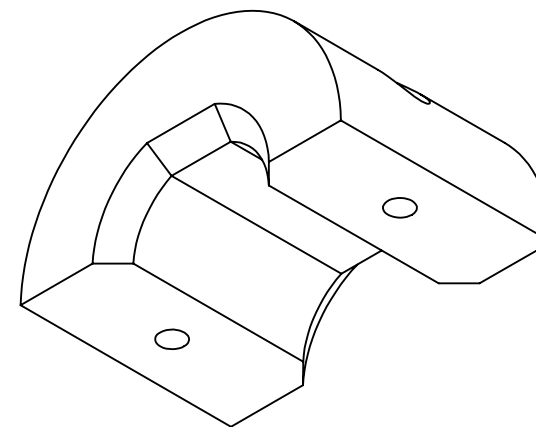
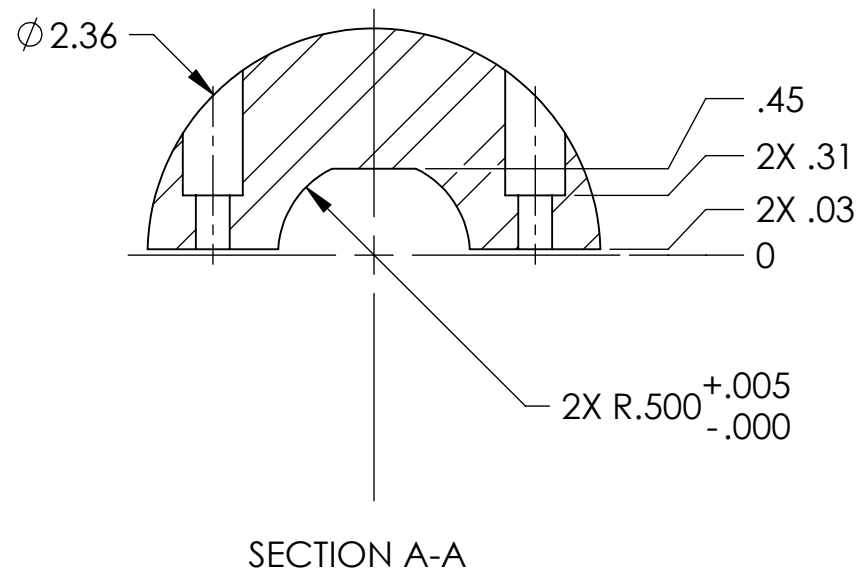
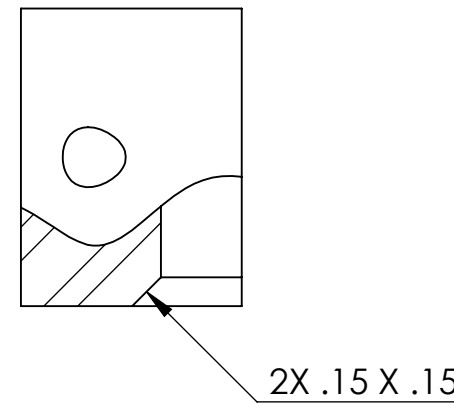
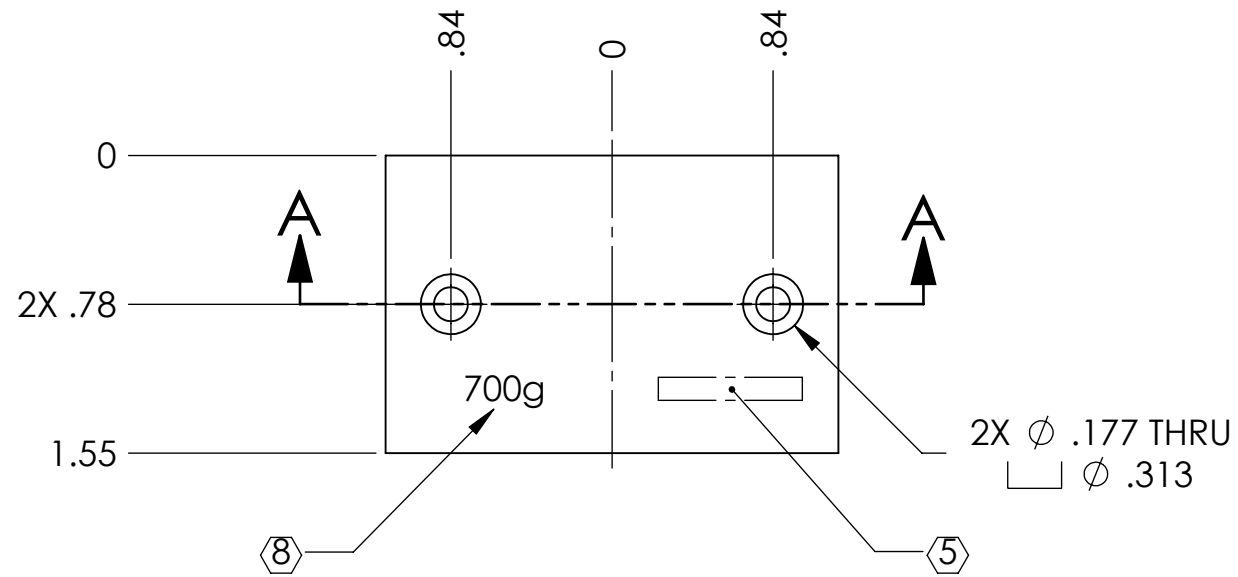


D080227_Advanced_LIGO_SUS_HLTS_Collar_Upper_700g_Intermediate_Mass_PART PDM REV: V1-001, DRAWING PDM REV: V1-002

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
-	-	-	-



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	FINISH
304 SSSL	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, 700g	
DESIGNER	D. BRIDGES	28 AUG 2008	SIZE DWG. NO.
DRAFTER	R. BIEDENHARN	29 OCT 2010	B
CHECKER	D. BRIDGES	04 NOV 2010	D080227
APPROVAL			REV. v2
SCALE: 1:1		PROJECTION:	SHEET 1 OF 1