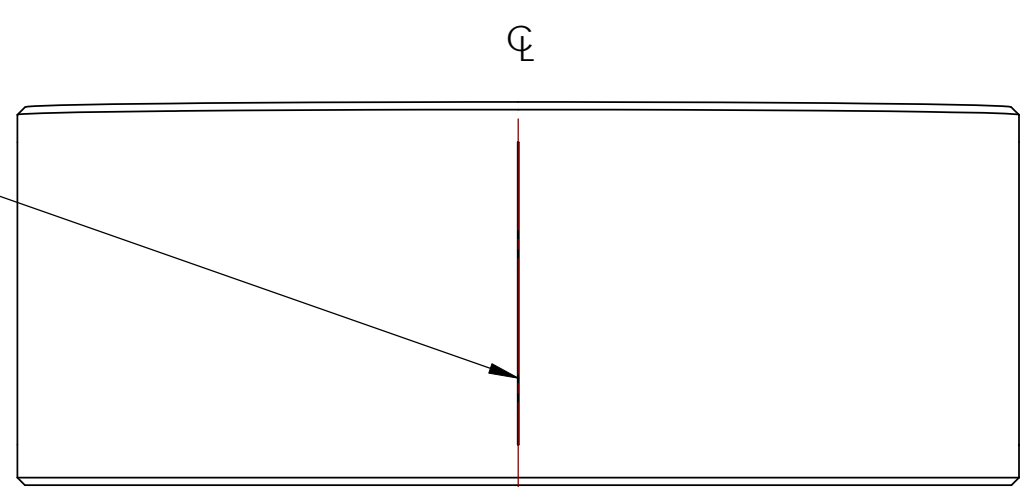


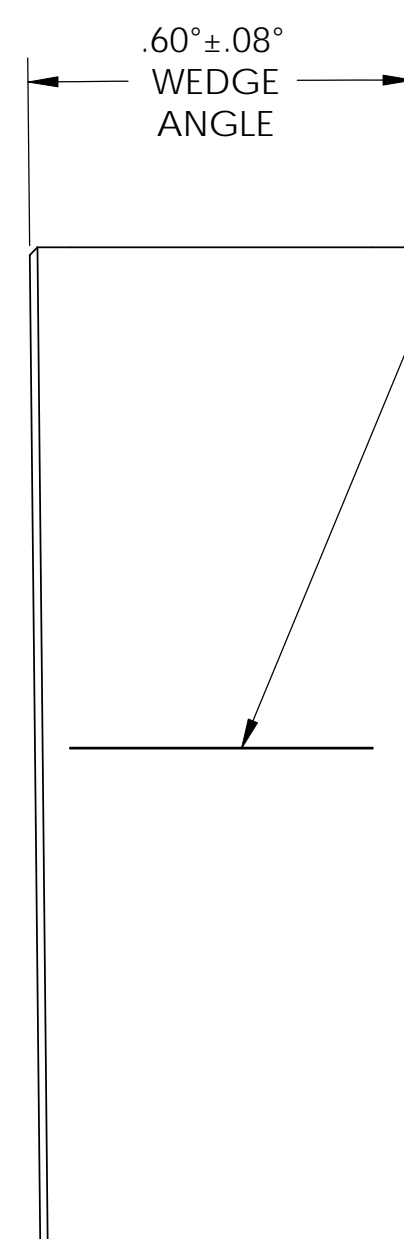
REV.	DATE	DCN #	DRAWING TREE #
v1	11th Nov 2008	E080530-00-D	
v2	2-20-09	LIGO-E0900046-V1	

ETCH OR GRIND REGISTRATION MARKS
 0.25mm ± 0.05mm WIDE x
 80mm ± 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.



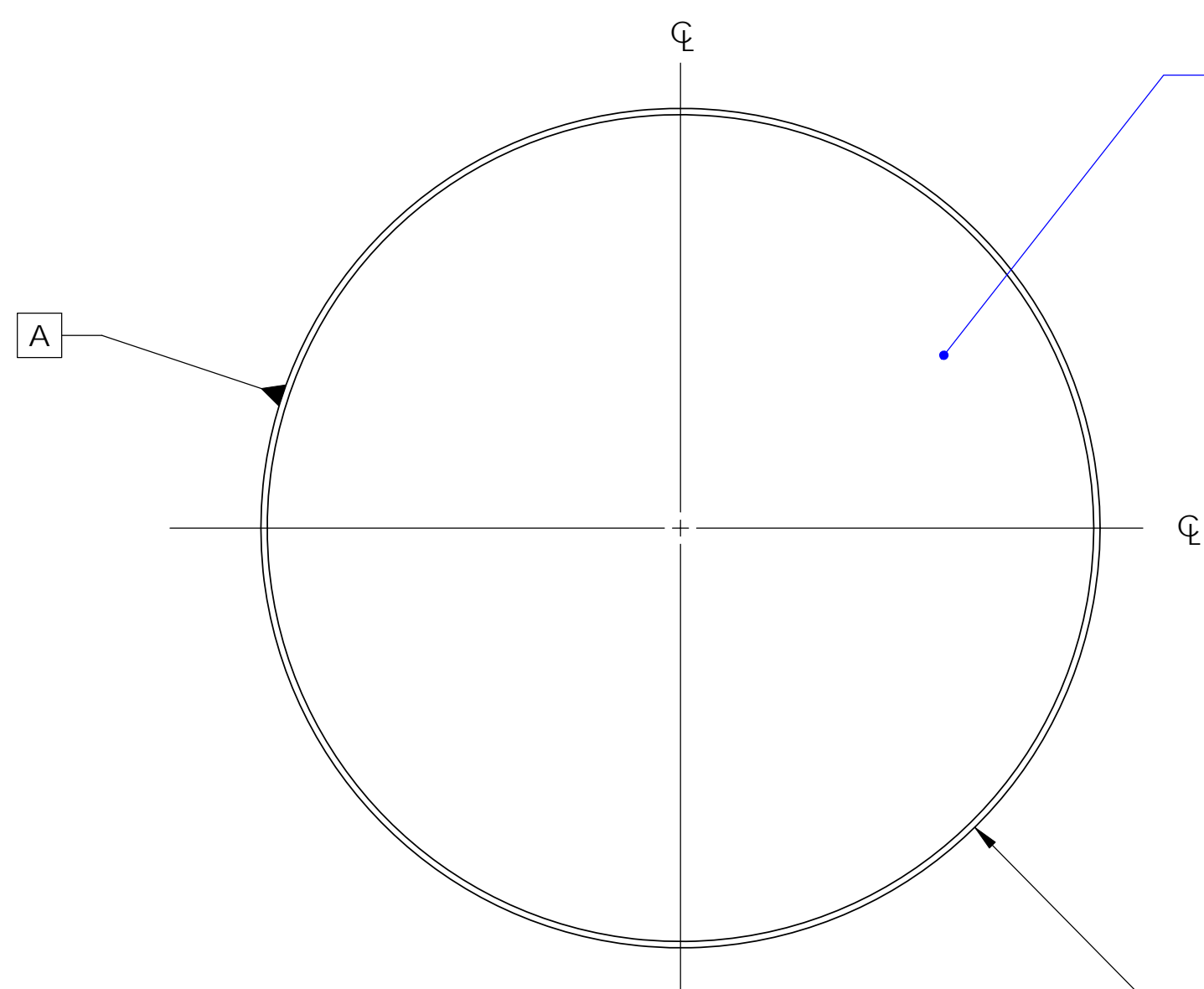
TOP VIEW

ETCH OR GRIND REGISTRATION MARKS
 0.25mm ± 0.05mm WIDE x
 80mm ± 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.



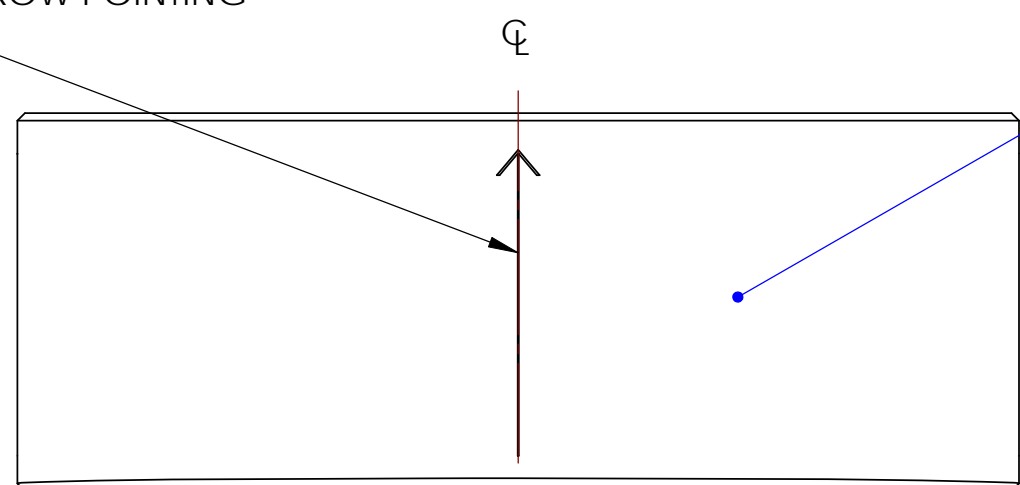
.60 ± .08°
 WEDGE
 ANGLE

S1



POLISH SURFACE 'S1'
 (SEE NOTE 4)

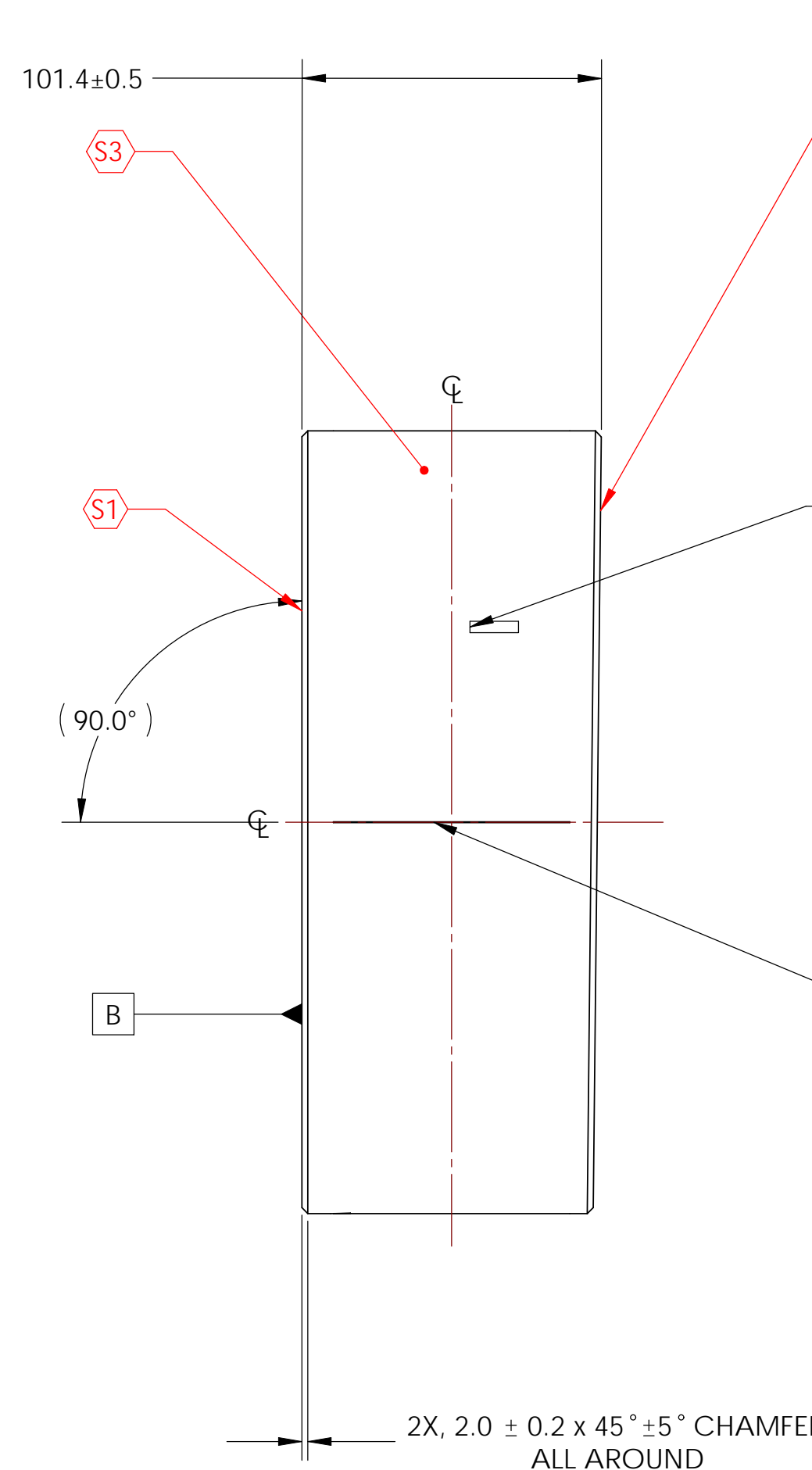
ETCH OR GRIND REGISTRATION MARKS
 0.25mm ± 0.05mm WIDE x
 80mm ± 3mm LONG MINIMUM LEGIBLE
 DEPTH LINE ALONG ϕ , CENTERED
 BETWEEN SURFACES 'S1' AND 'S2' AT
 LOCATION OF MINIMUM PART THICKNESS
 WITHIN ± 1° CLOCKING ANGLE
 (WITH RESPECT TO DATUM FEATURE -A-),
 AND PARALLEL TO THE CYLINDRICAL AXIS
 (DEFINED BY DATUM FEATURE -A-)
 WITHIN ± 0.1mm, WITH ARROW POINTING
 TO SURFACE 'S1'.



BOTTOM VIEW

Ø 265.00 ± 0.25
 0.1
 0.18 B

BARREL SIDE AND BEVEL POLISH
 (SEE NOTE 3).

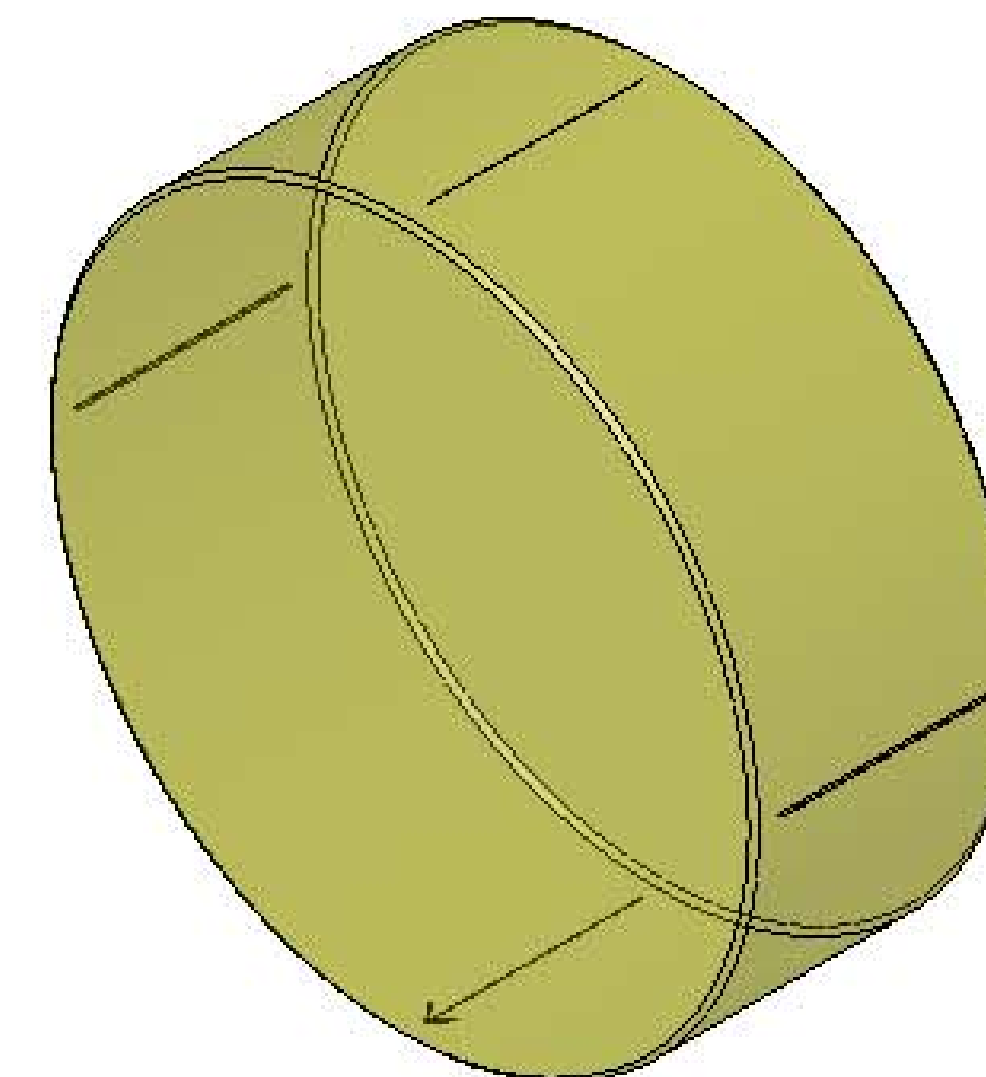


S2 POLISH SURFACE 'S2'
 (SEE NOTE 4).

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

ETCH OR GRIND REGISTRATION MARKS
 0.25mm ± 0.05mm WIDE x
 80mm ± 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.

2X, 2.0 ± 0.2 x 45° ± 5° CHAMFER,
 ALL AROUND



- MANUFACTURING NOTES:
- DO NOT SCALE FROM DRAWING.
 - INTERPRET DRAWING AS PER ANSI Y14.5M 1994.
 - BARREL SIDE AND BEVEL POLISH PER E080516-v2.
 - FINISH SURFACES 'S1' AND 'S2' AS PER E080516-v2.
 - REFER TO E080516-v2 FOR MORE INFORMATION ON SERIAL NUMBER.

PARTS LIST	
NOTES: (UNLESS OTHERWISE SPECIFIED)	LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY
DIMENSIONS ARE IN MILLIMETERS (mm)	SYSTEM ADVANCED LIGO
TOLERANCES	SUB-SYSTEM COC
X ± 0.1	NEXT ASSY PR3
XX ± 0.05	
ANGULAR ± 0.1°	
MATERIAL	
REF E080041-v1	
FINISH	SEE NOTES
NAME	DATE
DRAWN	C. TORRE 14 Nov 08
CHECKED	D. COYNE 10 Nov 08
CHECKED	F. GOSWAMI 18 Nov 08
APPROVED	D. COYNE 17 Dec 08
PART NAME	PR3 SUBSTRATE
DWG. NO.	D080662
SCALE	1:2
PROJECTION	
SHEET	1 OF 1