

REV	DATE	APPROVAL	DESCRIPTION
00	06/16/2008	A. STEIN	PRE-RELEASE, FOR RFQ.
01	09/15/2008	A. STEIN	PROTOTYPE RELEASE. ADDED PAINT AND P/N NOTES. CHANGED 1/2-13 HOLES TO 1/2-20. ADDED CHAMFERS AROUND PADS.
A	10/20/2008	DCN # E080509-00	RELEASE FOR PRODUCTION. SPECIFIED MATL AS 1018 CRS, INSTEAD OF "LOW CARBON STEEL". CHANGED P/N ENGRAVING SIZE, LOCATION.

NOTES:

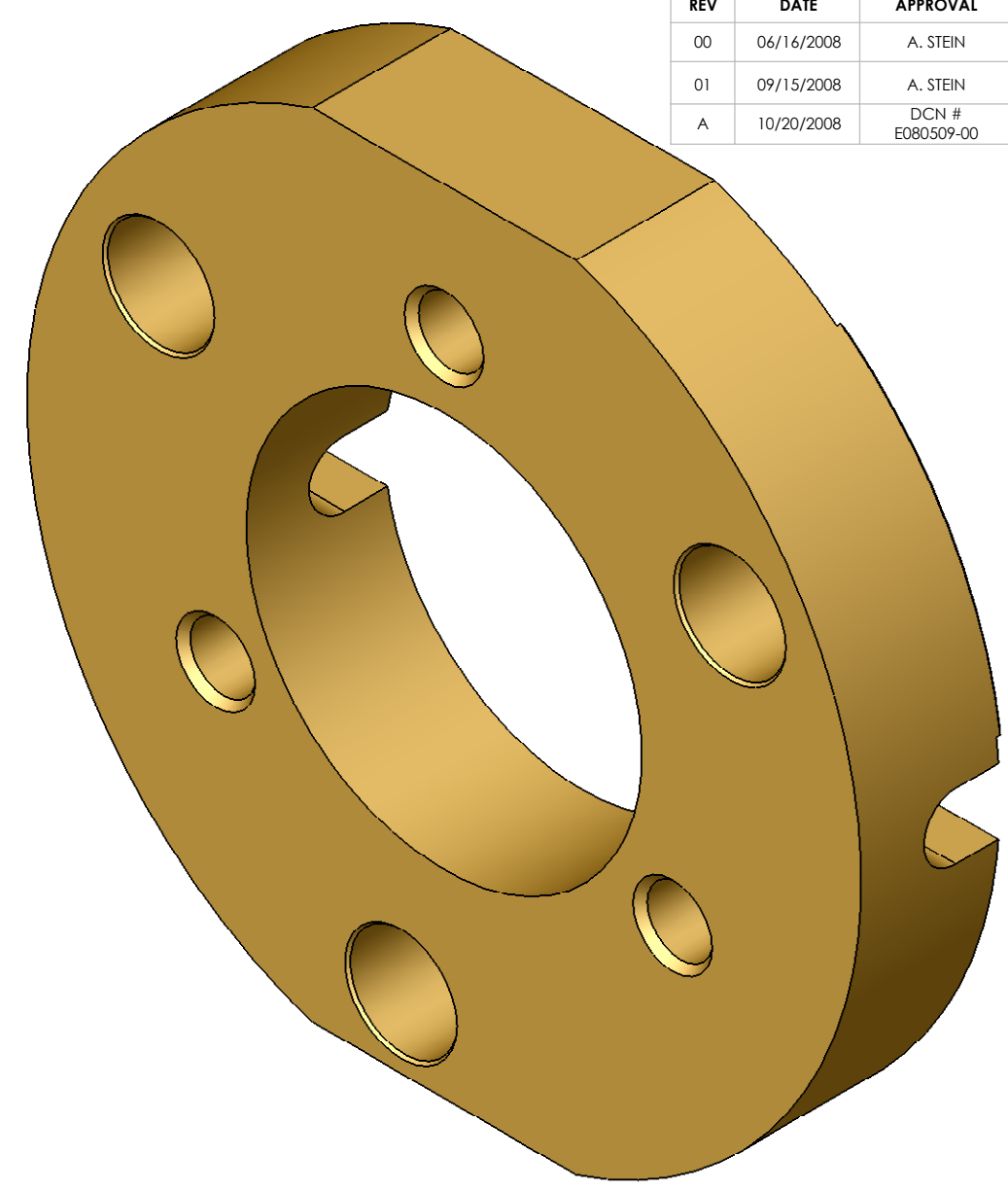
1) WHERE INDICATED, MECHANICALLY SCRIBE, STAMP, OR ENGRAVE THE FOLLOWING INFORMATION AS SHOWN BELOW: PART NUMBER-REVISION, FOLLOWED ON THE NEXT LINE WITH A UNIQUE 3-DIGIT SERIAL NUMBER STARTING AT 001 FOR THE FIRST PART AND INCREMENTING THEREAFTER. USE 0.24" TALL CHARACTERS UNLESS PART SIZE DICTATES SMALLER. LETTERING MUST BE VISIBLE AFTER PAINTING, IF APPLICABLE.

D080547-A  
S/N - ###

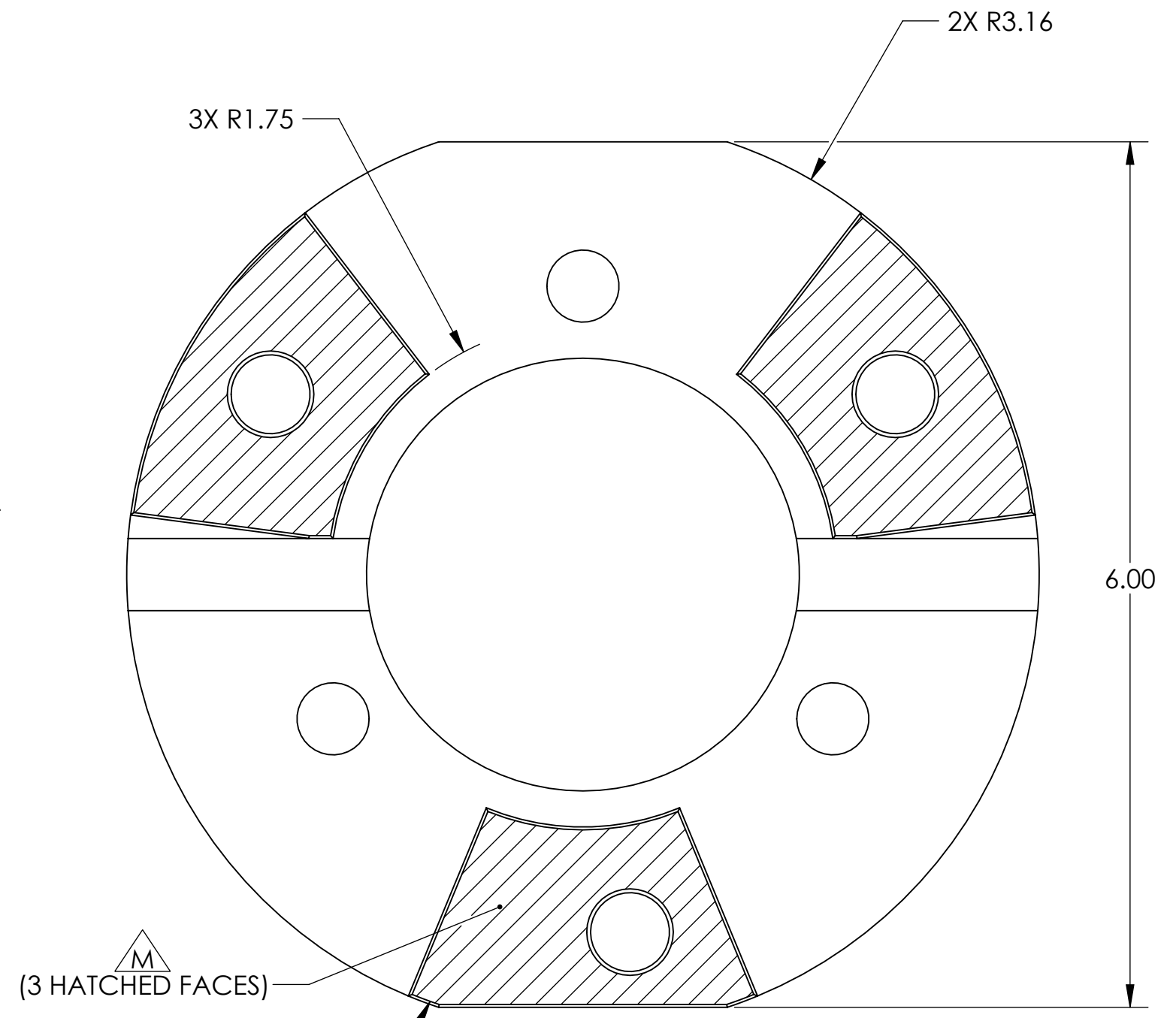
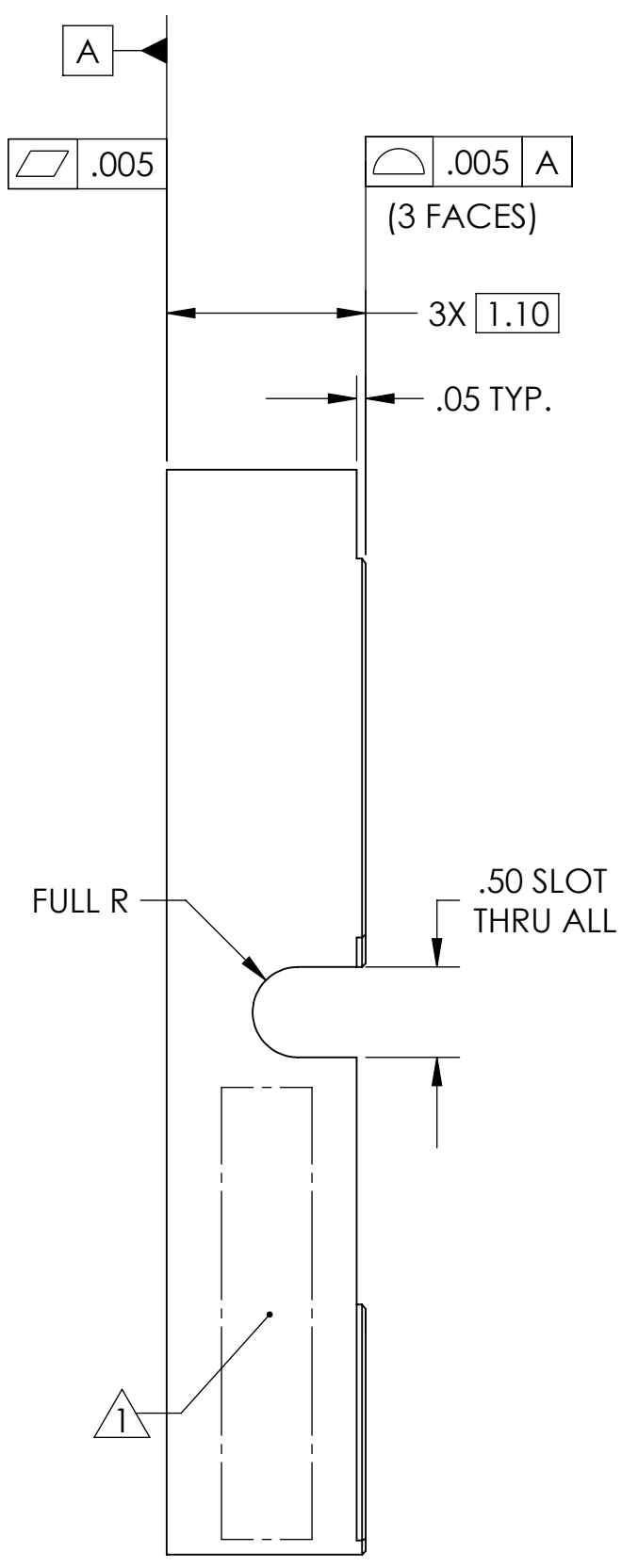
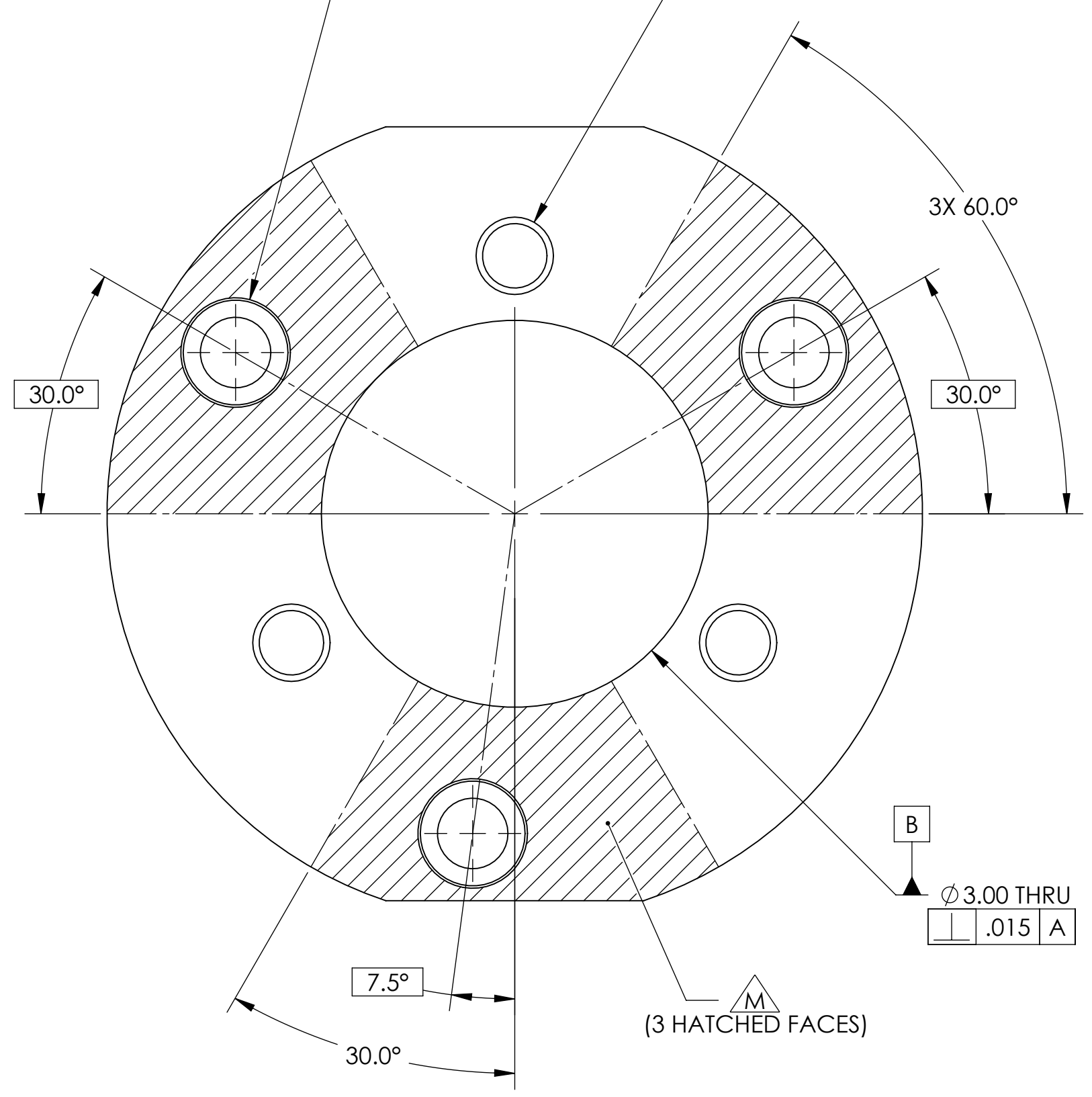
2) PLUG ALL SCREW HOLES, BOTH TAPPED AND THRU.

3) PAINT ALL SURFACES, EXCEPT WHERE INDICATED BY  $\triangle M$ . USE MEDIUM BLUE SHERWIN WILLIAMS (POLANE (R) T-PLUS POLYURETHANE ENAMEL). PRIME WITH SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER P60G2.

4) APPLY "OXISOLV RUST INHIBITOR" TO ALL UNPAINTED SURFACES, PER MFG INSTRUCTIONS. REMOVE PLUGS FROM ALL HOLES.



- 3X  $\phi$  .547 THRU ALL
- $\square$   $\phi$  .813  $\nabla$  .60
- $\sphericalangle$   $\phi$  .85 X 82°, NEAR SIDE
- $\sphericalangle$   $\phi$  .60 X 82°, FAR SIDE
- $\oplus$   $\phi$  .005  $\text{\textcircled{M}}$  A B
- 3X  $\phi$  .453 THRU ALL
- 1/2-20 UNF THRU ALL
- $\sphericalangle$   $\phi$  .60 X 82°, NEAR SIDE
- $\oplus$   $\phi$  .005 A B



NOTES: (UNLESS OTHERWISE SPECIFIED)		DIMENSIONS ARE IN INCHES		CALIFORNIA INSTITUTE OF TECHNOLOGY	
1. DO NOT SCALE FROM DRAWING.		TOLERANCES:		LIGO	
2. REMOVE ALL SHARP EDGES. LEAVE .005 X 45° MIN CHAMFER, OR .005 MIN RADIUS.		XXX ± 0.015		MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
3. ALL MACHINING FLUIDS MUST BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE. E.G., MILACRON CIMTECH 410.		XXX ± 0.005		IGR, GLASGOW UNIVERSITY GEO 600 GROUP	
4. CLEAN THOROUGHLY TO REMOVE ALL OIL, DIRT, AND CHIPS.		ANGULAR ± 0.5°		SYSTEM ADVANCED LIGO	
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:		MATERIAL 1018 CRS		SUB-SYSTEM SEI	
$\square$ .015 A B		FINISH SEE NOTES		NEXT ASSY D030326	
DRAWN A. STEIN 06/16/2008		NAME DATE		PART NAME HAM HEPI HORZ ACTUATOR ADAPTER 1	
CHECKED		SIZE DWG. NO. C D080547		REV. A	
APPROVED		SCALE: 1:1 PROJECTION:		SHEET 1 OF 1	