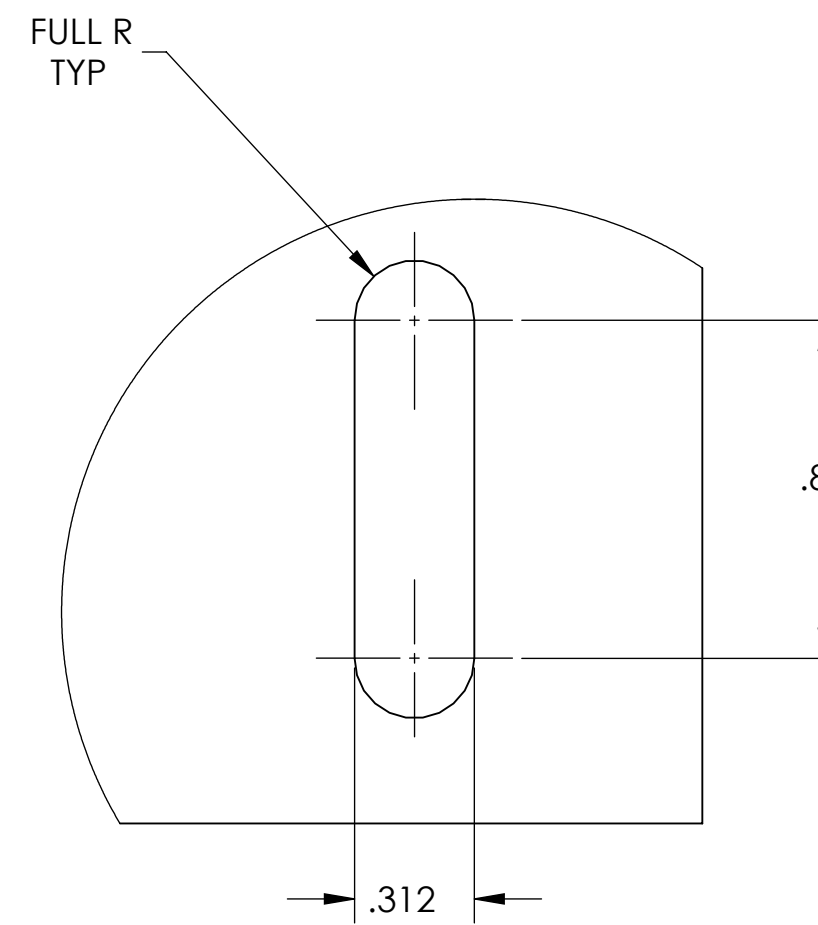


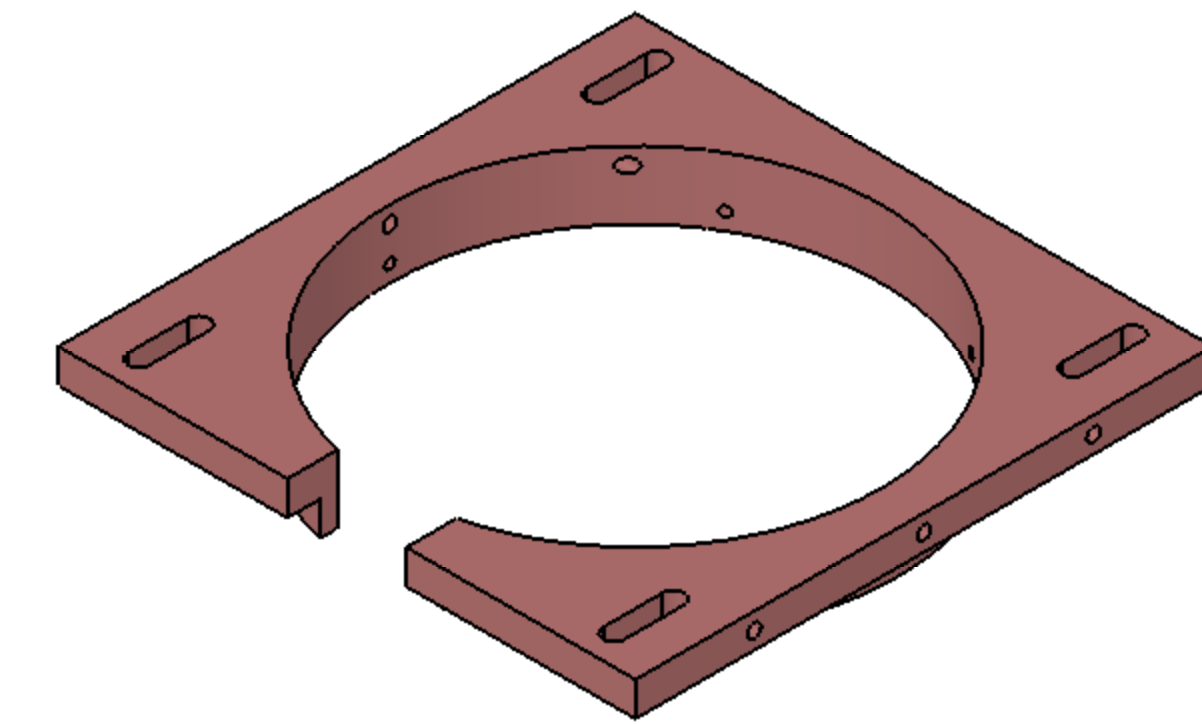
**NOTES: UNLESS OTHERWISE SPECIFIED**

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES 0.005" TO 0.015".
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. REFER TO LIGO E0900237 FOR LIST OF APPROVED COOLANTS.
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. APPROXIMATE WEIGHT = 1.647 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. 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.

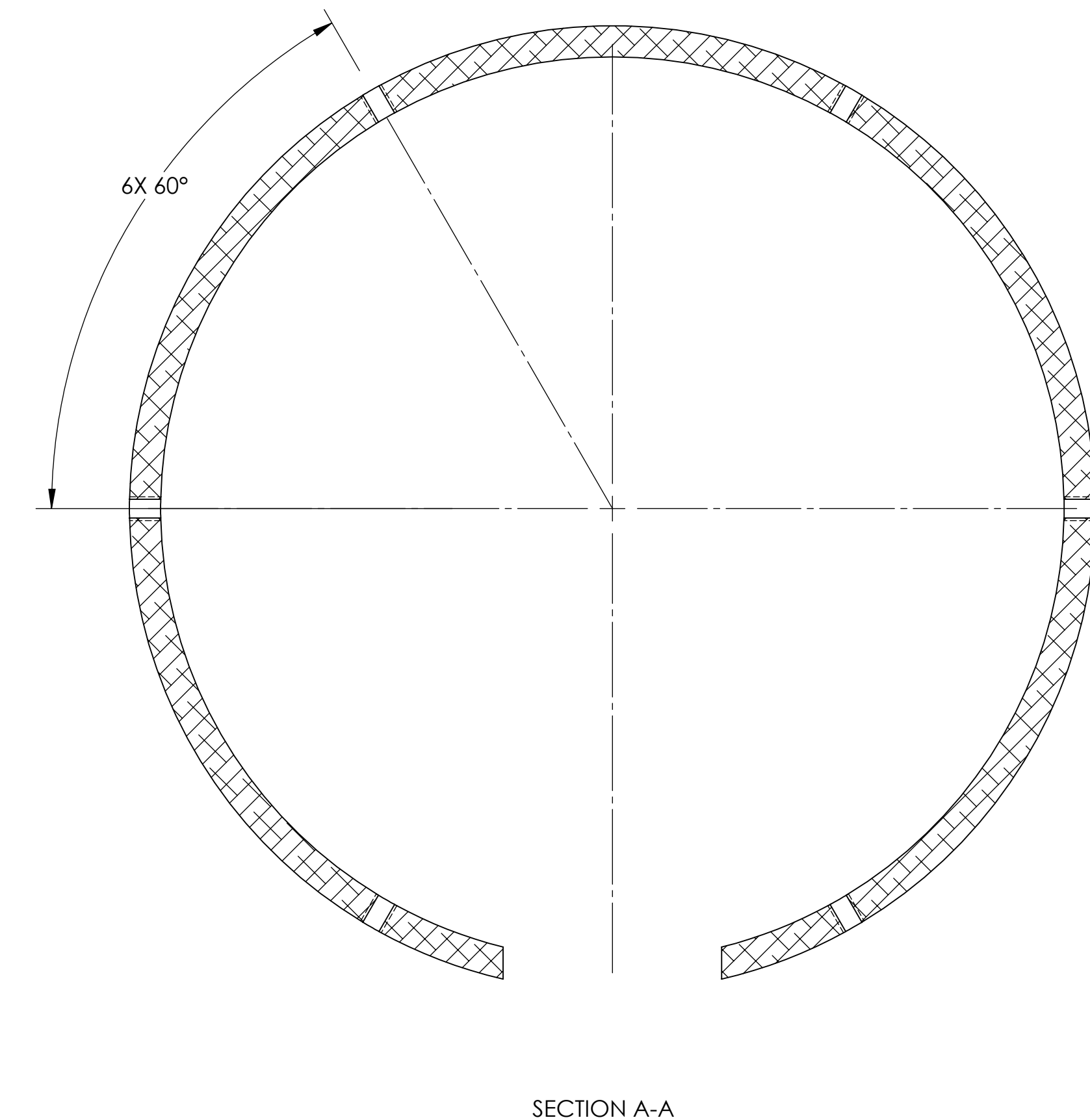
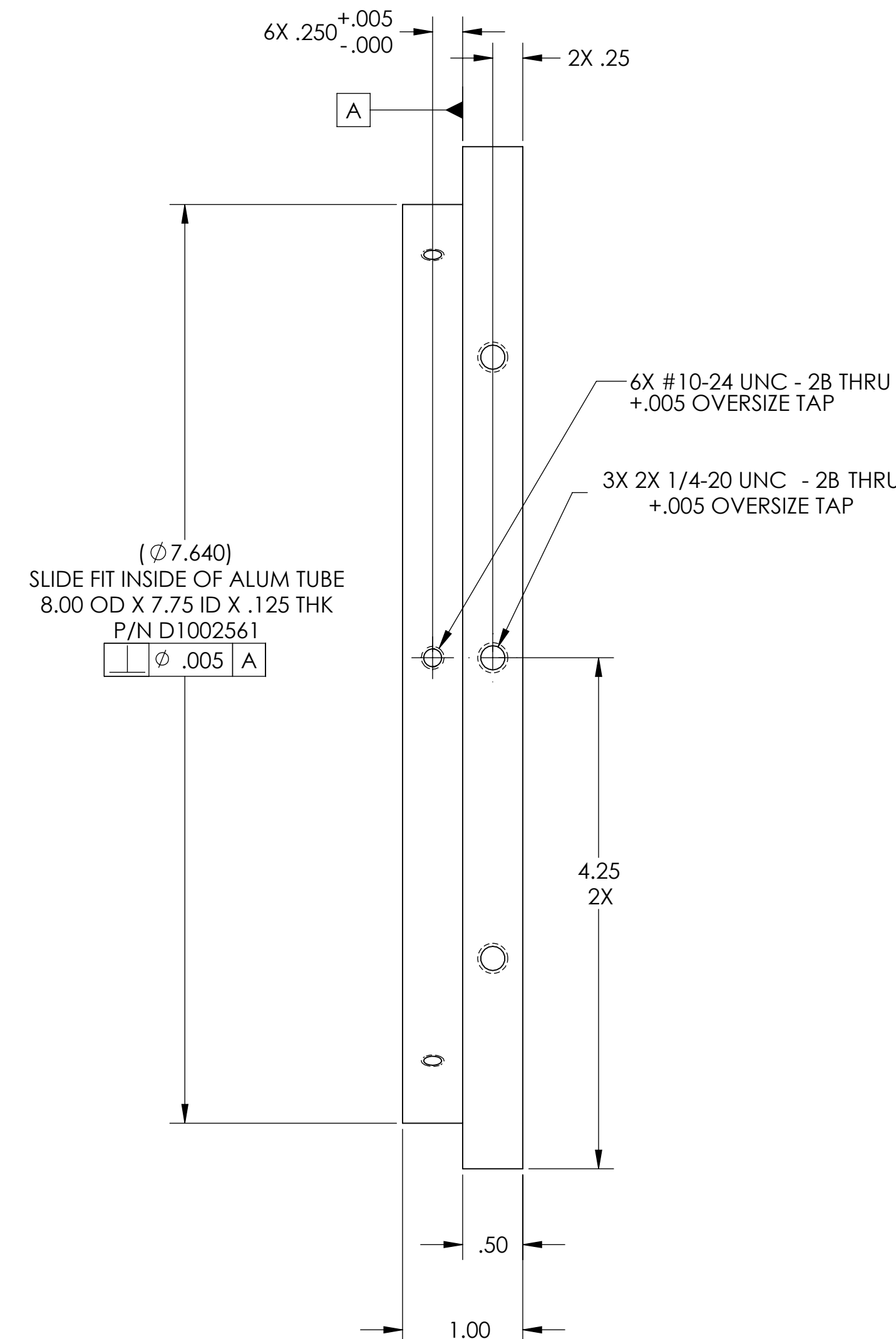
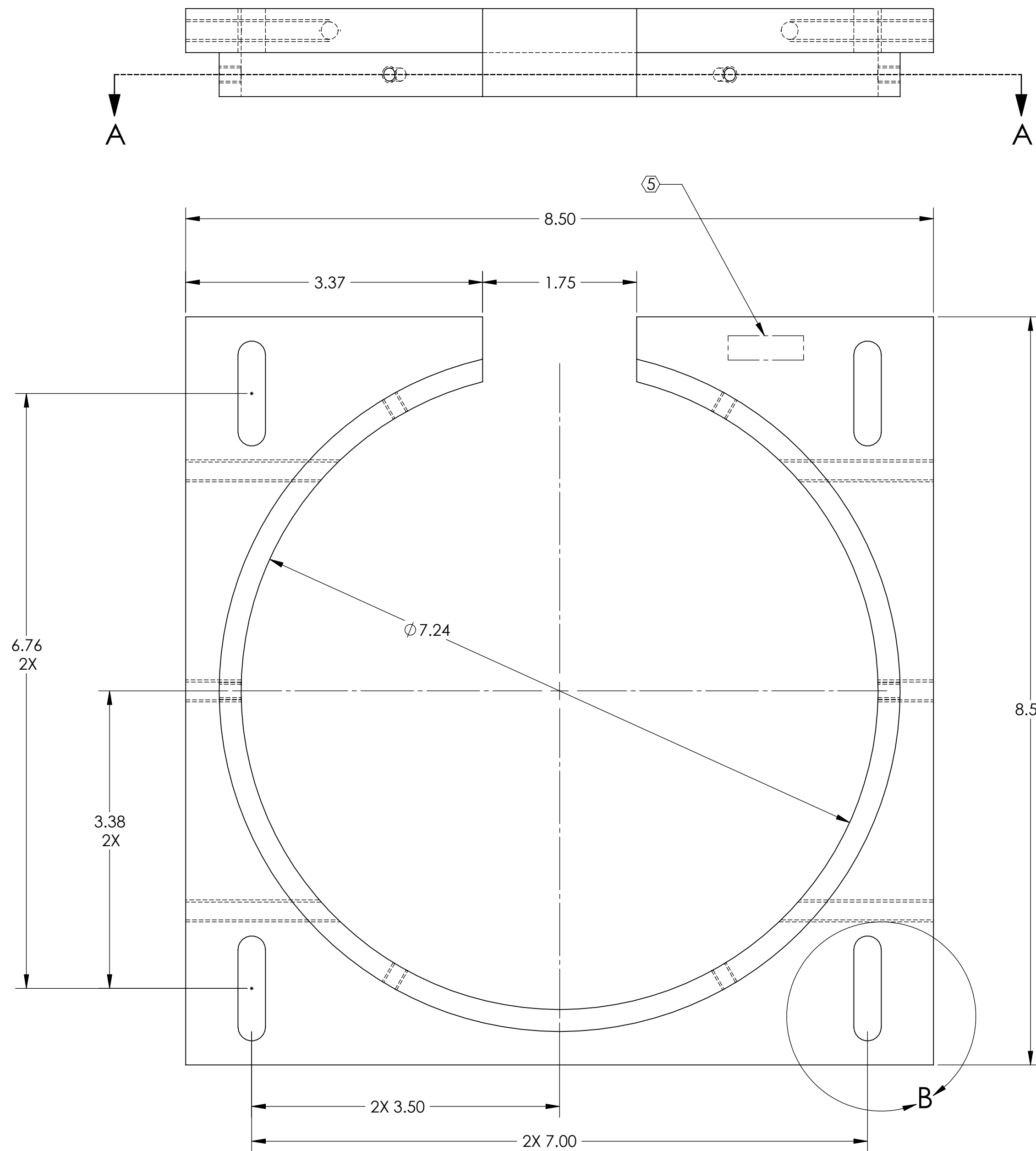
REV.	DATE	DCN #	DRAWING TREE #
v1	03 JUN 2010	E1000285	



DETAIL B  
SCALE 2 : 1  
4X



FOR REFERENCE VIEW ONLY  
NO SCALE



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY				PART NAME						
DIMENSIONS ARE IN INCHES								SLC DAMPING TUBE TOP PLATE						
TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± .5°								SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS		DESIGNER N.Nguyen	DATE 01 Jun 2010	SIZE D
MATERIAL 6061-T6 Al				FINISH 63 μinch		NEXT ASSY D1002563		DRAFTER TG. NGUYEN	DATE 21 MAY 2010	CHECKER M. SMITH	DATE 01 NOV 2010	SCALE 1:1	PROJECTION	SHEET 1 OF 1
								APPROVAL D. COYNE	DATE 10 NOV 2010					

D1002560\_AudiGO\_AOS\_SLC Damping Tube Top Plate\_PART PDM REV: X.013, DRAWING PDM REV: X.008