

8 7 6 5 4 3 2 1

D

D

C

C

B

B

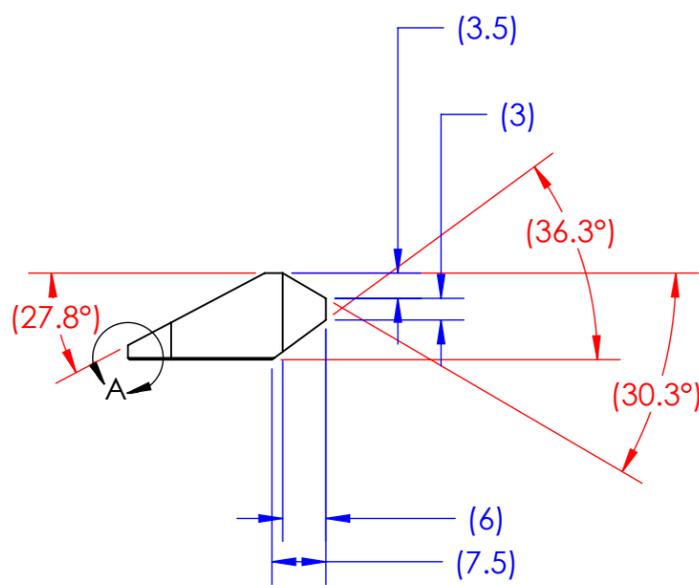
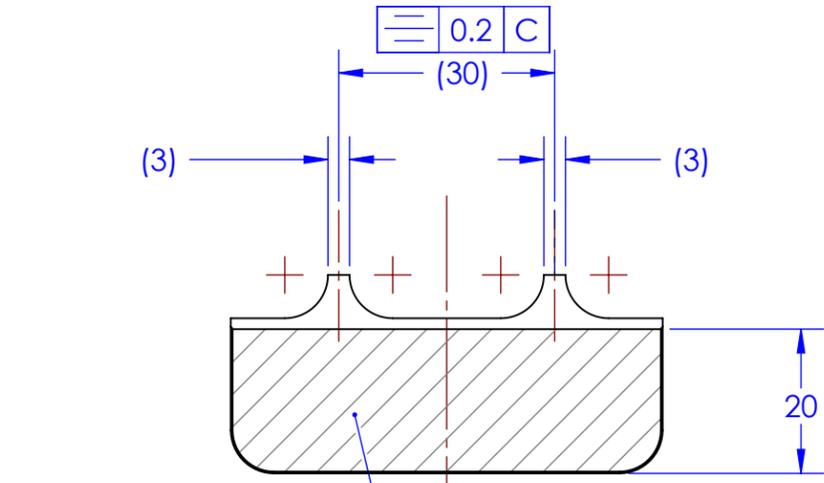
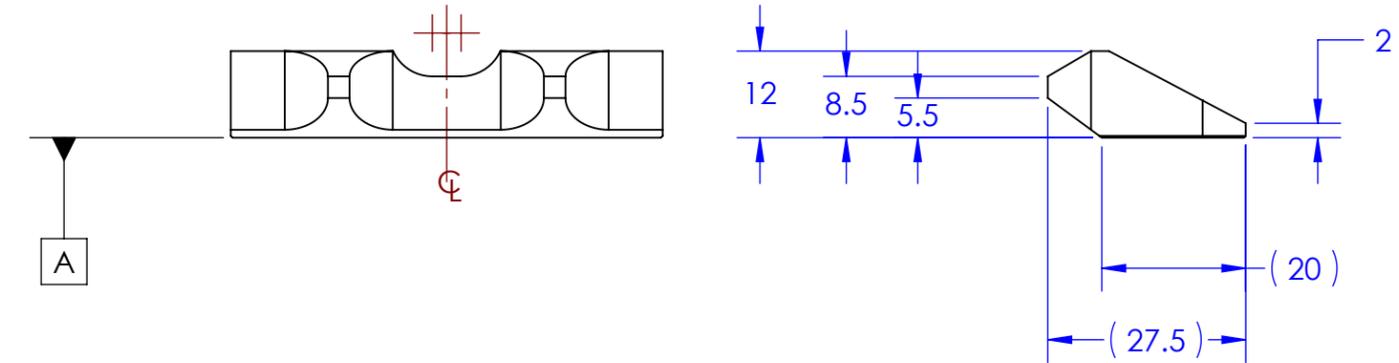
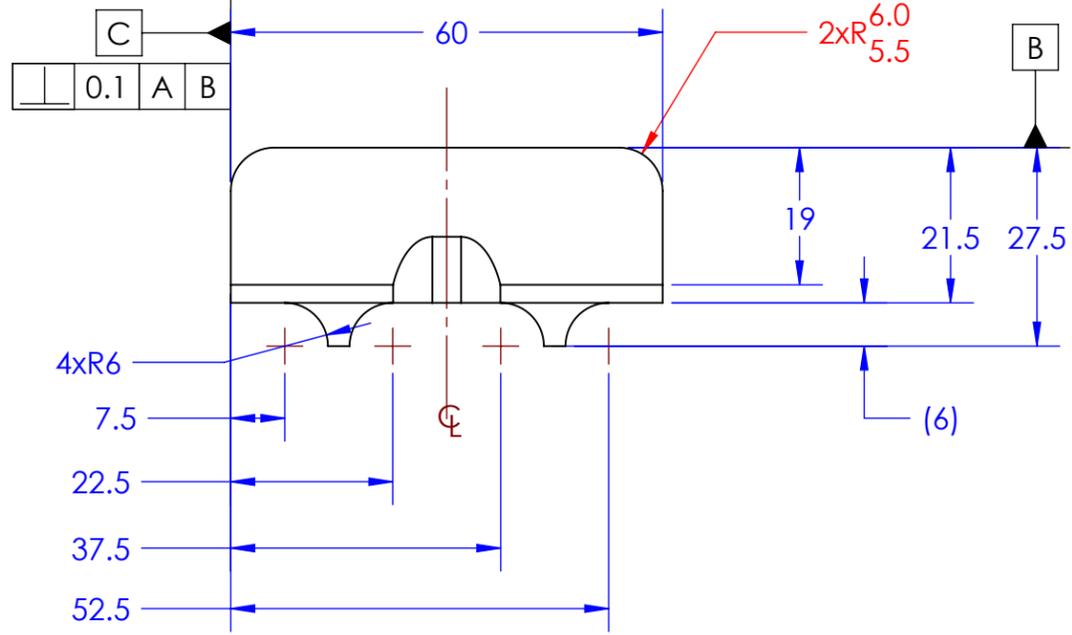
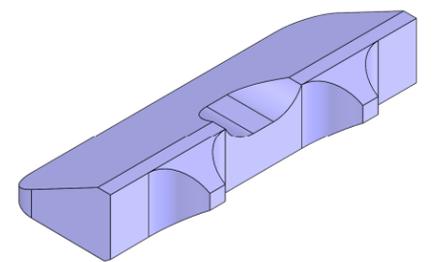
A

A

CHAMFER 0.3 mm MAX x45° ± 5°

DETAIL A SCALE 6 : 1

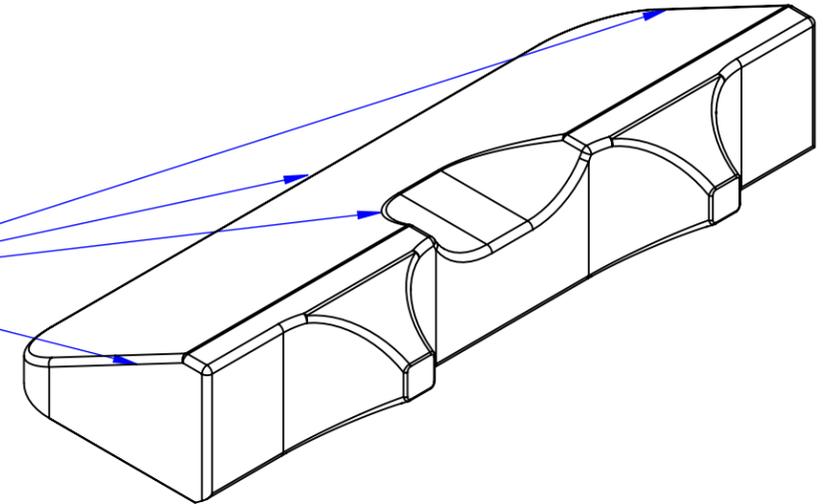
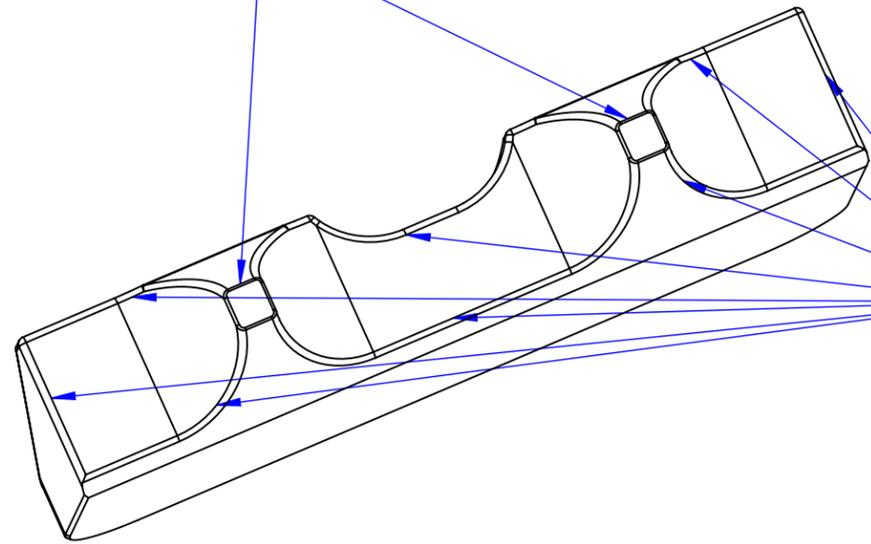
SURFACE "S1" (HATCHED)



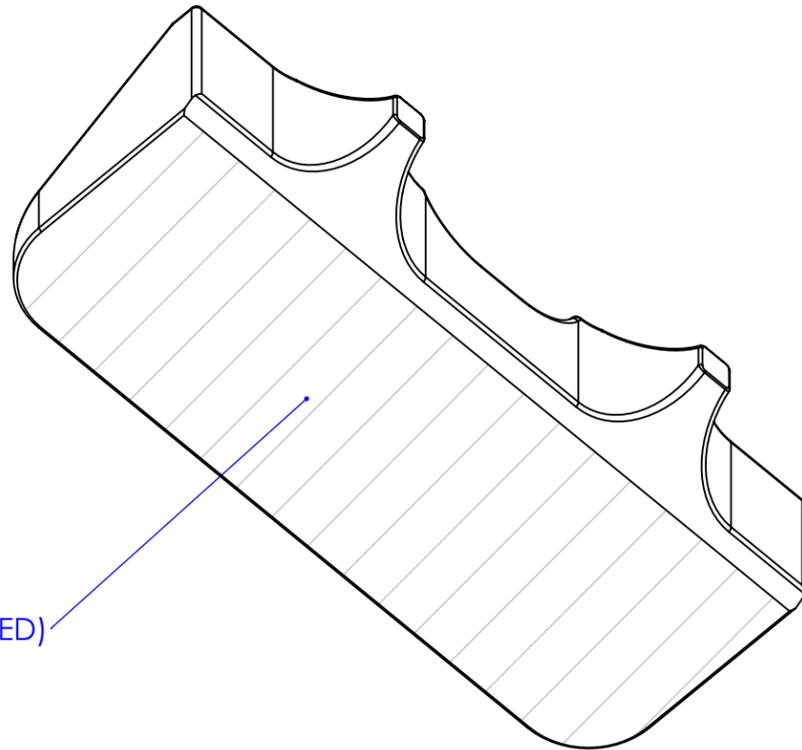
# FLAME POLISHING AND ANNEALING INSTRUCTIONS

Flame polish all horn edges  
Maximum radius 0.2

Flame polish indicated  
edges  
Maximum radius 0.5



Surface "S1" (HATCHED)



## MANUFACTURING NOTES

1. Ears shall be cleaned in a 9% hydrofluoric acid solution prior to flame polishing
2. Flame polish all surface and edges except surface "S1" and edges of surface "S1"
3. Flame polishing and annealing shall not change overall dimensions of the parts as in sheet 1
4. Annealing shall be done at 1120°C for 2 hours.
5. Extreme care shall be taken to not damage any surface in any way by scratching or chipping

## PARTS LIST

NOTES: (UNLESS OTHERWISE SPECIFIED)

1. Do not scale from drawing
2. Symmetric about centre line

DIMENSIONS ARE IN MILLIMETERS

TOLERANCES:  
± 0.1 MAX  
ANGULAR ± 0.2 °

MATERIAL Suprasil 312

FINISH see manufacturing notes

	NAME	DATE
DRAWN	MVV	21/11/08
CHECKED	R.JONES	21/11/08
APPROVED		

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY  
IGR, GLASGOW UNIVERSITY GEO 600 GROUP

SYSTEM Advanced LIGO

SUB-SYSTEM SUS

NEXT ASSY Penultimate Mass (PM)

PART NAME  
Production Ear\_with recess

SIZE DWG. NO. D090007 REV. v3

SCALE: 1:1 PROJECTION: SHEET 2 OF 2