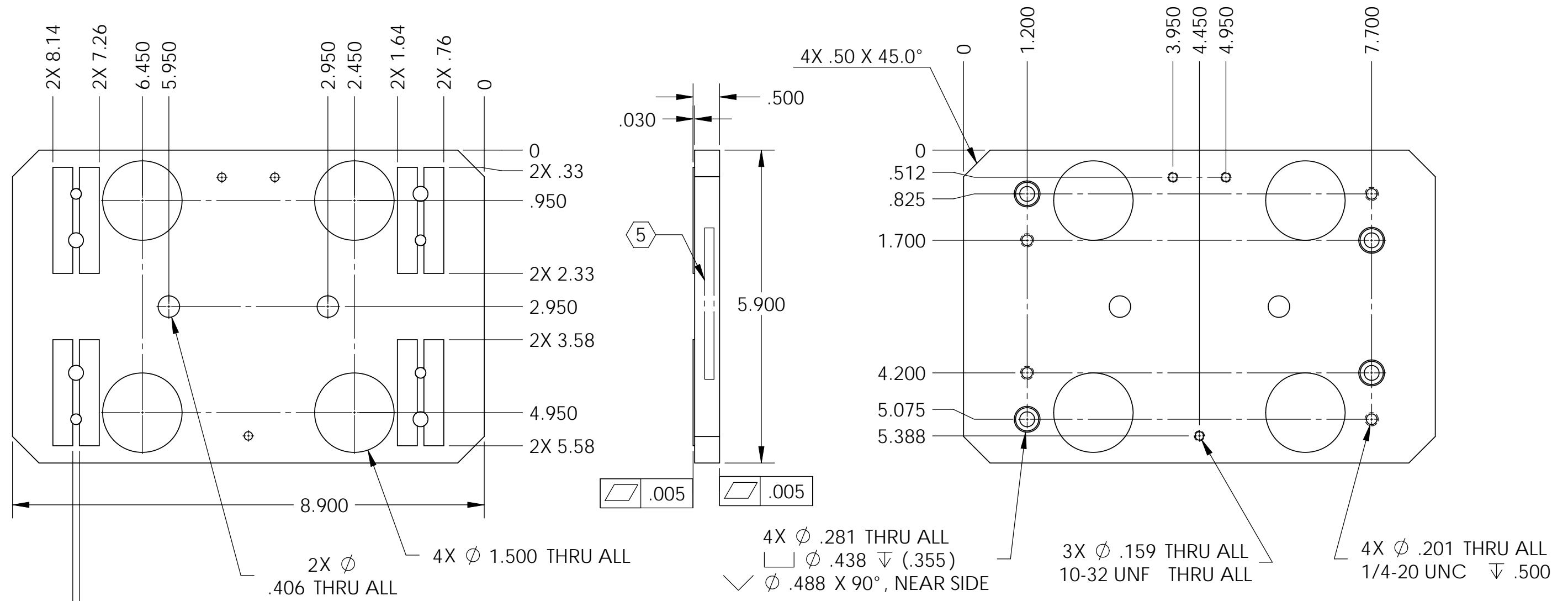


REV.	DATE	DCN #	DRAWING TREE #
v1	06 Dec. 2010	E1000758	E1000025

NOTES CONTINUED:

4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
5. SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXXX-VY, TYPE-XX, S/N XXX.
6. APPROXIMATE WEIGHT = 2 LB.=1 KG.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES (INCLUDING SANDING OR SCOURING FOR MATTE FINISH) IS NOT ALLOWED. USE OF SCOTCH-BRITE OR SIMILAR PRODUCTS IS FORBIDDEN.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NOT WELD REPAIRS OR PLUGS) UNLESS APPROVED IN ADVANCE AND IN WRITING BY LIGO, REFER TO LIGO-E0900364.
10. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE. THE MATERIAL USED MUST BE VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF AND WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH THE MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E09000364.

D1003166 TRIM MASS 1 KG, aLIGO BSC-ISI, PART PDM REV: X-003, DRAWING PDM REV: X-005



4X  $\phi$  .281 THRU ALL  
 $\square$   $\phi$  .438  $\nabla$  (.355)  
 $\surd$   $\phi$  .488 X 90°, NEAR SIDE

3X  $\phi$  .159 THRU ALL  
 10-32 UNF THRU ALL

4X  $\phi$  .201 THRU ALL  
 1/4-20 UNC  $\nabla$  .500

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				PART NAME		
DIMENSIONS ARE IN INCHES		1. INTERPRET DRAWING PER ASME Y14.5-1994.		TRIM MASS 1 KG, aLIGO BSC-ISI		
TOLERANCES: .XX ± .015 .XXX ± .005		2. REMOVE ALL SHARP EDGES, .03 x 45°.		DESIGNER	M.HILLARD 06 Dec. 2010	
ANGULAR ± .5°		3. DO NOT SCALE FROM DRAWING.		DRAFTER	M.HILLARD 06 Dec. 2010	
MATERIAL		6061-T6 Al	FINISH	63 $\mu$ inch	CHECKER	F.MATICHARD 06 Dec. 2010
NEXT ASSY		D1003161		APPROVAL	K.MASON 06 Dec. 2010	
SYSTEM		ADVANCED LIGO	SUB-SYSTEM	SEI	SIZE	DWG. NO.
SCALE		1:2	PROJECTION		B D1003166	
SHEET		1 OF 1		REV.		v1