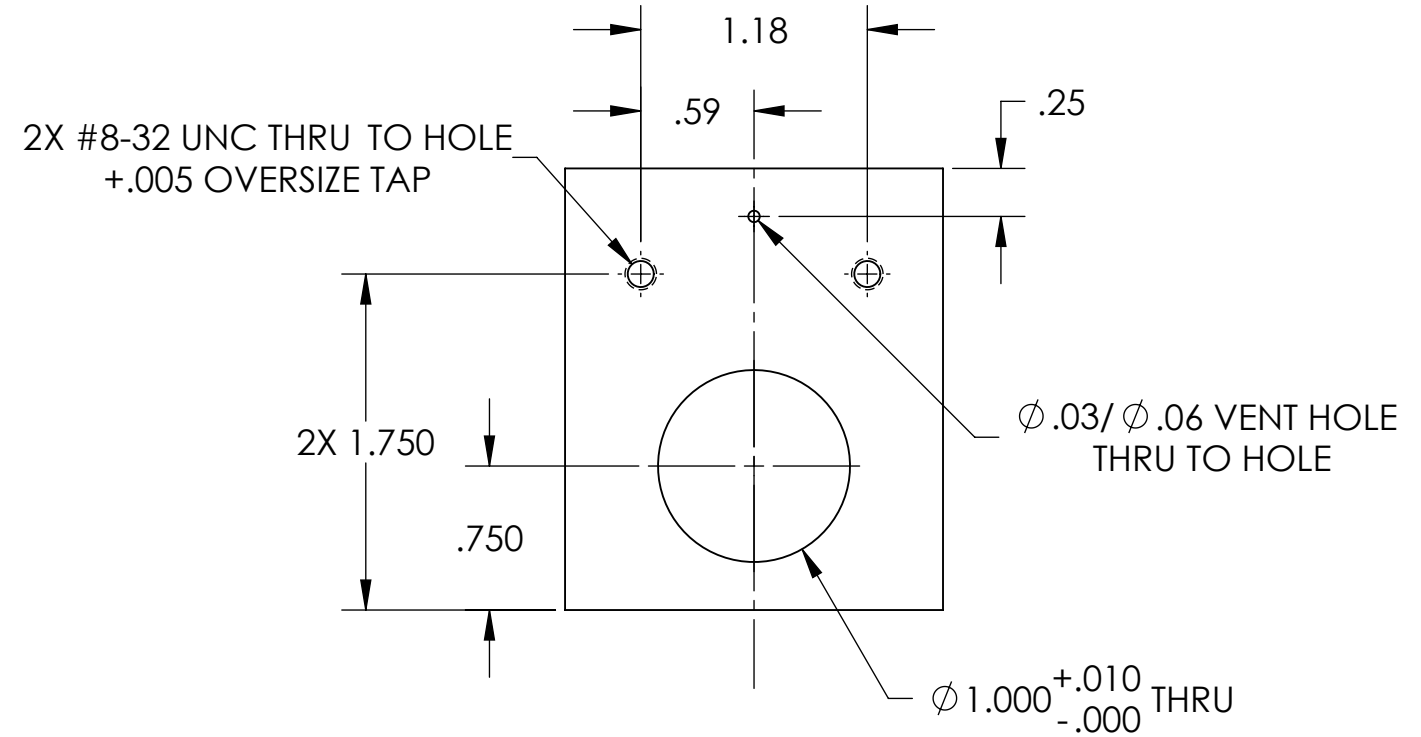
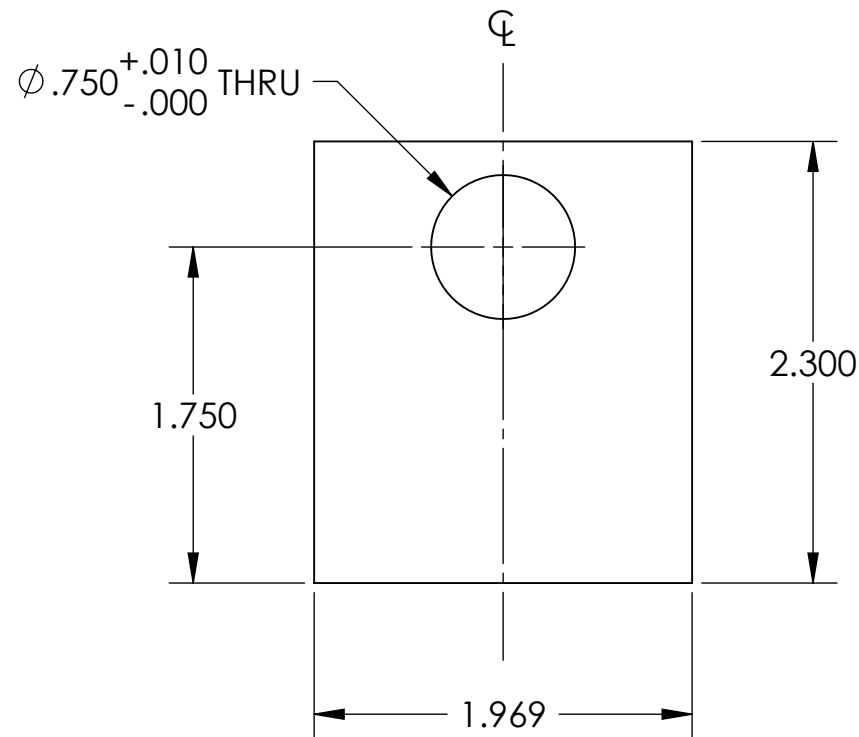
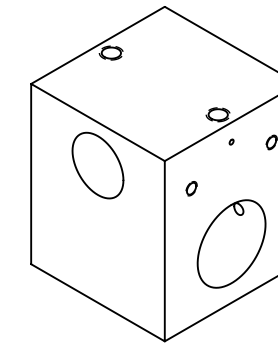
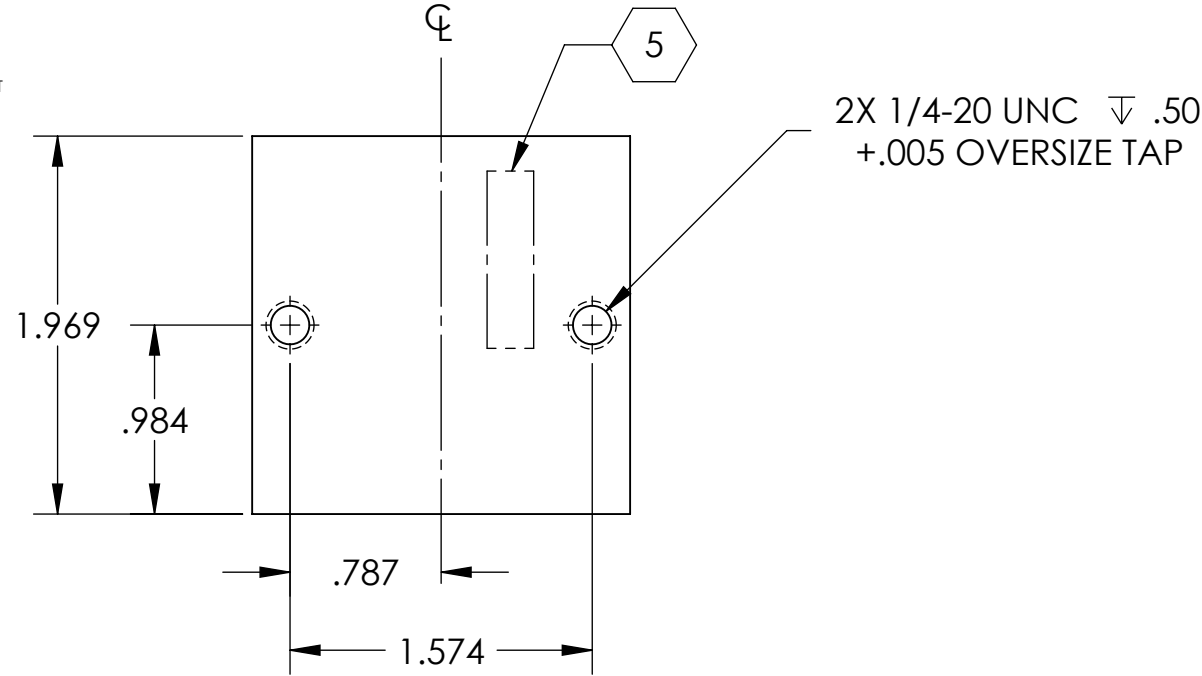


D020136_TSECTION_FOR_UPPERMASS, PART PDM REV: X-013, DRAWING PDM REV: X-007

NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, 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 101 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS. UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. APPROXIMATE WEIGHT = 1.852 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.
- 9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
- 10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

REV.	DATE	DCN #	DRAWING TREE #
A	24 JUN 2004	E040303-00	-
v1	09 JUL 2010	E0900501	E0900353
-	-	-	-

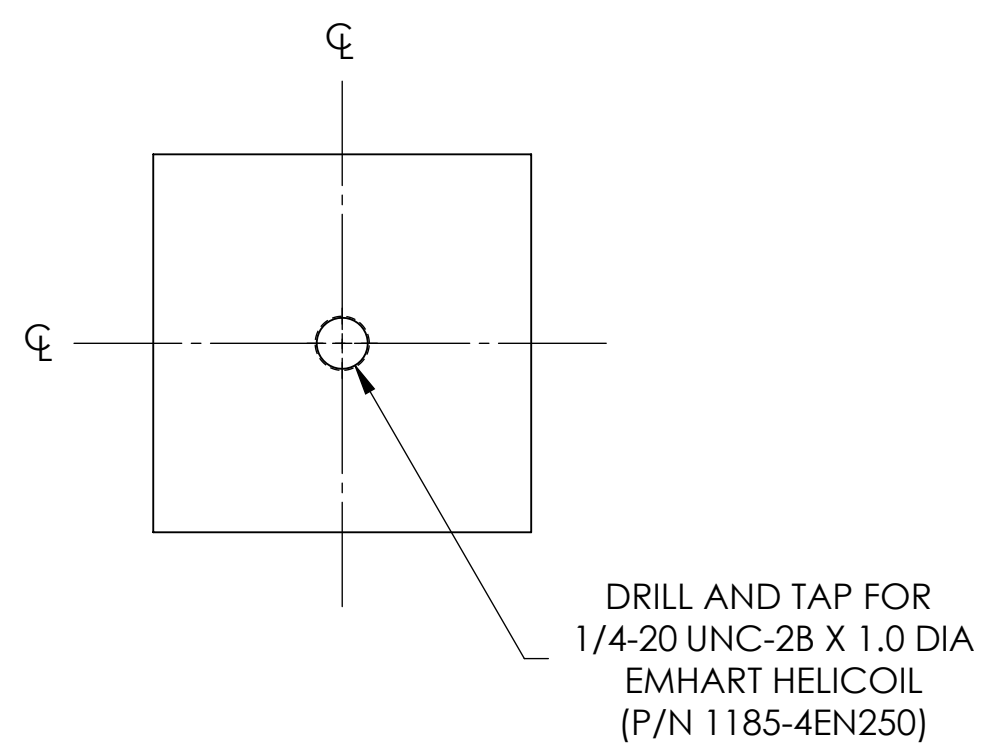
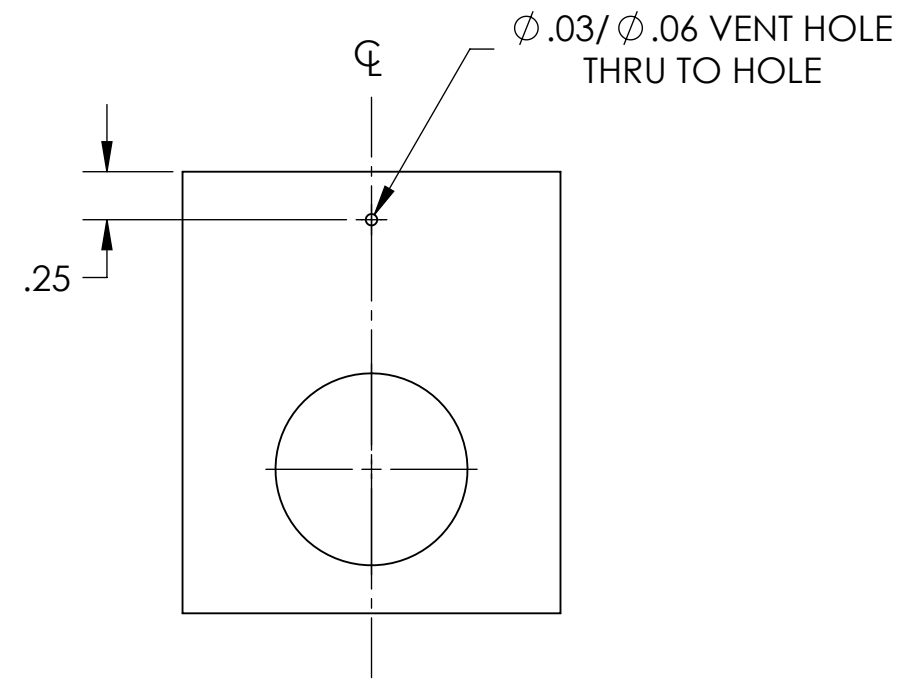
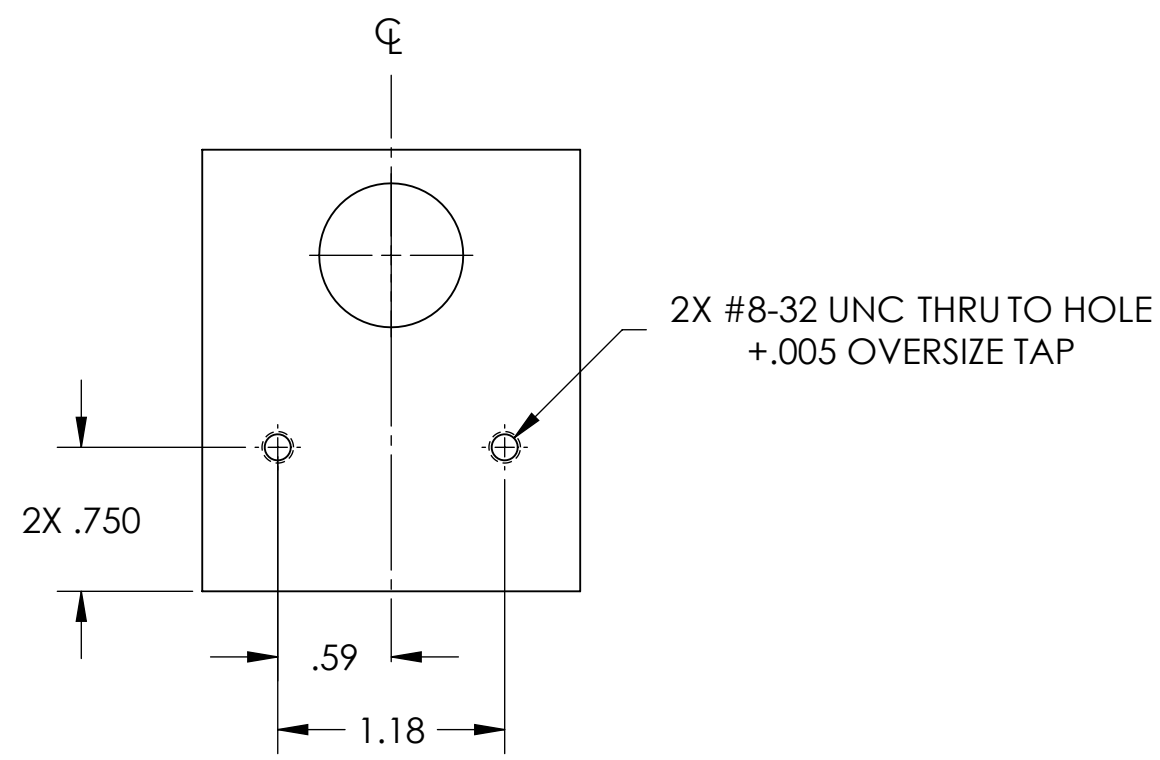




NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX \pm .01 .XXX \pm .005	
ANGULAR \pm 0.5°	
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.	
MATERIAL	FINISH
304, 316 OR 302 SSSL	32 μ inch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
ADVANCED LIGO		T-SECTION FOR UPPER MASS	
DESIGNER	C. TORRIE	01 MAY 2002	SIZE
DRAFTER	B. MOORE	11 NOV 2009	DWG. NO.
CHECKER	M. MEYER	22 JAN 2010	B
APPROVAL			D020136
NEXT ASSY		REV.	
D020534		v1	
SCALE: 1:1		PROJECTION:	
		SHEET 1 OF 2	

D020136_ISECTION_FOR_UPPERMASS, PART PDM REV: X-013, DRAWING PDM REV: X-007



 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE B	DWG. NO. D020136
SCALE: 1:1	REV. v1
PROJECTION: 	SHEET 2 OF 2