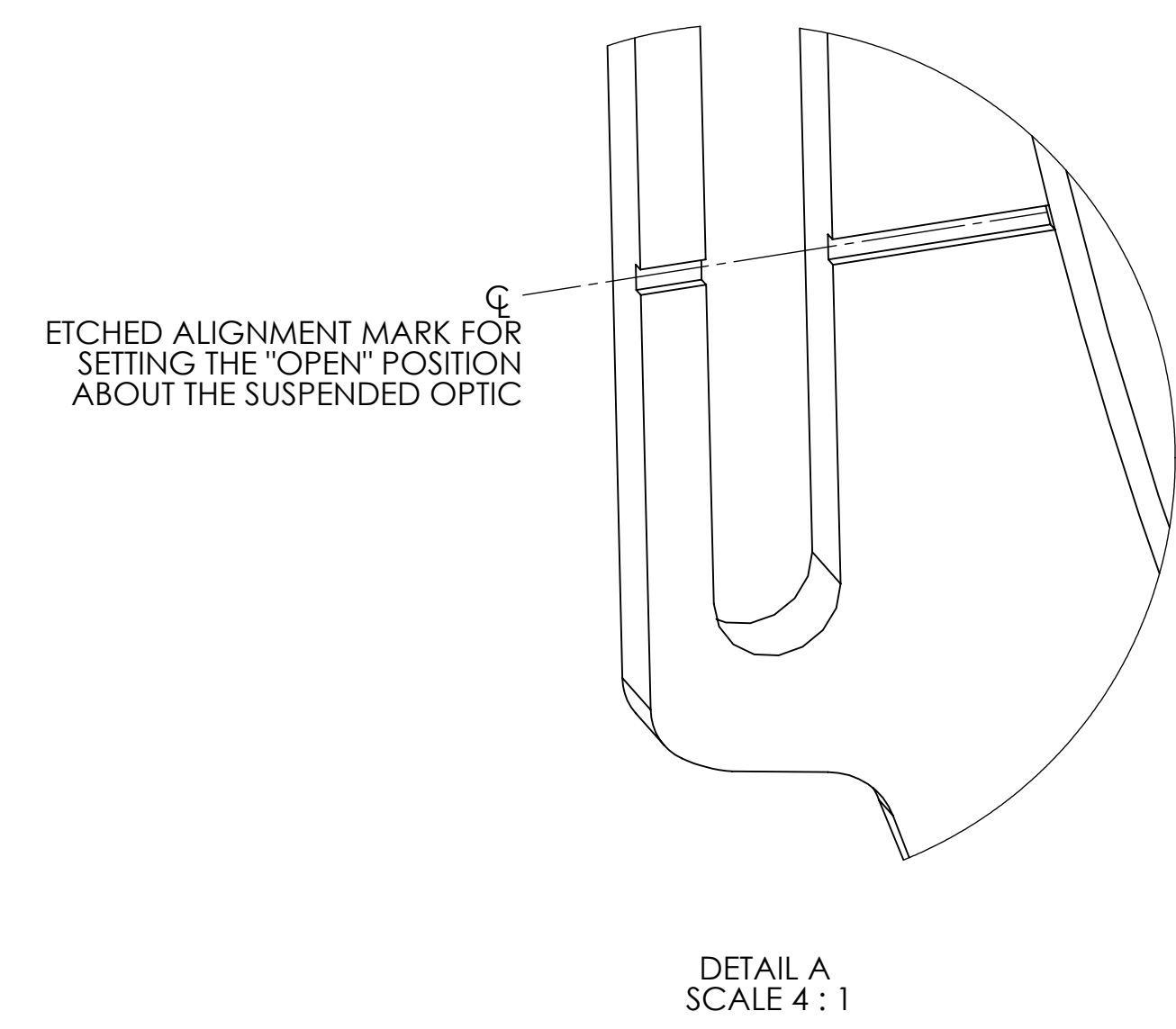
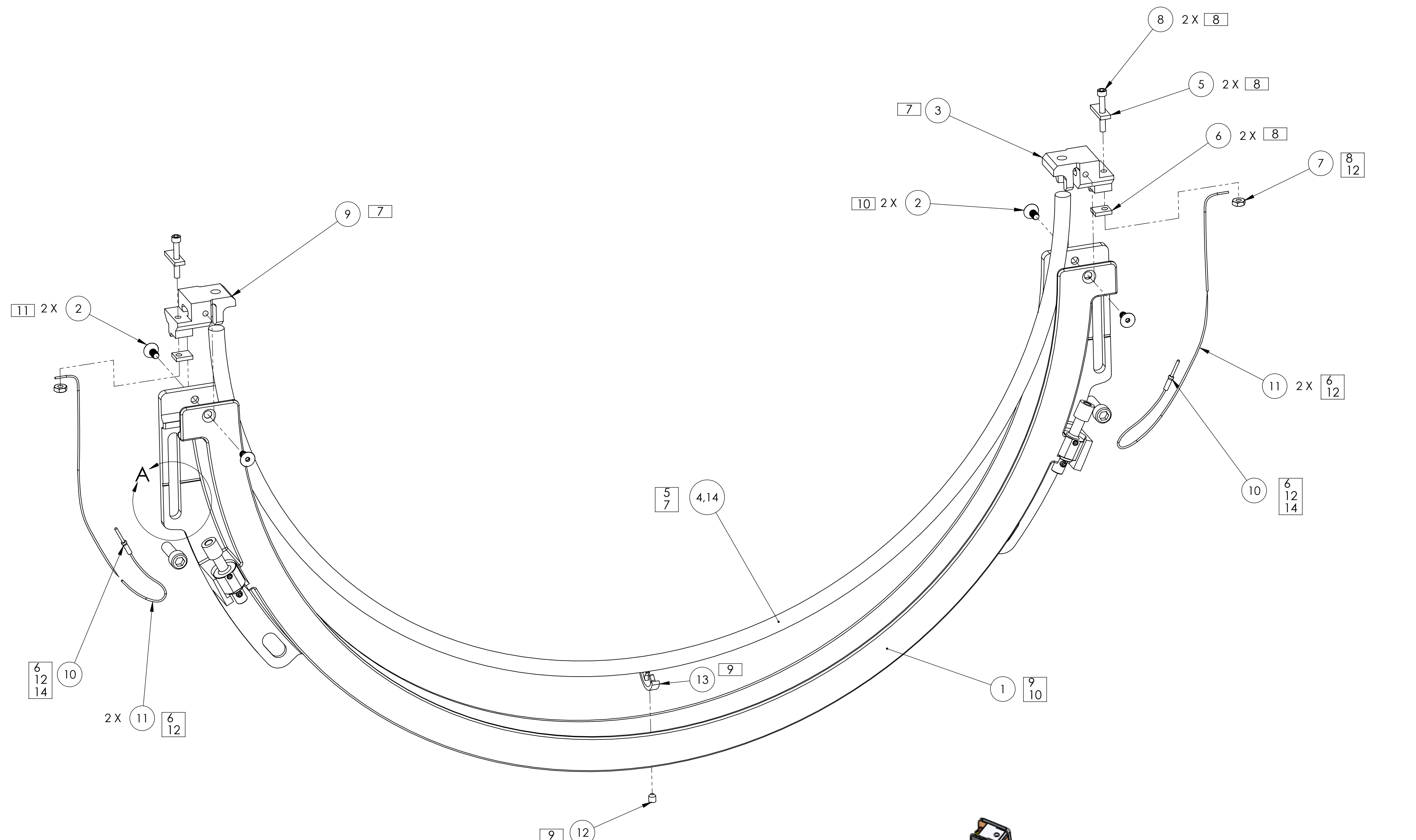


REV.	DATE	DCN #	DRAWING TREE #
v1	04-AUG-2010	E1000291	E1000295-v1
v2	17-NOV-2010	E1000291-v3	E1000295-v4
v3	03-DEC-2010	E1000291-v4	E1000295-v5
v4	06-JAN-2011	E1000291-v5	E1000295-v6



- NOTES CONTINUED:**
- ITEM 16 IS NOT DEPECTED; IT IS PRE-FORMED USING LIGO-D1002047 AND SLEEVED ONTO ITEM 4 PRIOR TO ASSEMBLY
 - ASSEMBLY STEP 1: TWO PIECES OF ITEM 11 ARE PRE-STRIPPED AND CRIMPED INTO ITEM 10
 - ASSEMBLY STEP 2: ITEMS 4 AND 16 ARE SET INTO ITEMS 3 AND 9
 - ASSEMBLY STEP 3: ITEM 16 IS WOUND ABOUT THE STEM OF ITEM 8 AND SECURED AGAINST ITEM 5 BY TIGHTENING ITEM 7
 - ASSEMBLY STEP 4: EITHER ITEM 13 OR ITEM 14 IS SECURED TO ITEM 1 USING ITEM 12
 - ASSEMBLY STEP 5: ITEM 1 IS BROUGHT INTO PLACE AND 2X ITEM 2 ARE SECURED INTO ITEM 3
 - ASSEMBLY STEP 6: ITEM 1 IS PIVOTED INTO PLACE ABOUT ITEM 9 AND 2X ITEM 2 ARE SECURED INTO ITEM 9
 - ASSEMBLY STEP 7: ITEM 7 IS USED TO SECURE THE COMBINED ITEMS 10 AND 11 AGAINST ITEM 6
 - SUBSYSTEM INTEGRATION STEP 1: TWO #8-32 ARE USED TO SECURE THE ASSEMBLY INTO PLACE
 - SUBSYSTEM INTEGRATION STEP 2: ITEM 10 IS SECURED INTO EACH OF THE JOINTS J5 AND J6 OF ASSEMBLY D1001517

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
14	MM 8880K52	24AWG NICHROME WIRE, PRE-CUT	CHROMEL-C	20 FT	20 FT	40 FT
13	D1003009	RH ELEMENT SPACER WHEEL	Ceramic Porcelain	1	0	1
12	T-402	SCREW, SOCKET SET, #4-40 UNC-2A X 0.125 LONG	18-8 SS	1	0	1
11	CZ1105	28 AWG PFA COATED COPPER WIRE, 2X 2X 9-IN, PRE-STRIPPED	PFA Coated Cu	18 IN	9 IN	27 IN
10	100170	Pin Contact, 10-24 AWG, AccuGlass	Copper	1	2	3
9	D1002544	RH ELEMENT CONNECTOR, SIMPLIFIED RIGHT	Ceramic Porcelain	1	0	1
8	C-210-N	SCREW, SOCKET HEAD CAP, #2-56 UNC-2A X 0.625 LONG	18-8 SS	2	2	4
7	N-256-A	HEX NUT #2-56 UNC 2B, UC COMPONENTS	18-8 SS, Ag Plated	2	2	4
6	D1001849	UPPER COPPER PLATE	Copper	2	2	4
5	D1001850	LOWER COPPER PLATE	Copper	2	2	4
4	D1002538	SIMPLIFIED GLASS FORMER	Glass	1	1	2
3	D1002543	RH ELEMENT CONNECTOR, SIMPLIFIED LEFT	Ceramic Porcelain	1	0	1
2	FA-404	VENTED, FSHCS #4-40 UNC-2A x .25 LG, UC COMPONENTS	18-8 SS	4	2	6
1	D1001680	αLIGO TCS LOWER MONOLITHIC RH SHIELD	6061 Alloy	1	0	1

DIMENSIONS ARE IN TOLERANCES: .XX ± .XXX ± ANGULAR ± °		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) 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.		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME αLIGO TCS RING HEATER LOWER SEGMENT ASSY	
MATERIAL		FINISH		SYSTEM		SUB-SYSTEM	
N/A		N/A μinch		ADVANCED LIGO		AOS	
				NEXT ASSY		D1002027	
				DESIGNER		M. JACOBSON 26 JUL 2010	
				DRAFTER		A. COLE 30 JUL 2010	
				CHECKER		CALUM TORRIE 06 JAN 2011	
				APPROVAL		P. WILLEMS 11 JAN 2011	
				SIZE		DWG. NO.	
				D		D1001895	
				SCALE: 1:2		PROJECTION:	
				SHEET 1 OF 1		REV. v4	

D1001895 αLIGO TCS RING HEATER LOWER SEGMENT ASSY PART PDM REV: X-286 DRAWING PDM REV: X-013