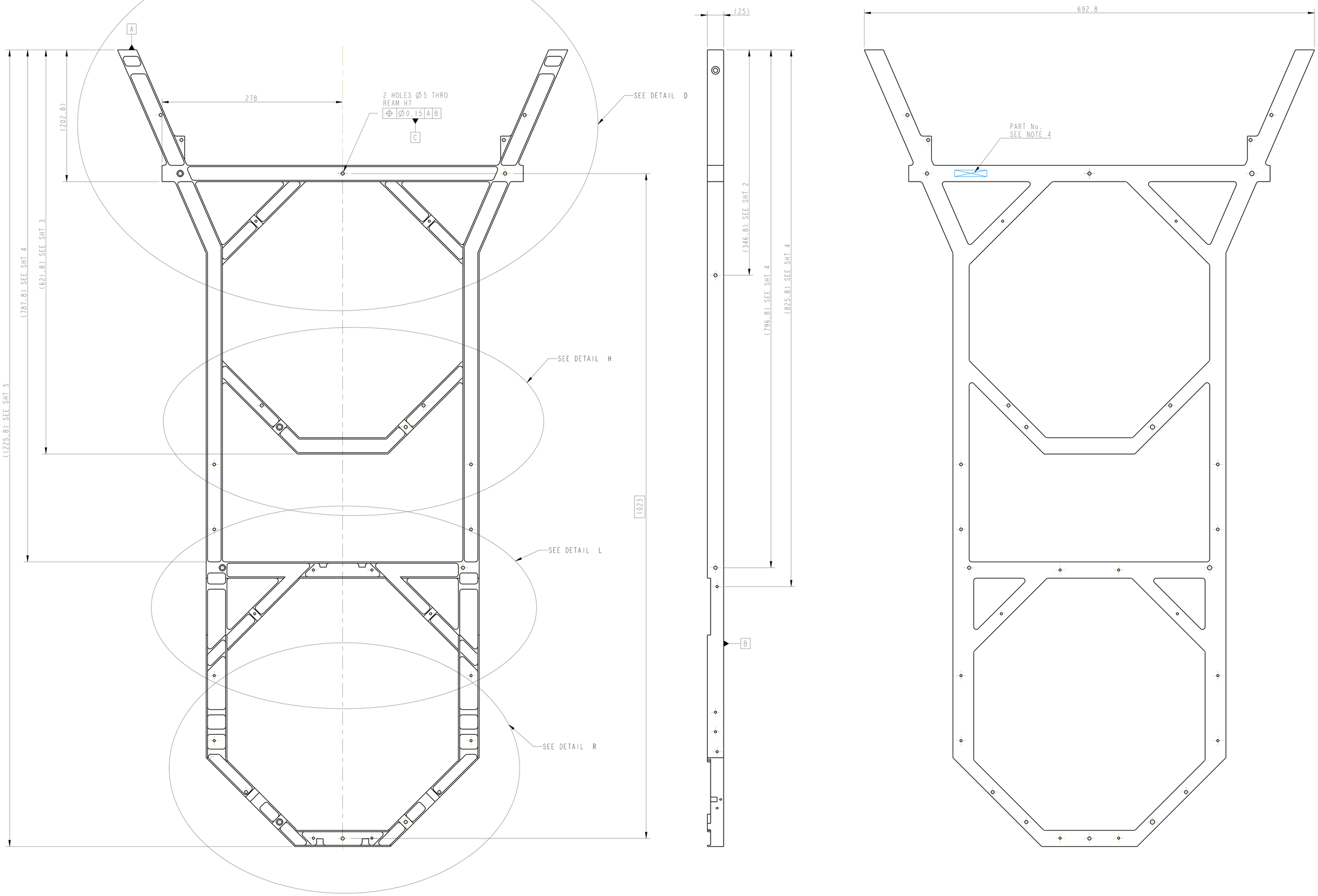
INTRALINK NAME: D060462

REV.	DATE	DCN #	DRAWING TREE #
A	30-OCT-06	E060260-00	.
B	21/DEC/07	E060260-B	.
C	28/JULY/08	E080405	
D	9/SEPT/08	E080473	



NOTES: (UNLESS OTHERWISE SPECIFIED)

1. REMOVE ALL SHARP EDGES, R.02 MIN.
2. DO NOT SCALE FROM DRAWING.
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)
4. SCRIBE, ENGRAVE OR STAMP DRAWING PARTNUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .17" HIGH CHARACTERS. EXAMPLE: D020188-001, A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X.XX ±0.2 mm (INCHES)
ANGULAR ±0.25°

MATERIAL: ALUMINIUM ALLOY 6082

FINISH: CLEAN AND DEGREASED
m (µin) Ra : 1.6

	NAME	DATE
DRAWN	A J BRUMMER	18/08/04
CHECKED	AJB	9/SEPT/08
APPROVED	JW	-/-/-/-

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
IGR, GLASGOW UNIVERSITY GEO 600 GROUP
RUTHERFORD APPLETON LABORATORIES

SYSTEM **ADVANCED LIGO**

SUB-SYSTEM **SUS**

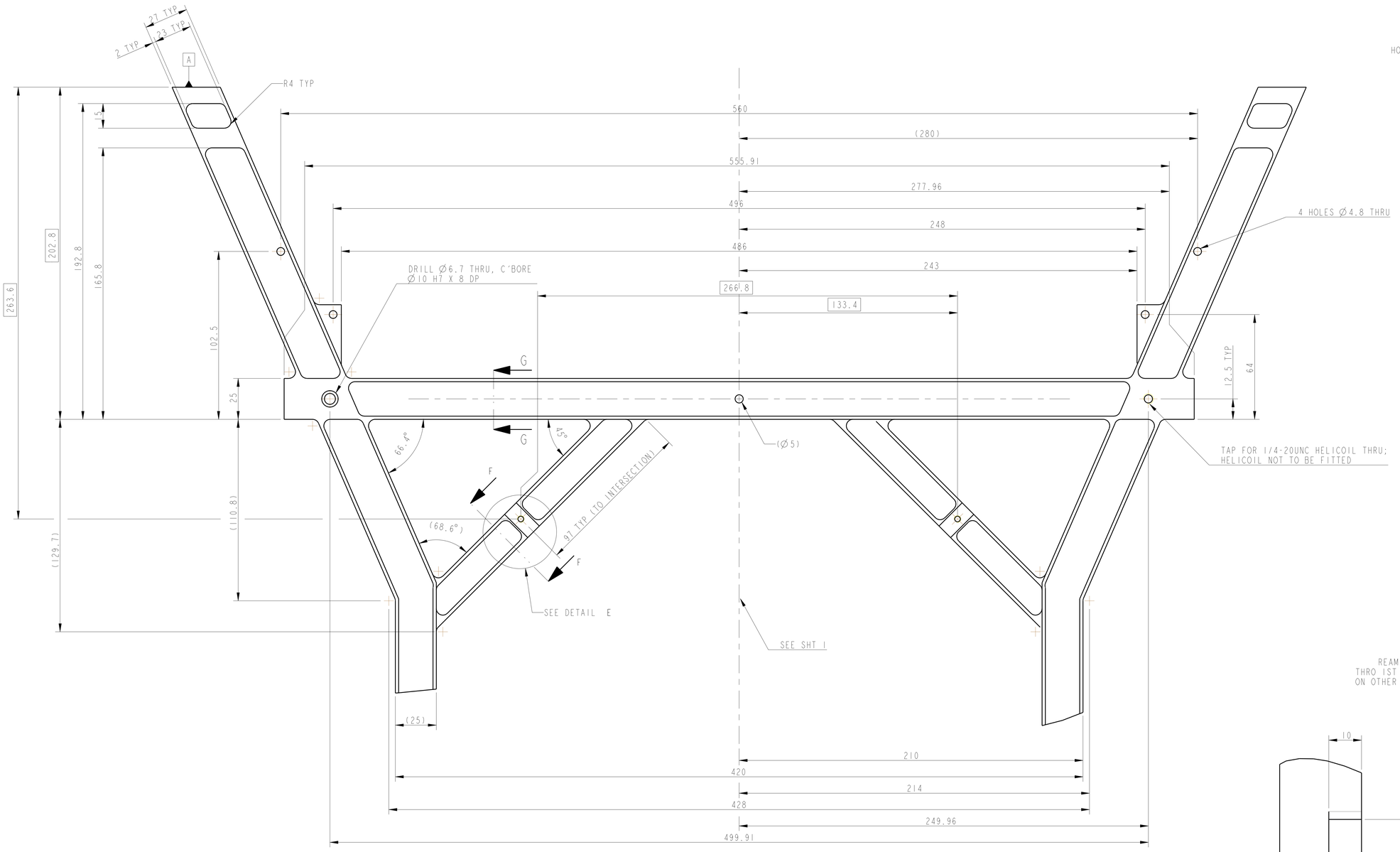
NEXT ASSY **QUAD NPTYPE LOWER STRUCTURE**

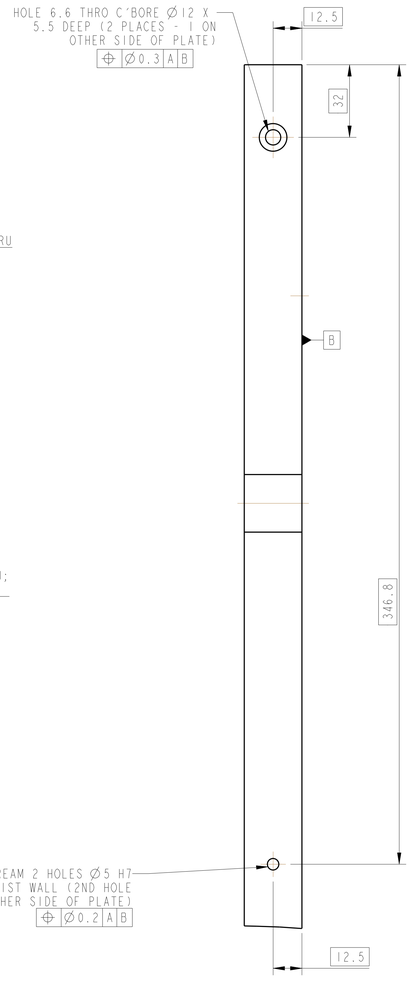
PART NAME **INNER FACE PLATE LOWER STRUCTURE**

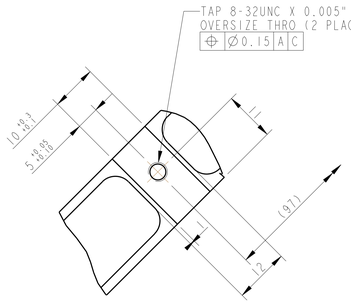
SIZE **E** DRG. NO. **D060462** REV **D.**

SCALE 1:2 PROJECTION SHEET 1 OF 5

INITIAL INK NAME: D060462

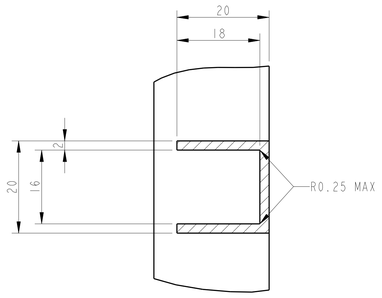




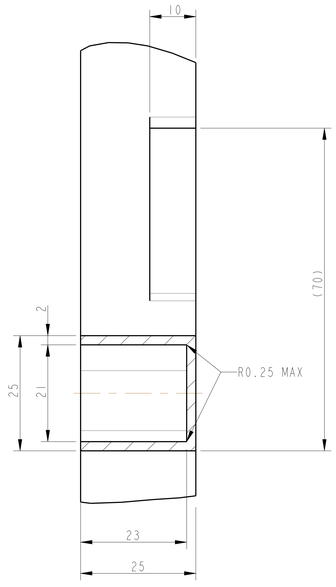


DETAIL E
SHOWING HOLE DETAILS
SCALE 2:1

DETAIL D
(SEE SHT 1)
SCALE 1:1



SECTION F-F
SCALE 2:1



PARTIAL SECTION G-G
SHOWING DEPTH OF SECTION
SCALE 2:1

NOTES: (UNLESS OTHERWISE SPECIFIED)
1. REMOVE ALL SHARP EDGES, 0.02 MIN.
2. DO NOT SCALE FROM DRAWING.
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND NOT CONTAIN CHLORINE AND SILICONE SUCH AS CINCINNATI MILACRON'S CIMTECH 410 STAINLESS STEEL!
4. SCRIBE, ENGRAVE OR STAMP DRAWING PARTNUMBER ON NOTED SURFACE AND IN A VISIBLE LOCATION AFTER ALL PARTS AND FINAL NUMBERS EXIST. AT SSS FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: D020180-001, A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X.XX ±0.2 mm (INCHES)
ANGULAR ±0.25°

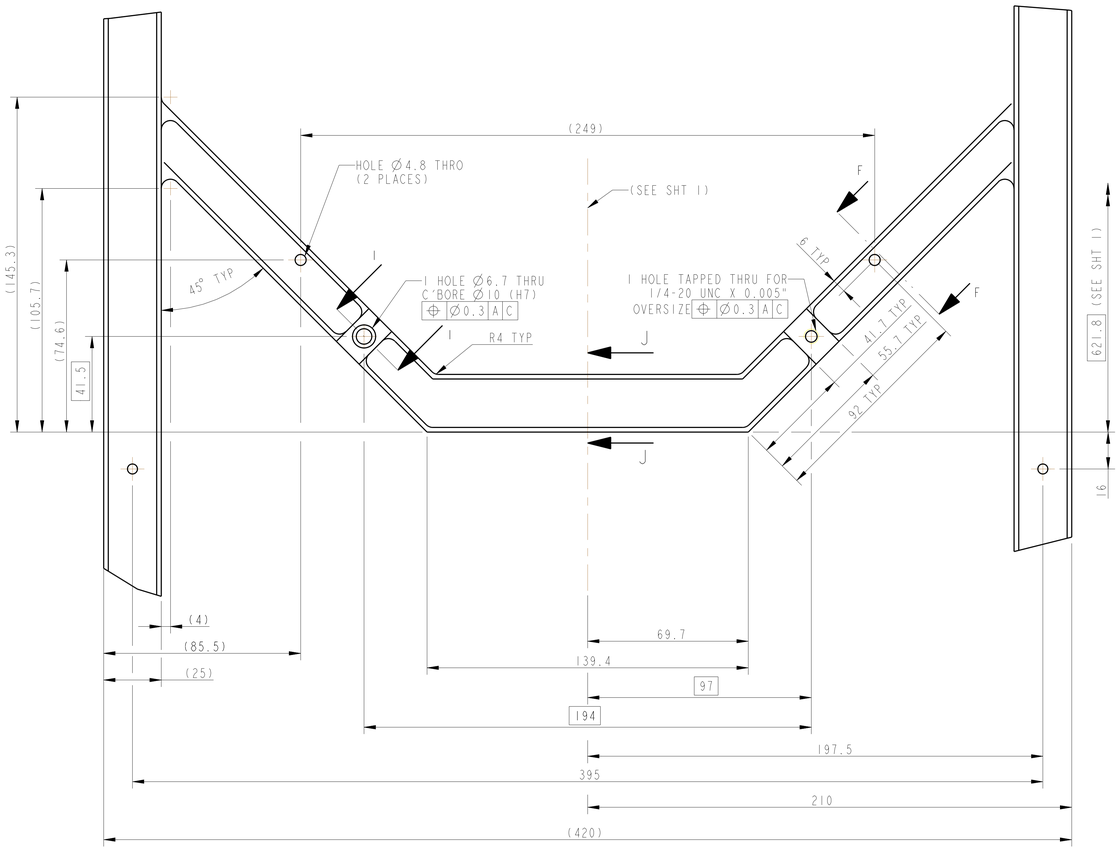
MATERIAL: ALUMINUM ALLOY 6061
FINISH: CLEAN AND DEGREASED m finish Ra: 1.6

	NAME	DATE
DRAWN	A.J. BRUMMITT	08/04/04
CHECKED	K.R.	9/13/11/08
APPROVED	I.W.	-/-/--

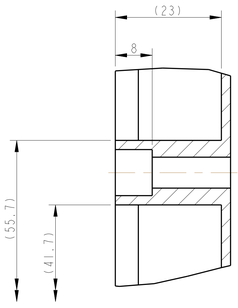
LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY, GLASGOW UNIVERSITY, RUTHERFORD APPLETON LABORATORIES

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: THS
PART NAME: INNER FACE PLATE
LOWER STRUCTURE
ORG. NO.: D060462
SIZE: E
REV: D
SCALE 1/2 PROJECTION
SHEET 1 OF 2

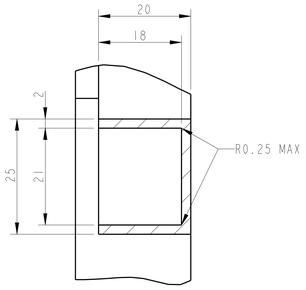
INTRALINK NAME: D060462



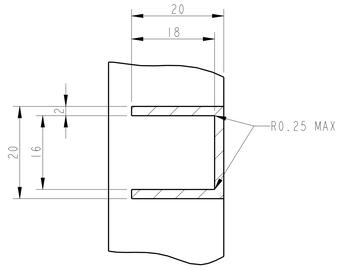
DETAIL H
(SEE SHT 1)
SCALE 1:1



PARTIAL SECTION I-I
SCALE 2:1



PARTIAL SECTION J-J
SHOWING DEPTH OF SECTION
SCALE 2:1



SECTION F-F
SCALE 2:1

NOTES: (UNLESS OTHERWISE SPECIFIED)
1. REMOVE ALL SHARP EDGES, 0.02 MIN.
2. DO NOT SCALE FROM DRAWING.
3. ALL MACHINING FLUIDS SHALL BE FREE OF SULFUR, LEAD, CHLORINE, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).
4. SCRIBE, ENGRAVE OR STAMP DRAWING NUMBER, SERIAL NUMBER ON EACH PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY.
5. REMOVE BURRS AND SLIVERS, EXCEPT DESIGNED BRS. A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X.XX ±0.2 mm (INCHES)
ANGULAR ±0.25°
MATERIAL: ALUMINUM ALLOY 6061
FINISH: CLEAN AND DEGREASED in fairn Ra 7.5

	NAME	DATE
DRAWN	R.J.BRUNKHORST	08/04
CHECKED	A.R.	9/13/11
APPROVED	I.W.	9/13/11

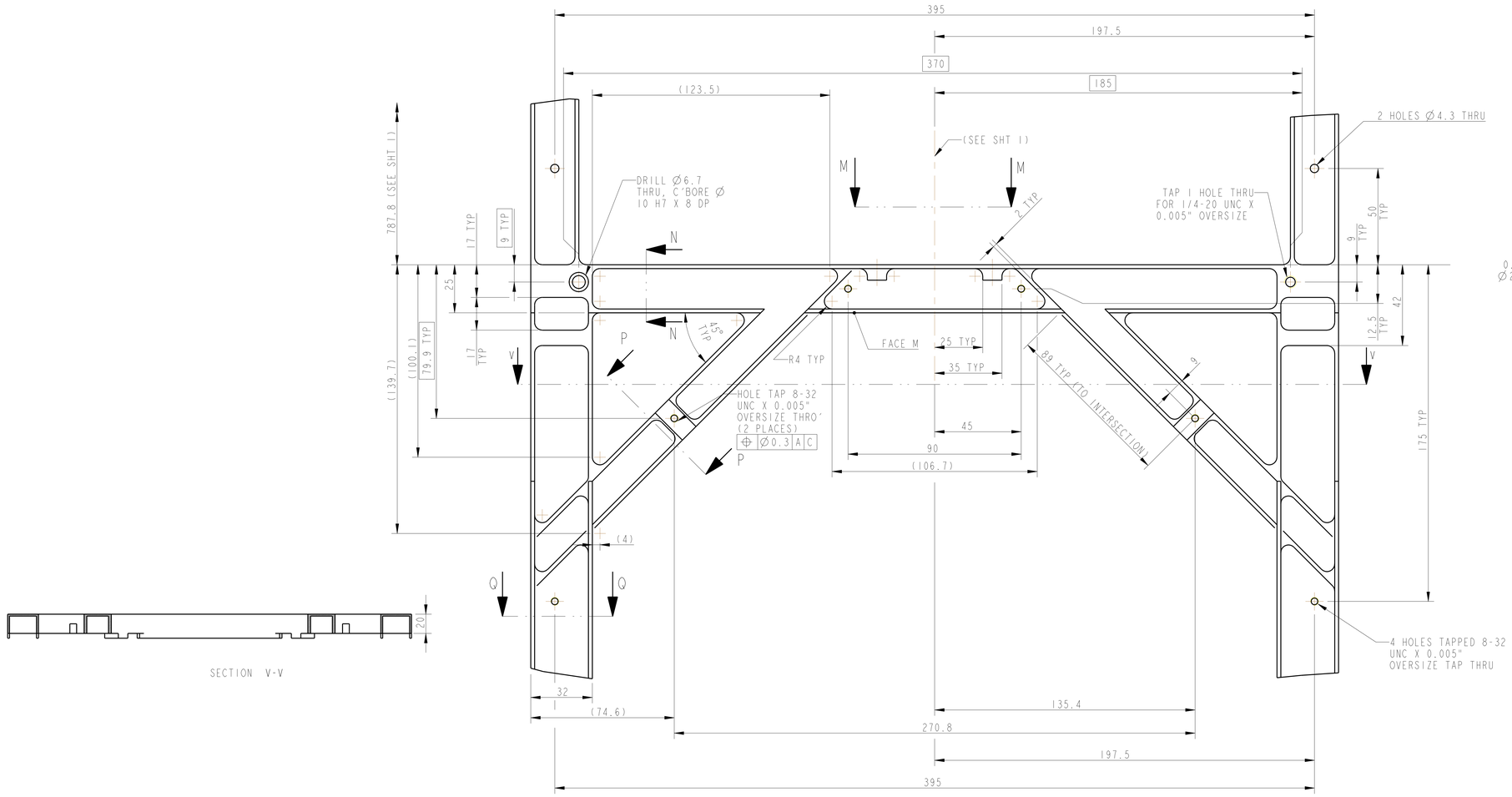
LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY, LIGO HANFORD OBSERVATORY, LIGO LIVINGSTON OBSERVATORY, GEO 600 GROUP, UNIVERSITY OF GLASGOW, RUTHERFORD APPLETON LABORATORY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: QUAD NAYTYPE LOWER STRUCTURE
PART NAME: INNER FACE PLATE
LOWER STRUCTURE

SIZE: E | DRG. NO.: D060462 | REV: D.

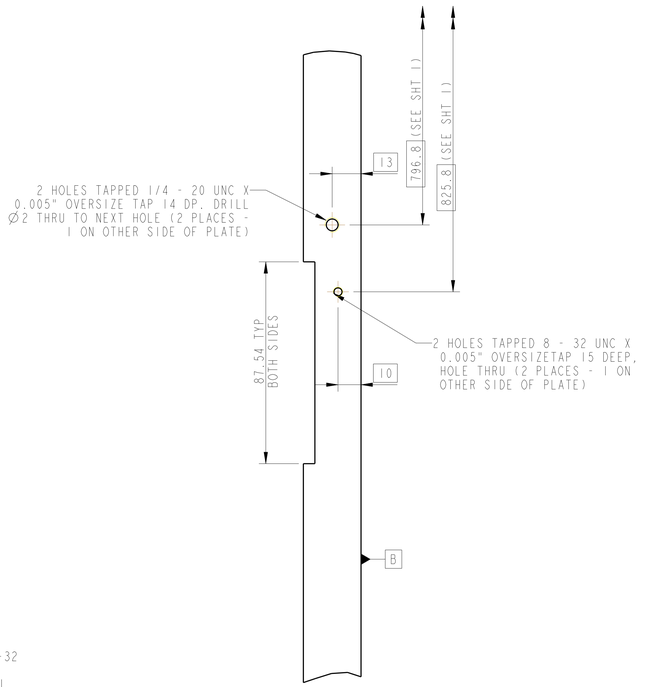
SCALE (-2) PROJECTION | SHEET 2 OF 2

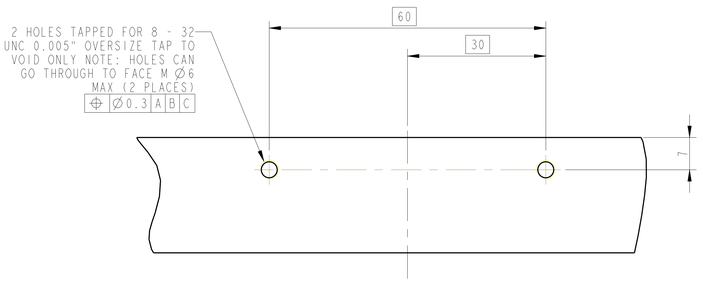
INTRALINK NAME: D060462



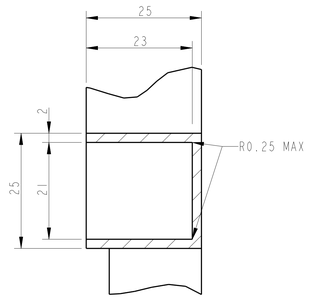
DETAIL L
(SEE SHT 1)
SCALE 1:1

SECTION V-V

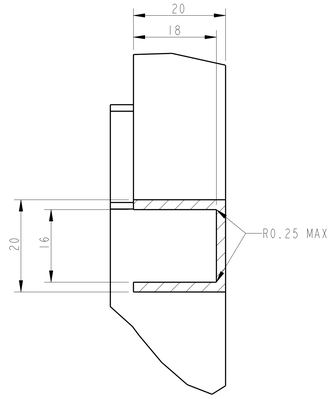




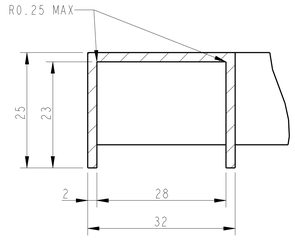
PARTIAL SECTION M-M
SHOWING HOLE POSITIONS
SCALE 2:1



PARTIAL SECTION N-N
SHOWING DEPTH OF SECTION
SCALE 2:1



PARTIAL SECTION P-P
SHOWING DEPTH OF SECTION
SCALE 2:1



PARTIAL SECTION Q-Q
SHOWING DEPTH OF SECTION
SCALE 2:1

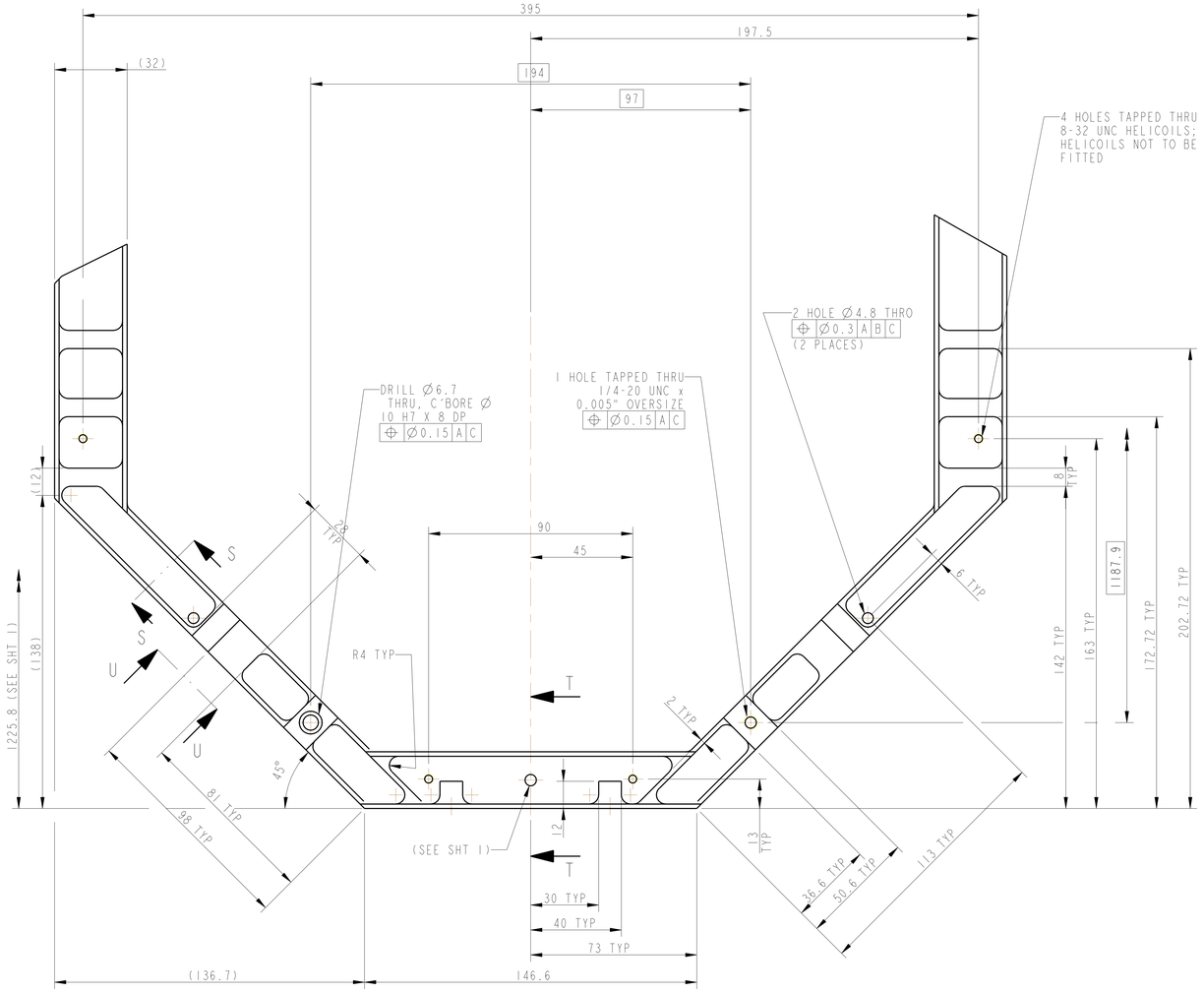
NOTES: (UNLESS OTHERWISE SPECIFIED)
1. REMOVE ALL SHARP EDGES, 0.2/0.8%.
2. DO NOT SCALE FROM DRAWING.
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S TRIM SOL OR TRIM VHP 210 OR EQUIV.
4. SERIES ENGRAVED ON STAMP BEARING PARTNUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE 5 MM HIGH CAPITAL CHARACTERS, EXAMPLE: D020180-001. A VIBRATORY TOOL MAY BE USED.

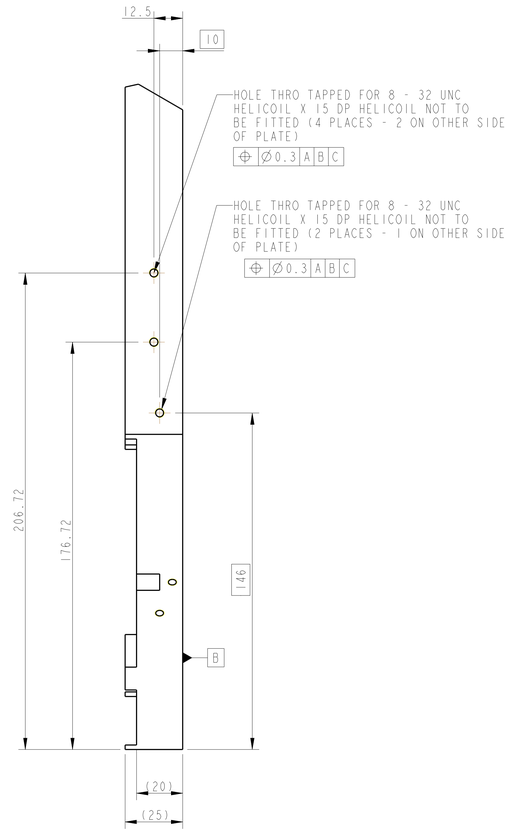
DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X.XX ±0.2 mm (INCHES)
ANGULAR ±0.25°
MATERIAL: ALUMINUM ALLOY 6061
FINISH: CLEAN AND DEGREASED m (µin) Ra 1.6

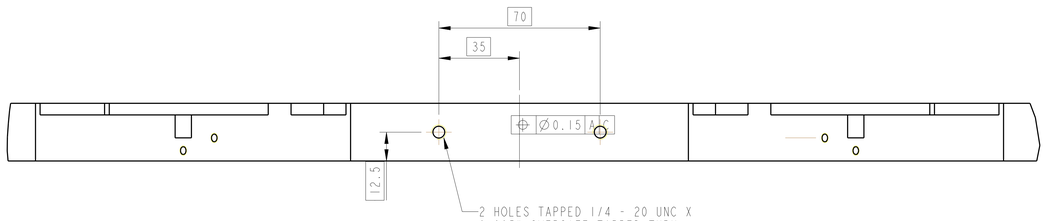
	NAME	DATE
DRAWN	K.J.BRUMBLE	10/2/14
CHECKED	K.ADE	10/SEPT/08
APPROVED	I.W.	/-/-/-

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY, UNIVERSITY OF GLASGOW, LIGO LABORATORIES, RUTHERFORD APPLETON LABORATORIES

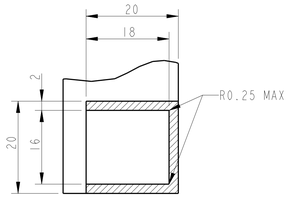
SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: QUAD N-PTYPE LOWER STRUCTURE
PART NAME: INNER FACE PLATE LOWER STRUCTURE
SIZE: E | DRG. NO.: D060462 | REV: D.
SCALE 1:2 | PROJECTION | SHEET 4 OF 5



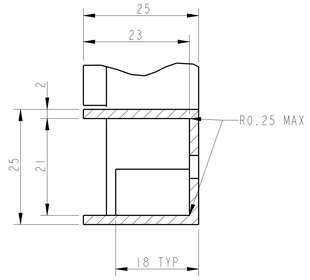




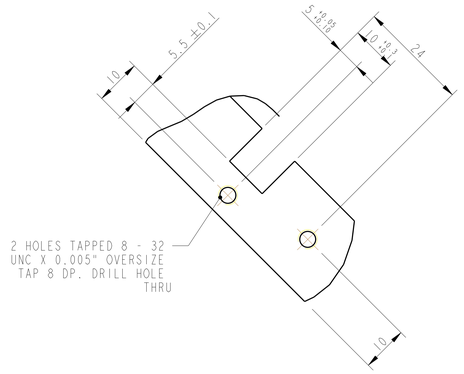
DETAIL R
(SEE SHT 1)
SCALE 1:1



PARTIAL SECTION S-S
SHOWING DEPTH OF SECTION
SCALE 2:1



PARTIAL SECTION T-T
SHOWING DEPTH OF SECTION
SCALE 2:1



PARTIAL SECTION U-U
SHOWING HOLE POSITION
(TYP 2 PLACES)

NOTES: (UNLESS OTHERWISE SPECIFIED)

1. REMOVE ALL SHARP EDGES, 0.02 MIN.
2. DO NOT SCALE FROM DRAWING.
3. ALL PARTS TO BE CLEANED TO BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH #10 ISTAINLESS STEEL
4. PERMANENTLY MARK THE FOLLOWING PARTNUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERING START AT 001 FOR THE FIRST PART AND SPECIFY MARK CHARACTERS. EXAMPLE: D020188-001. A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X.XX ±0.2 mm (INCHES)
ANGULAR ±0.25

MATERIAL: ALUMINIUM ALLOY 6082
FINISH: CLEAN AND DEGREASED m (µin)
NEXT ASSY | QUAD N-PTYPE LOWER STRUCTURE
DRAWN: K.J. BRUNETT 08/08/08
CHECKED: K.M. 11/12/08
APPROVED: J.M.

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
UNIVERSITY OF GLASGOW
LIGO PROJECT, LOUISIANA STATE UNIVERSITY
MIT, LIGO LABORATORY
SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
PART NAME: INNER FACE PLATE
LOWER STRUCTURE
SIZE: E
DRG. NO.: D060462
REV: D
SCALE 1:1 | PROJECTION | SHEET 1 OF 1