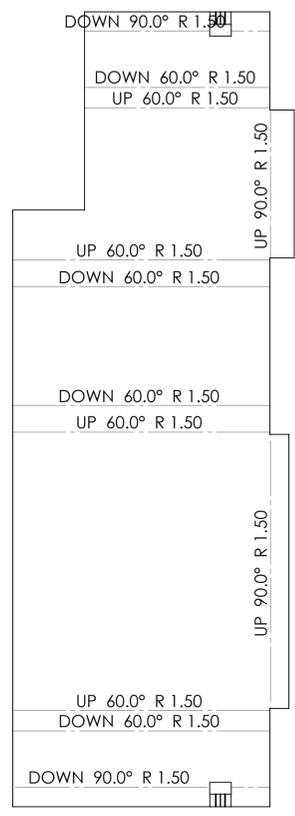
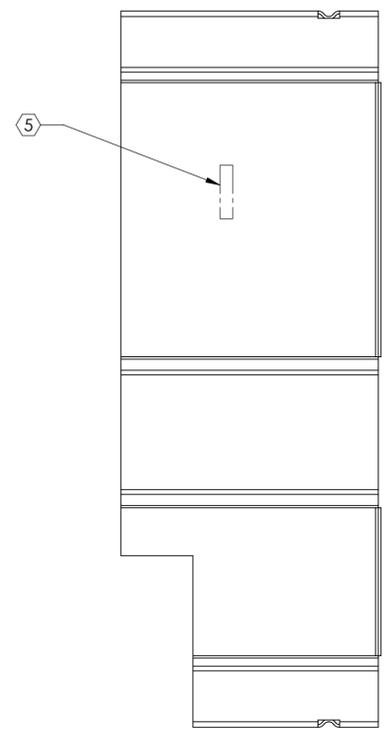
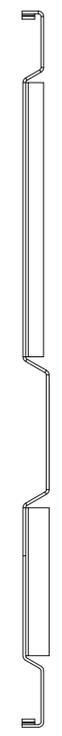


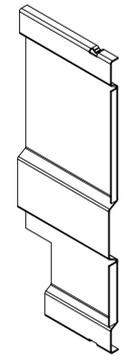
D1100055-010003 SUS LOWER QUAD SHIELD - LH PART PDM REV-X-002 DRAWING PDM REV-X-002

**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. APPROXIMATE WEIGHT = 0.54 LB.
- 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. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- 10. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.



FLAT PATTERN - REF



NOTE: THIS PART IS A MIRROR IMAGE OF D1100054  
 SEE D1100054 FOR DIMENSIONS

<b>NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)</b> 1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.				CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		<b>PART NAME</b> LOWER QUAD SHIELD - LH											
DIMENSIONS ARE IN MILLIMETERS TOLERANCES: .XX ± .25 .XXX ± .13 ANGULAR ± .5°		<b>MATERIAL</b> 16 GAUGE (1.5mm THK) 5052-H32		<b>FINISH</b> 63 μinch		<b>SYSTEM</b> ADVANCED LIGO		<b>SUB-SYSTEM</b> SUS		<b>DESIGNER</b> K. BUCKLAND 14 JAN 2011		<b>SIZE</b> D		<b>DWG. NO.</b> D1100055		<b>REV.</b> v2	
<b>APPROVAL</b>						<b>CHECKER</b>		<b>DRAFTER</b> K. BUCKLAND 14 JAN 2011		<b>SCALE:</b> 1:2		<b>PROJECTION:</b>		SHEET 1 OF 1			

REV.	DATE	DCN #	DRAWING TREE #
V1	14 JAN 2011	-	-
V2	27 JUN 2011	-	-
-	-	-	-