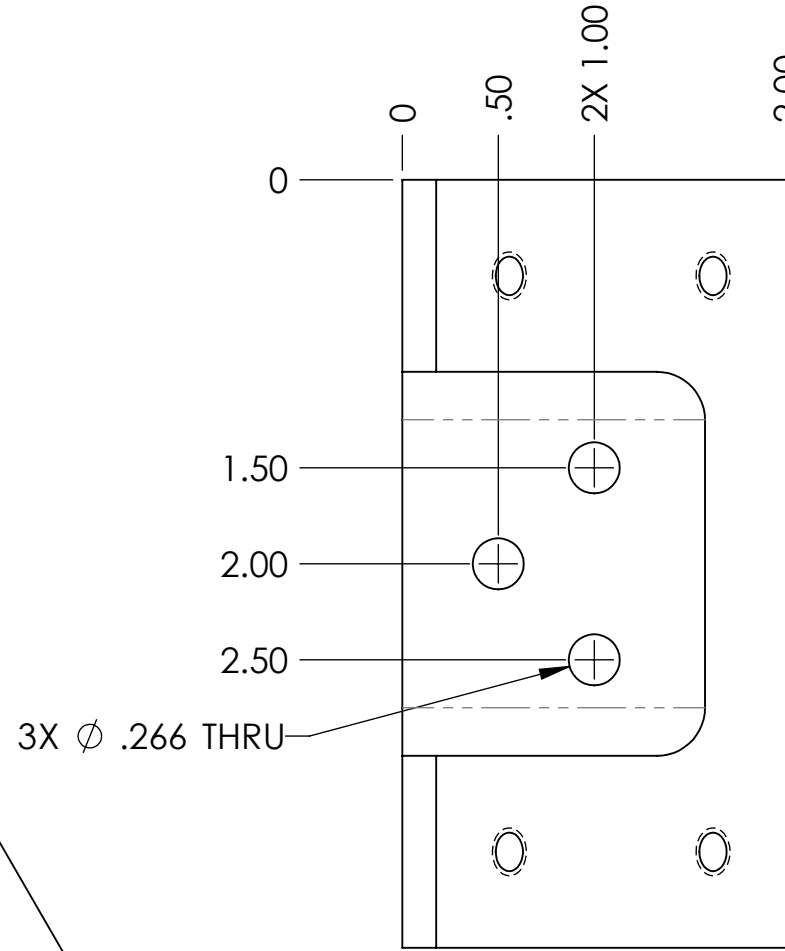
REV.	DATE	DCN #	DRAWING TREE #
v1	22 OCT 2009	E0900369	-
v2	02 SEP 2011	E1100826	-
-	-	-	-

D

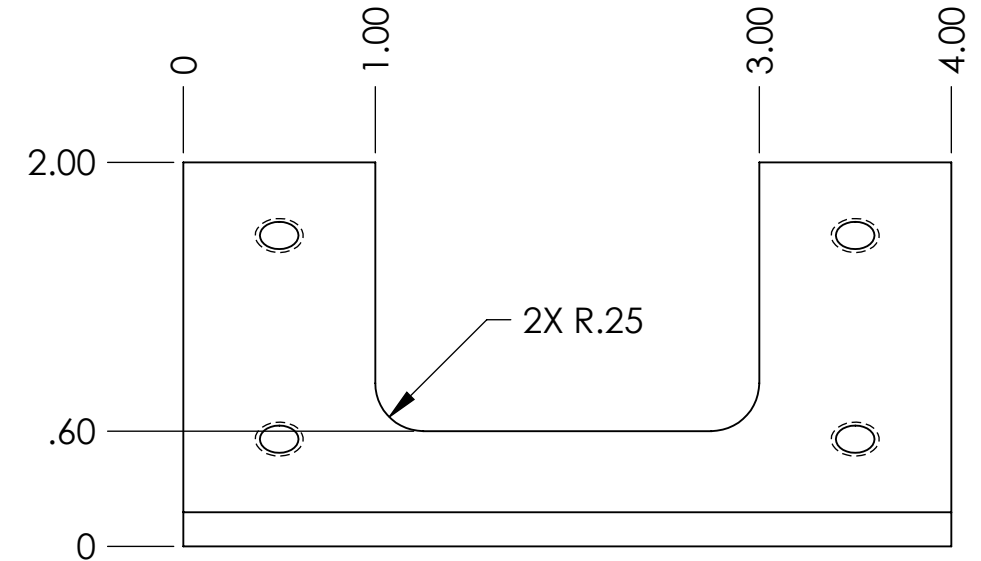
C

B

A



VIEW A-A



D

C

B

A

**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

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.

MATERIAL 6061-T6 Al FINISH N/A μinch

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM SUS  
 NEXT ASSY OPTIC HOLDER, HAM TRIPLE SUS.

PART NAME OPTIC REST WEDGE

DESIGNER	D. BRIDGES	24 OCT 2009	SIZE	DWG. NO.	REV.
DRAFTER	R. BIEDENHARN	15 NOV 2010	B	D0902461	v2
CHECKER	D. BRIDGES	09 SEP 2011	SCALE:	1:1	PROJECTION:
APPROVAL					SHEET 1 OF 1

8

7

6

5

4

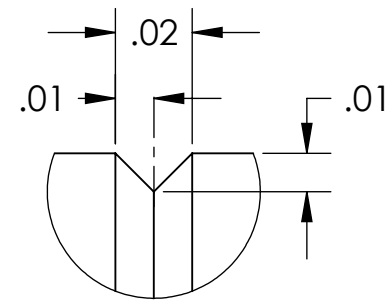
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2

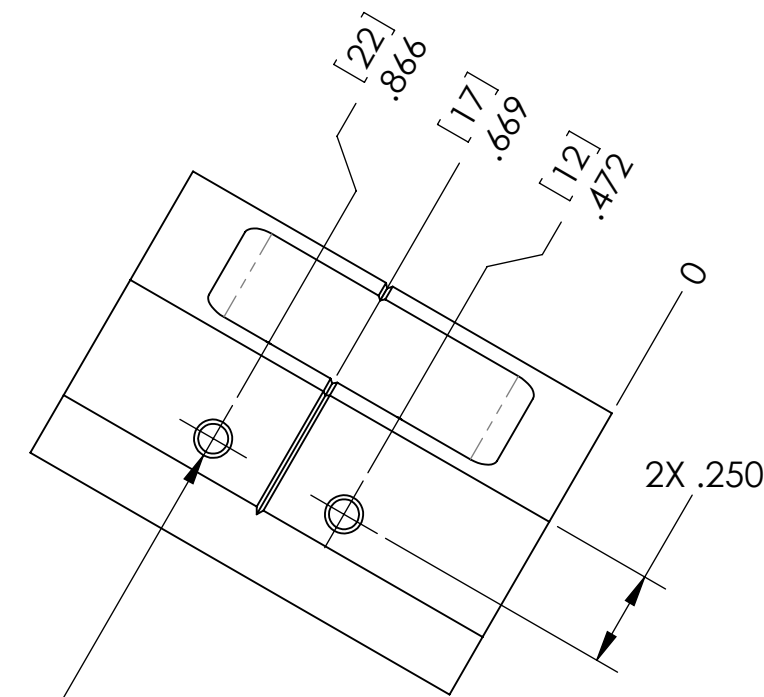
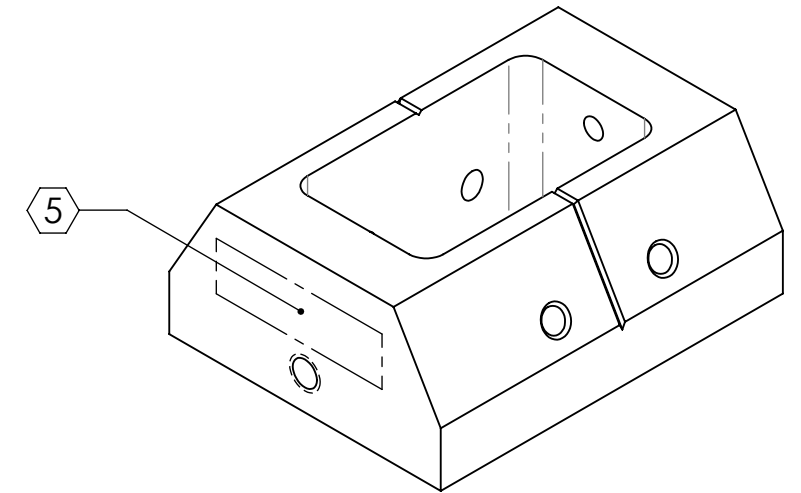
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NOTES CONTINUED:  
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS 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.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 OCT 2009	E0900369	E080191
v2	02 SEP 2011	E1100826	E080191
-	-	-	-



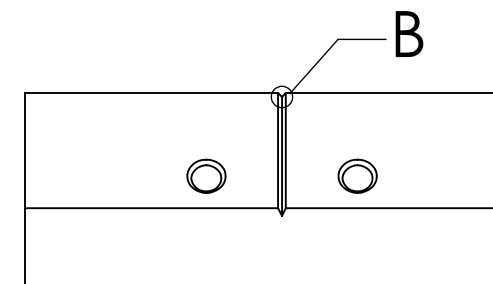
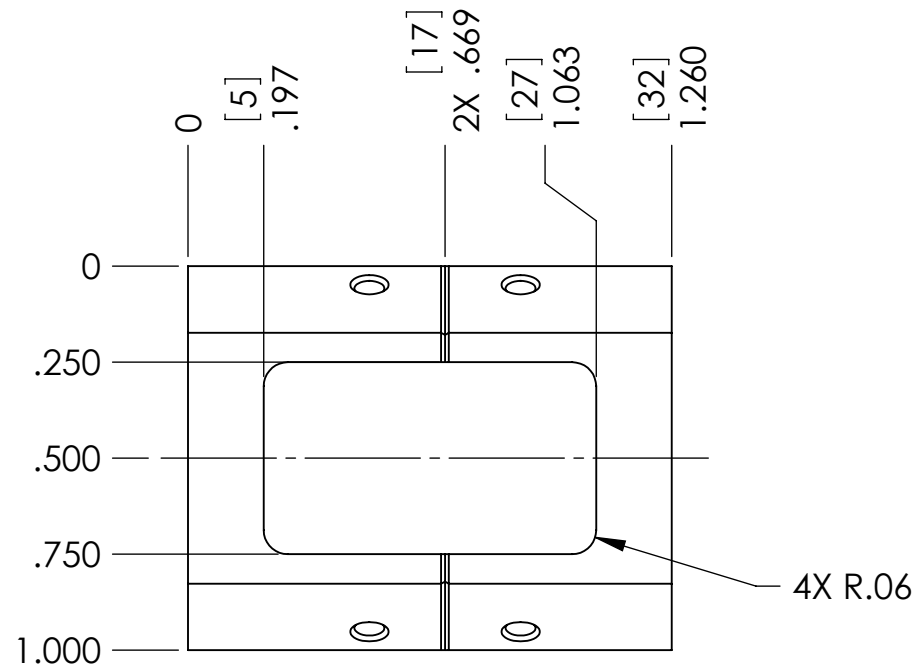
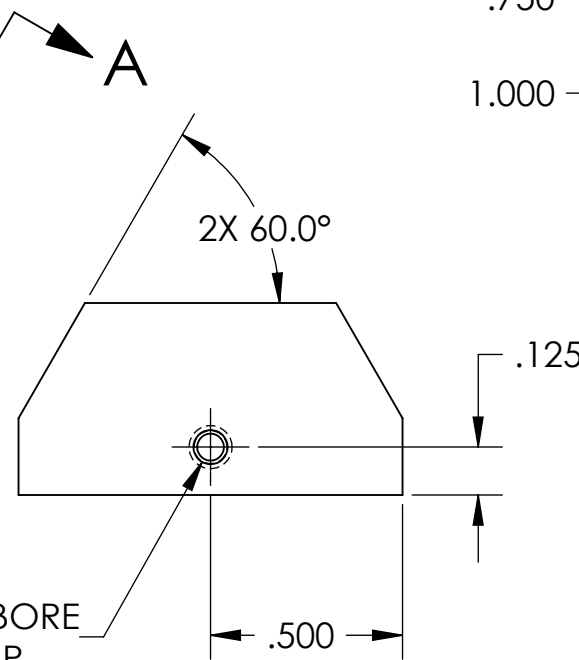
DETAIL B  
 SCALE 20 : 1  
 TYPICAL



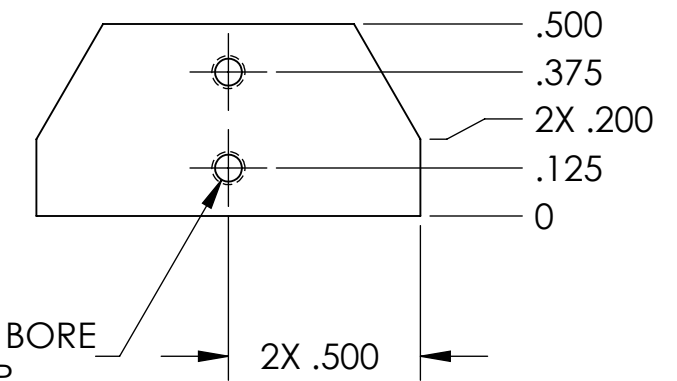
2X  $\phi$  .0781 $\pm$ .0005 THRU TO BORE  
 $\checkmark$   $\phi$  .100 MAX X 90°, NEAR SIDE

VIEW A-A

#4-40 UNC THRU TO BORE  
 +.005 OVERSIZE TAP



2X #2-56 UNC THRU TO BORE  
 +.003 OVERSIZE TAP



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)  
 DIMENSIONS ARE IN INCHES [MM]  
 TOLERANCES:  
 .XX  $\pm$  .01  
 .XXX  $\pm$  .005  
 ANGULAR  $\pm$  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.  
 MATERIAL 6061-T6 Al  
 FINISH 63  $\mu$ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY  
 SYSTEM ADVANCED LIGO SUB-SYSTEM SUS  
 NEXT ASSY SAPPHIRE PRISM HOLDER

PART NAME SAPPHIRE PRISM HOLDER  
 DESIGNER D. BRIDGES 06 SEP 2011  
 DRAFTER D. BRIDGES 06 SEP 2011  
 CHECKER B. MOORE 07 SEP 2011  
 APPROVAL  
 SIZE DWG. NO. B D0902664  
 REV. v2  
 SCALE: 2:1 PROJECTION: SHEET 1 OF 1

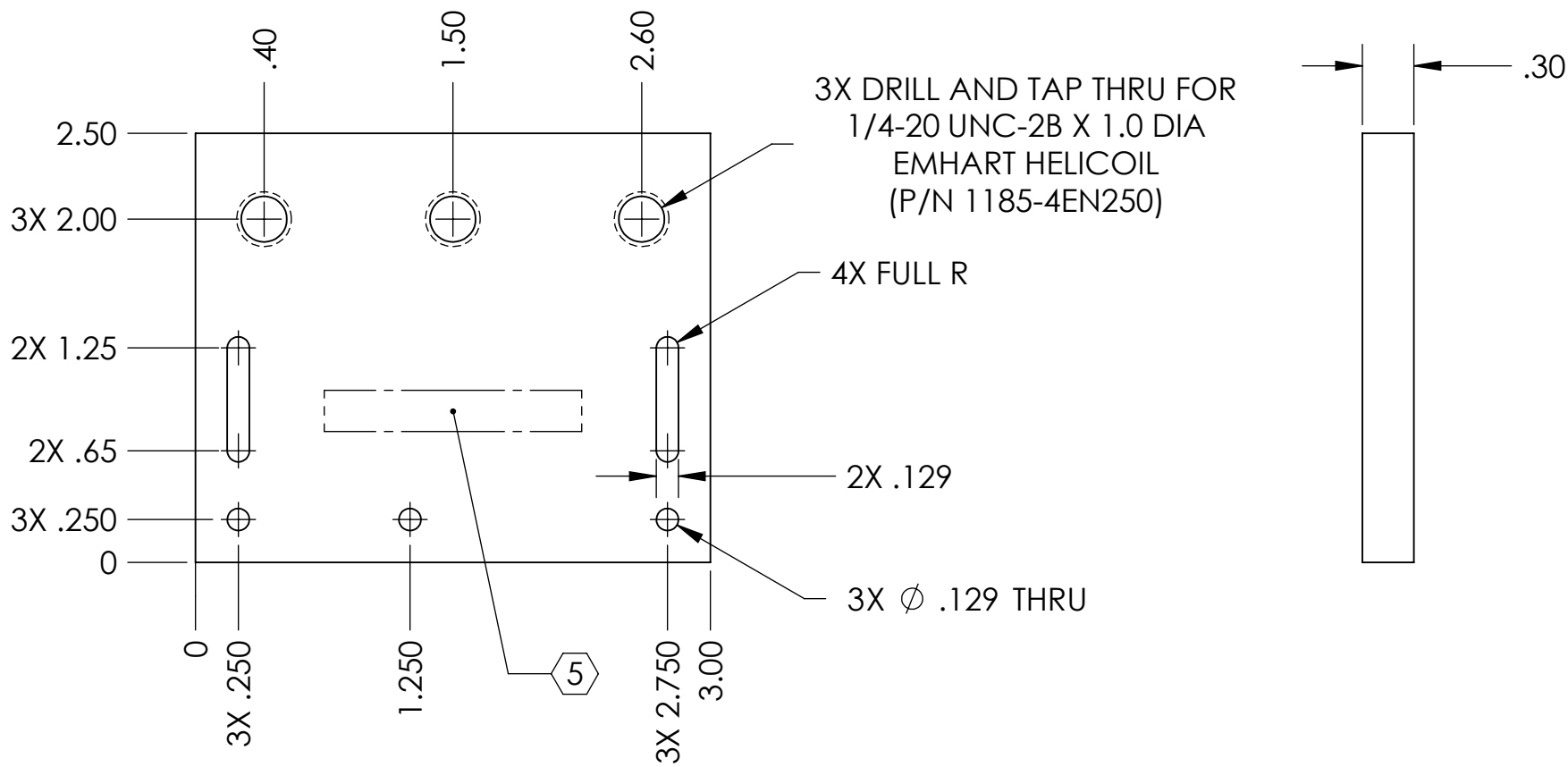
D0902664\_Advanced\_LIGO\_SUS\_HLTS\_Sapphire\_Prism\_Holder\_PART PDM REV: V1-002, DRAWING PDM REV: V1-002



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. ALL HELICOIL HOLES TO BE PREPARED IN ACCORDANCE WITH EMHART HELICOIL PRODUCT CATALOG, HC2000, REV. 4.
- 9. ALL HELICOILS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY, CLEANING AND BAKING OF FINISHED PARTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 OCT 2009	E0900369	-
v2	02 SEP 2011	E1100826	E080191
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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.

MATERIAL 6061-T6 Al

FINISH 63 μinch

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM SUS

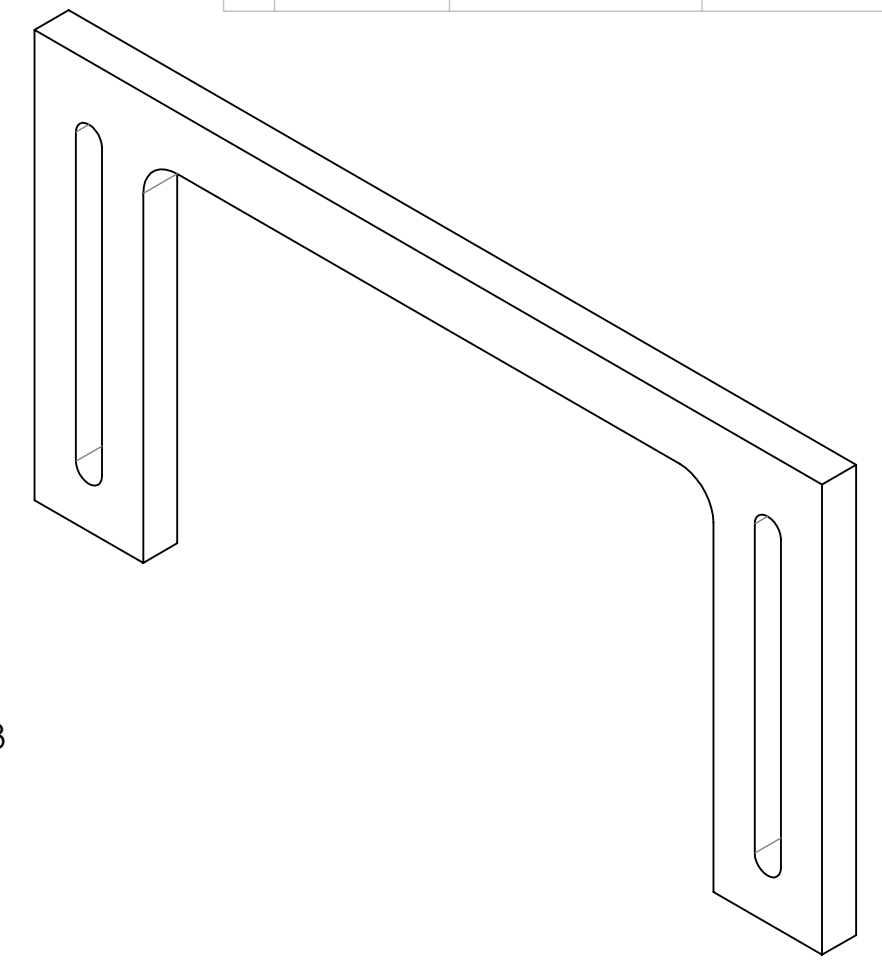
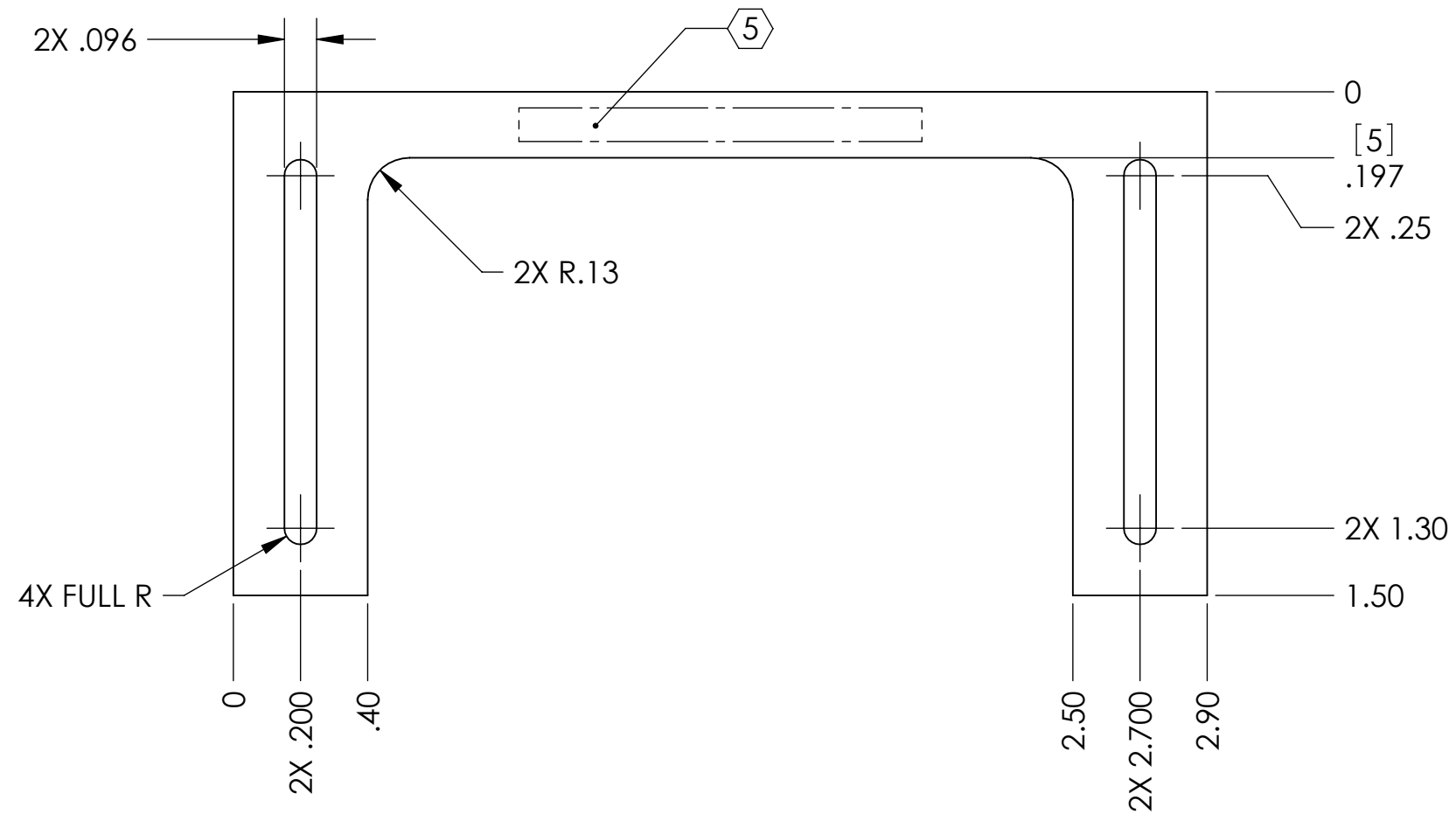
NEXT ASSY SAPPHIRE PRISM BONDING FIXTURE

PART NAME			BONDING TEMPLATE SIDE		
DESIGNER	D. BRIDGES	12 NOV 2009	SIZE	DWG. NO.	REV.
DRAFTER	D. BRIDGES	02 SEP 2011	A	D0902666	v2
CHECKER	B. MOORE	06 SEP 2011	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1
APPROVAL					

D0902721\_Advanced\_LIGO\_SUS\_HAM\_Triple\_Suspension\_Sapphire\_Prism\_Holder\_Guide, PART PDM REV: V1-000, DRAWING PDM REV: V1-001

**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-VV 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.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 OCT 2009	E0900369	-
v2	02 SEP 2011	E1100826	-
-	-	-	-

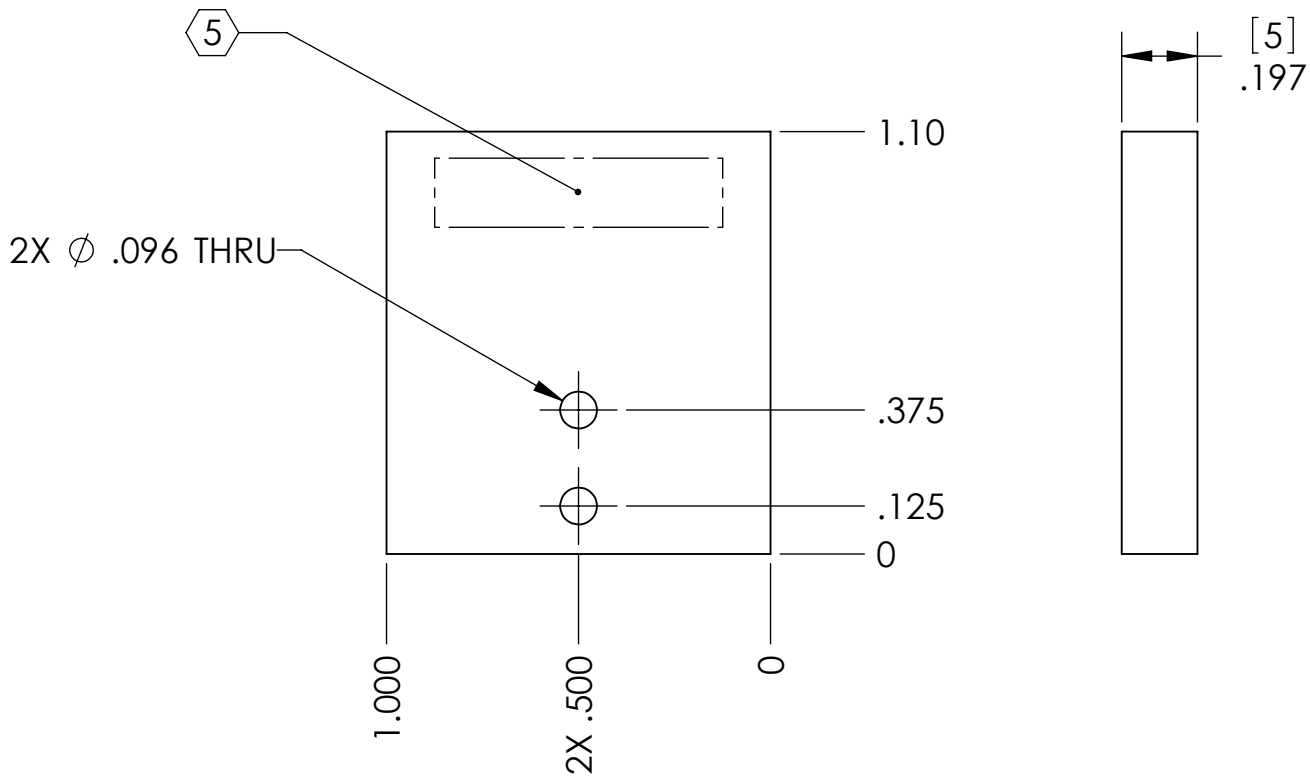


NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES [MM]				ADVANCED LIGO		SAPPHIRE PRISM HOLDER GUIDE	
TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°				SUB-SYSTEM SUS		DESIGNER D. BRIDGES	21 NOV 2009
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.				NEXT ASSY SAPPHIRE PRISM BONDING FIXTURE		DRAFTER D. BRIDGES	02 SEP 2011
MATERIAL 6061-T6 Al				FINISH 63 μinch		CHECKER B. MOORE	06 SEP 2011
						APPROVAL	
						SIZE B	DWG. NO. D0902721
						SCALE: 2:1	PROJECTION:  SHEET 1 OF 1
						REV. v2	

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.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 OCT 2009	E0900369	E080191
v2	02 SEP 2011	E1100826	E080191
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES [MM]  
 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.

**MATERIAL** 6061-T6 Al  
**FINISH** 63 μinch

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LIGO**      SUB-SYSTEM: **SUS**  
 NEXT ASSY: **SAPPHIRE PRISM HOLDER**

PART NAME: **SAPPHIRE PRISM HOLDER EXTENSION**

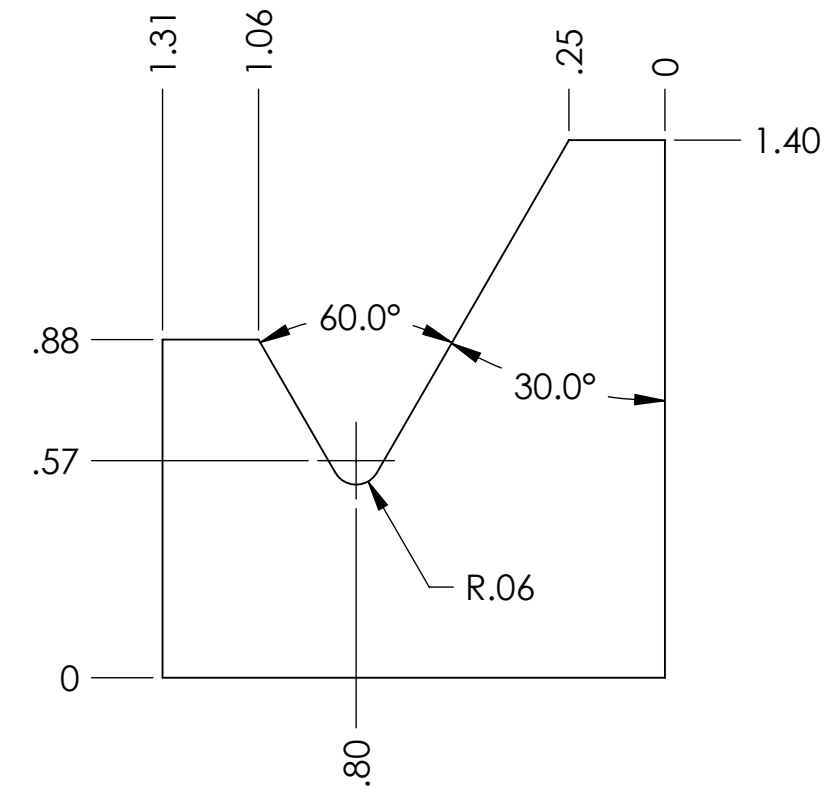
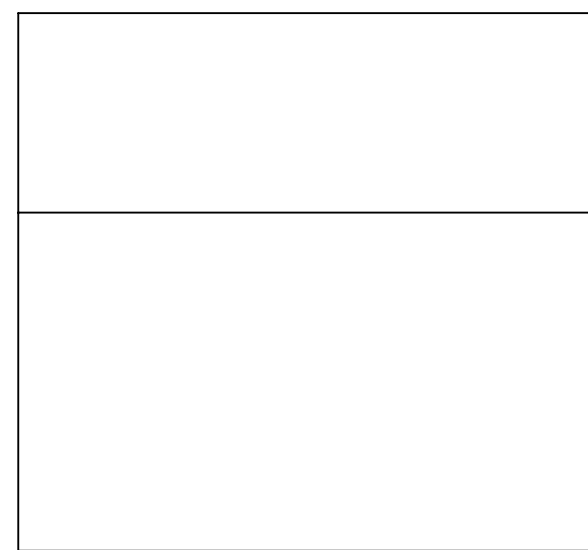
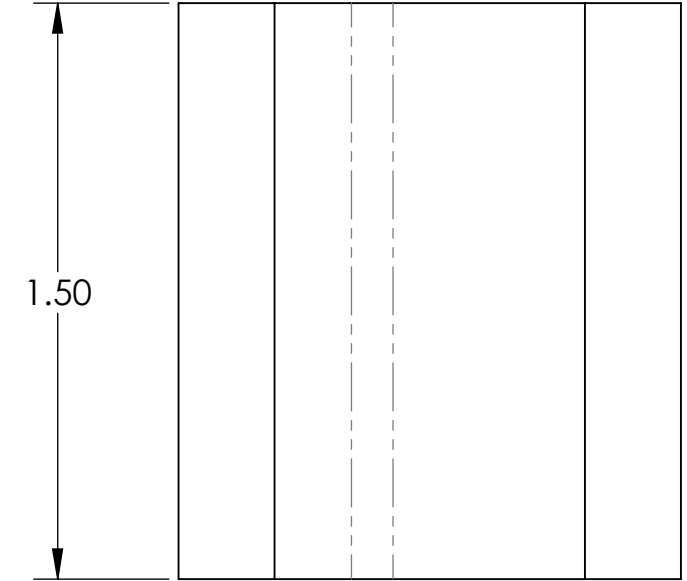
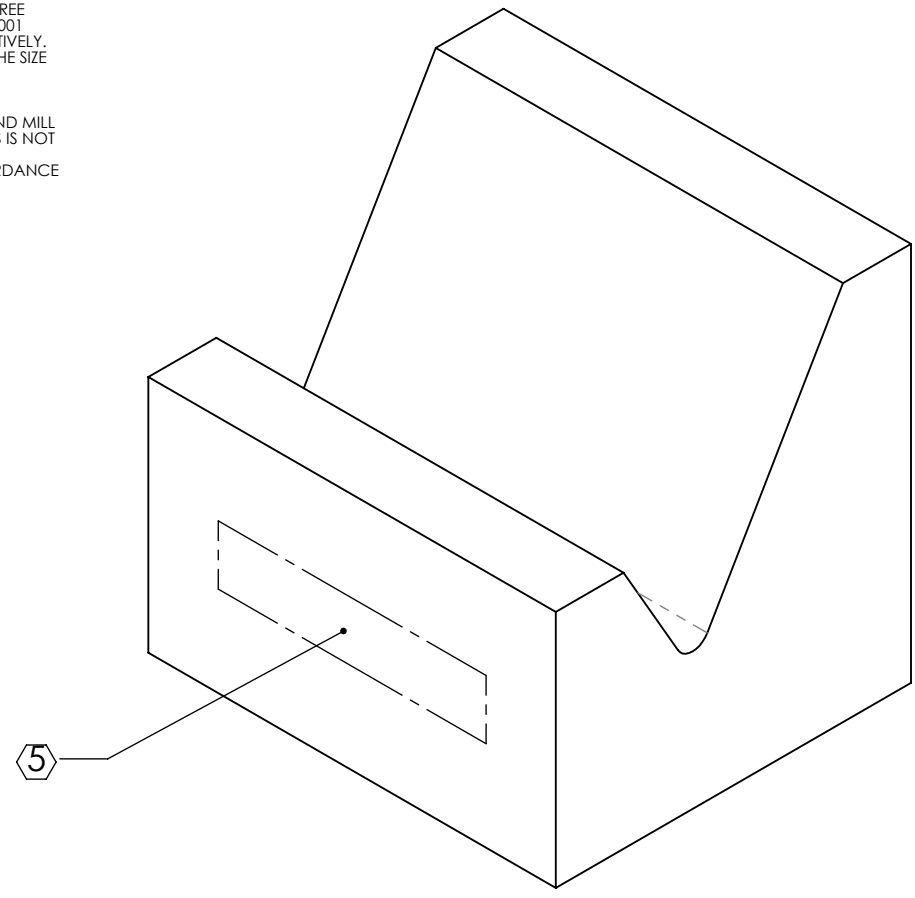
DESIGNER	D. BRIDGES	06 SEP 2011	SIZE	DWG. NO.	REV.
DRAFTER	D. BRIDGES	06 SEP 2011	A	<b>D0902722</b>	v2
CHECKER	B. MOORE	07 SEP 2011	SCALE: 2:1	PROJECTION:	SHEET 1 OF 1
APPROVAL					



D1101779\_Advanced\_LIGO\_SUS\_HLTS\_Dowel\_Pin\_Insertion\_Fixture,\_Sapphire\_Prism\_Holder, 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.

REV.	DATE	DCN #	DRAWING TREE #
v1	02 SEP 2011	E1100826	-
-	-	-	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
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.	
MATERIAL	6061-T6 Al
FINISH	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME DOWEL PIN INSERTION FIXTURE, SAPPHIRE PRISM HOLDER	
SYSTEM ADVANCED LIGO	SUB-SYSTEM SUS	DESIGNER D. BRIDGES	07 SEP 2011
NEXT ASSY N/A		DRAFTER D. BRIDGES	07 SEP 2011
		CHECKER B. MOORE	08 SEP 2011
		APPROVAL	
SCALE: 2:1		PROJECTION:	SHEET 1 OF 1

8 7 6 5 4 3 2 1

D C B A

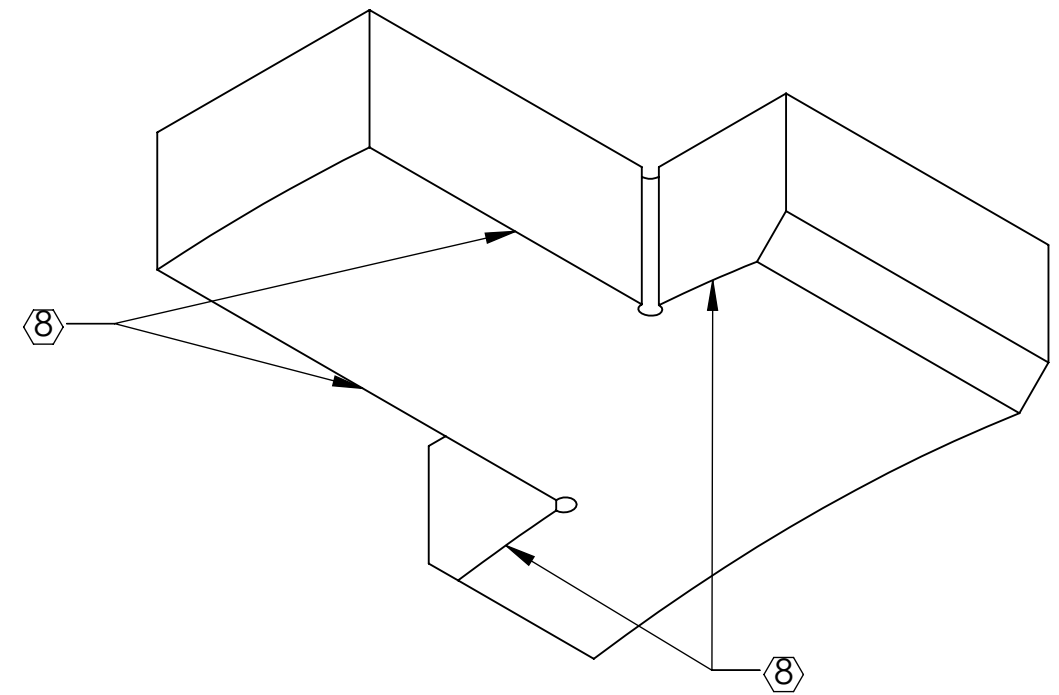
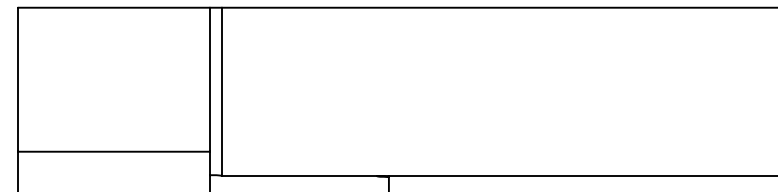
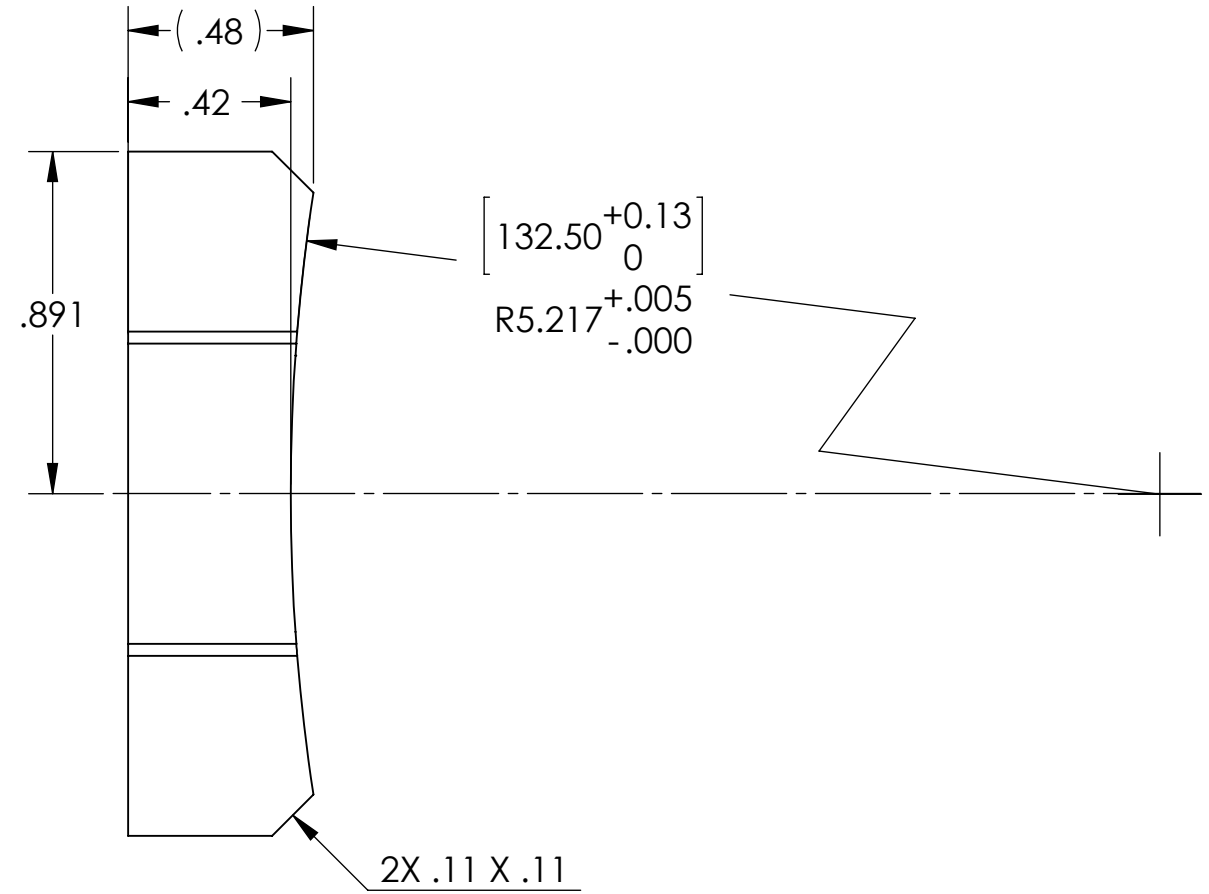
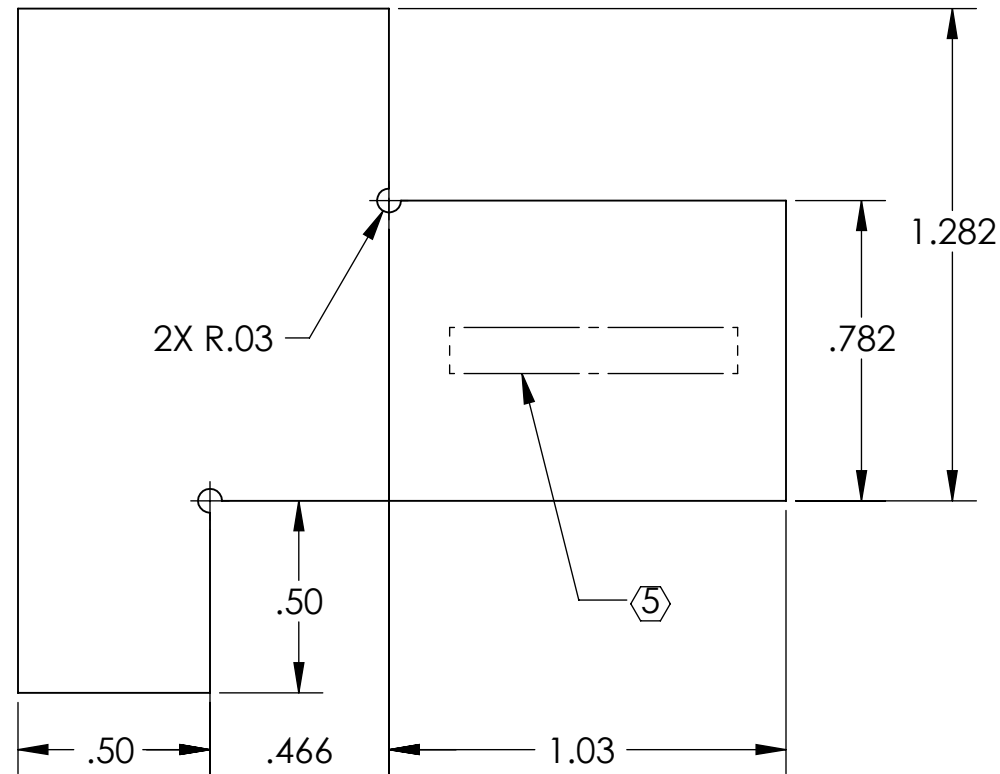
D C B A

8 7 6 5 4 3 2 1

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