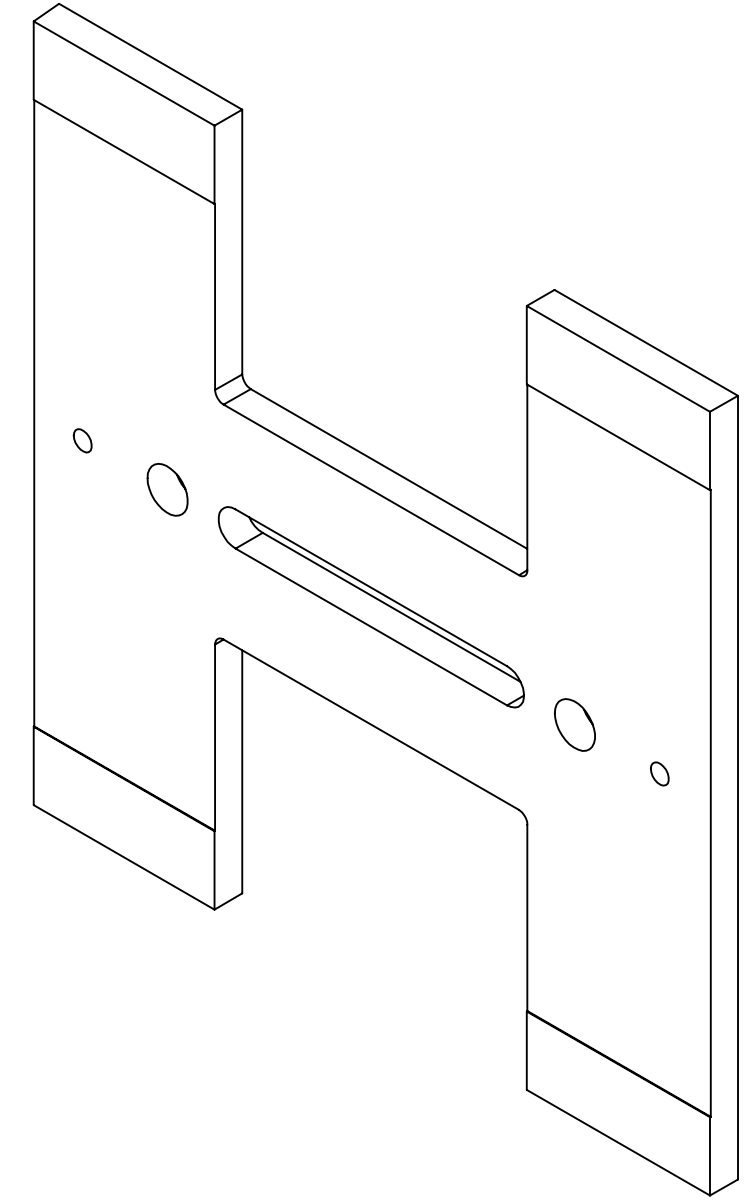
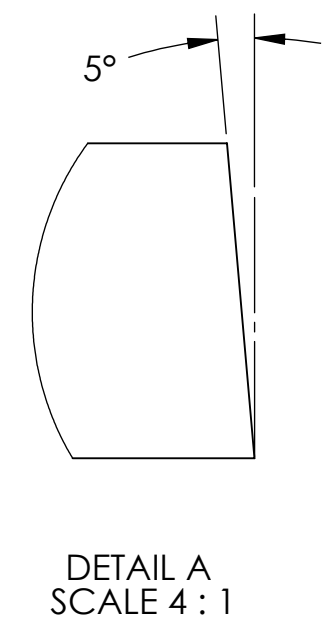
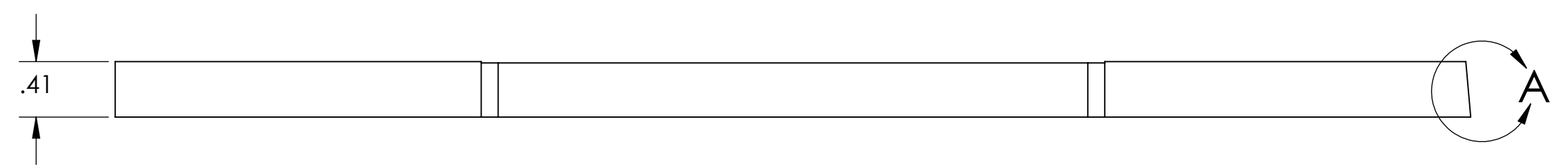
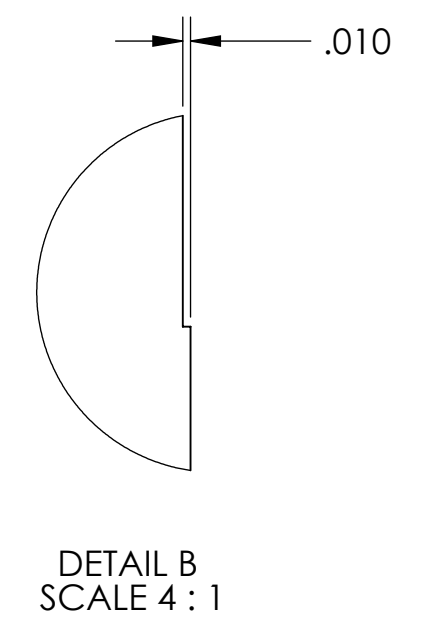
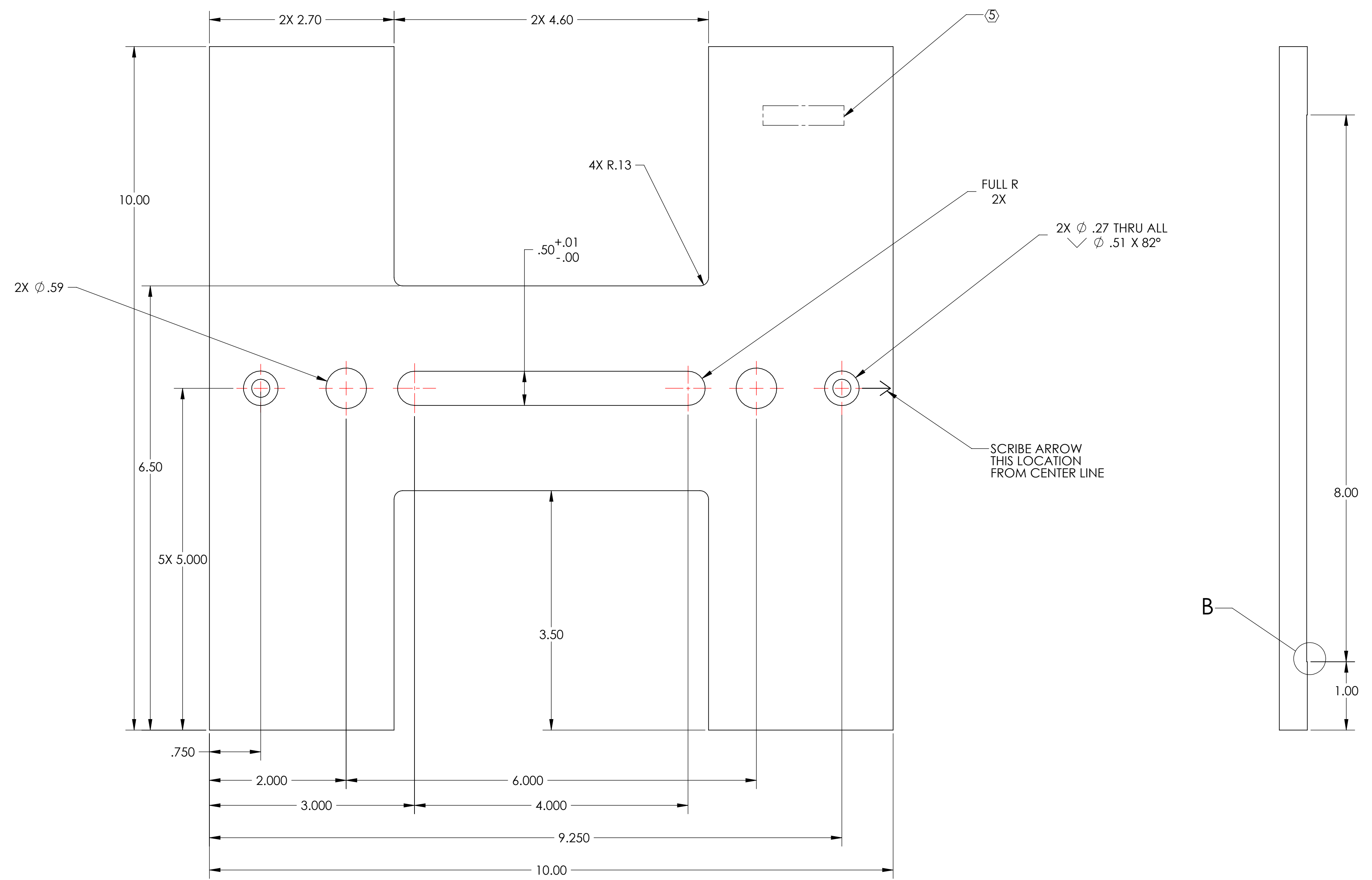


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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.

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



GENERAL VIEW FOR REFERENCE ONLY NO SACLE



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
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.	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± 0.5°	
MATERIAL	FINISH
304, 316 OR 302 SSTL	63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

NEXT ASSY: D1002402

PART NAME		REV.	
UPPER HORIZONTAL WEIGHT		v3	
DESIGNER	TQ. NGUYEN	10 SEPT 2010	SIZE DWG. NO.
DRAFTER	TQ. NGUYEN	21 SEPT 2010	D D1002417
CHECKER	M. SMITH		
APPROVAL	D. COYNE		
SCALE: 1:1		PROJECTION:	
		SHEET 1 OF 1	

D:\002417_d\UGO_Monfield Coy\Baffle_Upper Horizontal Weight_PDM.PDM\REV-X.017.DRAWING.PDM\REV-X.013