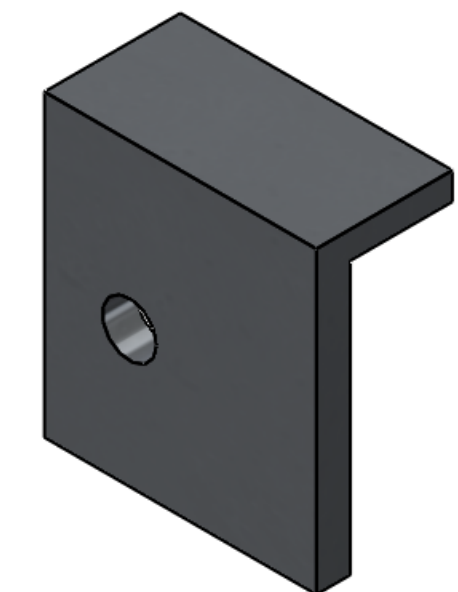
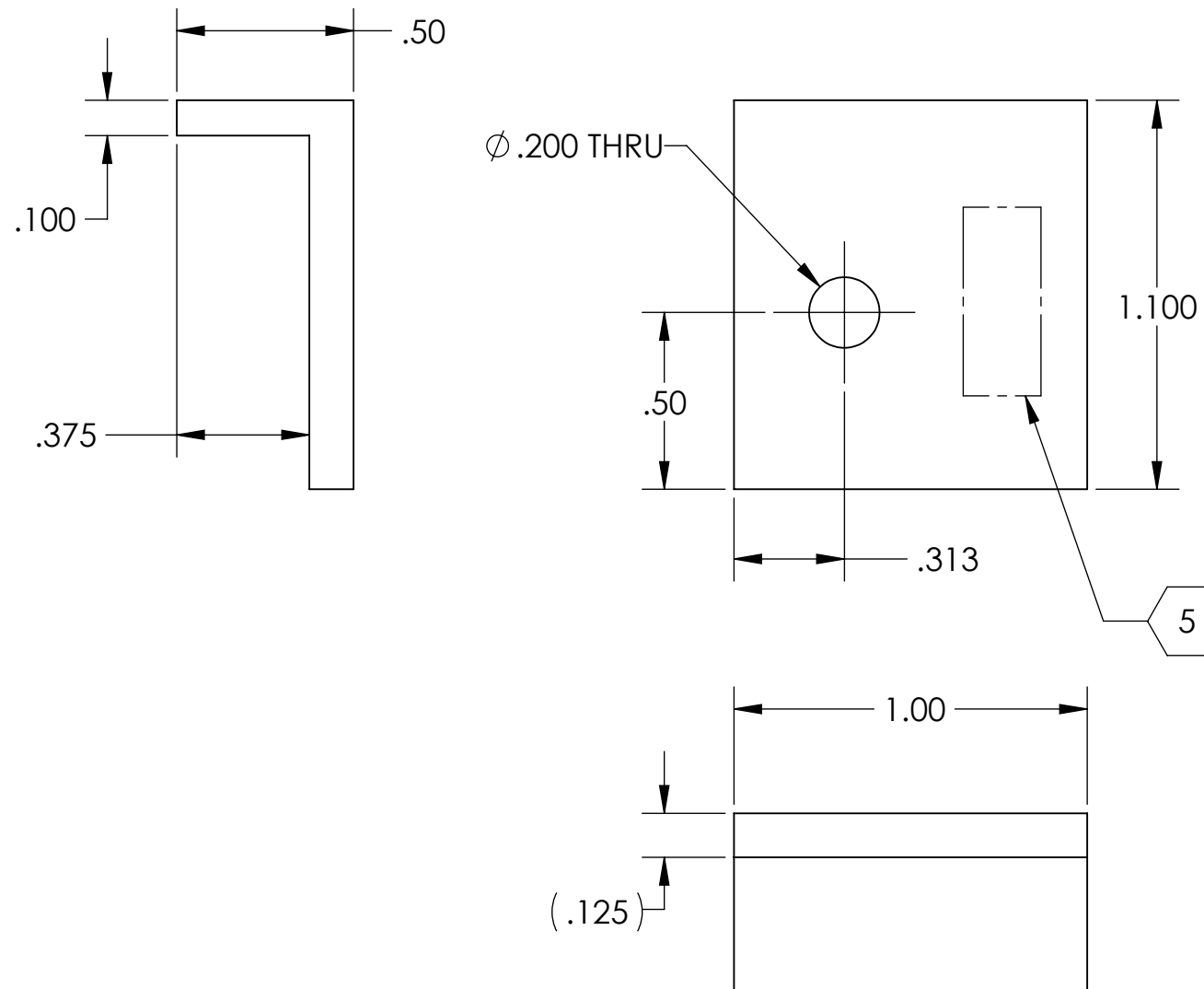


NOTES CONTINUED:

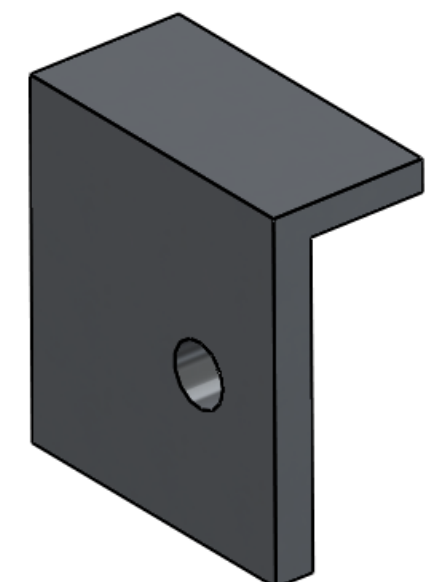
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE 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 = .017 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	28-MAY-12	E1200540-v1	E1200541-v1
-	-	-	-
-	-	-	-



-01 LEFT SIDE



-02 RIGHT SIDE (MIRROR OF -01)

D1200786\_UPPER STOP, SHUTTER, PART PDM REV: X-001, DRAWING PDM REV: X-001

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	1. INTERPRET DRAWING PER ASME Y14.5-1994.
TOLERANCES:	2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02
.XX ± .01	3. DO NOT SCALE FROM DRAWING.
.XXX ± .005	4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.
ANGULAR ± °	
MATERIAL	6061 Alloy
FINISH	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		UPPER STOP, SHUTTER	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	AOS	DESIGNER	M. JACOBSON 24-MAY-12
NEXT ASSY	D1200782	DRFTER	M. JACOBSON 28-MAY-12	SIZE DWG. NO.	B D1200786
		CHECKER	A. COLE 29-MAY-12	REV.	v1
		APPROVAL	HEPTONSTALL 29-MAY-12	SCALE:	2:1
				PROJECTION:	
				SHEET	1 OF 1