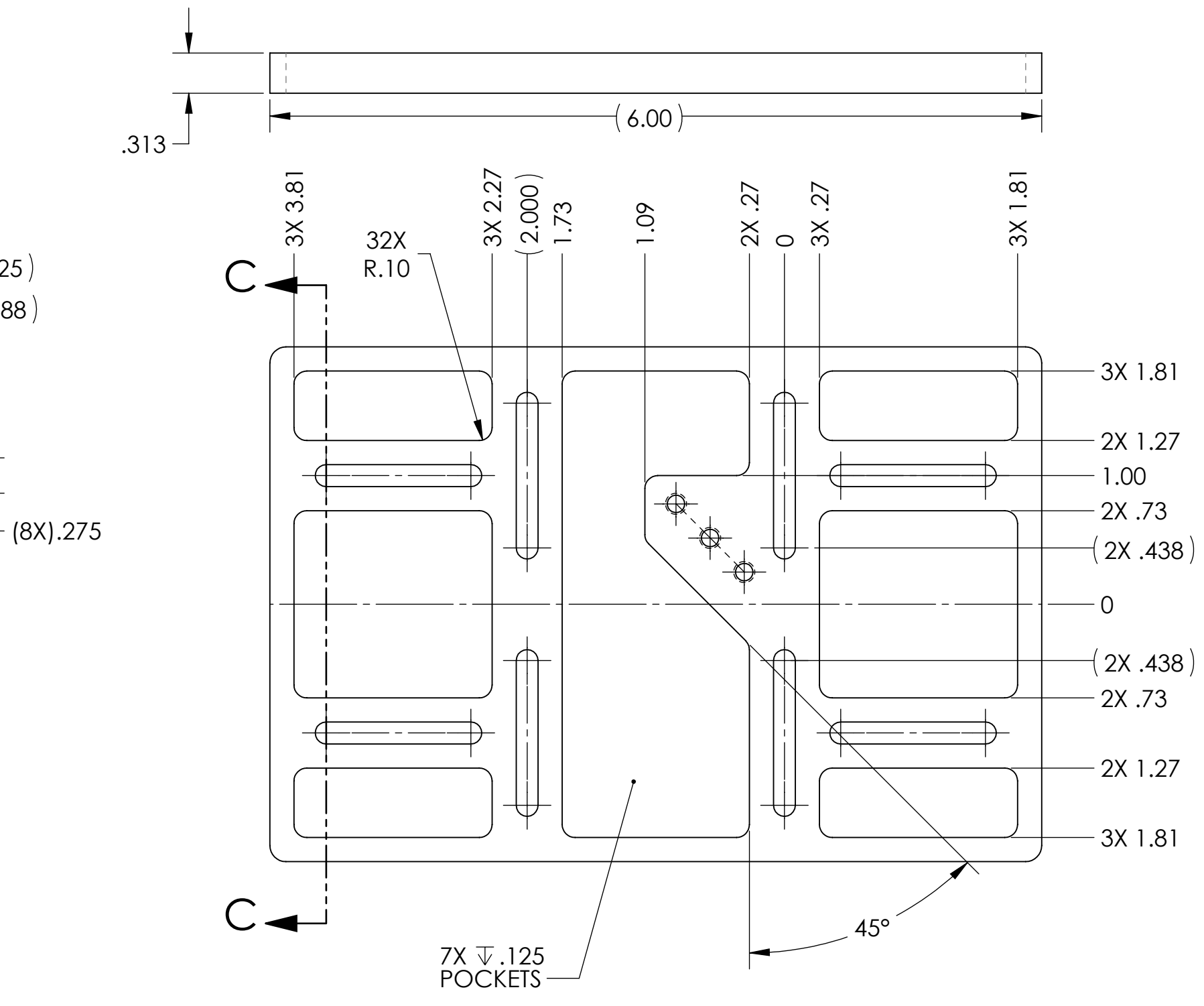
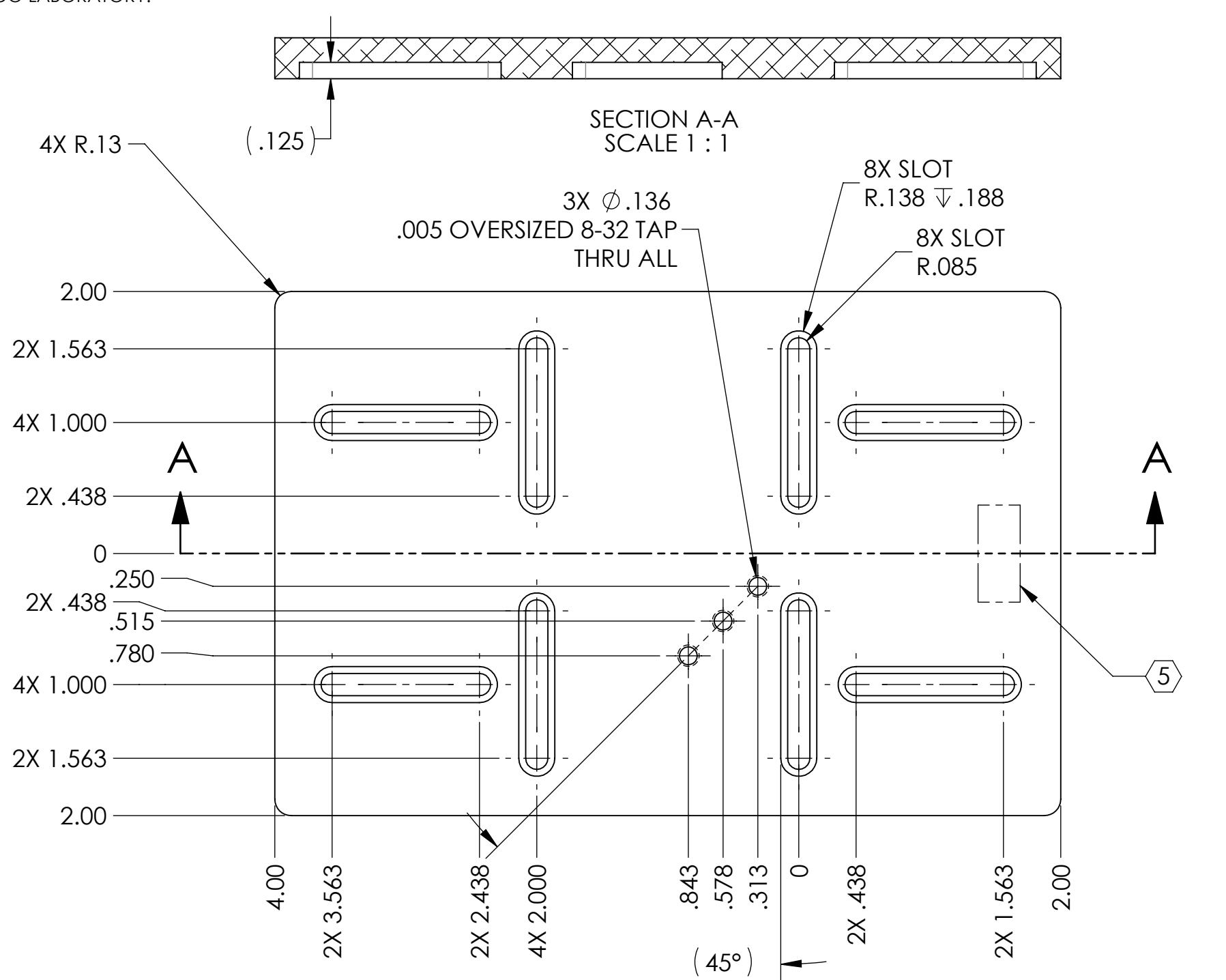


NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001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

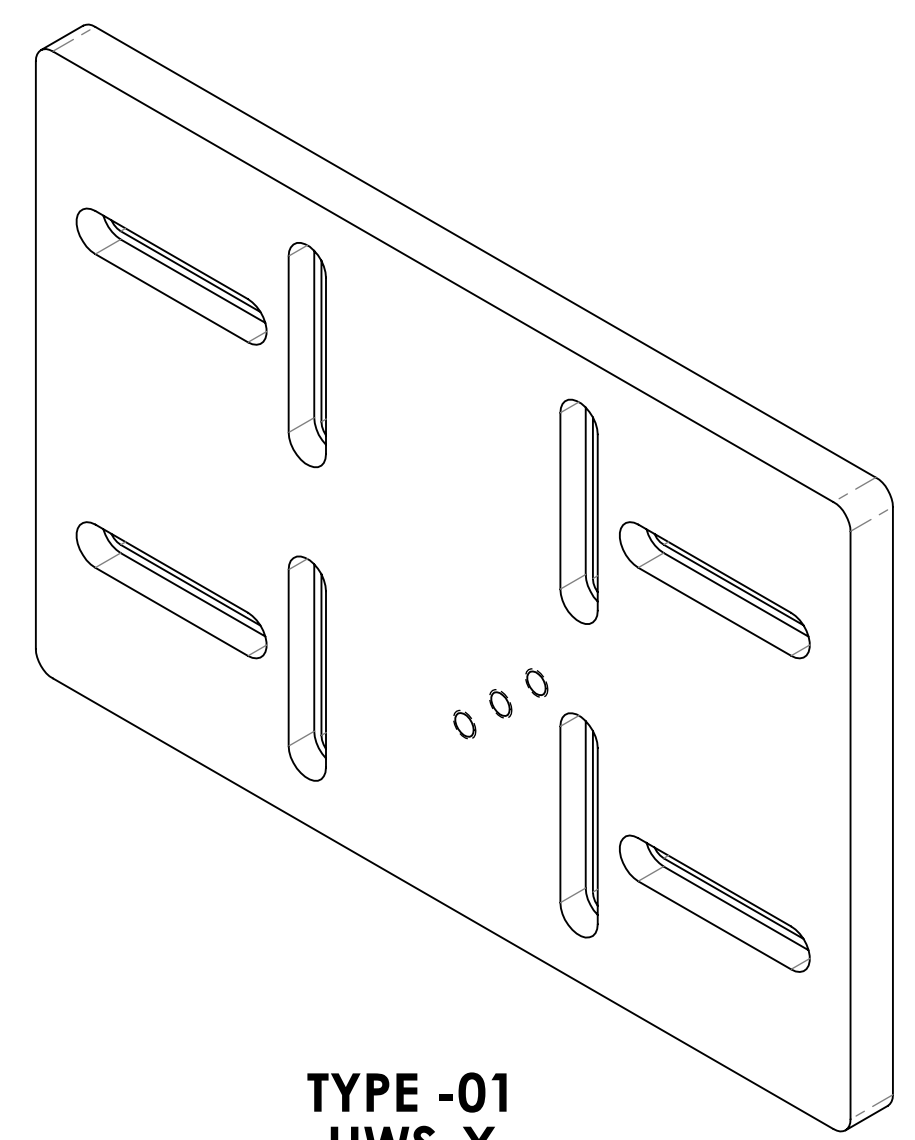
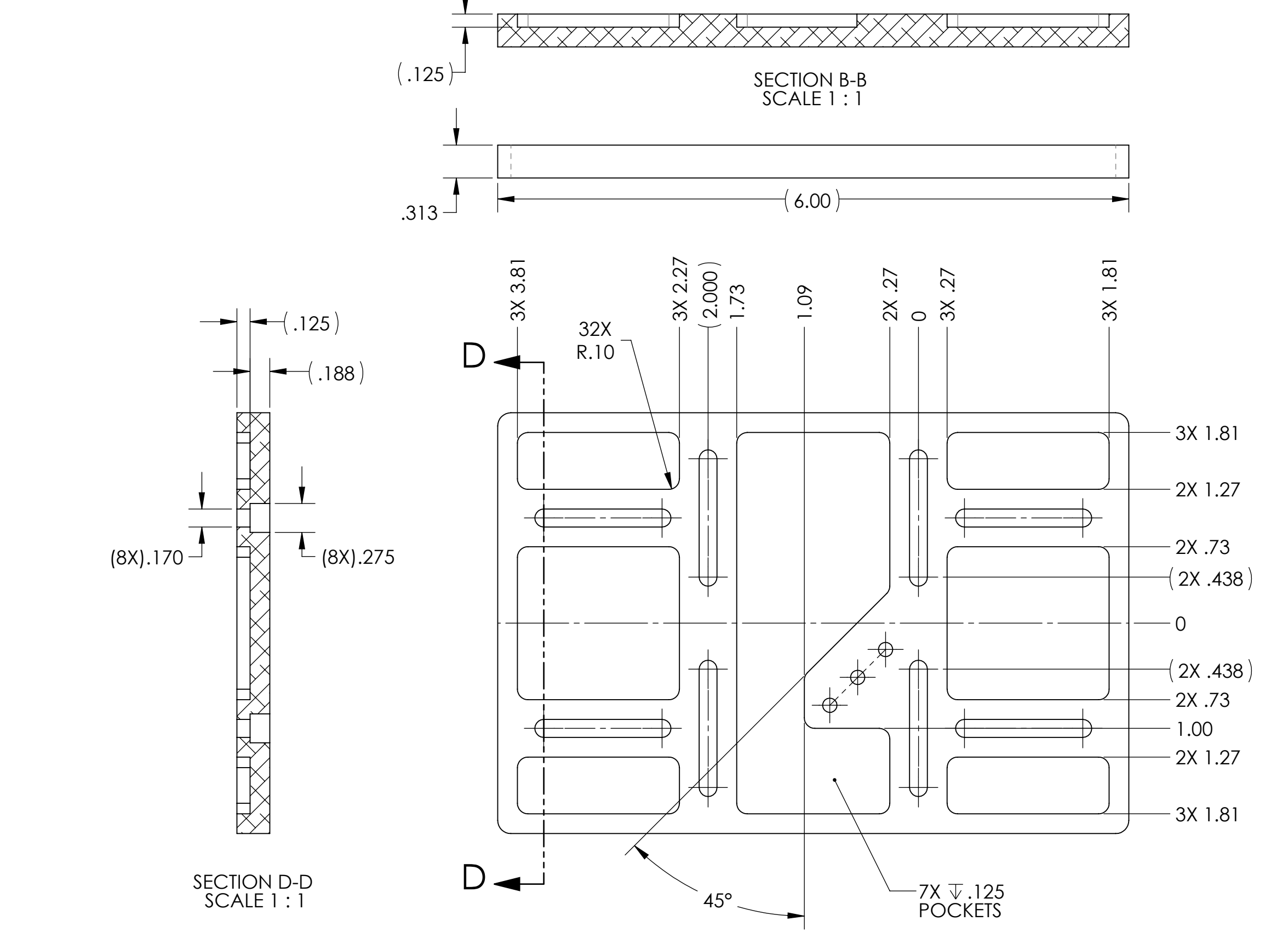
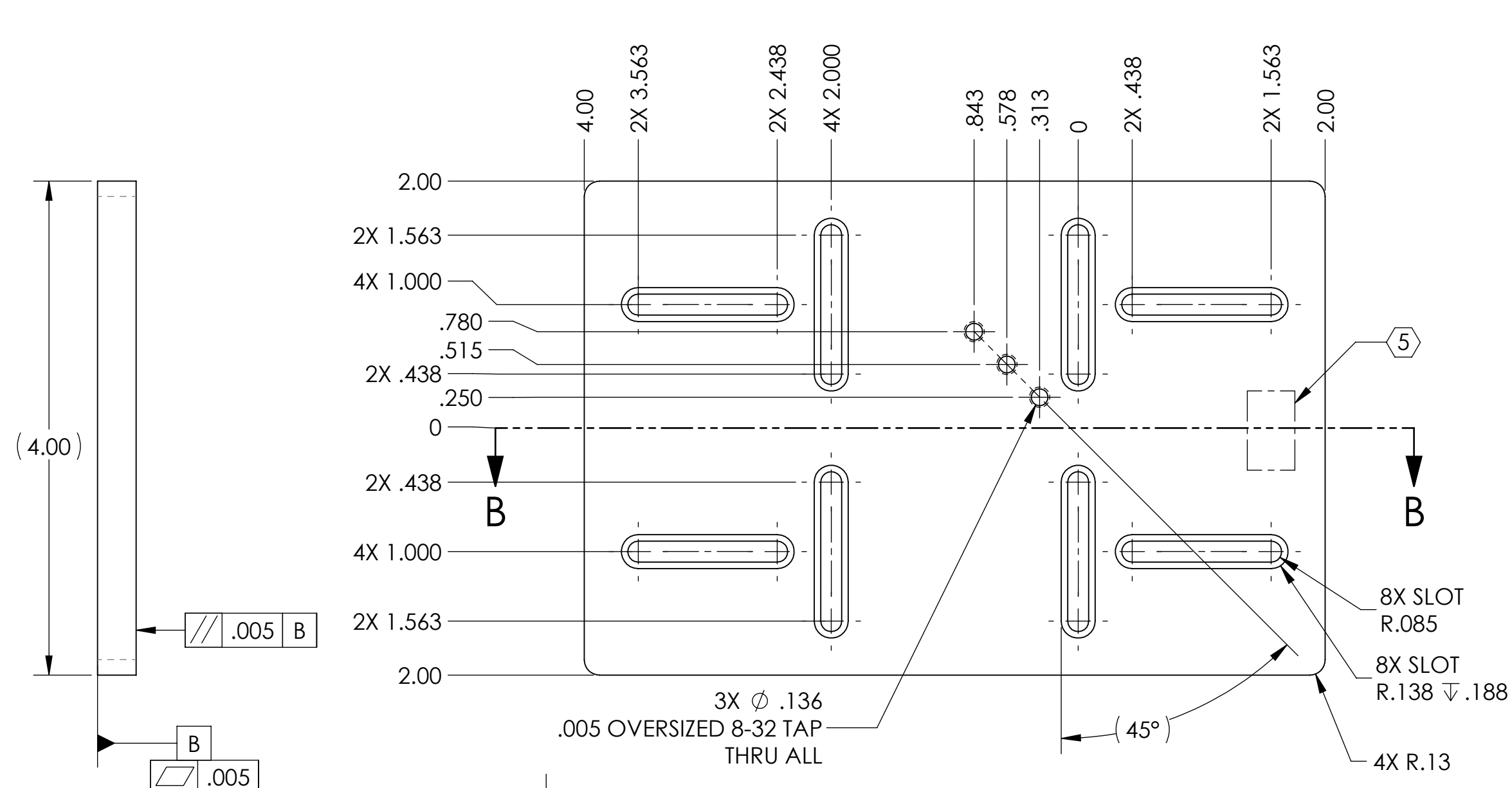
6. APPROXIMATE WEIGHT = .51 LB
 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-ED900364
 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION ED900364.
 9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-ED900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	17-APR-13	E1300281-x0	E1300170-v1

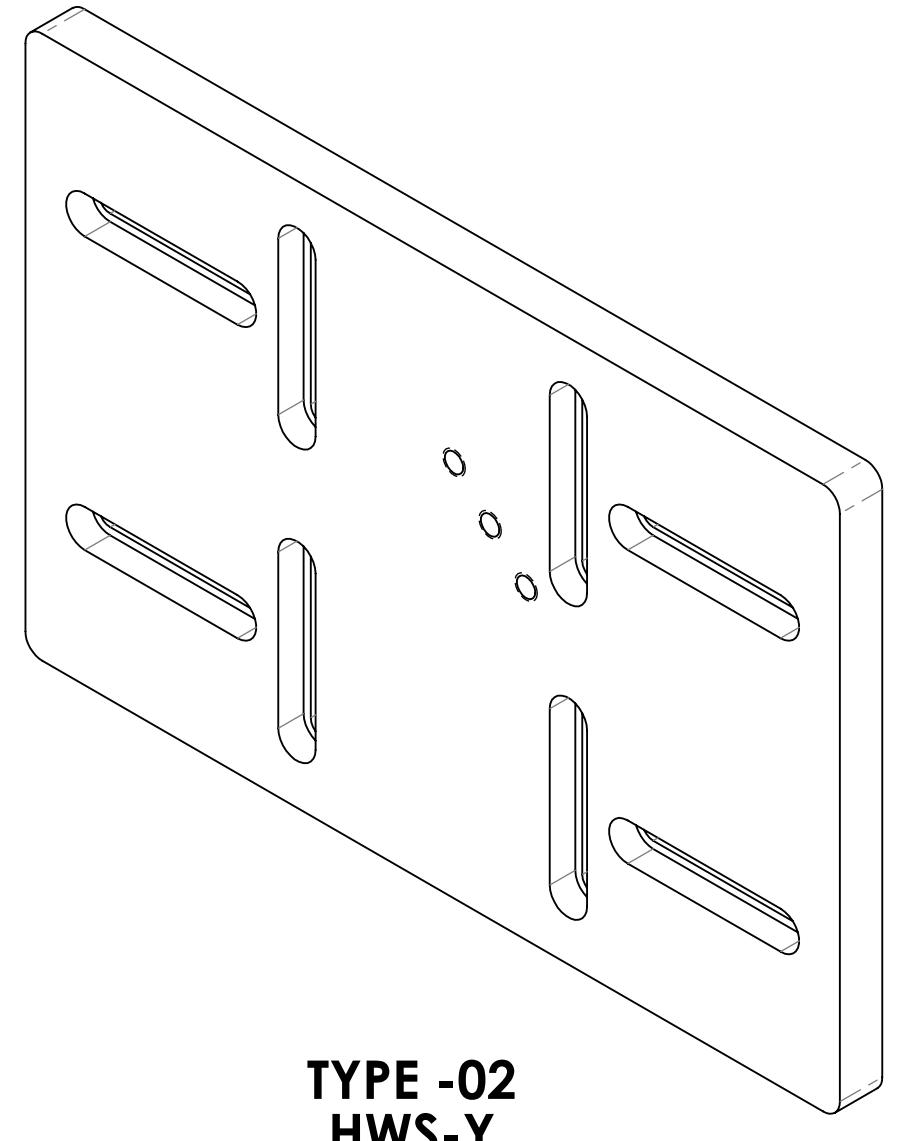
**TYPE -01
HWS-X**



**TYPE -02
HWS-Y**



**TYPE -01
HWS-X**



**TYPE -02
HWS-Y**

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME							
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.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.				ADVANCED LIGO		AOS		ALIGO TCS HWS ITM UPPER PERISCOPE PLATE					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1.0°				MATERIAL: 6061 Alloy FINISH: 63 μinch		NEXT ASSY: D1300198		DESIGNER: M.JACOBSON 04-MAR-13 DRAFTER: M.JACOBSON 17-APR-13 CHECKER: J.LEWIS 18-APR-13 APPROVAL: A.BROOKS		SIZE: D DWG. NO.: D1102409 SCALE: 1:1 PROJECTION:		REV. v1 SHEET 1 OF 1	

D1102409 ALIGO TCS HWS ITM UPPER PERISCOPE PLATE PART PDM REV: X.007 DRAWING PDM REV: X.005