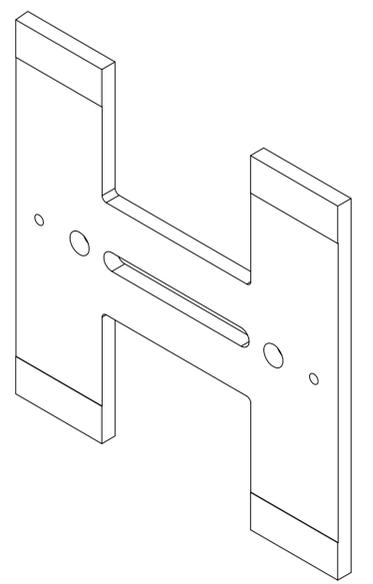
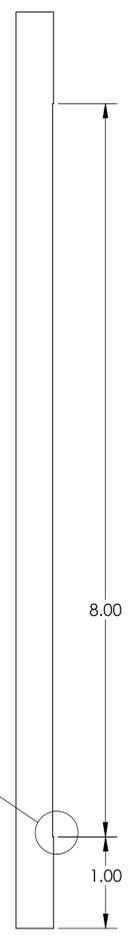
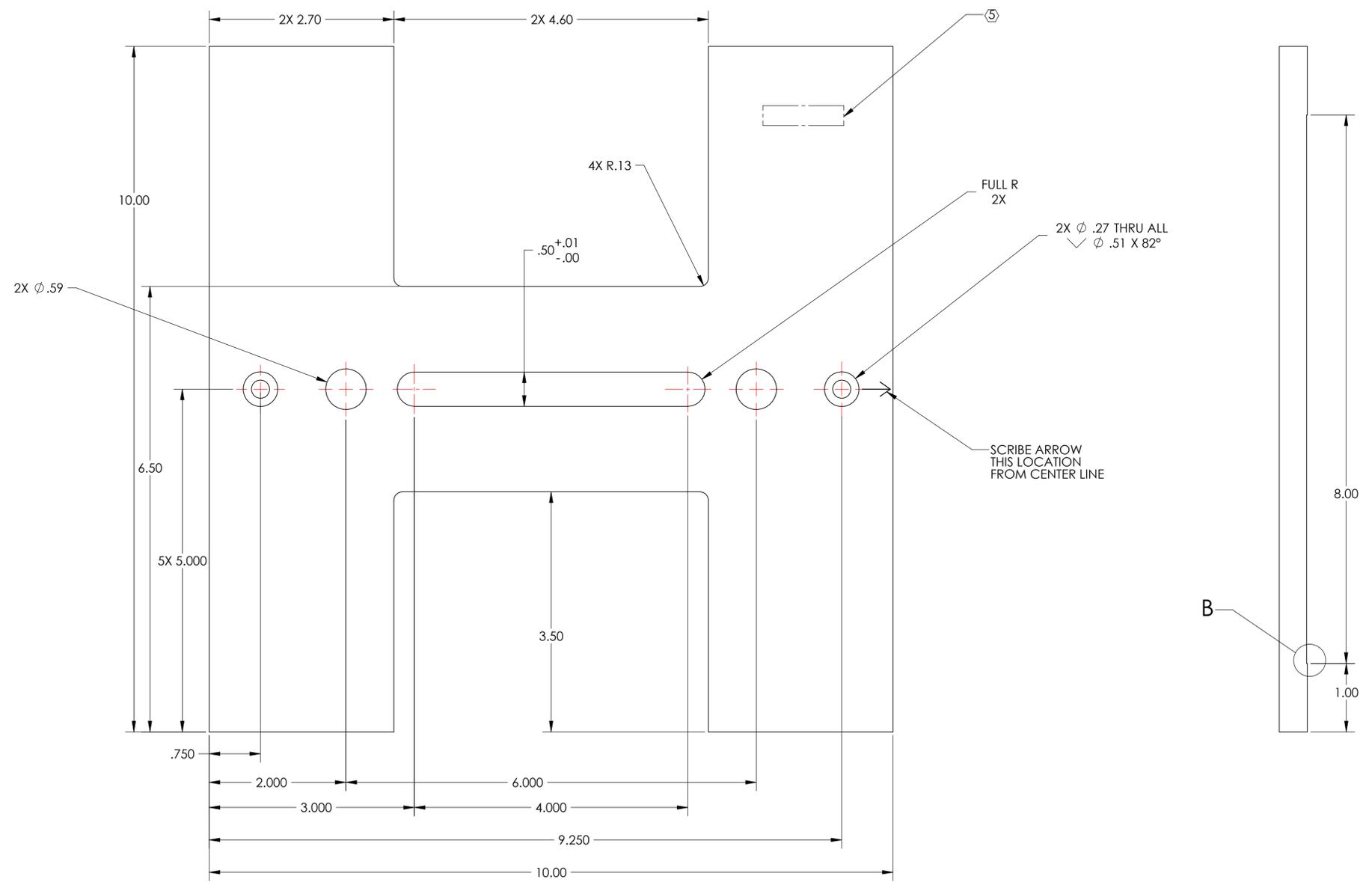
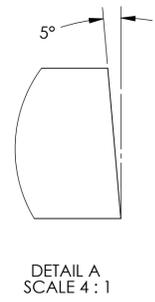
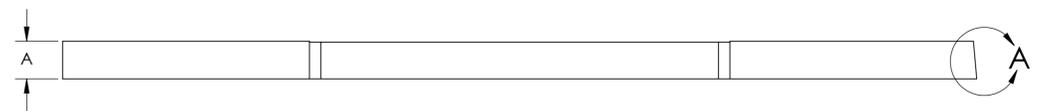


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT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



GENERAL VIEW FOR REFERENCE ONLY NO SACLE

REV.	DATE	DCN #	DRAWING TREE #
v1	5 OCT 2010	E1000185	E1000491
v2	12 MAY 2011	E1000360-v2	-
v3	6 OCT 2011	E1000360-v3	-
v4	30 JAN 2013	E1000360-v5	-

VERSION	DIMENSION A	WEIGHT
D1002417-1	0.41	7.5LB
D1002417-2	0.21	3.75LB

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: 304, 316 OR 302 SSTL FINISH: 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				v4	
DESIGNER	TQ. NGUYEN	10 SEPT 2010	SIZE	DWG. NO.	
DRAFTER	TQ. NGUYEN	21 SEPT 2010	D	D1002417	
CHECKER	M. SMITH		SCALE: 1:1	PROJECTION:	SHEET 1 OF 1
APPROVAL	D. COYNE				

D:\002417_d\UGO_Monfield Cyo\Baffle_Upper Horizontal Weight_PART PDM_REV-X.017_DRAWING_PDM_REV-X.014