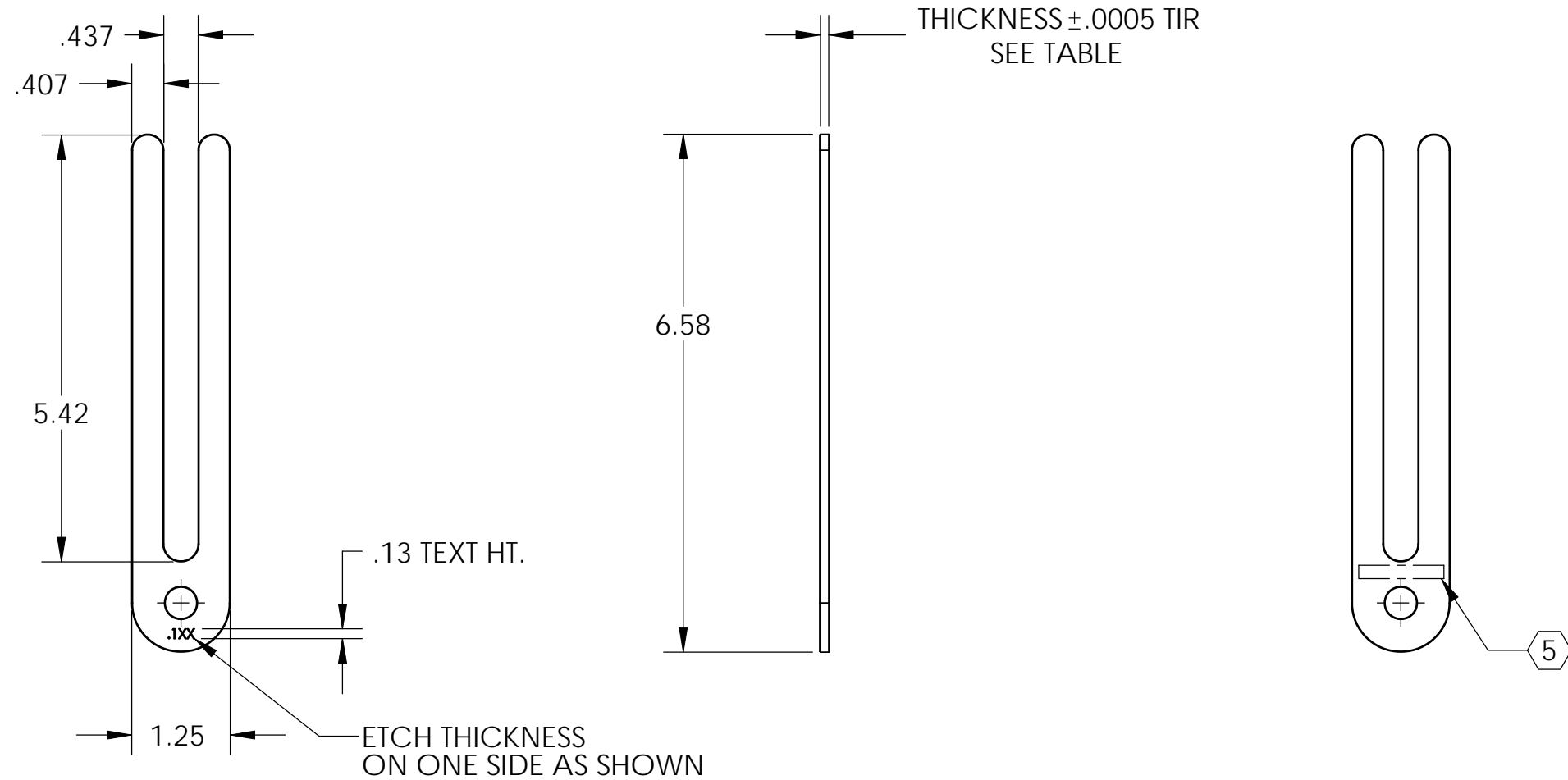


D0902551\_Stage1-2 Locker, Base Shim Spacer, PART PDM REV. X-006, DRAWING PDM REV. X-004

8 7 6 5 4 3 2 1

**NOTES CONTINUED:**  
 (5) SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.  
 EXAMPLE (PART): 001-V1  
 EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY:TBD  
 6. APPROXIMATE WEIGHT = 0.20 LB.  
 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.  
 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	01 Mar. 2010	E1000115	E1000025
v2	28 July 2010	E1000339	E1000025
v3	28 Jan 2011	E1100074	E1000025



Design Table for: D0902551

LIGO TYPE	Thickness
-00	0.120
-01	0.121
-02	0.122
-03	0.123
-04	0.124
-05	0.125
-06	0.126
-07	0.127
-08	0.128
-09	0.129
-10	0.130
-11	0.110
-12	0.111
-13	0.112
-14	0.113
-15	0.114
-16	0.115
-17	0.116
-18	0.117
-19	0.118
-20	0.119

DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± .5°		<b>NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)</b> 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.		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME STAGE 1-2 LOCKER, BASE SHIM SPACER, aLIGO BSC ISI	
MATERIAL 304 SS		FINISH 16 μinch		SYSTEM ADVANCED LIGO		SUB-SYSTEM SEI	
NEXT ASSY D1000855		DESIGNER S.BARNUM 17 Aug 2009		SIZE B		DWG. NO. D0902551	
CHECKER M.HILLARD 01 Mar. 2010		APPROVAL K.MASON 01 Mar. 2010		REV. v3		SCALE: 1:2 PROJECTION:  SHEET 1 OF 1	

8 7 6 5 4 3 2 1