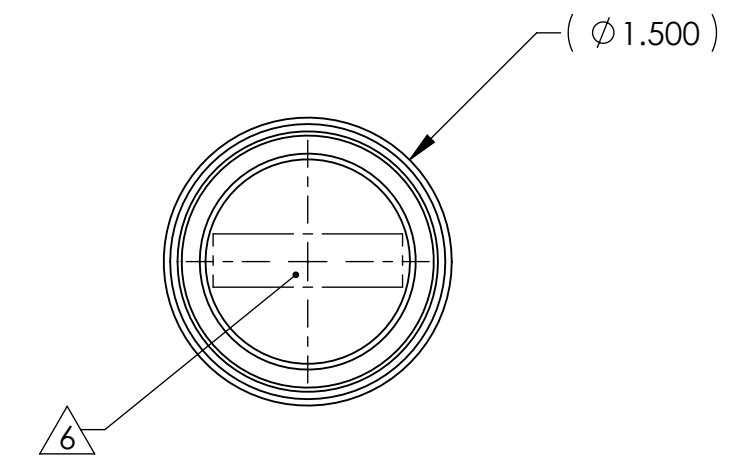
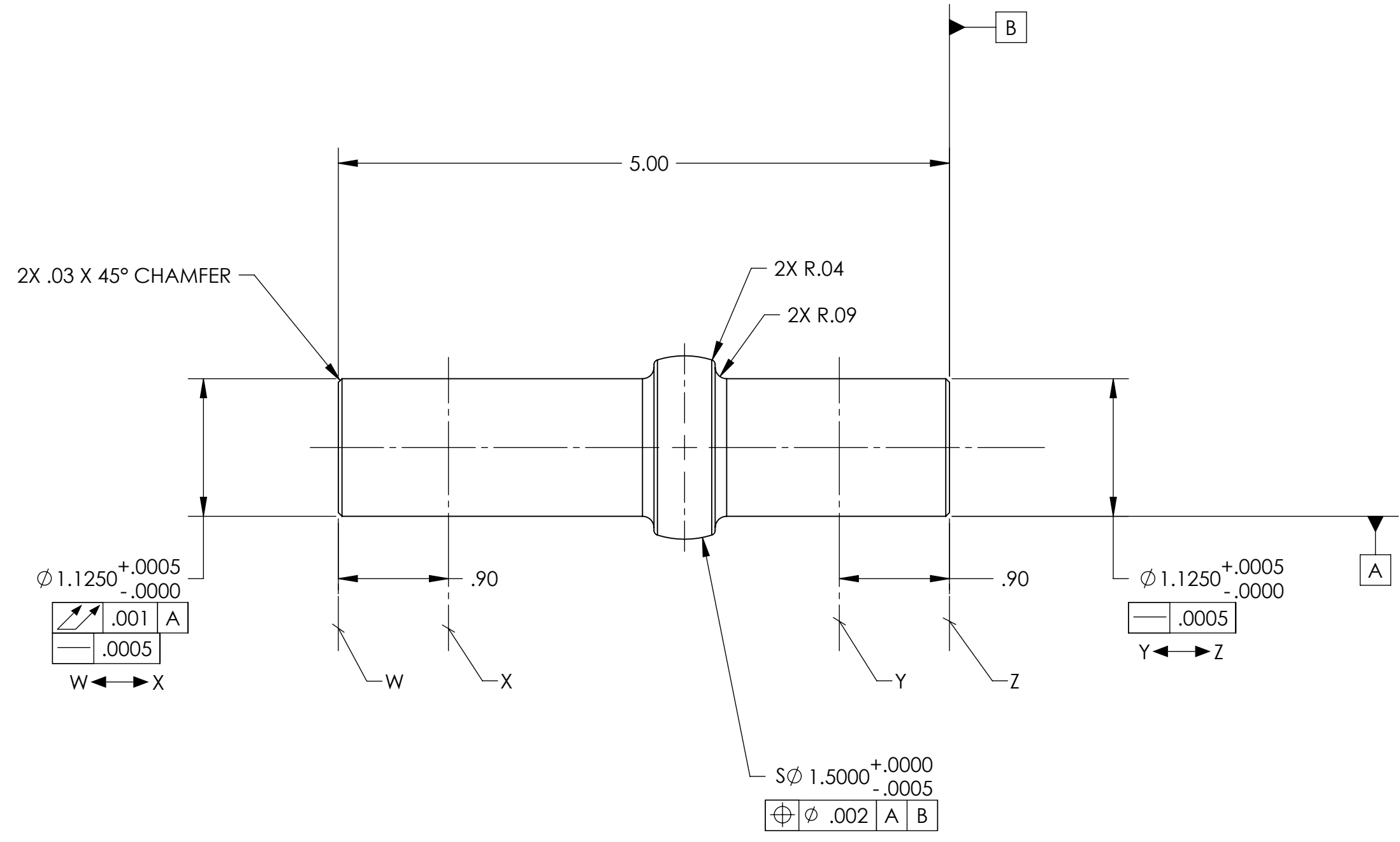
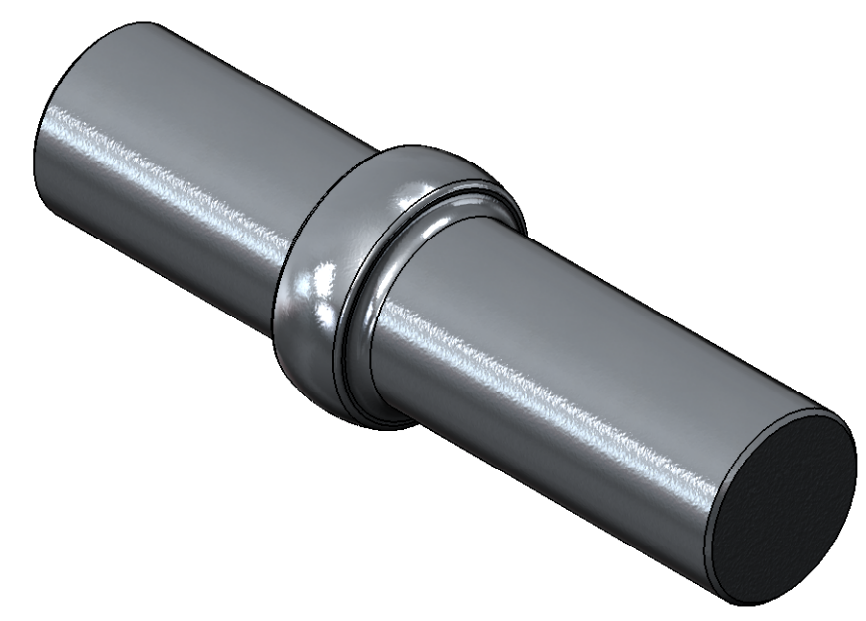


REVISION HISTORY				
REV	DATE	ECO	APPROVAL	DESCRIPTION
V1 / B	19 Jul 2007		A. Stein	Release for Enhanced LIGO.
V2	9 Apr 2009		A. Stein	Release for Advanced LIGO. No change to geometry. Minor changes to tolerances, only.



MANUFACTURING NOTES:

- 1) MAKE FROM 440C CRES PER AMS 5630.
- 2) BEFORE FINAL MACHINE, HEAT TREAT TO RC57 PER AMS-H-6875A.
- 3) MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. ABRASIVE REMOVAL TECHNIQUES (OTHER THAN DRESSED BLANCHARD GRINDING) ARE NOT ACCEPTABLE.
- 4) ALL MACHINING FLUIDS MUST BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE, AND SILICONE, SUCH AS CINCINNATI MILACRON CIMTECH 410.
- 5) THOROUGHLY CLEAN PART TO REMOVE ALL OIL, GREASE, DIRT, AND CHIPS.
- 6) WHERE INDICATED, MECHANICALLY SCRIBE, STAMP, OR ENGRAVE THE FOLLOWING INFORMATION AS SHOWN BELOW: **PART NUMBER-REVISION** (AND **TYPE** IF INDICATED). FOLLOWED ON THE NEXT LINE WITH A UNIQUE 3-DIGIT **SERIAL NUMBER** STARTING AT 001 FOR THE FIRST PART AND INCREMENTING THEREAFTER. USE 0.38" TALL CHARACTERS UNLESS PART SIZE DICTATES SMALLER.

D047935-V2
S/N - ###

POST-MANUFACTURING NOTES:

- P1) CLEAN TO LIGO STANDARDS, CLASS A (PER E0900047 AND E960022).

APPROVALS ENGINEERING (ASI): R. Kovac 1/24/2005 QUALITY (ASI): G. de los Santos 1/25/2005 MATERIAL: See Notes FINISH: See Notes MASS: 1.5 lbs		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES DECIMAL TOLERANCES: .XX ±.015 .XXX ±.005 ANG TOL: ± 1° SURFACE ROUGHNESS: 6.3 REMOVE ALL SHARP EDGES. LEAVE .005 X 45° MIN CHAMFER. OR .005 MIN RADIUS. THIS PRINT & THE EMBEDDED CAD MODEL ARE THE DOCUMENTATION OF RECORD. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS IN THE MODEL ARE BASIC, WITH TOLERANCES GIVEN BY:		ORIGINAL DESIGN BY: ALLIANCE SPACESYSTEMS, INC. 1250 Lincoln Ave., Suite 100 Pasadena, CA 91103 MODIFIED BY: LIGO	
DESCRIPTION: Locker Spherical Pin P/N: D047935 CONFIG: - CAD FILE NAME: D047935_Locker_Spherical_Pin		PROJECT: HAM ISI, Advanced LIGO SIZE: C SCALE: 1:1 DRAWN BY: R.D. Billing REV: V2 SHEET 1 OF 1 DATE PRINTED: 4/10/2009			