

D020330\_Housing\_Stiffener-Right-Panel, PART PDM REV: X-006, DRAWING PDM REV: X-001

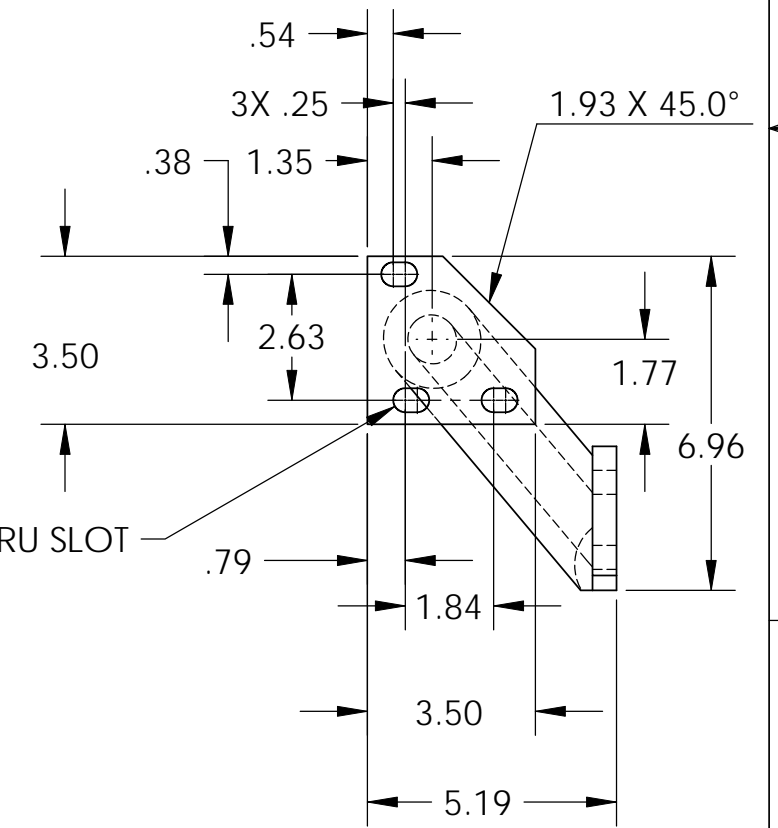
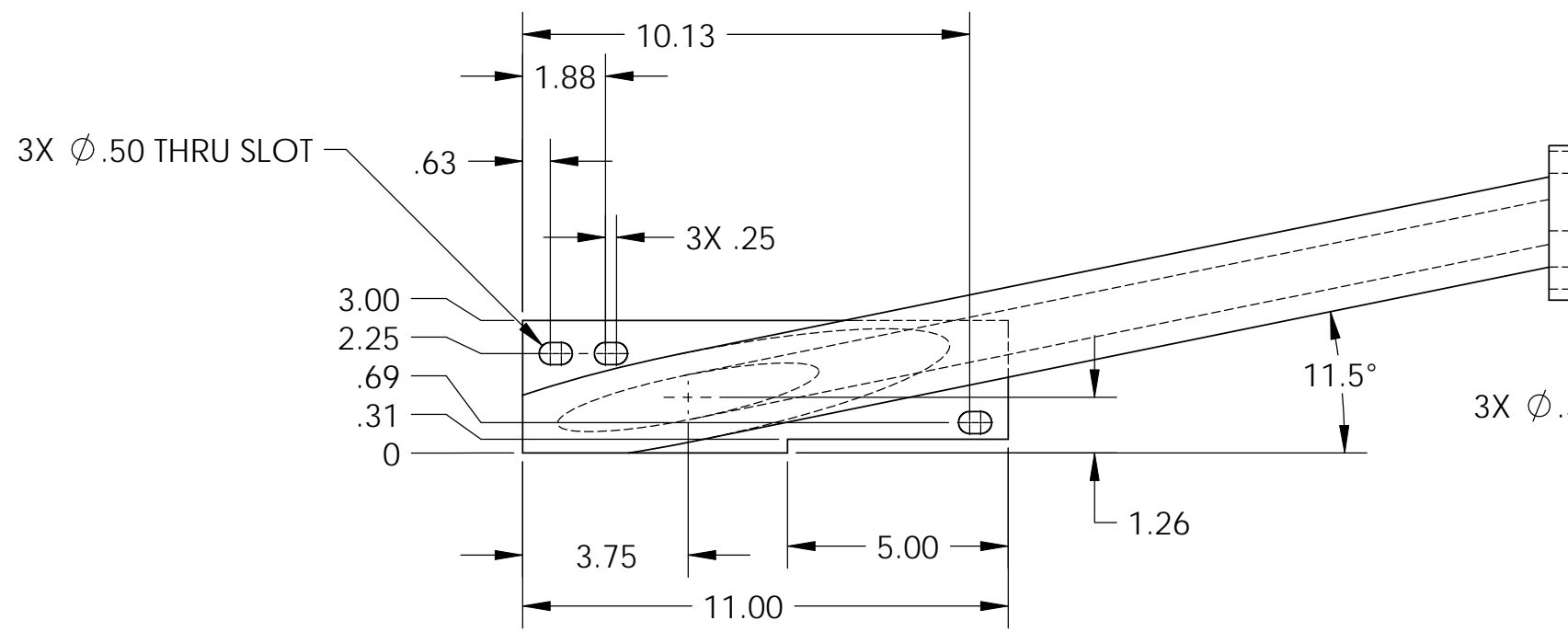
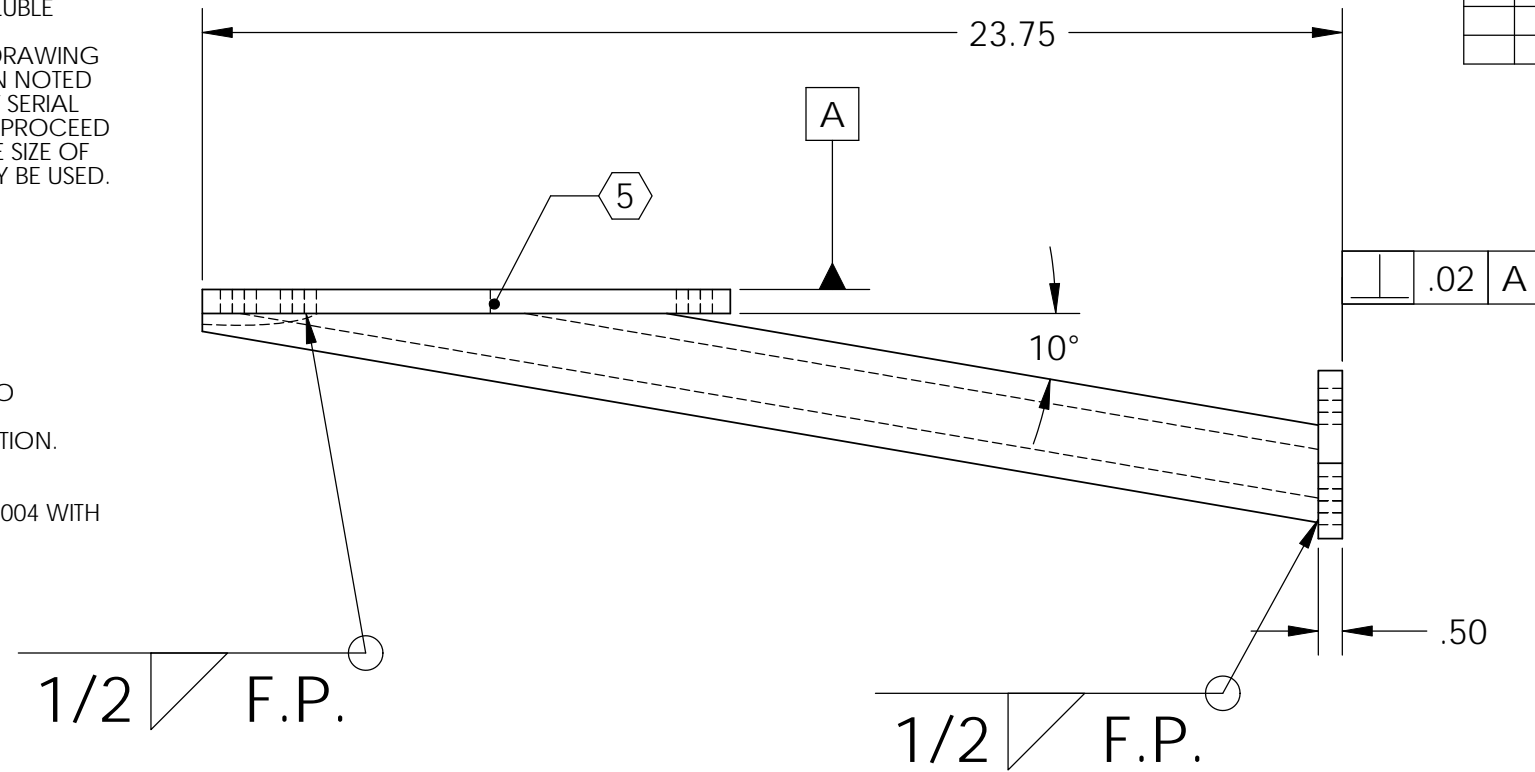
NOTES CONTINUED:

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 = 8.63 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       |
|      |              |          |                |
|      |              |          |                |

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| 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                                                                 |  | PRE-ISOLATOR ASSEMBLY, HOUSING STIFFENER, RIGHT, PANEL |  |
| TOLERANCES:<br>.XX ± .015<br>.XXX ± .005           |  | 2. REMOVE ALL SHARP EDGES, .03 x 45°.     |  | SUB-SYSTEM<br>SEI                                                             |  | DESIGNER K.MASON 20 June 2002                          |  |
| ANGULAR ± .5°                                      |  | 3. DO NOT SCALE FROM DRAWING.             |  | NEXT ASSY<br>D1100144, D1100241                                               |  | DRAFTER M.HILLARD 28 Mar. 2011                         |  |
| MATERIAL<br>ASTM A519 Steel                        |  | FINISH<br>63 μinch                        |  | CHECKER K.MASON 20 June 2002                                                  |  | SIZE DWG. NO.<br>B D020330                             |  |
|                                                    |  |                                           |  | APPROVAL K.MASON 28 Mar. 2011                                                 |  | REV.<br>v1                                             |  |
|                                                    |  |                                           |  |                                                                               |  | SCALE: 1:4 PROJECTION:  SHEET 1 OF 1                   |  |

8 7 6 5 4 3 2 1