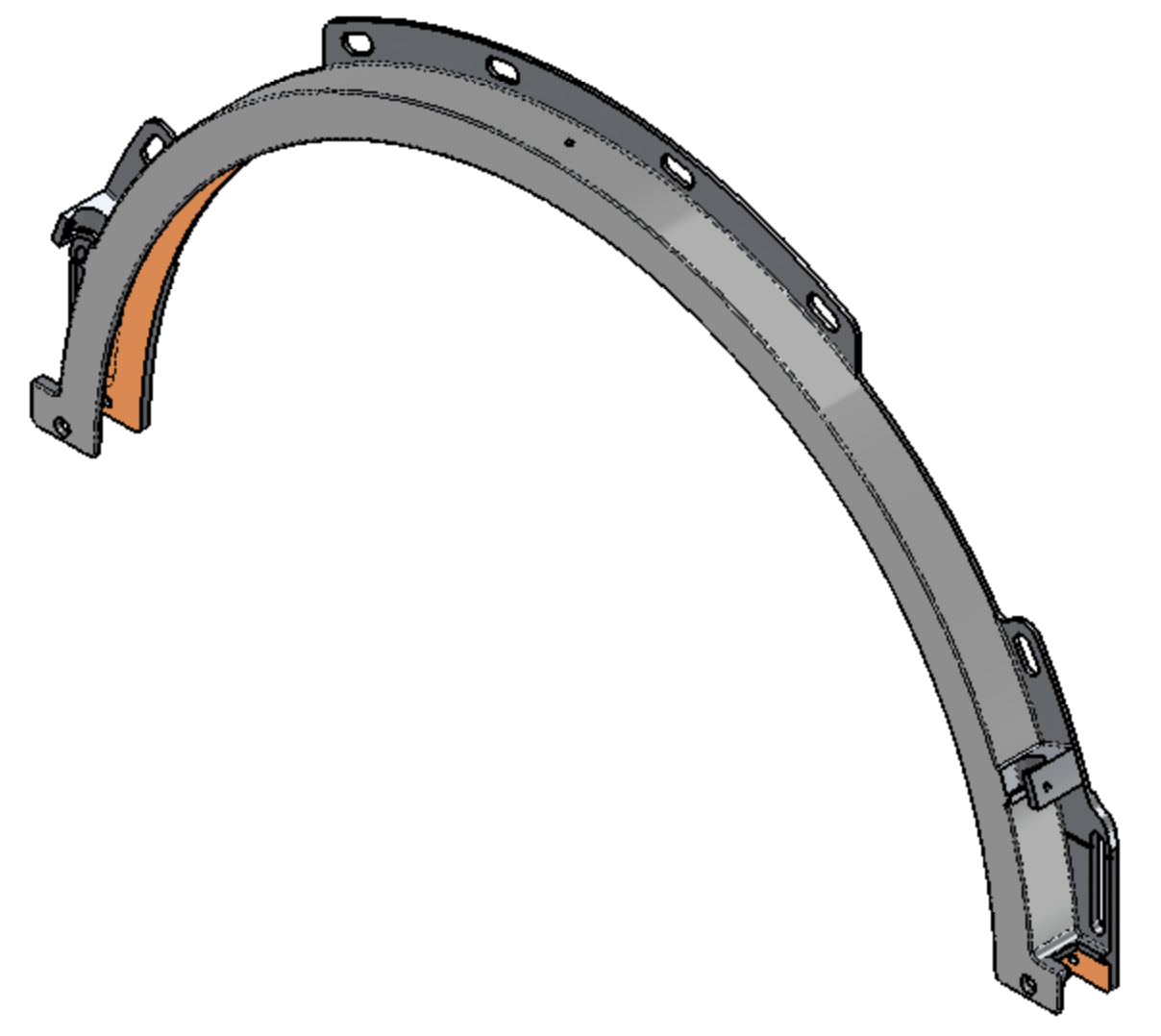
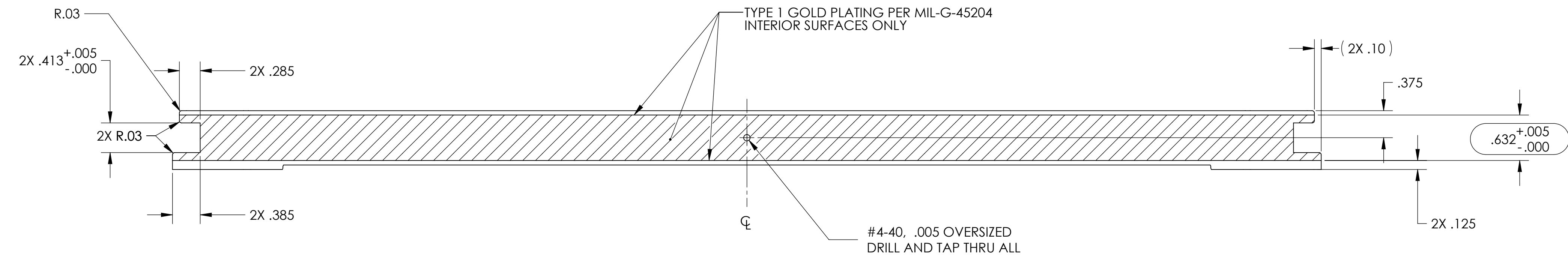
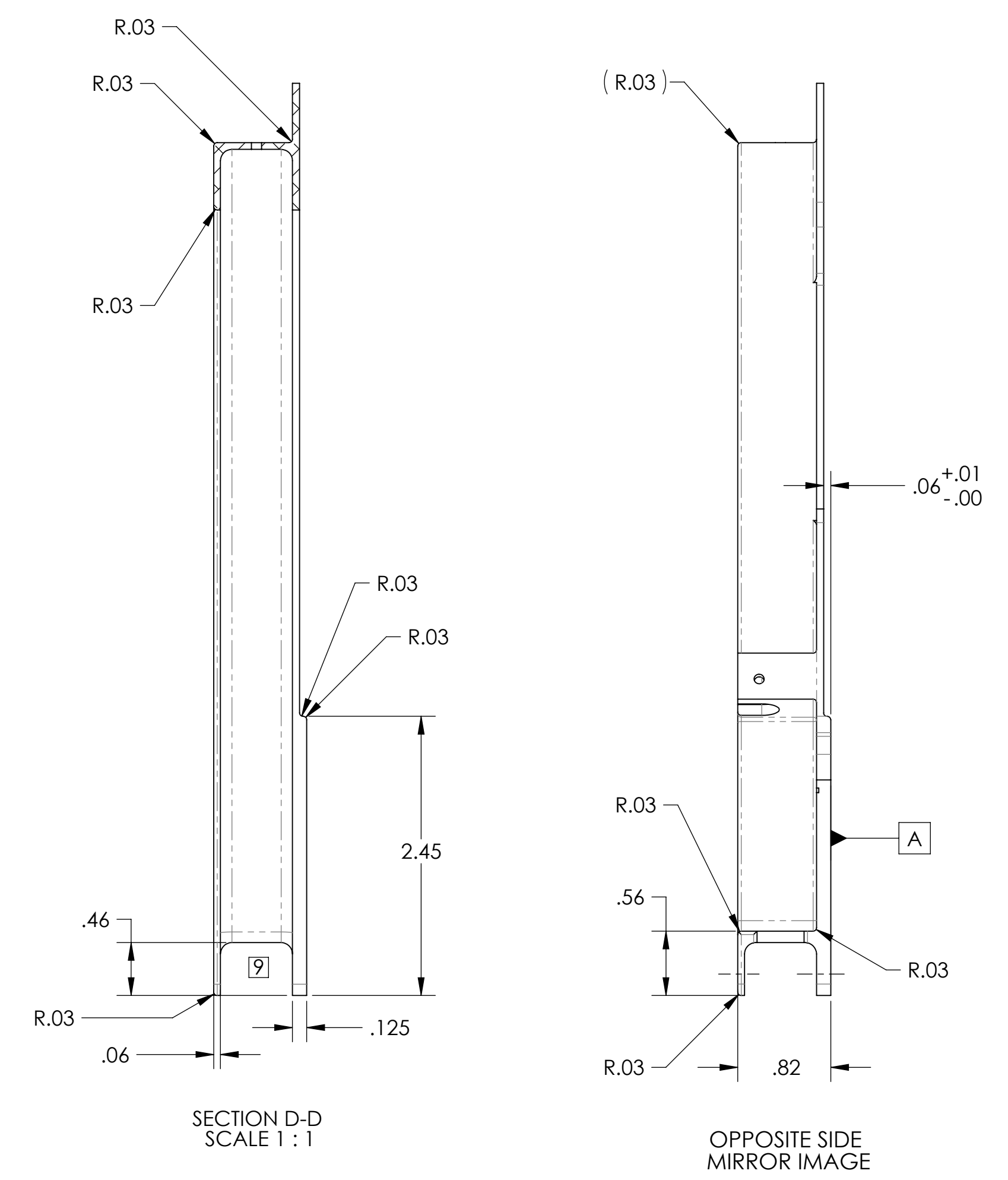
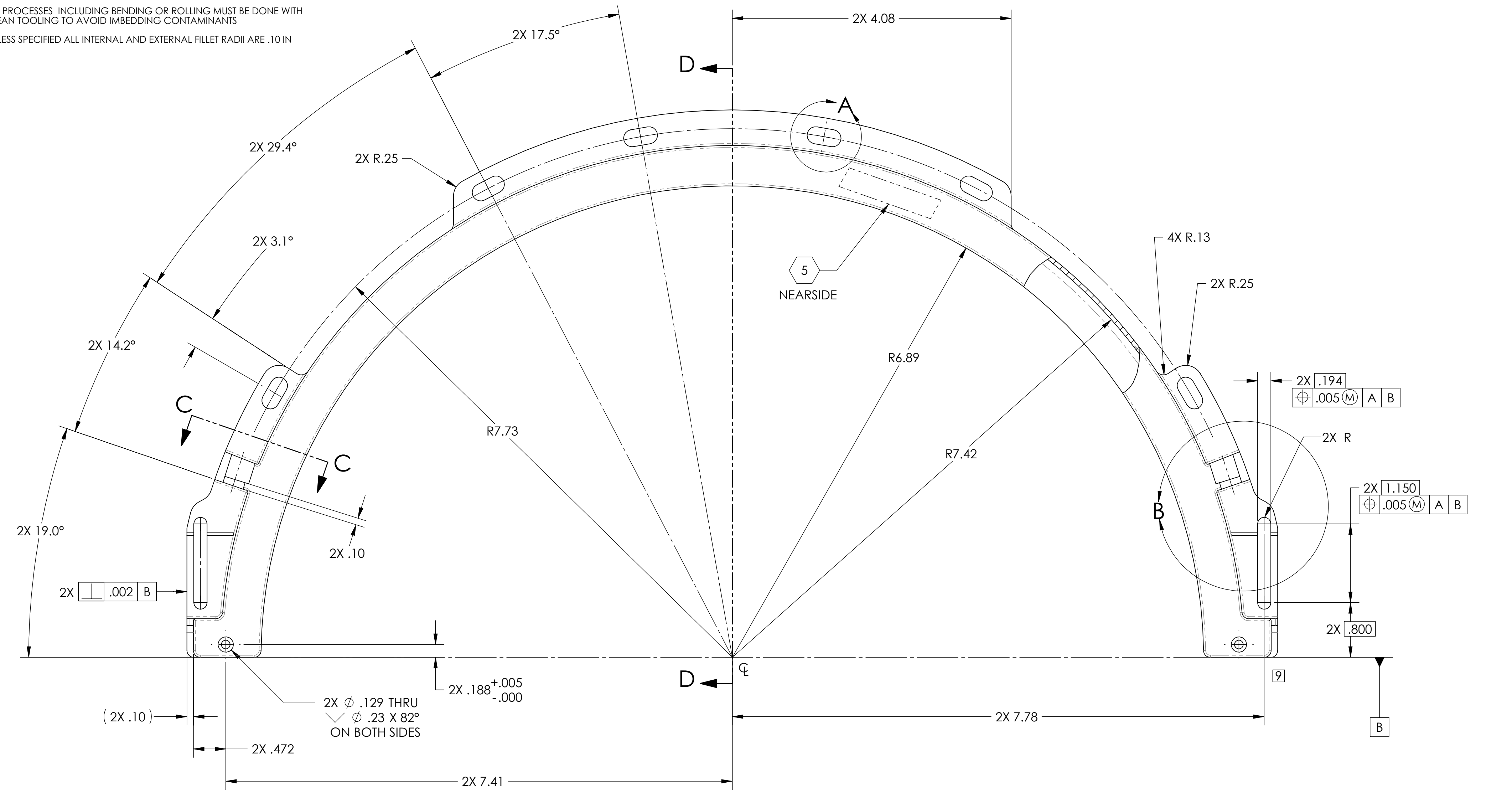


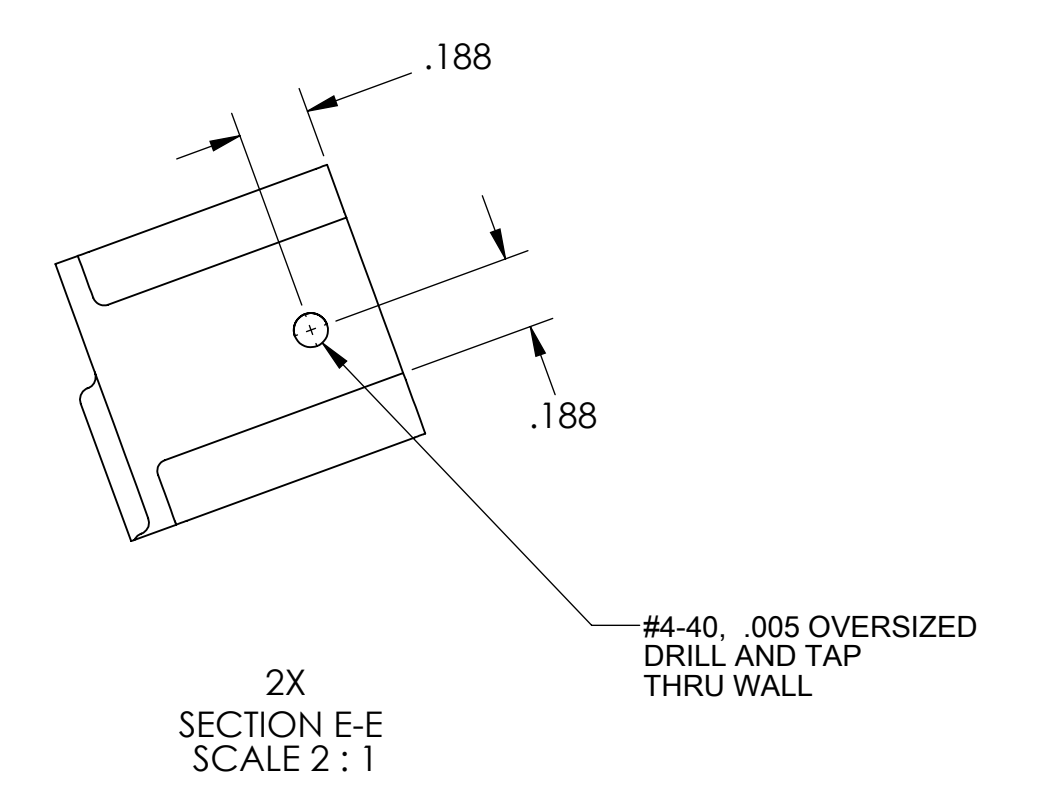
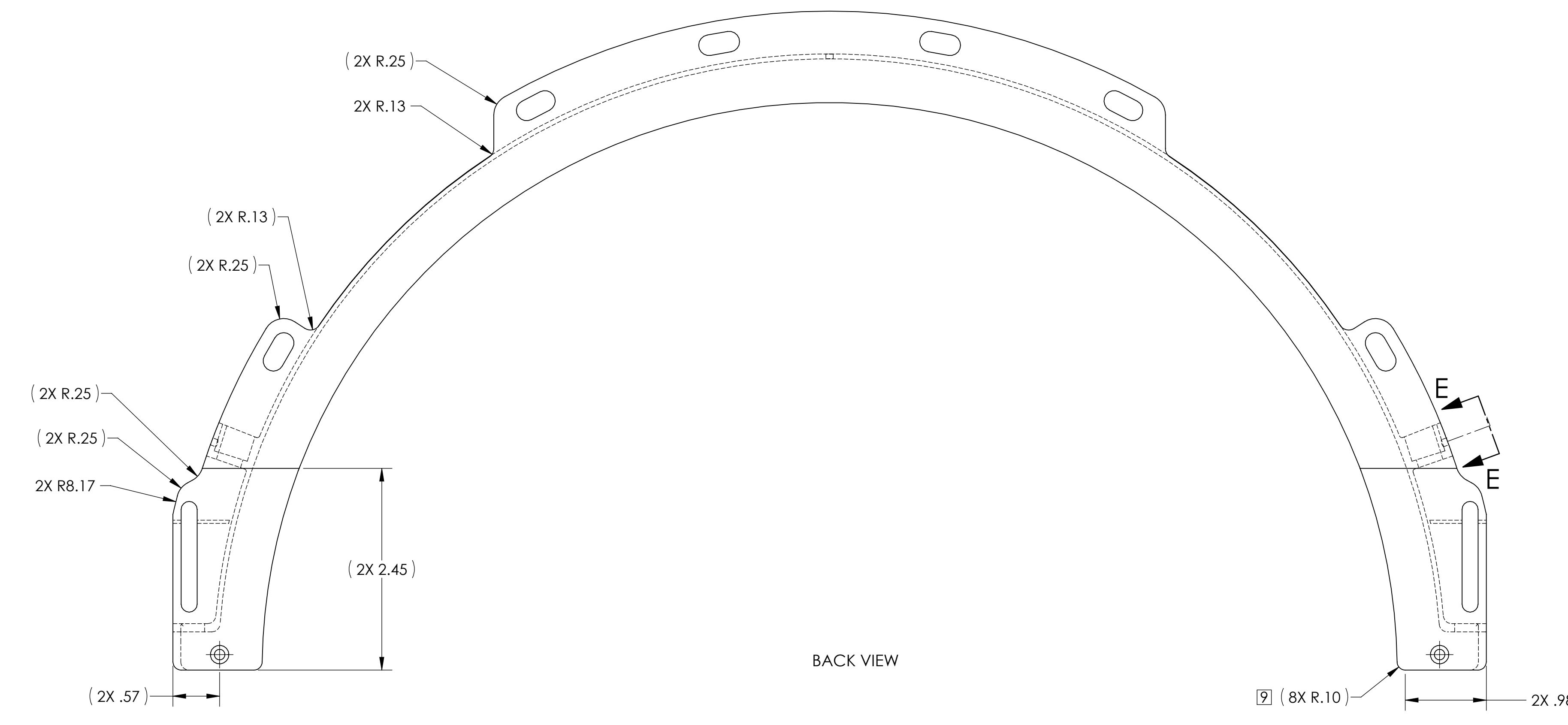
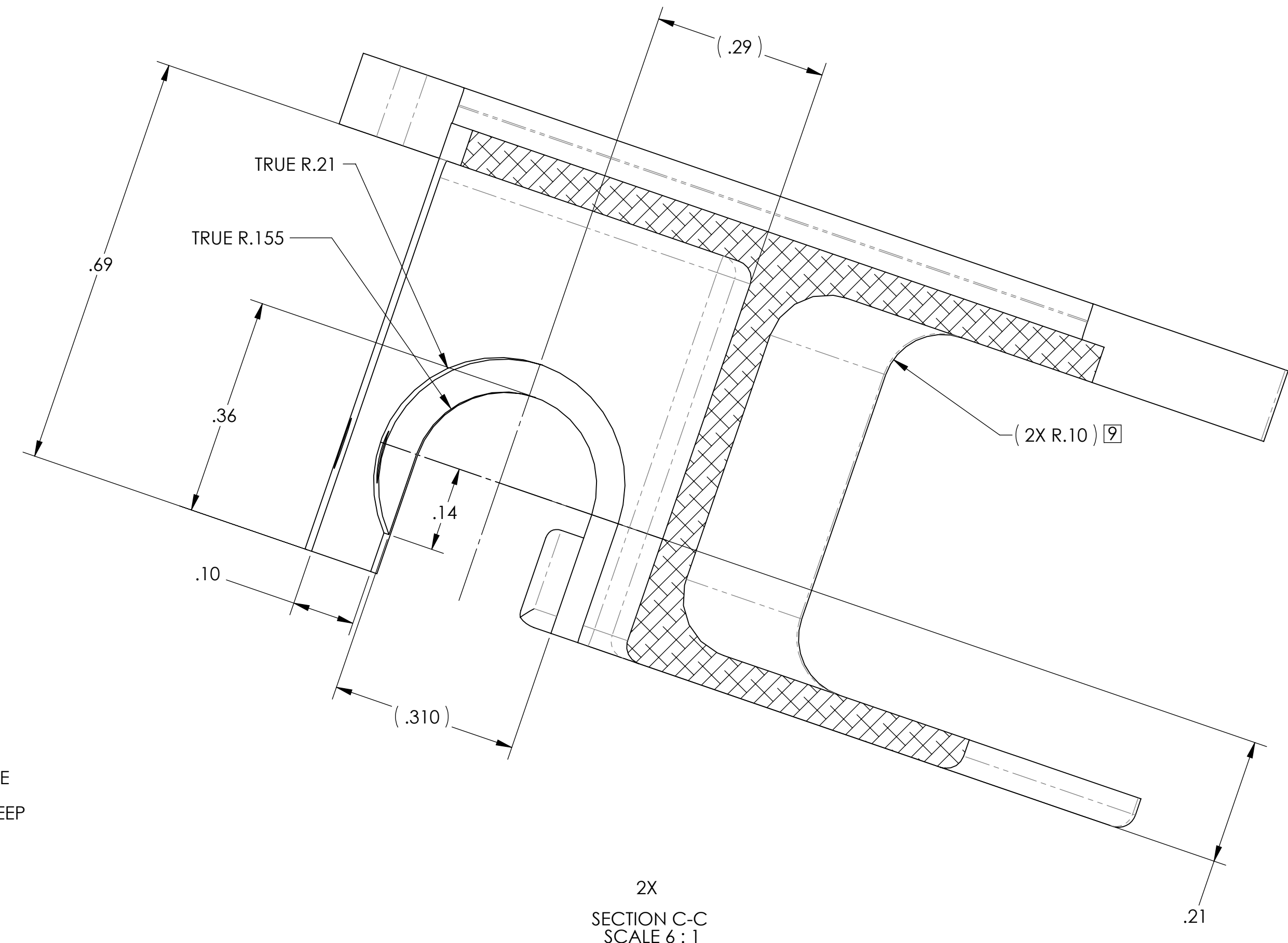
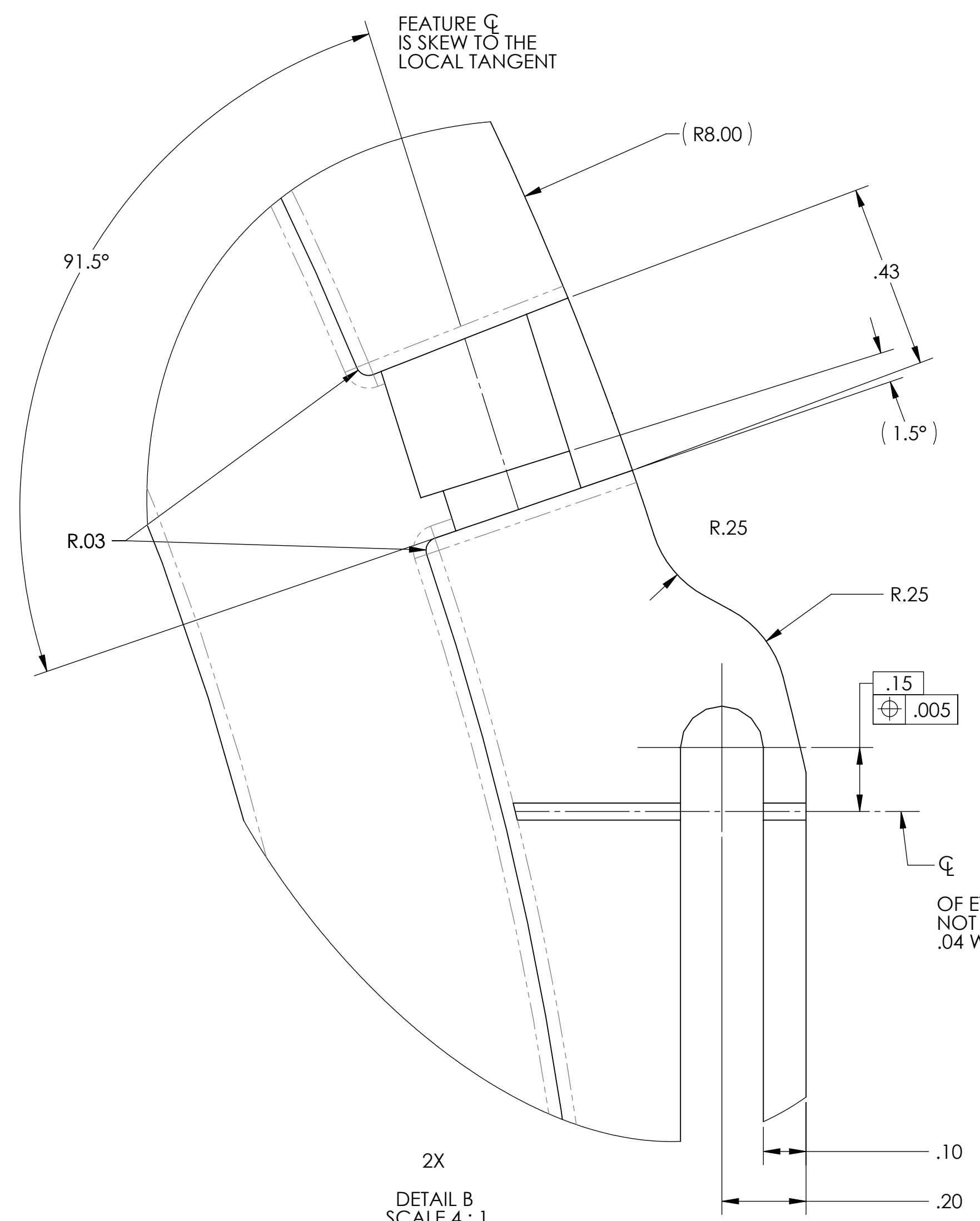
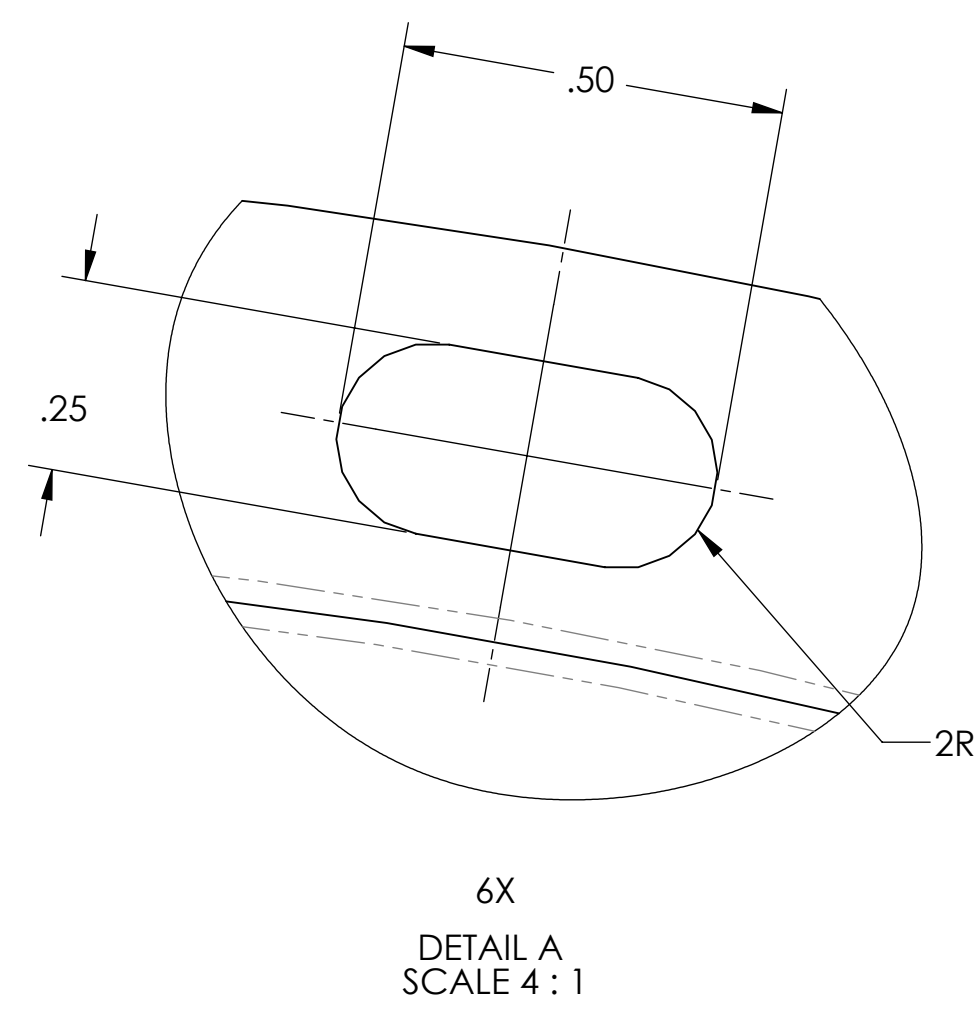
- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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.
 - 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - 8. ALL PROCESSES INCLUDING BENDING OR ROLLING MUST BE DONE WITH CLEAN TOOLING TO AVOID IMBEDDING CONTAMINANTS
 - 9. UNLESS SPECIFIED ALL INTERNAL AND EXTERNAL FILLET RADII ARE .10 IN

REV.	DATE	DCN #	DRAWING TREE #
v1	04-AUG-2010	E1000291-v1	E1000295-v1
v2	20-OCT-2010	E1000291-v2	E1000295-v3
v3	16-NOV-2010	E1000291-v3	E1000295-v4
v4	03-DEC-2010	E1000291-v4	E1000295-v5
v5	28-FEB-2010	E1000291-v6	E1000295-v7



DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± .01 .XXX ± .005		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.		ADVANCED LIGO		aLIGO TCS UPPER MONOLITHIC RH SHIELD	
ANGULAR ± 0.5°		MATERIAL: 6061 Alloy		FINISH: 32 μinch		NEXT ASSY: D1001838	
				DESIGNER: M. JACOBSON 21 APR 2010 DRAFTER: A. COLE 7/13/2010 CHECKER: C. TORRIE 07/19/2010 APPROVAL: P. WILLEMS 3/03/2011		SIZE: D DWG. NO.: D1001679 SCALE: 1:2 PROJECTION:	
						REV. v5 SHEET 1 OF 2	

D1001679_ALIGO TCS UPPER MONOLITHIC RH SHIELD PART PDM REV. X.042 DRAWING PDM REV. X.037



LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE DWG. NO.	REV.
D D1001679	v5
SCALE: 1:2	PROJECTION:

SHEET 2 OF 2

D1001679_ALIGO_TCS_UPPER_MONOLITHIC_RING_HEATER_SHIELD_PART_PDM_REV_X3042_DRAWING_PDM_REV_X037