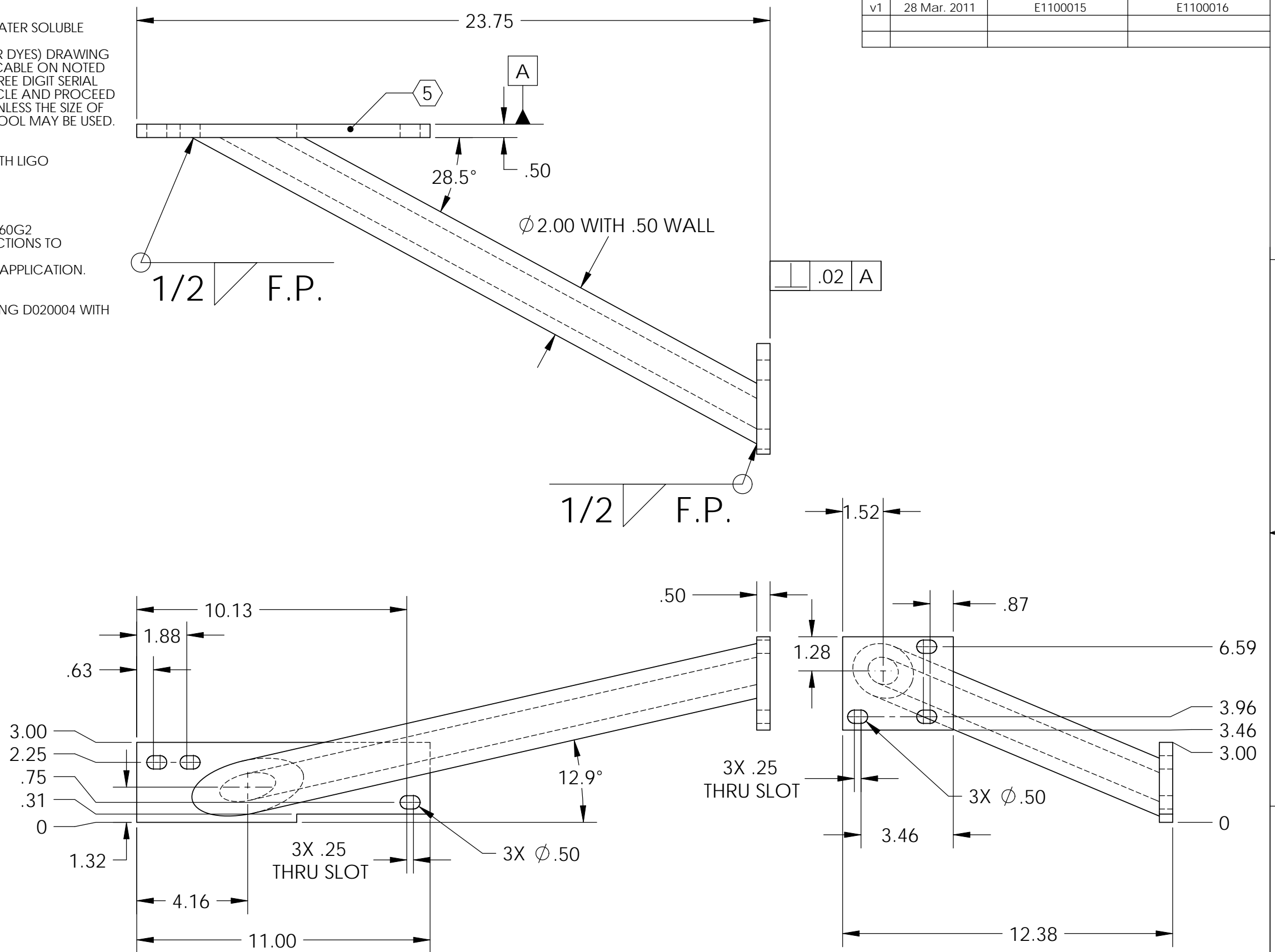


D020329_Housing_Stiffener-Right-Actuator, PART PDM REV: X-006, DRAWING PDM REV: X-003

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 DXXXXXX-VY, TYPE-XX, S/N XXX.
6. APPROXIMATE WEIGHT = 9.55 LB.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. PAINT: ALL VISIBLE SURFACES 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.
10. FULL WELDED CONSTRUCTION.
11. STRESS RELIEVE BEFORE FINISH MACHINING.
12. AFTER FINAL MACHINE TO FIT, MARK STIFFENERS AND HOUSING D020004 WITH CORRESPONDING SERIAL NUMBERS

REV.	DATE	DCN #	DRAWING TREE #
v1	28 Mar. 2011	E1100015	E1100016



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO		PART NAME	
DIMENSIONS ARE IN INCHES				CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PRE-ISOLATOR ASSEMBLY, HOUSING STIFFENER, RIGHT, ACTUATOR	
TOLERANCES: .XX ± .015 .XXX ± .005				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .03 x 45°. 3. DO NOT SCALE FROM DRAWING.		DESIGNER	K. Mason
ANGULAR ± .5°				MATERIAL		DRAFTER	M.HILLARD
ASTM A519 Steel				FINISH		CHECKER	K.MASON
63 μinch				NEXT ASSY		APPROVAL	K.MASON
				D1100146, D1100242		DATE	14 Mar. 2003
						DATE	28 Mar. 2011
						DATE	20 June 2011
						DATE	28 Mar. 2011
						SIZE	DWG. NO.
						B	D020329
						REVISION	v1
						SCALE	1:4
						PROJECTION	ASME
						SHEET 1 OF 1	