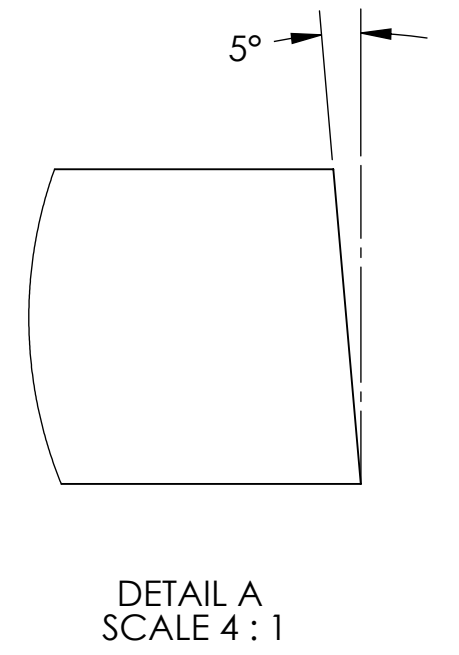
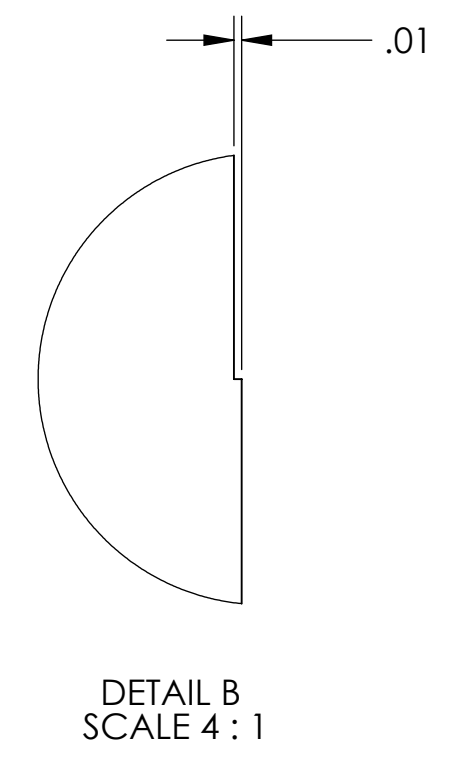
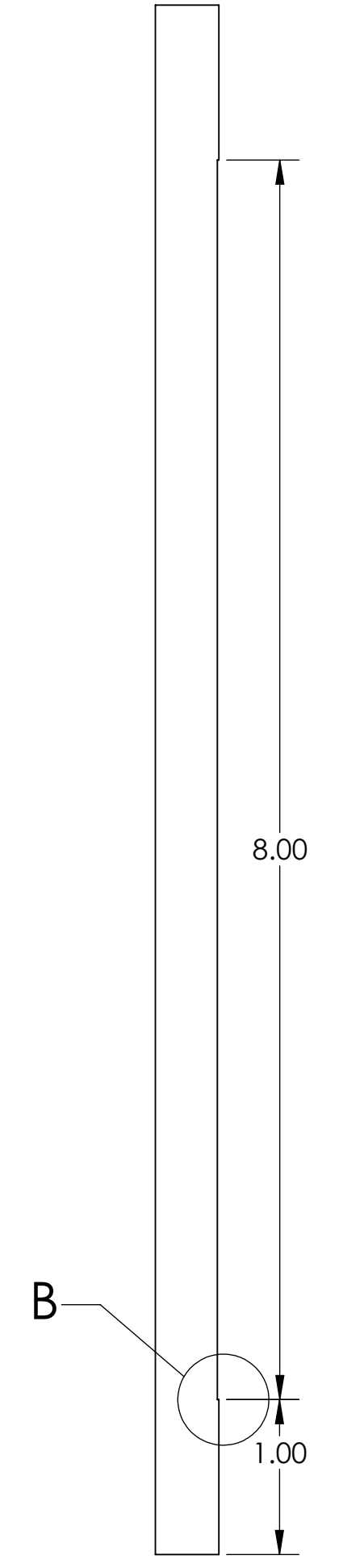
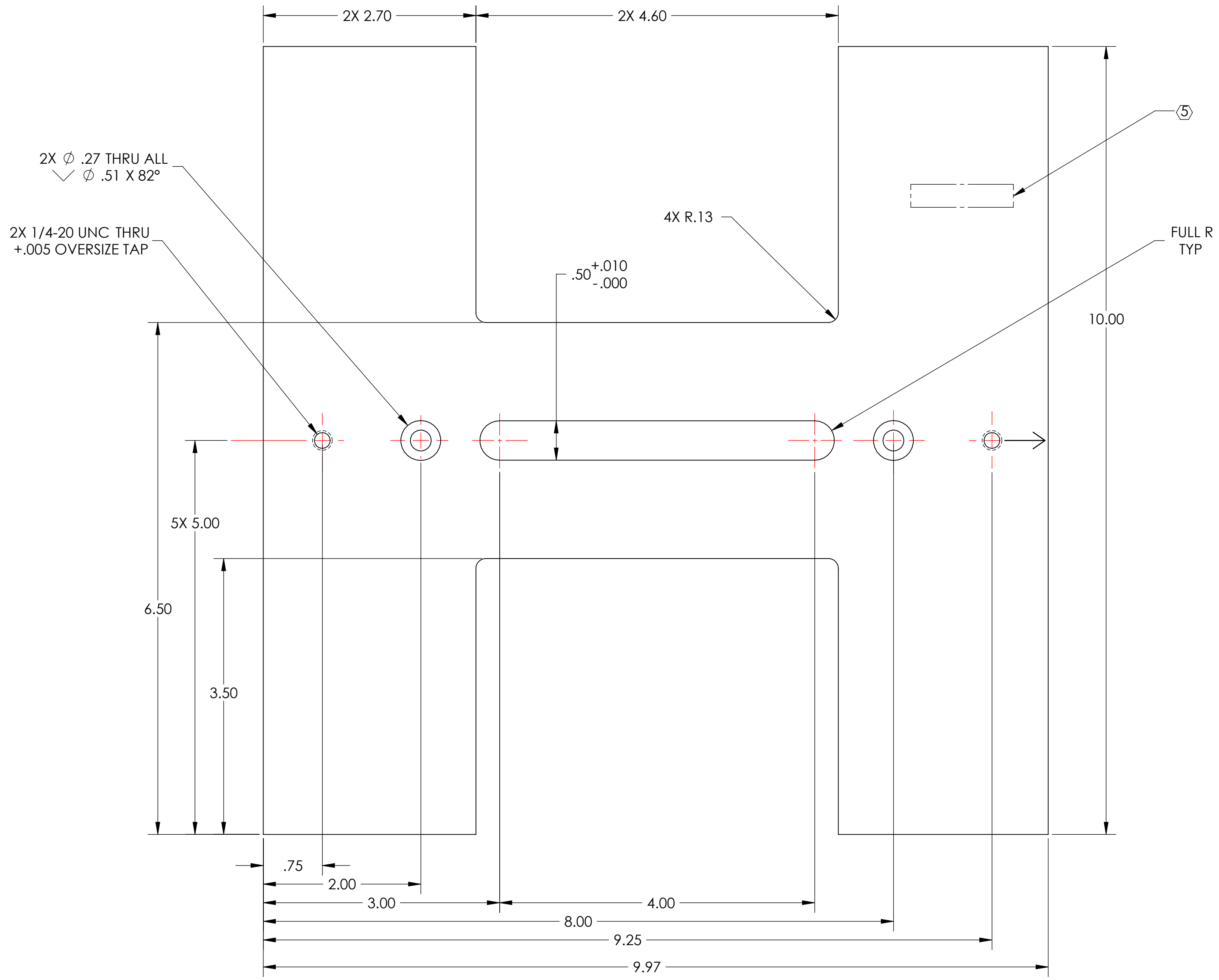
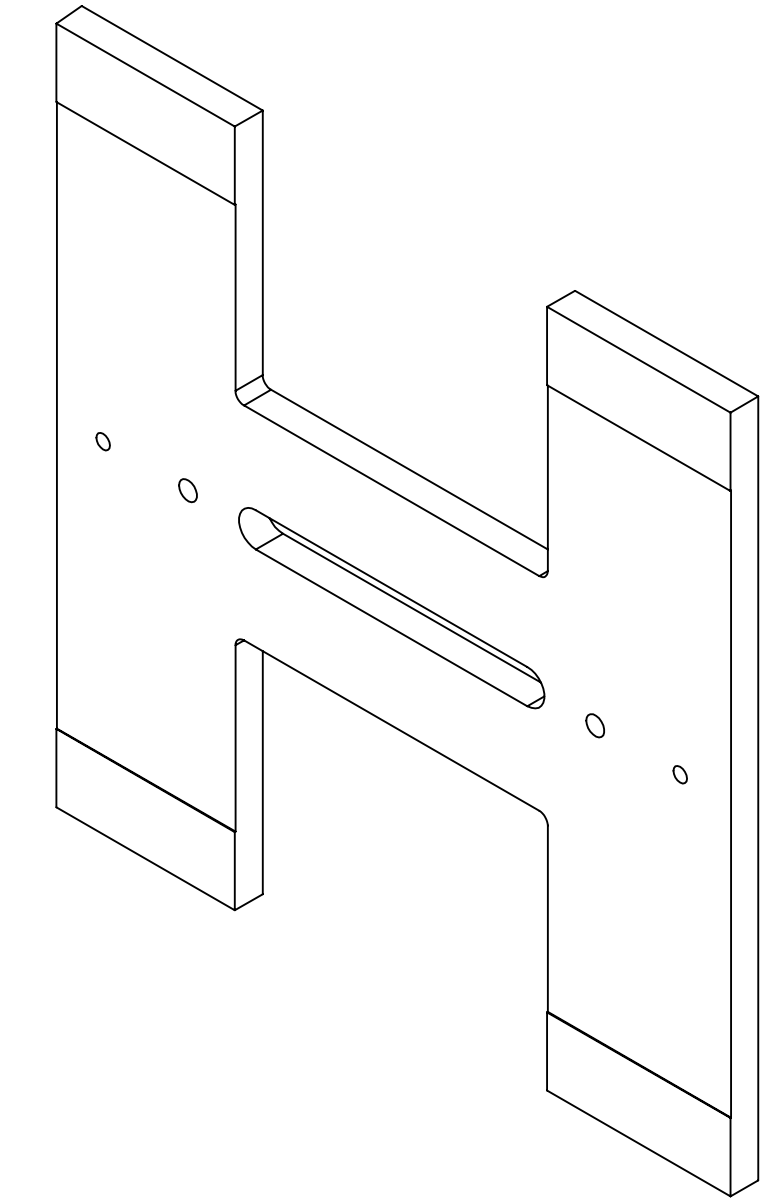


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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, FLUGS 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: 7.528 LBS.



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



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

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	SYSTEM	SUB-SYSTEM
	ADVANCED LIGO	AOS
NEXT ASSY	D1002402	

PART NAME				MID HORIZONTAL WEIGHT			
DESIGNER	TQ. NGUYEN	10 SEPT 2010	SIZE	DWG. NO.	REV.		
DRAFTER	TQ. NGUYEN	21 SEPT 2010	D	D1002418	v3		
CHECKER	M. SMITH		SCALE: 1:1	PROJECTION:	SHEET 1 OF 1		
APPROVAL	D. COYNE						