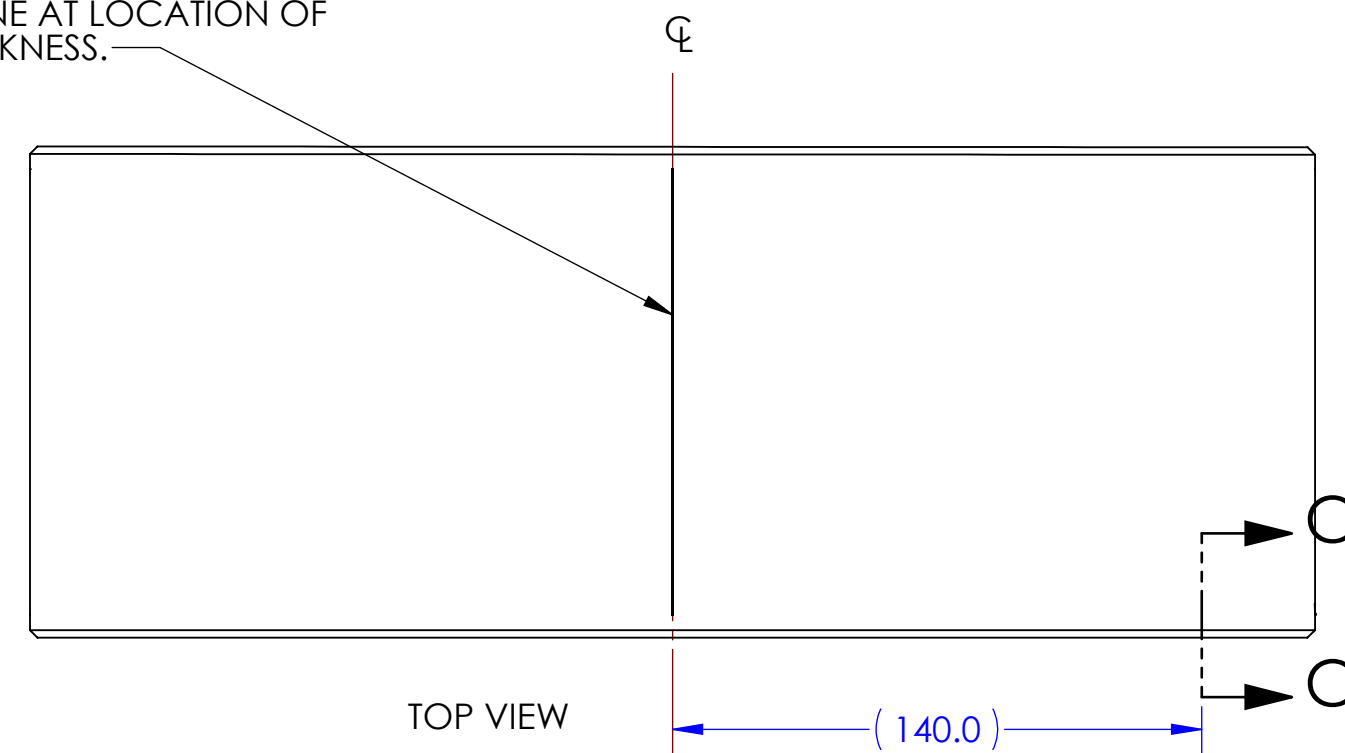


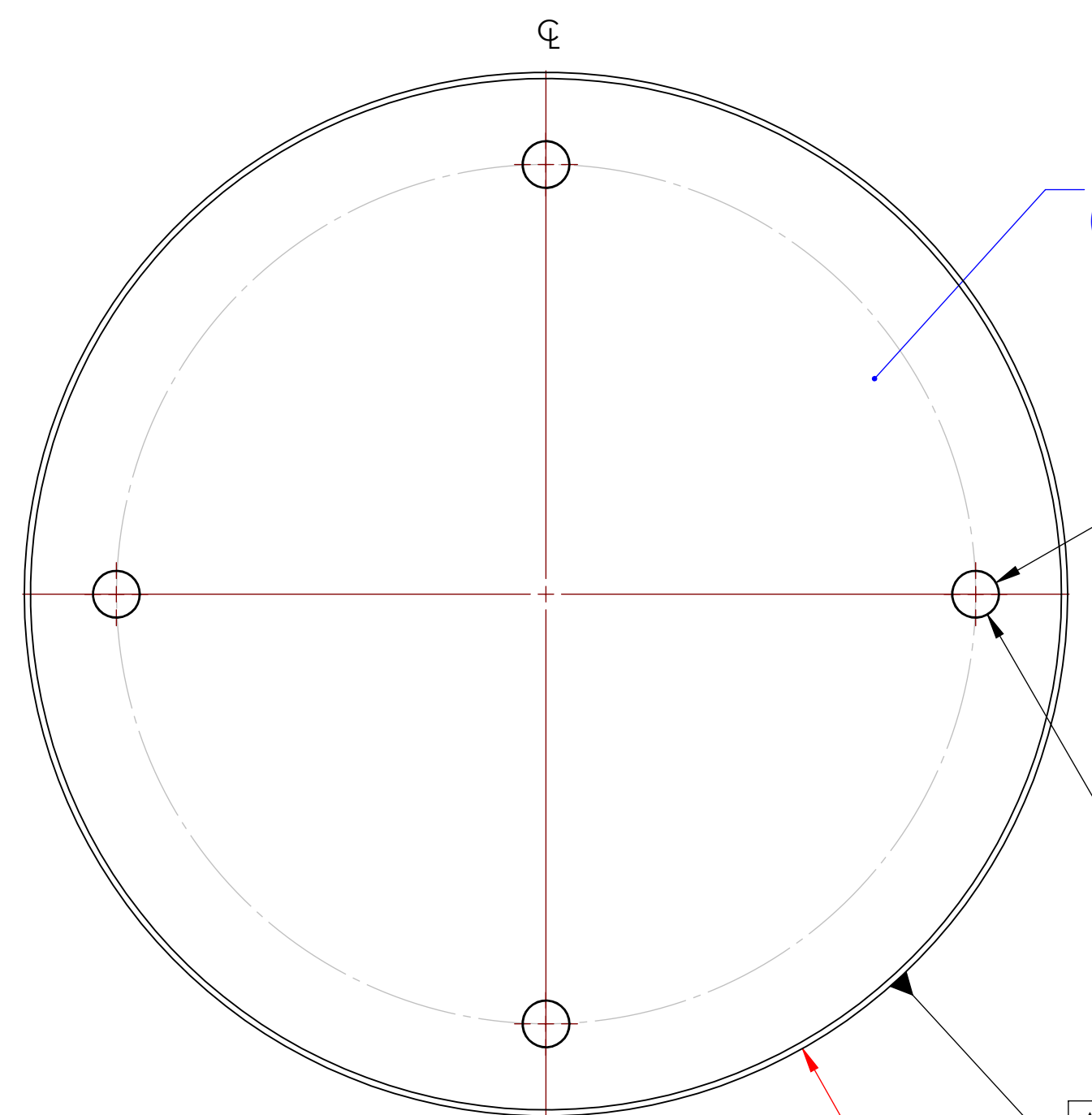
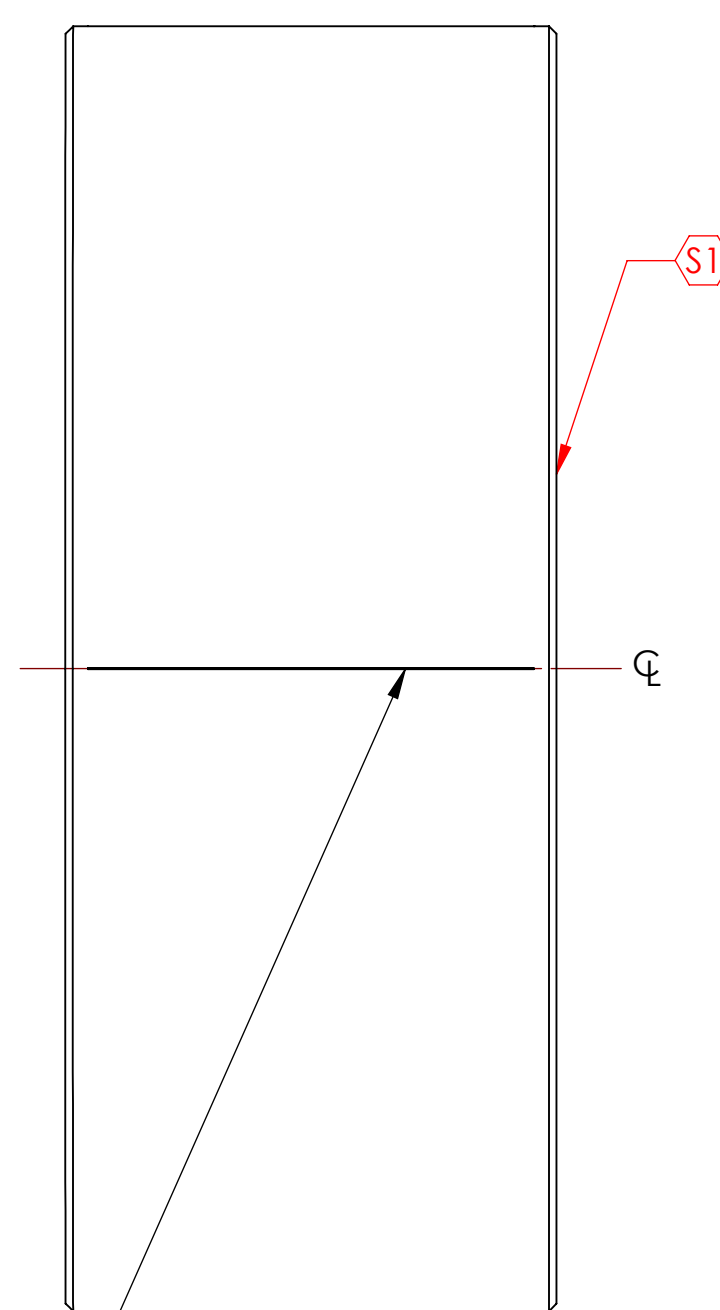
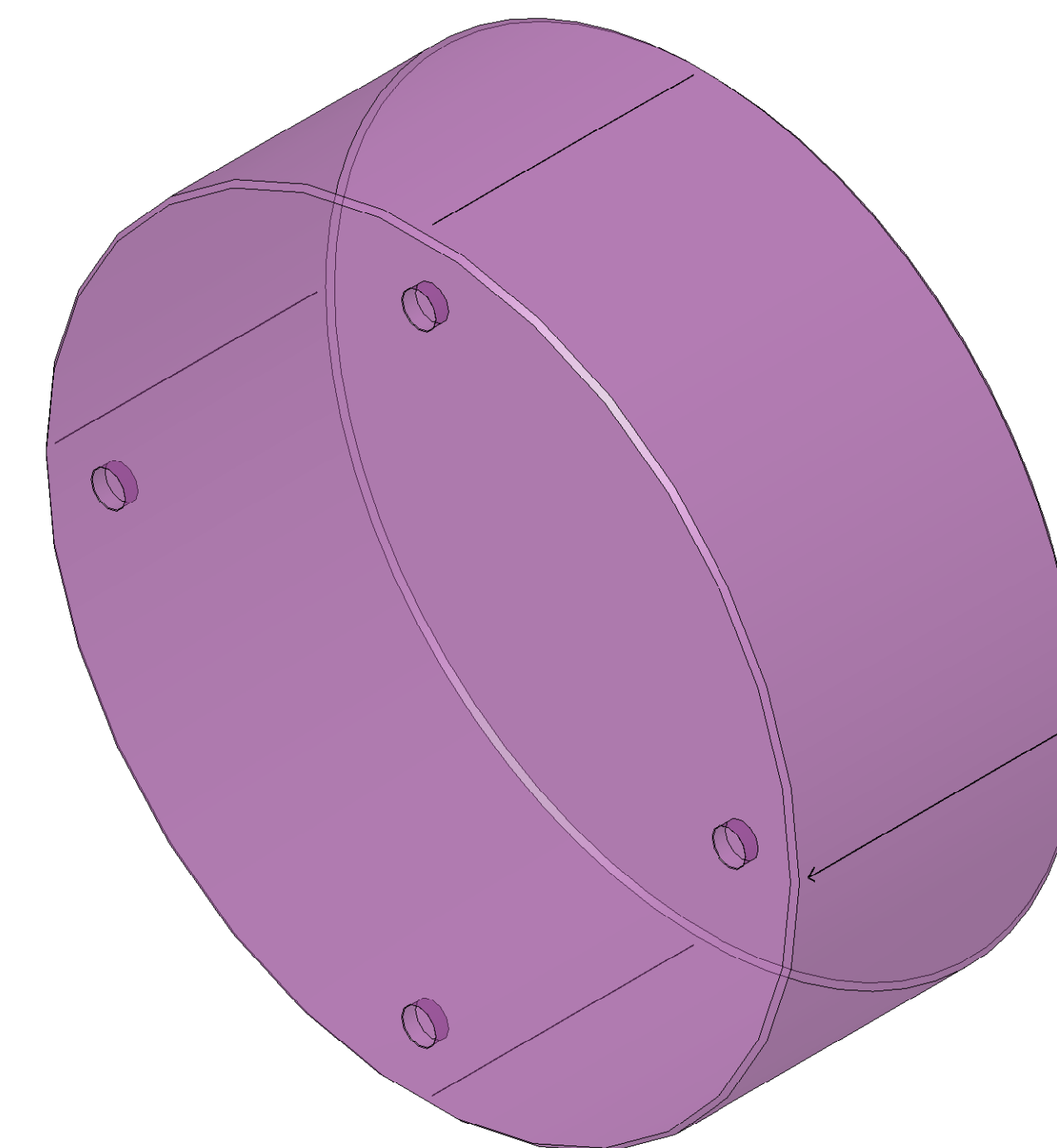
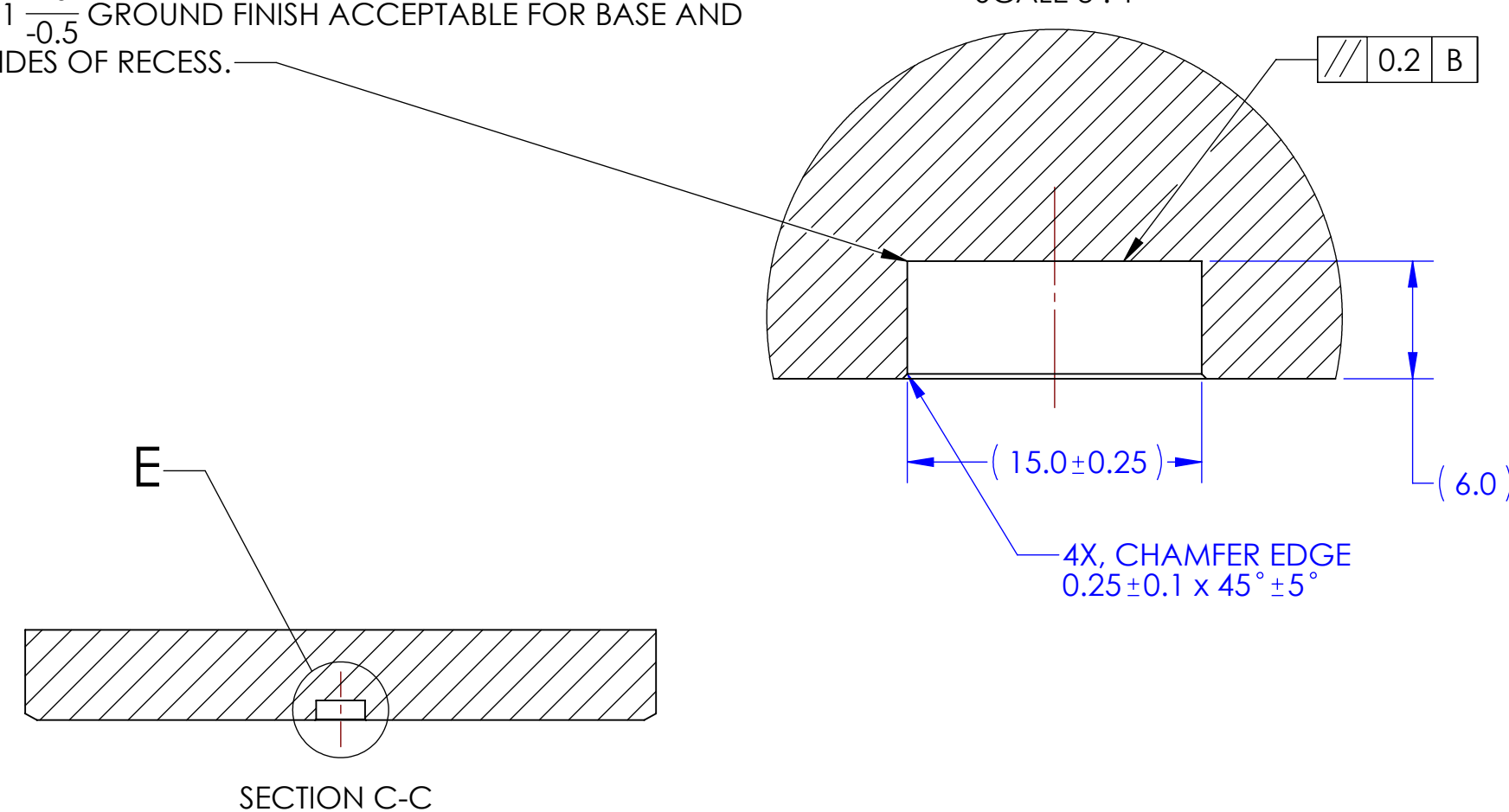
REV.	DATE	DCN #	DRAWING TREE #
v1	10/2008	E080530-v1	
v2	Feb - 20 - 2009	LIGO-E0900046-v1	
v3	28 MAY 2010	E1000188	

ETCH OR GRIND REGISTRATION MARKS
 0.25mm ± 0.05mm WIDE x
 118mm ± 3mm LONG MINIMUM LEGIBLE
 DEPTH LINE ALONG ϕ , CENTERED
 BETWEEN SURFACES 'S1' AND 'S2', PARALLEL
 TO THE CYLINDRICAL AXIS
 (DEFINED BY DATUM FEATURE -A-)
 WITHIN ± 0.1mm AND
 90° FROM SCRIBE LINE AT LOCATION OF
 MINIMUM PART THICKNESS.



RADIUS AROUND BOTTOM OF RECESS
 $R1 \frac{+0}{-0.5}$ GROUND FINISH ACCEPTABLE FOR BASE AND
 SIDES OF RECESS.

DETAIL E
 SCALE 3 : 1



POLISH SURFACE 'S1'
 (SEE NOTE 4)

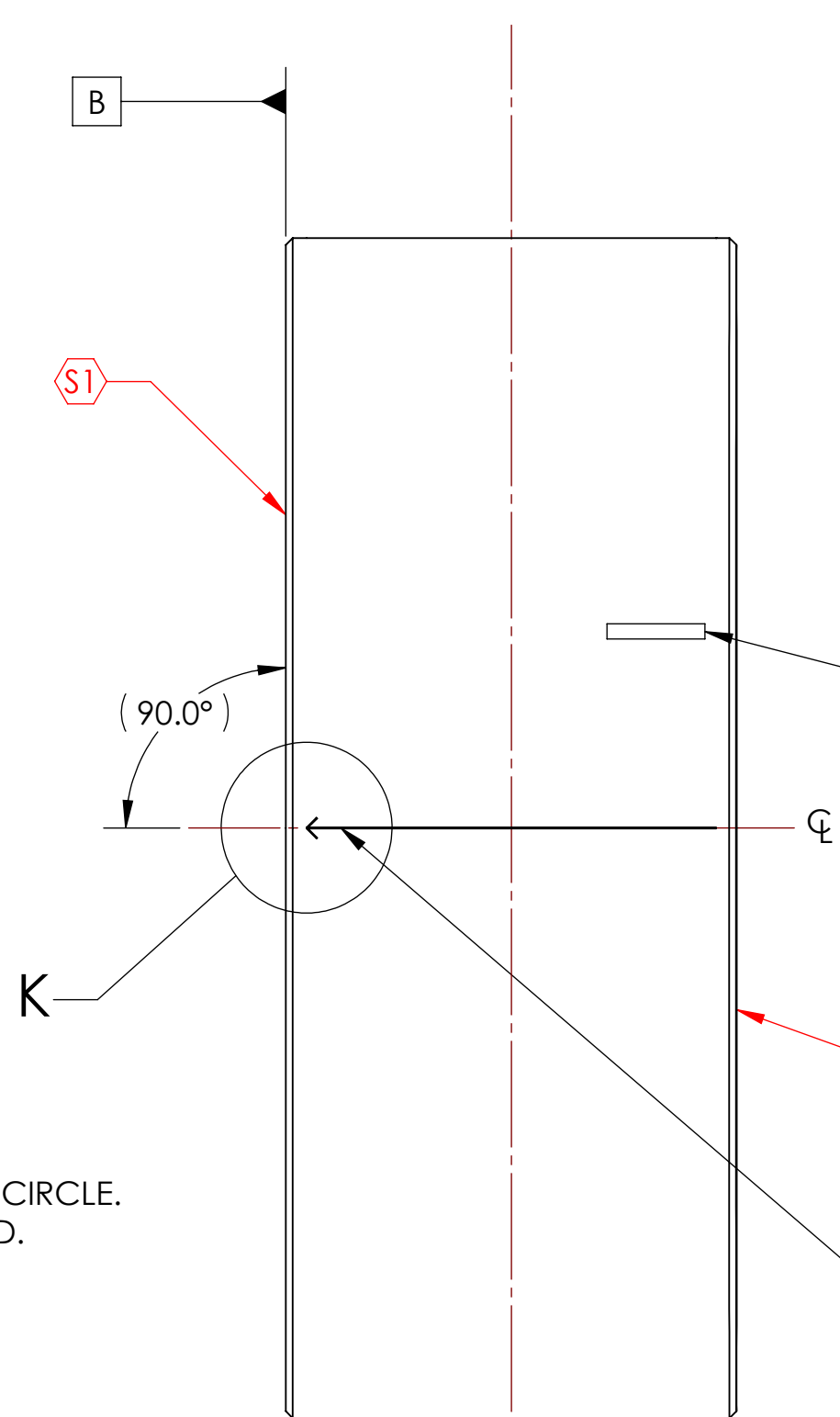
STRADDLE THE ARROWED
 REFERENCE LINE, INDICATING
 PART OF MINIMUM THICKNESS
 (REFER TO DETAIL K.)

4X, $\phi 15.0 \pm 0.25 \nabla 6.0$
 EQUALLY SPACED ON A 280 ± 0.5 BOLT CIRCLE.
 EDGE CHIPPING TO BE MINIMISED.

0.25 A

$\phi 340.00 \pm 0.25$
 0.1 0.18 B

2X, $\pm 0.2 \times 45^\circ \pm 5^\circ$ CHAMFER,
 ALL AROUND

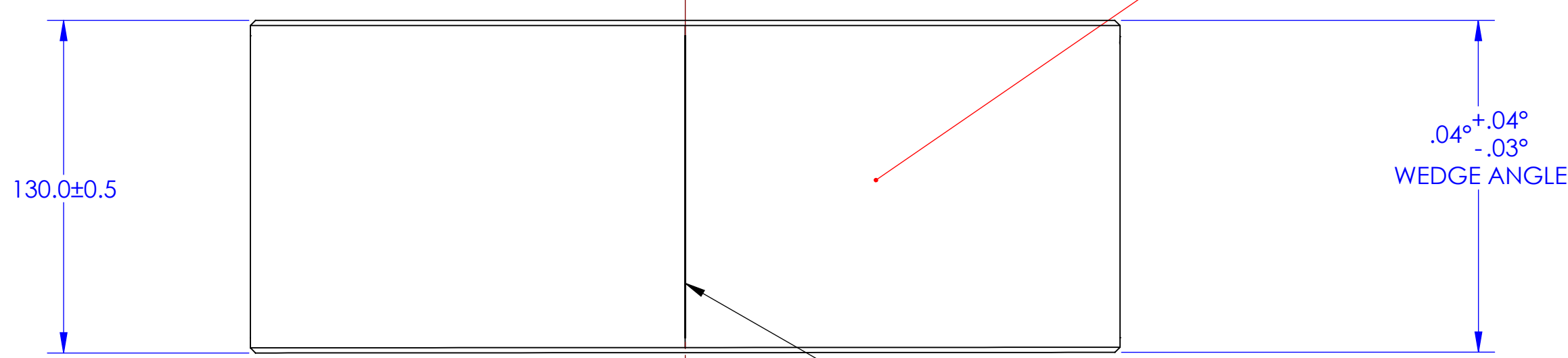


ETCH OR GRIND SERIAL
 NUMBER, APPROX. WHERE SHOWN,
 LETTERING APPROX. 4mm HIGH
 (SEE NOTE 5 FOR FURTHER DETAILS)

POLISH SURFACE 'S2'
 (SEE NOTE 4)

ETCH OR GRIND REGISTRATION MARKS
 0.25mm ± 0.05mm WIDE x
 118mm ± 3mm LONG MINIMUM LEGIBLE
 DEPTH LINE ALONG ϕ , CENTERED
 BETWEEN SURFACES 'S1' AND 'S2', PARALLEL
 TO THE CYLINDRICAL AXIS
 (DEFINED BY DATUM FEATURE -A-)
 WITHIN ± 0.1mm, WITH ARROW POINTING
 TO SURFACE 'S1'.

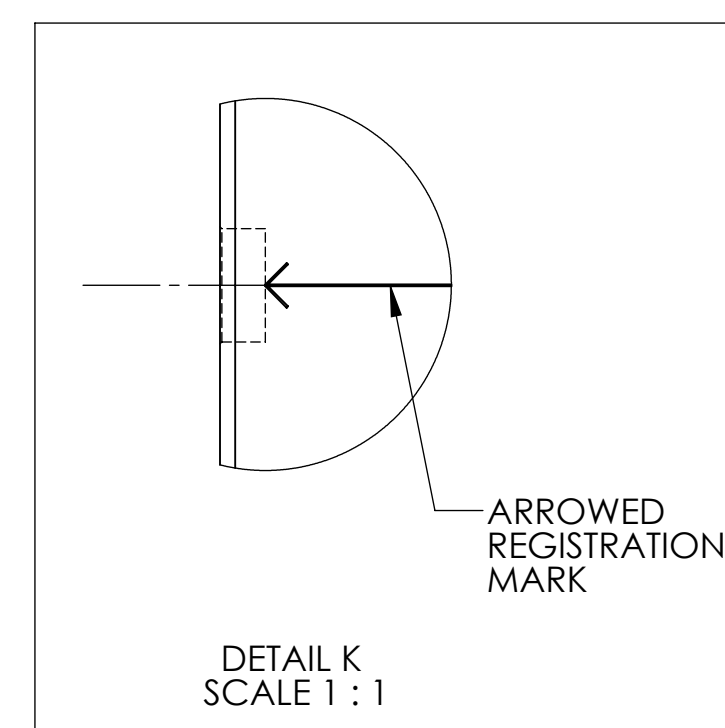
ETCH OR GRIND REGISTRATION MARKS
 0.25mm ± 0.05mm WIDE x
 118mm ± 3mm LONG MINIMUM LEGIBLE
 DEPTH LINE ALONG ϕ , CENTERED
 BETWEEN SURFACES 'S1' AND 'S2', PARALLEL
 TO THE CYLINDRICAL AXIS
 (DEFINED BY DATUM FEATURE -A-)
 WITHIN ± 0.1mm AND
 180° FROM SCRIBE LINE AT LOCATION OF
 MINIMUM PART THICKNESS.



BOTTOM VIEW

ETCH OR GRIND REGISTRATION MARKS
 0.25mm ± 0.05mm WIDE x
 118mm ± 3mm LONG MINIMUM LEGIBLE
 DEPTH LINE ALONG ϕ , CENTERED
 BETWEEN SURFACES 'S1' AND 'S2', PARALLEL
 TO THE CYLINDRICAL AXIS
 (DEFINED BY DATUM FEATURE -A-)
 WITHIN ± 0.1mm AND
 90° FROM SCRIBE LINE AT LOCATION OF
 MINIMUM PART THICKNESS.

S3
 BARREL SIDE AND BEVEL POLISH
 (SEE NOTE 3)



DETAIL K
 SCALE 1 : 1

MANUFACTURING NOTES:

- DO NOT SCALE FROM DRAWING.
- INTERPRET DRAWING AS PER ANSI Y14.5M 1994.
- BARREL SIDE AND BEVEL POLISH PER E080513.
- FINISH SURFACES 'S1' AND 'S2' AS PER E080513.
- REFER TO E080513 OR MORE INFORMATION ON SERIAL NUMBER.
- APPLY COATING PER E0900074.
- APPLY BARREL GOLD COATING PER E0900112.
- APPLY ESD GOLD COATING PER E0900113.

PARTS LIST	
NOTES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN MILLIMETERS (MM)	
TOLERANCES:	
XX ± 0.1	
XX ± 0.05	
ANGULAR ± 0.1 °	
MATERIAL:	
REFER TO E080037-v1	NEXT ASSY: COMPENSATION PLATE (CP)
FINISH: SEE NOTES	PART NAME: (CP) SUBSTRATE
DRAWN: C. TORRE 30/NOV/09	SIZE: DWG. NO. D080659
CHECKED: D. COINE 18/NOV/09	SCALE: 1:2
CHECKED: E. GAGLIARDI 18/NOV/09	PROJECTION: 1st
APPROVED: D. COINE 24/DEC/08	SHEET 1 OF 1