
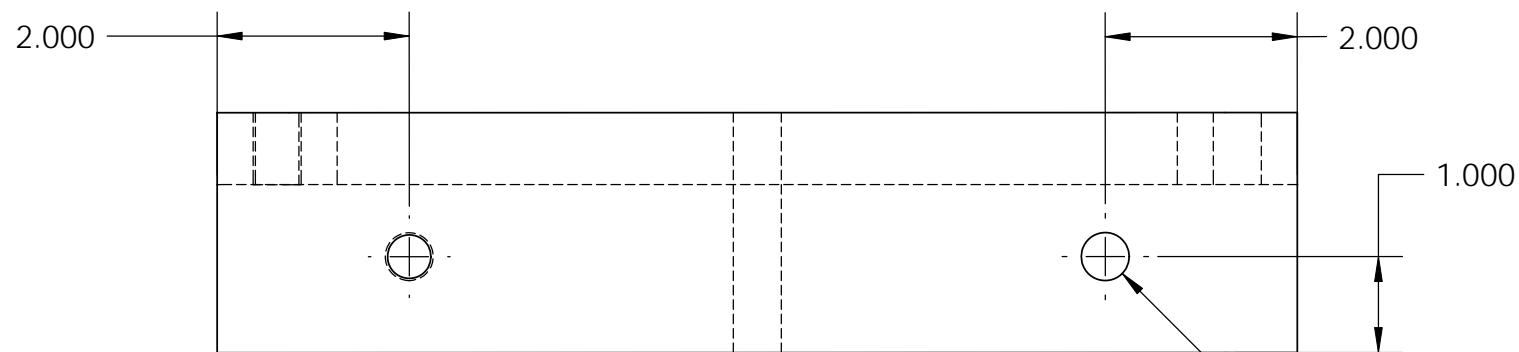
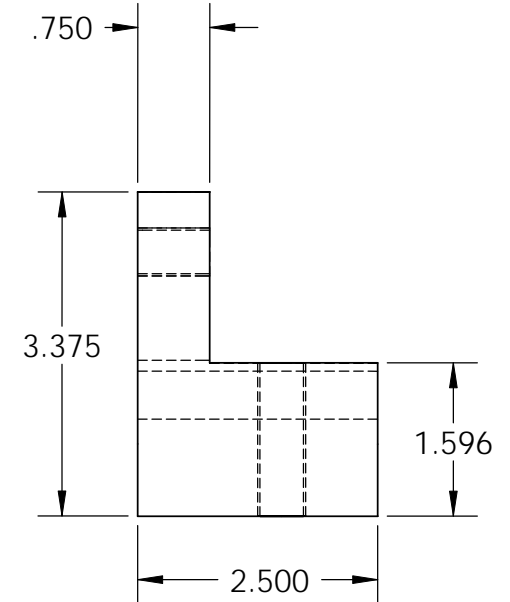
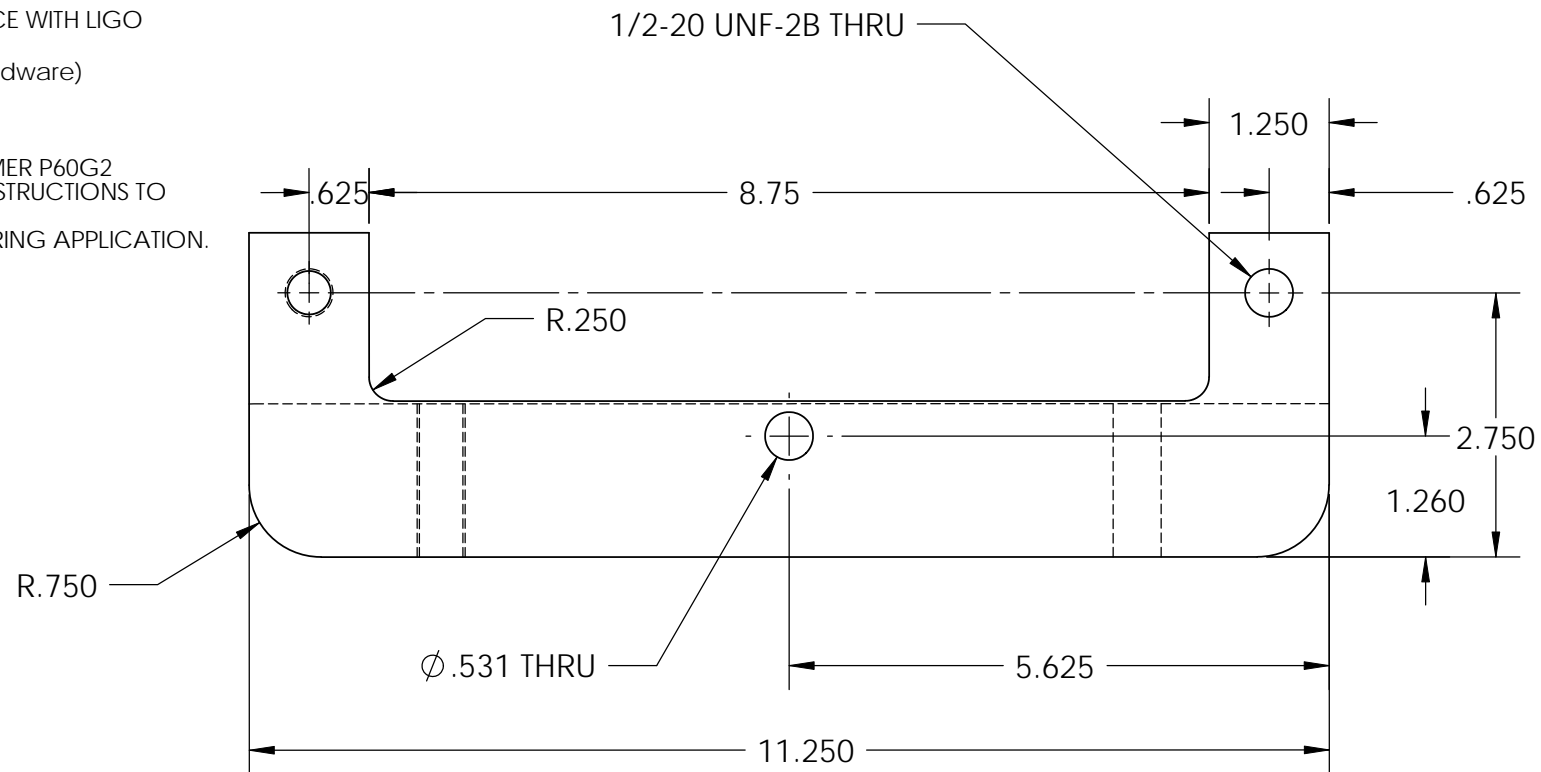


8 7 6 5 4 3 2 1

REV.	DATE	DCN #	DRAWING TREE #
v1	24 Mar. 2011	E1100015	E1100016

NOTES CONTINUED:

4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
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 001 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 DXXXXXXX-VY, TYPE-XX, S/N XXX.
6. APPROXIMATE WEIGHT = 13.21634997 LB.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. PAINT: ALL VISIBLE SURFACES (exclude fastening hardware) EXCEPT AREAS IDENTIFIED BY  M MEDIUM BLUE SHERWIN WILLIAMS (POLANE (R) T-PLUS POLYURETHANE ENAMEL) #SW-F63TX-L-2822-5864 PRIME WITH SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER P60G2
9. "OXI SOLV RUST INHIBITOR" TO BE APPLIED PER MFG. INSTRUCTIONS TO ALL UNPAINTED SURFACES. BOTH TAPPED AND THRU HOLES WILL BE PLUGGED DURING APPLICATION.



Ø .453 THRU ALL
1/2-20 UNF THRU ALL

D020269, PART PDM REV: X-005, DRAWING PDM REV: X-001

D C B A

D C B A

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES		1. INTERPRET DRAWING PER ASME Y14.5-1994.		ADVANCED LIGO		DOUBLE CLAMP	
TOLERANCES: .XX ± .015 .XXX ± .005		2. REMOVE ALL SHARP EDGES, .03 x 45°.		SEI		DESIGNER K.MASON 29 May. 2002	
ANGULAR ± .5°		3. DO NOT SCALE FROM DRAWING.		NEXT ASSY D030367		DRAFTER M.HILLARD 24 Mar. 2011	
MATERIAL AISI 1018 Steel, Cold Rolled		FINISH 63 μinch		D020269-A-SLDPRT		CHECKER K.MASON 14 Mar. 2003	
						APPROVAL K.MASON 24 Mar. 2011	
						SCALE: 1:1 PROJECTION:  SHEET 1 OF 1	

8 7 6 5 4 3 2 1