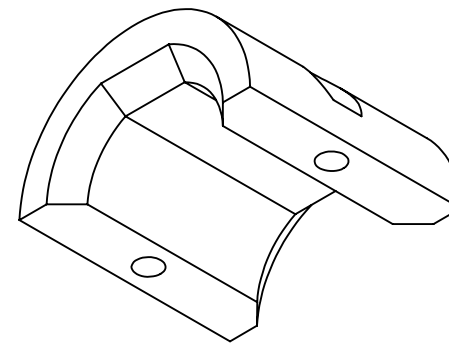
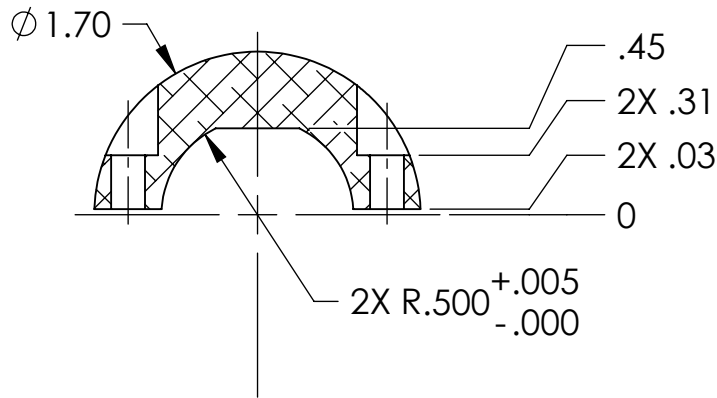
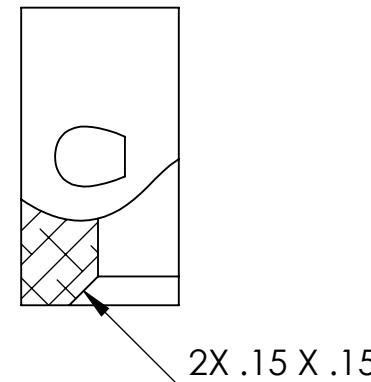
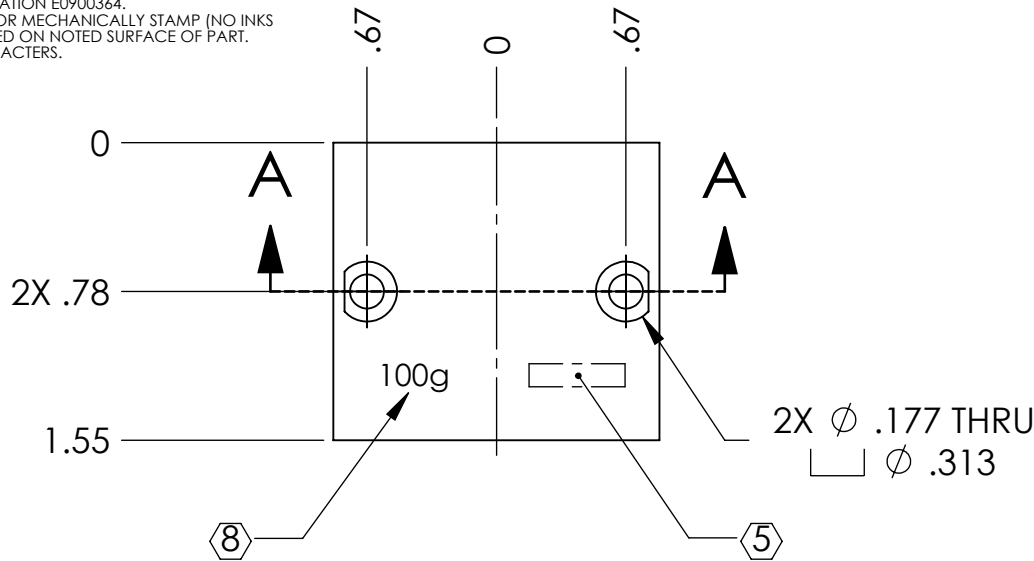


NOTES CONTINUED:

- ⑤ SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED.
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- ⑧ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) AS MARKED ON NOTED SURFACE OF PART. USE .12" HIGH CHARACTERS.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 JUN 2009	E0900173	E080191
v2	28 JUN 2010	E1000236	E080191
-	-	-	-



SECTION A-A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± 0.5°

- 1. INTERPRET DRAWING PER ASME Y14.5-1994.
- 2. REMOVE ALL SHARP EDGES, R.02 MIN.
- 3. DO NOT SCALE FROM DRAWING.
- 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL: 6061-T6 Al
 FINISH: 32 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
 SUB-SYSTEM: SUS
 NEXT ASSY: INT. MASS CHANGER

PART NAME			COLLAR, UPPER, 100g		
DESIGNER	D. BRIDGES	28 AUG 2008	SIZE	DWG. NO.	REV.
DRAFTER	R. BIEDENHARN	29 OCT 2010	A	D080182	v2
CHECKER	D. BRIDGES	04 NOV 2010	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1
APPROVAL					