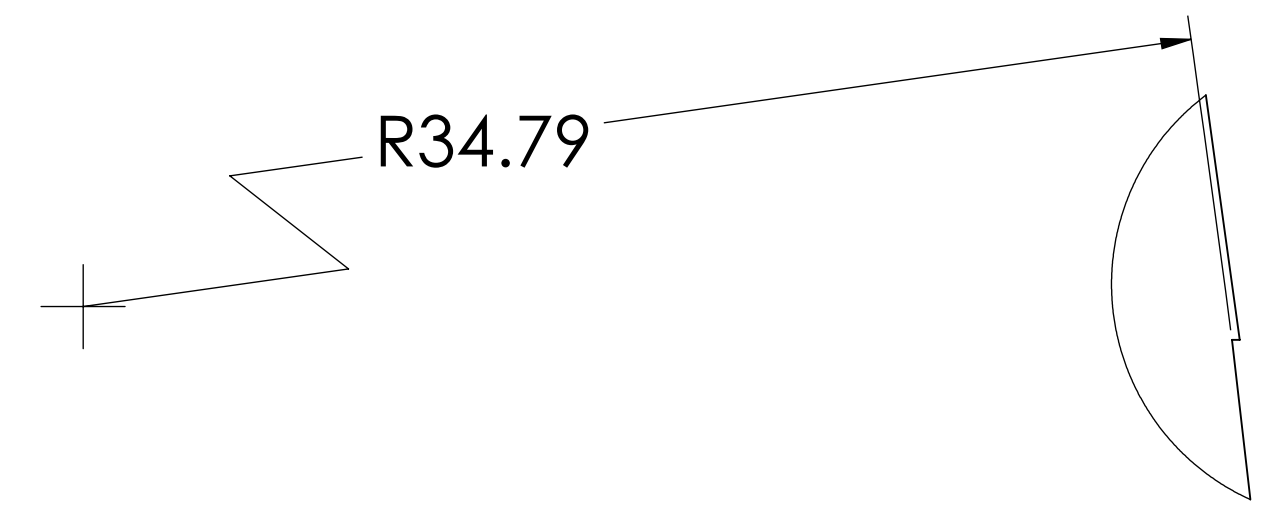
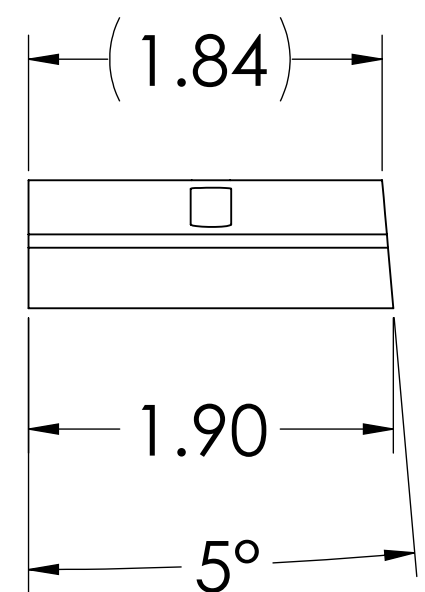


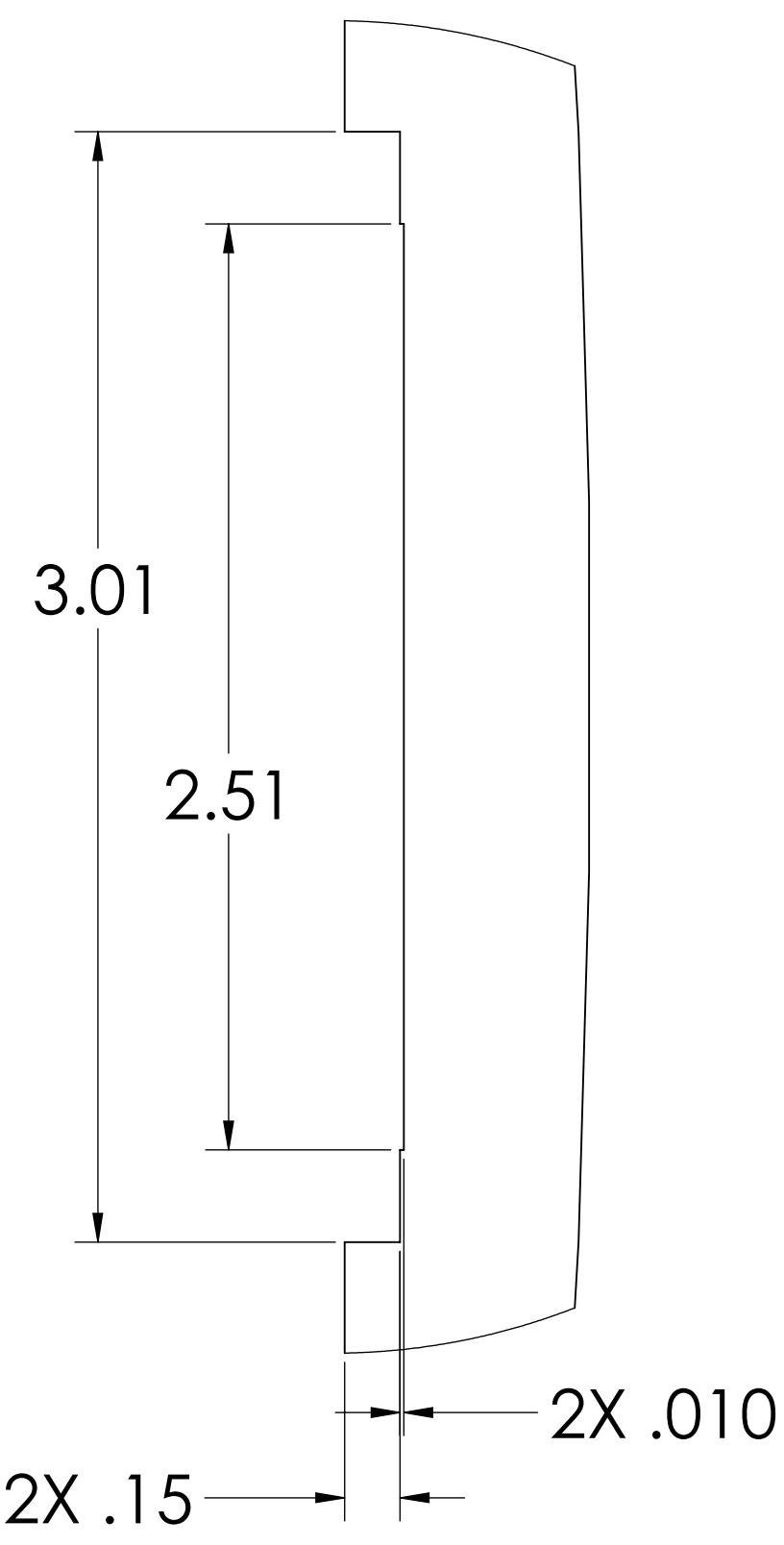
- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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. REFER TO LIGO-E0900364
  - 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
  - 8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
  - 9. PART TO BE OXIDIZED PER LIGO SPECIFICATION E1100842.

10. APPROXIMATE WEIGHT: 2.54 LBS.

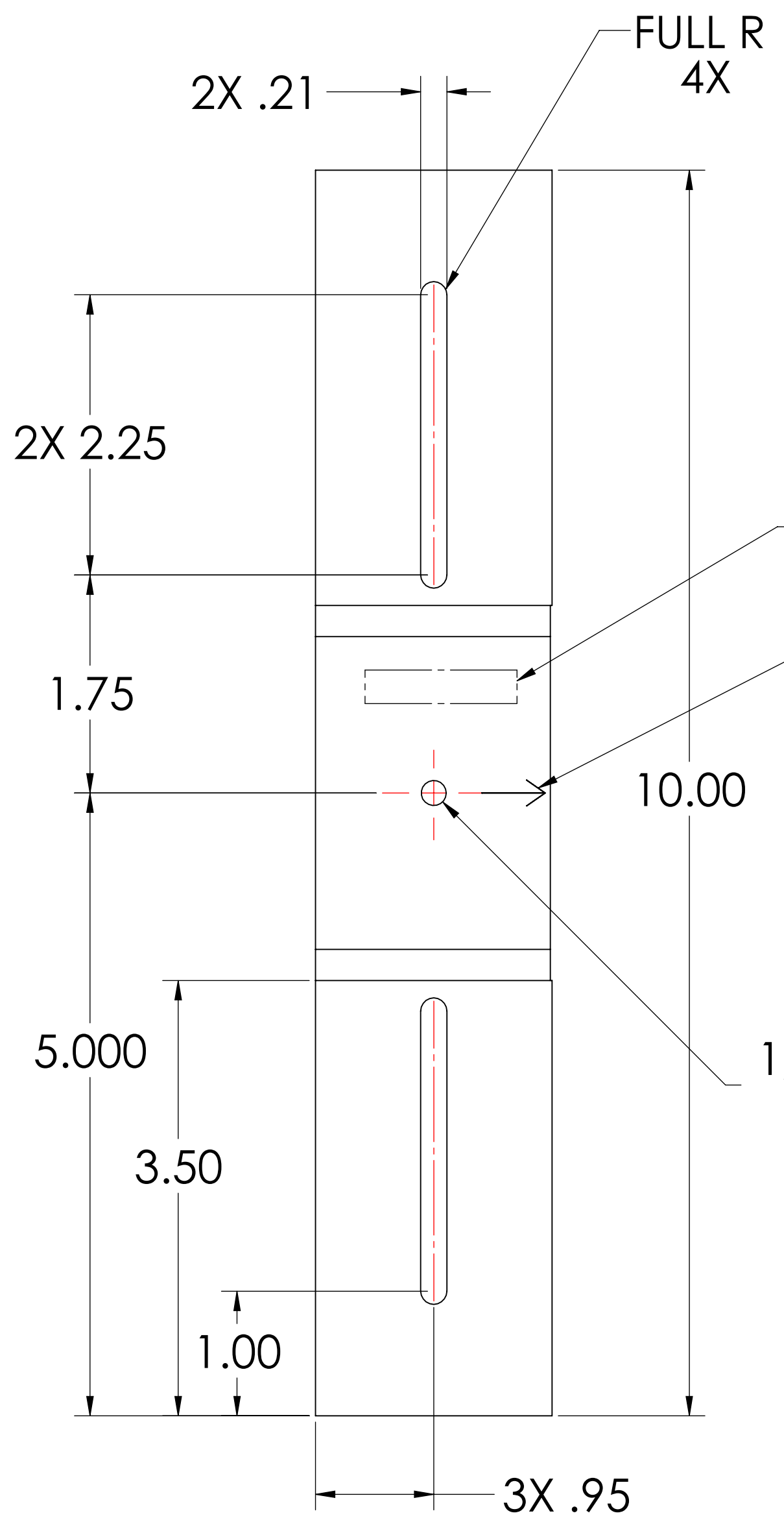
REV.	DATE	DCN #	DRAWING TREE #
v1	5 OCT 2010	E1000185	E1000491
v2	12 MAY 2011	E1000360-v2	-
v3	6 OCT 2011	E1000360-v3	-
v4	21 DEC 2012		



DETAIL B  
SCALE 4:1

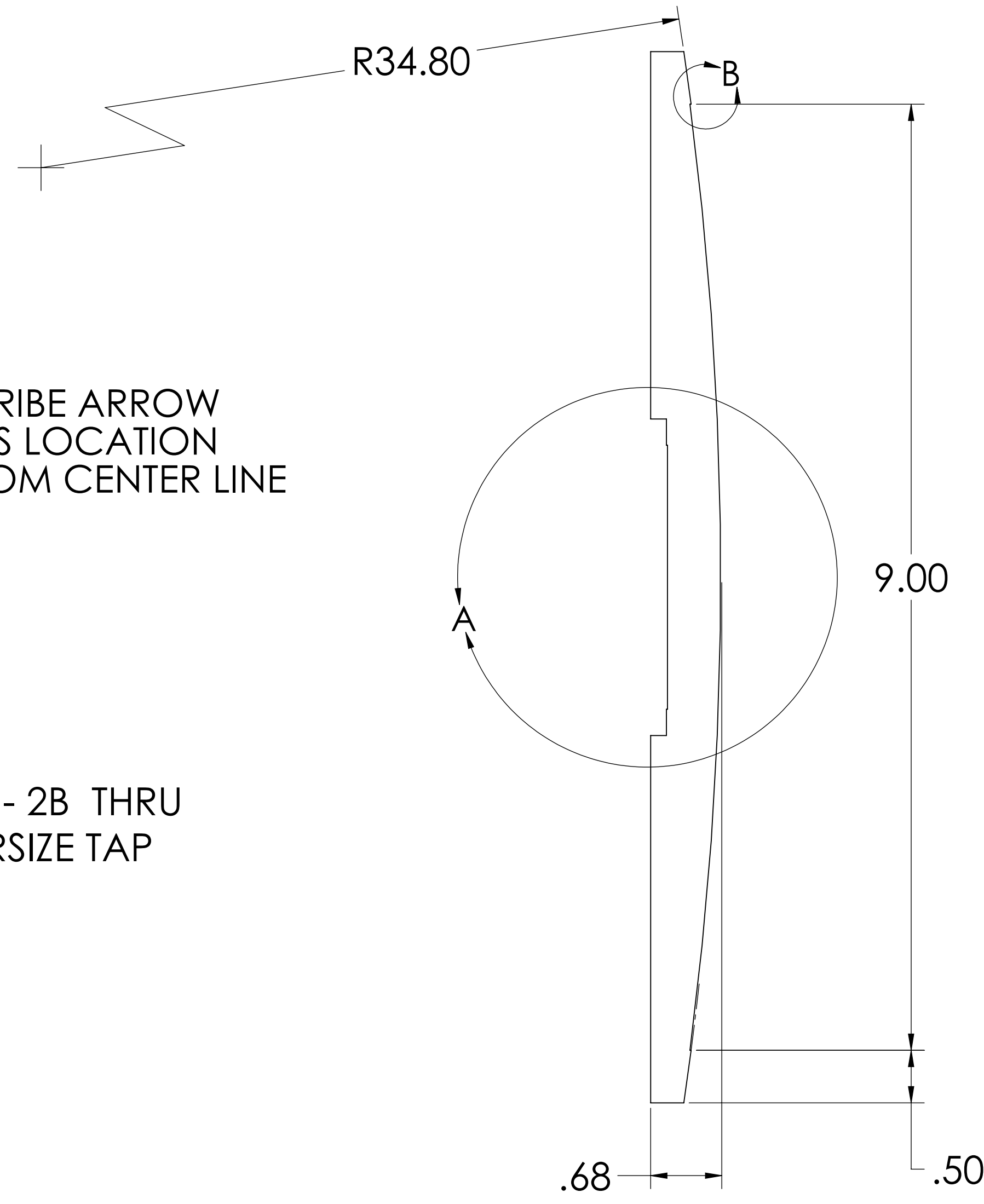


DETAIL A  
SCALE 2:1

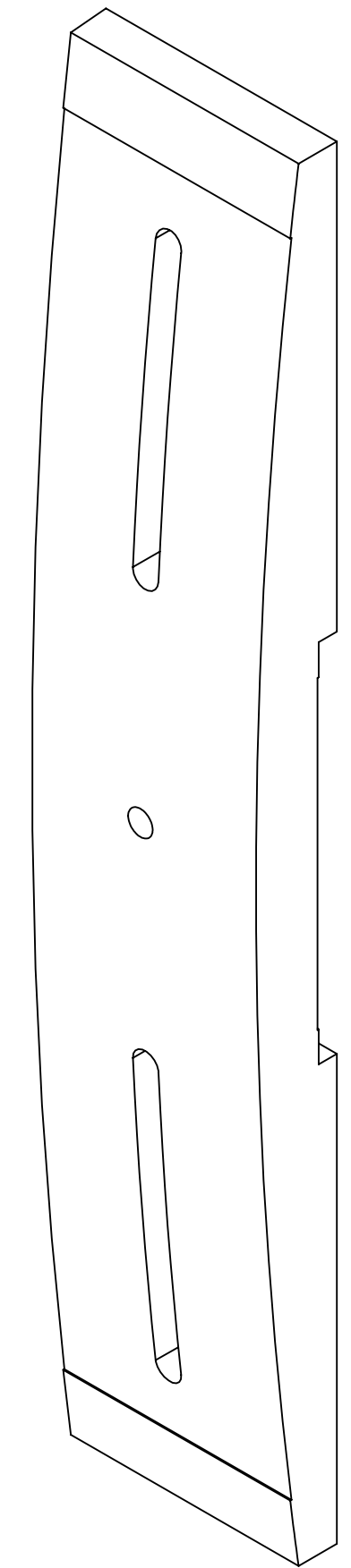


SCRIBE ARROW  
THIS LOCATION  
FROM CENTER LINE

1/4-20 UNC - 2B THRU  
+.005 OVERSIZE TAP



GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015 ON ALL EDGES AND HOLES. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		<b>ADVANCED LIGO</b>		<b>VERTICAL WEIGHT</b>		DESIGNER TQ. NGUYEN 08 SEPT 2010 DRAFTER TQ. NGUYEN 21 SEPT 2010 CHECKER M. SMITH APPROVAL D. COYNE	
MATERIAL 304, 316 OR 302 SSSL		FINISH 63 μinch		NEXT ASSY D1002402		SUB-SYSTEM AOS		SIZE DWG. NO. D D1002403		REV. v4	
						SCALE: 1:1		PROJECTION:		SHEET 1 OF 1	