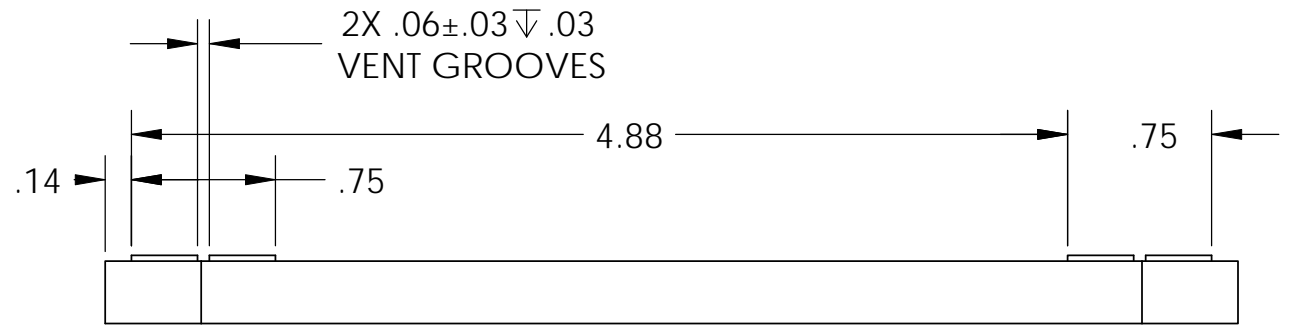


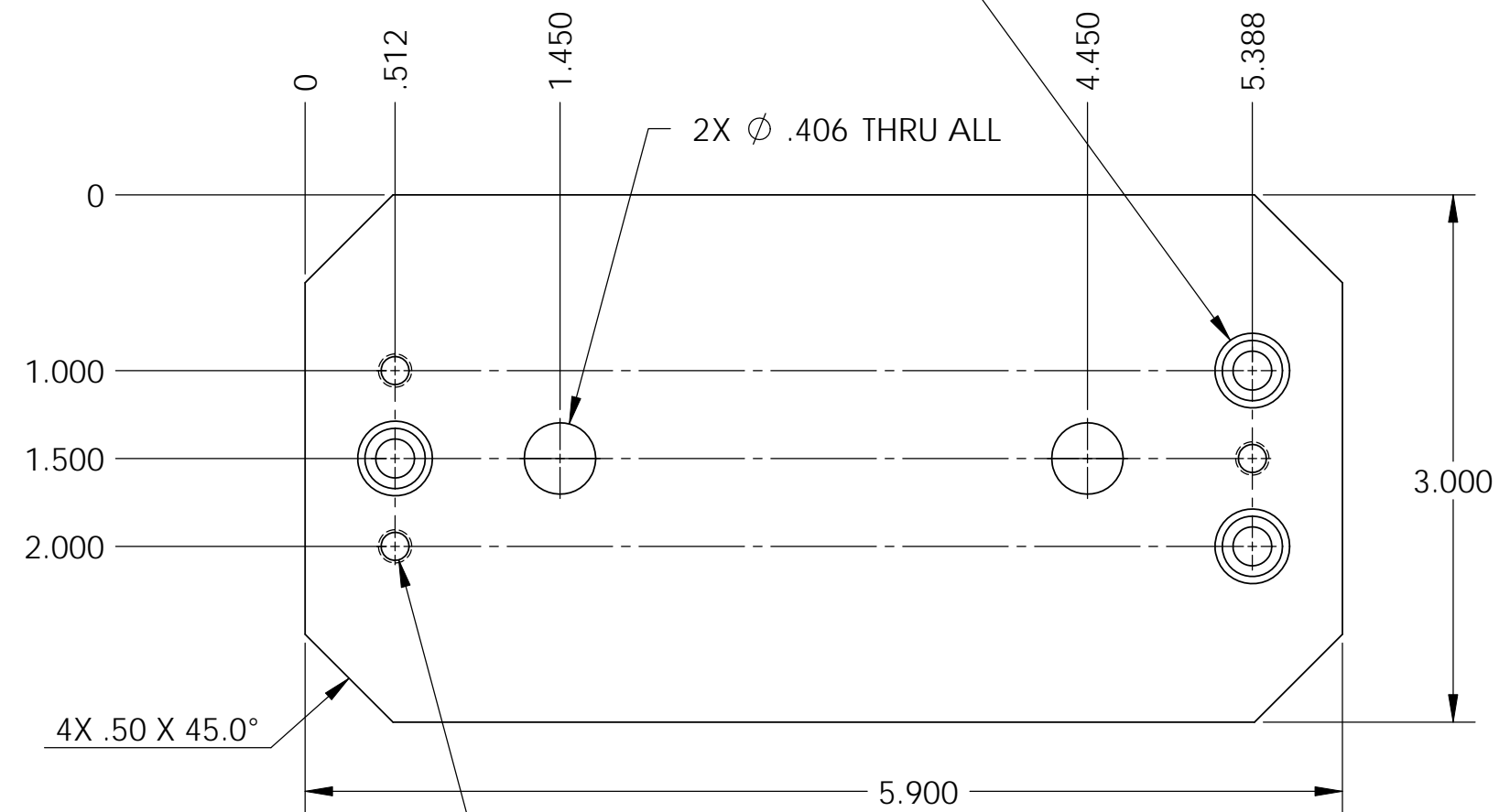
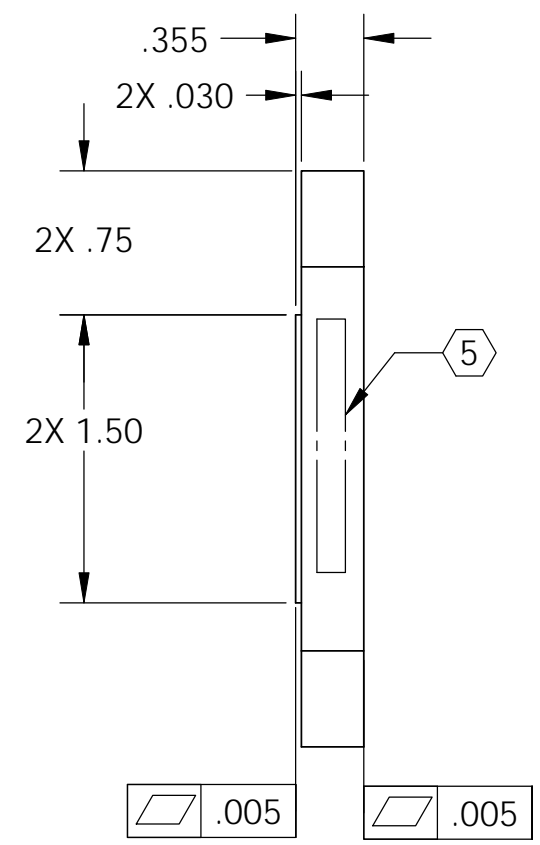
REV.	DATE	DCN #	DRAWING TREE #
v1	01 Dec. 2010	E1000758	E1000025

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 = 0.5 LB. = 25 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.



3X ϕ .221 THRU ALL
 \square ϕ .343 ∇ .262
 \sphericalangle ϕ .425 X 90°, NEAR SIDE



D1003168 TRIM MASS .25 KG, aLIGO BSC-ISI, PART PDM REV: X-003, DRAWING PDM REV: X-003

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY				PART NAME			
DIMENSIONS ARE IN INCHES				1. INTERPRET DRAWING PER ASME Y14.5-1994.				TRIM MASS .25 KG, aLIGO BSC ISI			
TOLERANCES: .XX ± .015 .XXX ± .005				2. REMOVE ALL SHARP EDGES, .03 x 45°.				DESIGNER M.HILLARD 01 Dec. 2010			
ANGULAR ± .5°				3. DO NOT SCALE FROM DRAWING.				DRAFTER M.HILLARD 01 Dec. 2010			
MATERIAL 6061-T6 Al				FINISH 63 μ inch				NEXT ASSY D1003161			
								CHECKER F.MATICHARD 01 Dec. 2010			
								APPROVAL K.MASON 01 Dec. 2010			
								SIZE DWG. NO. B D1003168		REV. v1	
								SCALE: 1:1 PROJECTION: SHEET 1 OF 1			