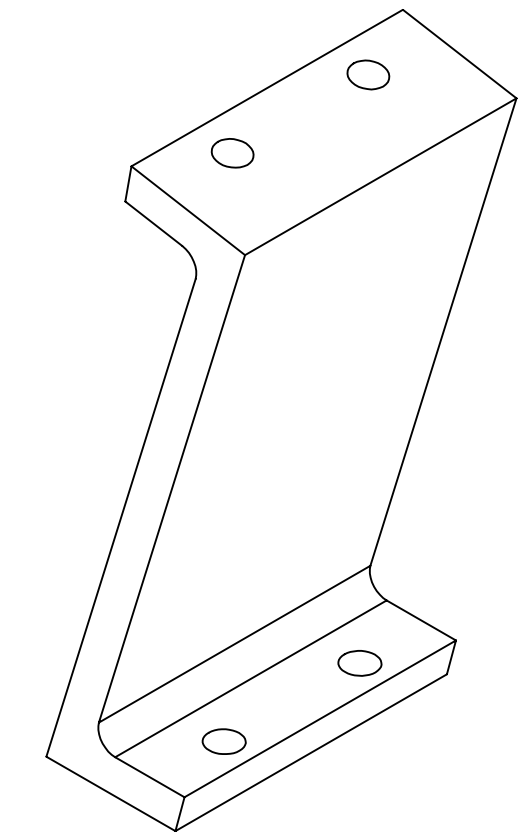
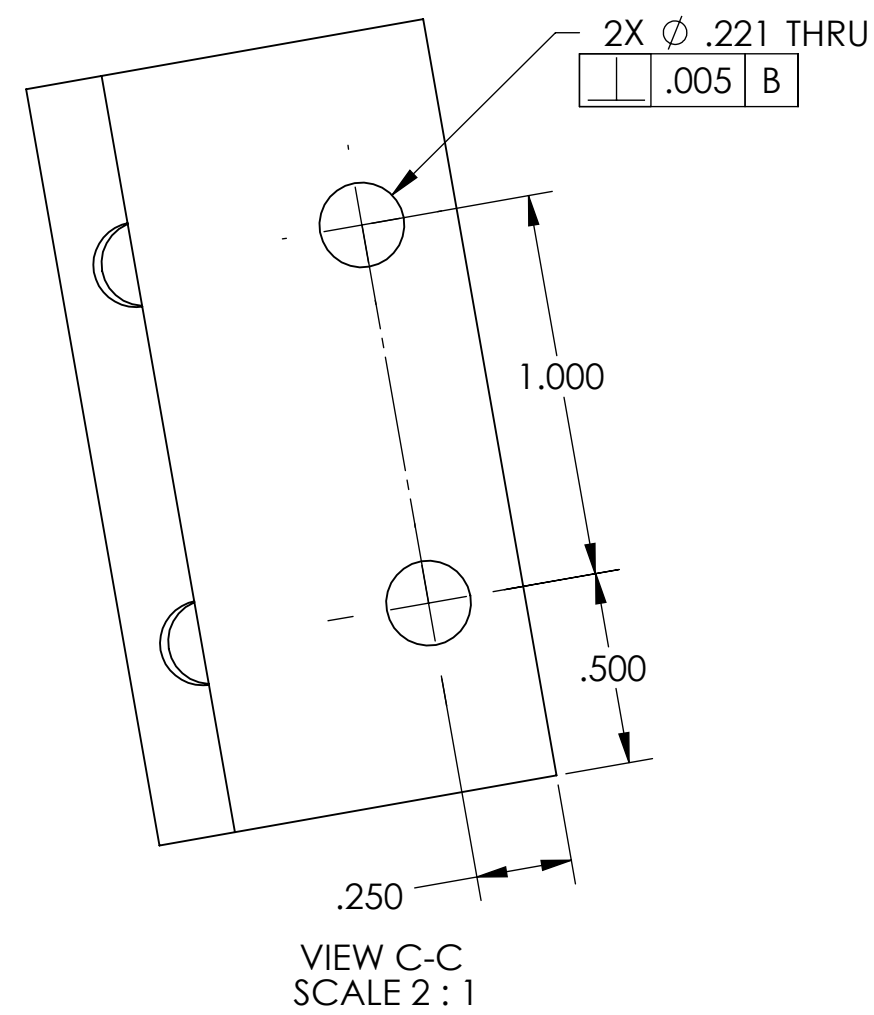


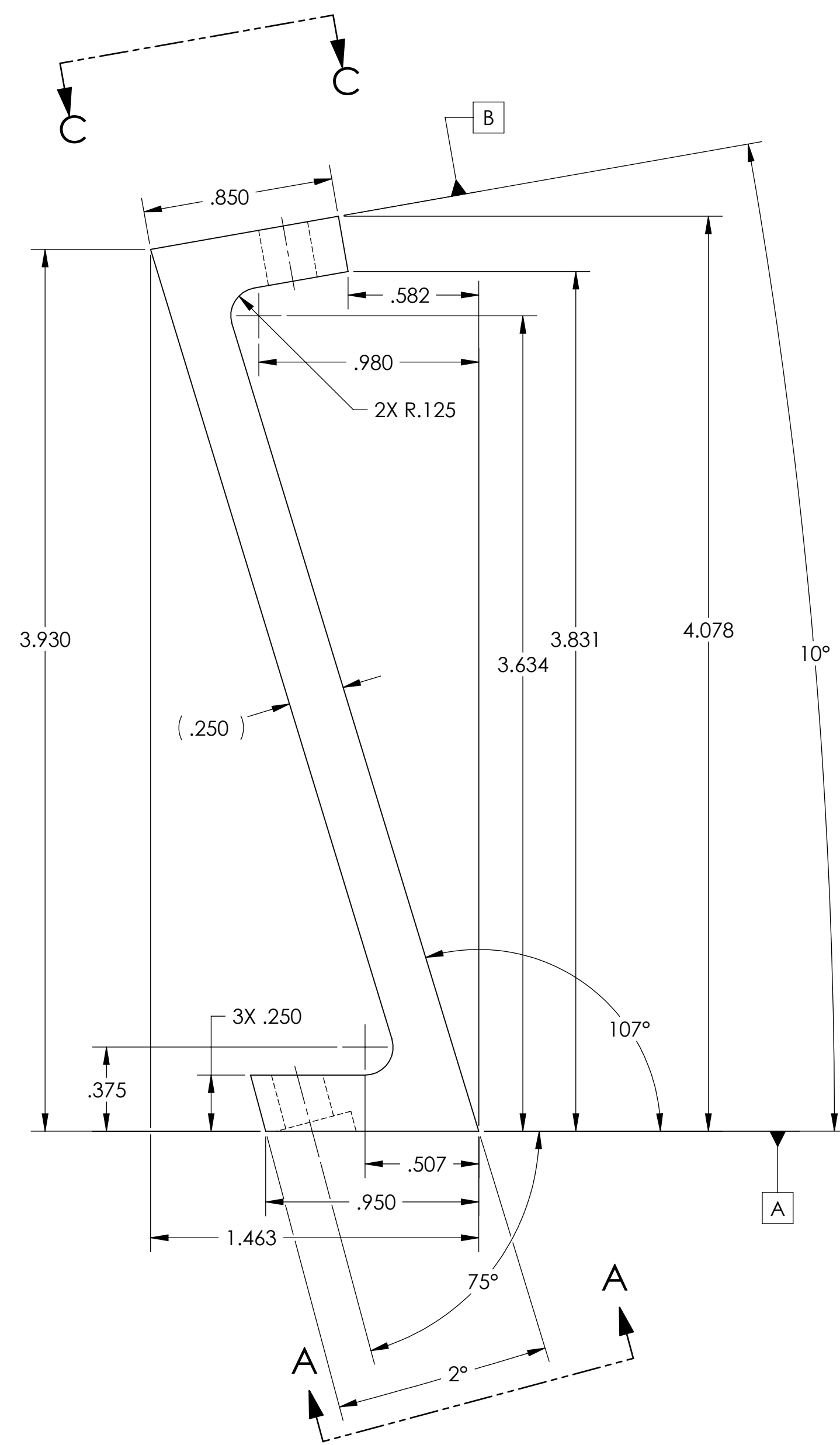
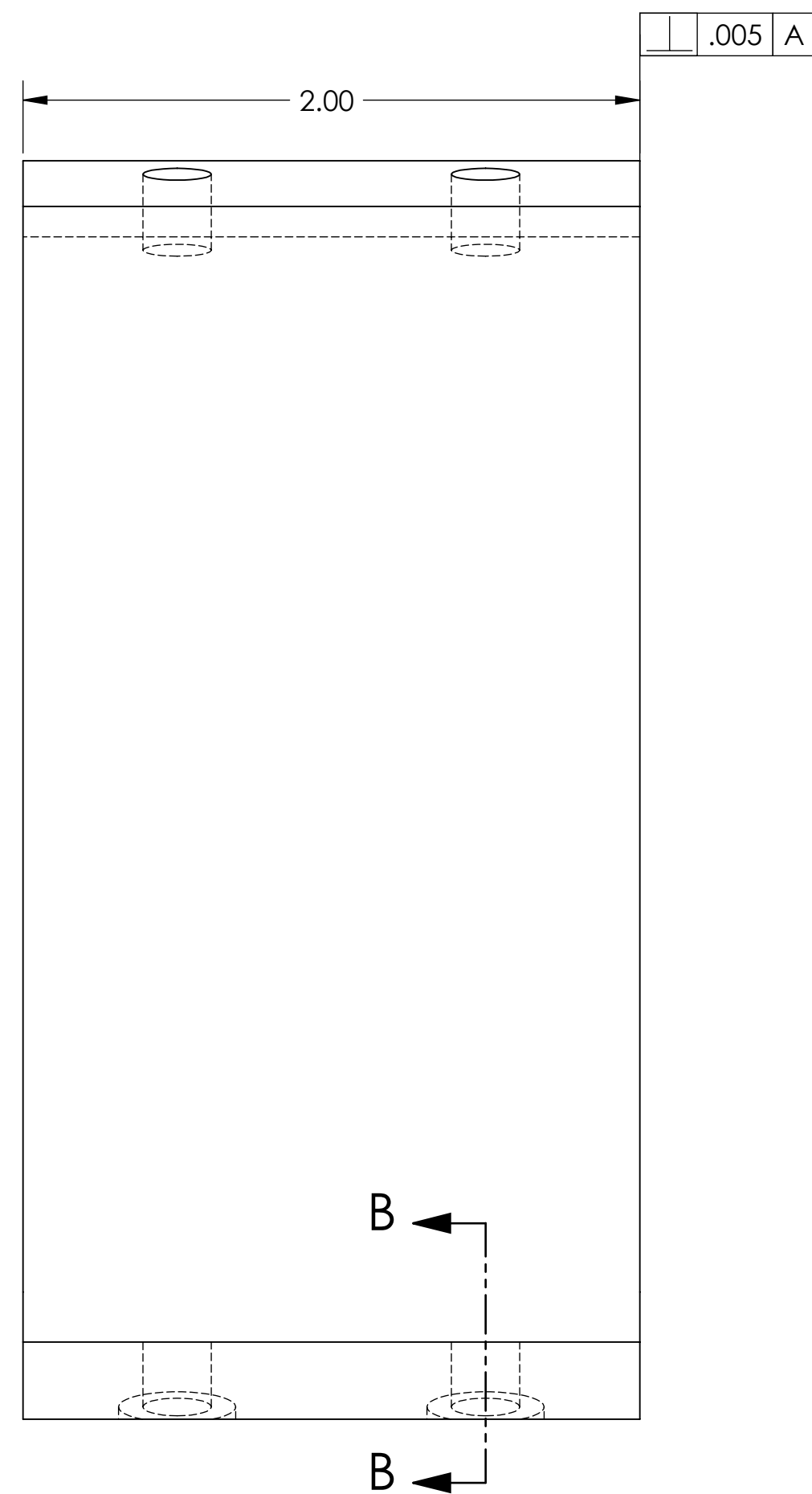
NOTES: UNLESS OTHERWISE SPECIFIED

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES 0.005" to 0.015".
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. REFER TO LIGO E0900237 FOR LIST OF APPROVED COOLANTS.
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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. 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. REFER TO LIGO-E0900364
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

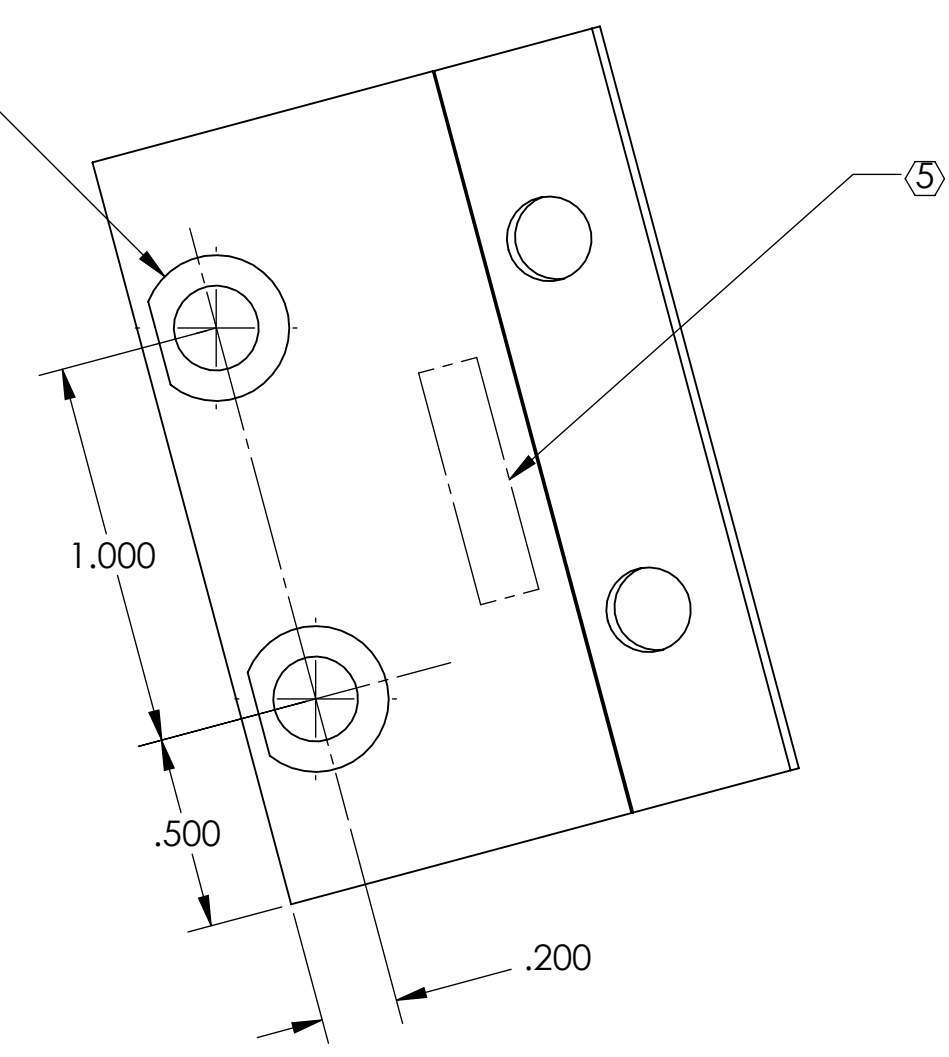
REV.	DATE	DCN #	DRAWING TREE #
v1	19 MAY 2011	E1000822-v1	-
-	-	-	-
-	-	-	-



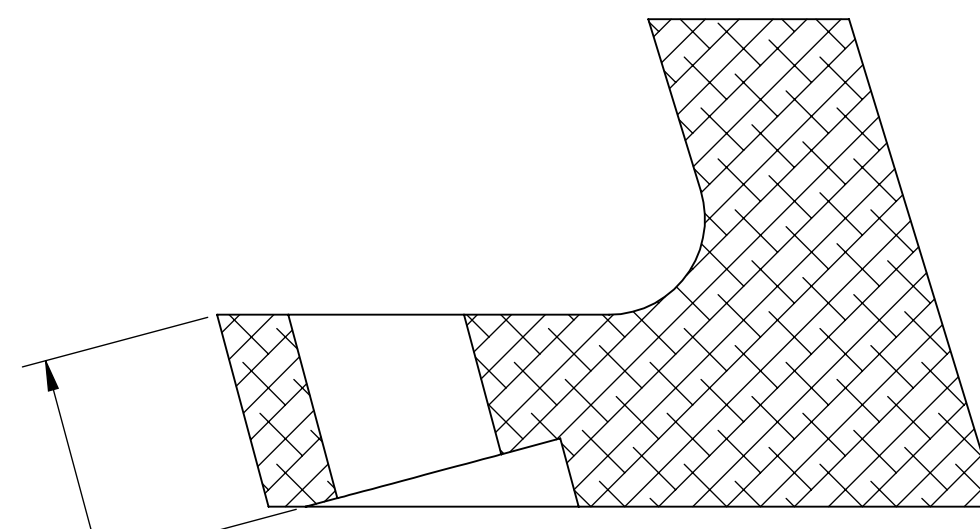
GENERAL VIEW FOR REFERENCE ONLY NO SCALE



2X Ø .221 ∇ .50
 \square Ø .38
 SEE SECTION B-B FOR COUNTERBORE DEPTH



VIEW A-A



.27
 FLAT CLEARANCE FOR #10 SOCKET HEAD CAP SCREW

SECTION B-B SCALE 4:1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY				PART NAME					
DIMENSIONS ARE IN INCHES								STANDOFF SPACER_RIGHT					
TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°								SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS		DESIGNER H. KELMAN	8 OTC 2010
MATERIAL 6061-T6 Al				FINISH 63 μ inch		NEXT ASSY D1002863		DRAFTER TG. NGUYEN	9 NOV 2010	SCALE: 2:1		PROJECTION:	SHEET 1 OF 1
								CHECKER M. SMITH					
								APPROVAL D. COYNE					