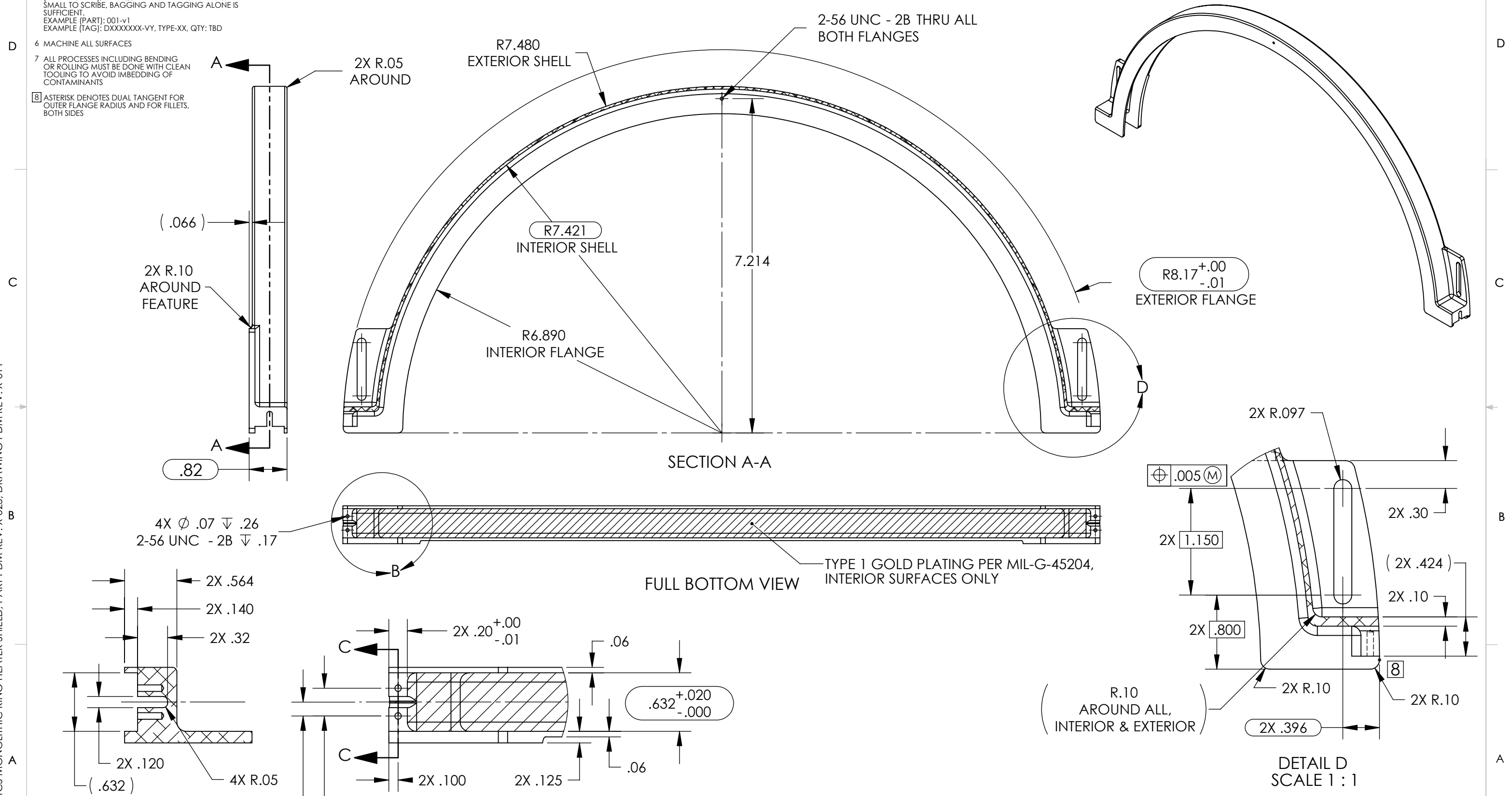


D1000969_dLIGO TCS MONOLITHIC RING HEATER SHIELD, PART PDM REV: X-025, DRAWING PDM REV: X-011

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 MACHINE ALL SURFACES
 7 ALL PROCESSES INCLUDING BENDING OR ROLLING MUST BE DONE WITH CLEAN TOOLING TO AVOID IMBEDDING OF CONTAMINANTS
 8 ASTERISK DENOTES DUAL TANGENT FOR OUTER FLANGE RADIUS AND FOR FILLETS, BOTH SIDES

REV.	DATE	DCN #	DRAWING TREE #
v2	07 MAY 2010	E1000154-v1	-
-	-	-	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES, R.02 MIN.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN INCHES [MM]

TOLERANCES:
 .XX ± .01
 .XXX ± .005

ANGULAR ± 0.5°

MATERIAL	6061 Alloy	FINISH	32 μinch
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME aLIGO TCS MONOLITHIC RING HEATER SHIELD	
SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS	DESIGNER M. JACOBSON 21 APR 2010	SIZE DWG. NO. B D1000969
DRAFTER M. JACOBSON 26 APR 2010	CHECKER C. TORRIE 27 APR 2010	APPROVAL P. WILLEMS 7 MAY 2010	REV. v2
NEXT ASSY D1000978		SCALE: 1:2	PROJECTION:
			SHEET 1 OF 1