

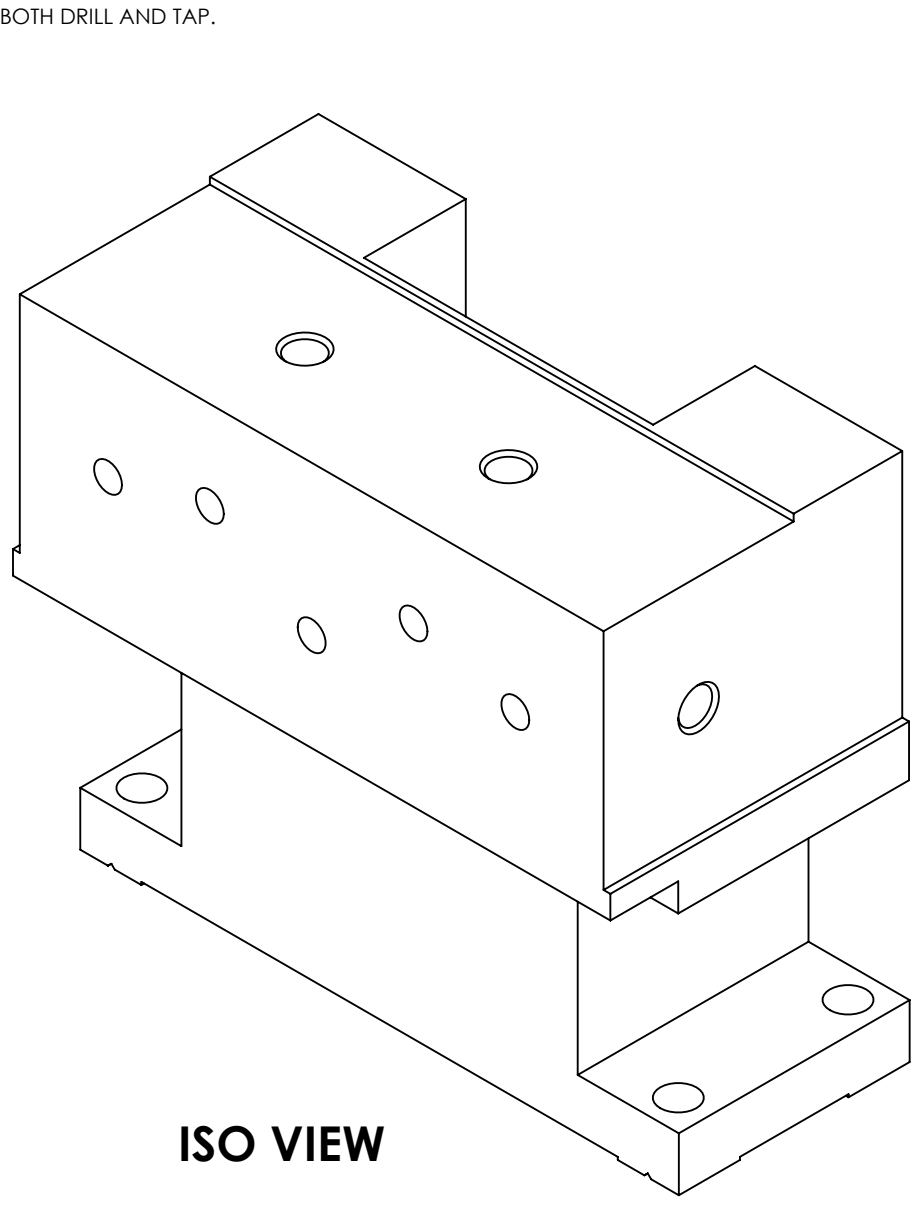
NOTES (CONTINUED):

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

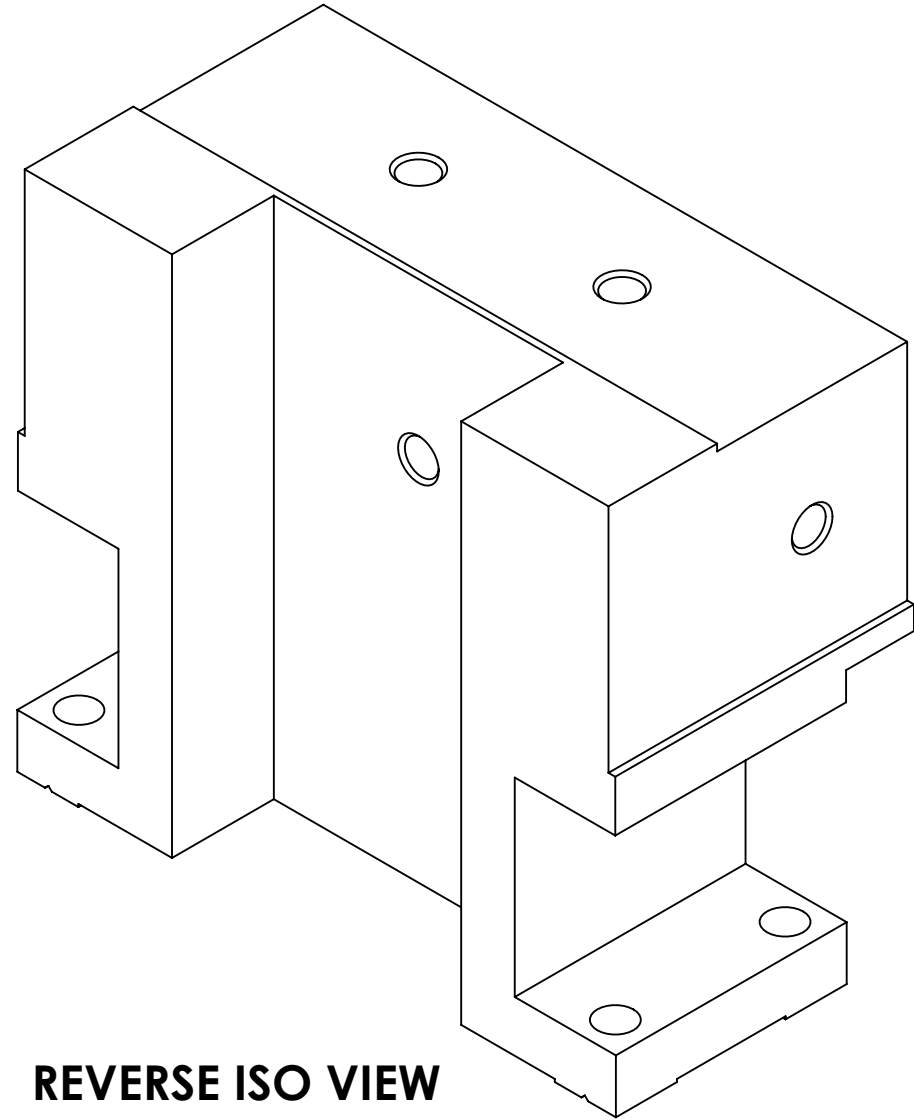
- 6. MASS: 2.914 KG [6.425 LB].
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL, WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE PART SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

⑩ ALL TAPPED HOLES: 0.005 OVERSIZE BOTH DRILL AND TAP.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 MAR 2012	E1101214	



ISO VIEW

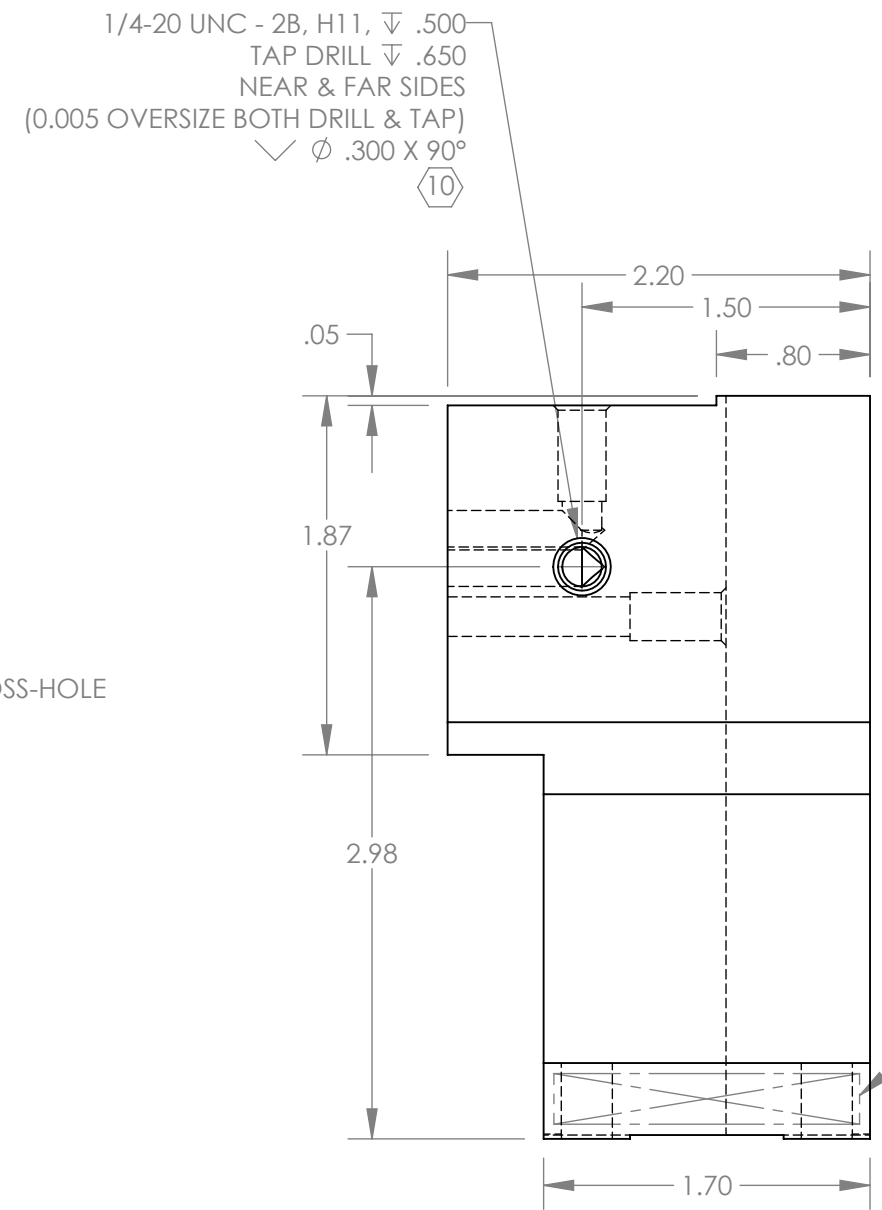
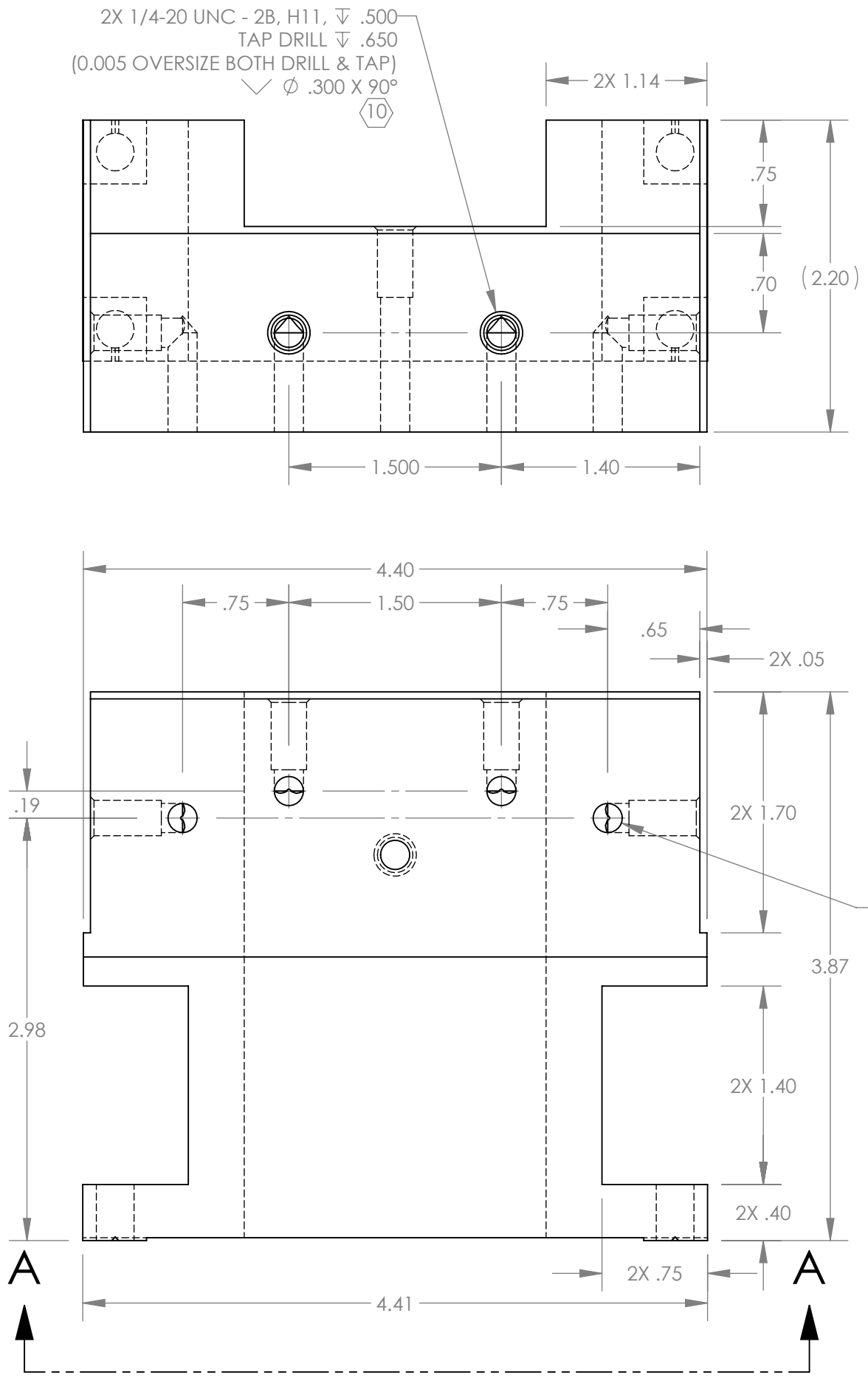


REVERSE ISO VIEW

D1101519 aLIGO TMS Top Add Mass Tower, PART PDM REV: X-014, DRAWING PDM REV: X-000

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.1°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.		aLIGO TMS TOP ADD MASS TOWER	
MATERIAL		FINISH		SYSTEM		SUB-SYSTEM	
304 SSSL		63 µinch Ra		ADVANCED LIGO		AOS	
NEXT ASSY				DESIGNER		SIZE DWG. NO.	
D1101526				K. MAILAND 28 JUL 2011		B D1101519	
APPROVAL				DRAFTER		REV.	
SEE DCN				C. CONLEY 22 MAR 2012		v1	
SCALE: NONE				CHECKER		PROJECTION:	
PROJECTION:				SEE DCN		SHEET 1 OF 3	

D1101519 dLIGO TMS Top Add Mass Tower, PART PDM REV: X-014, DRAWING PDM REV: X-000



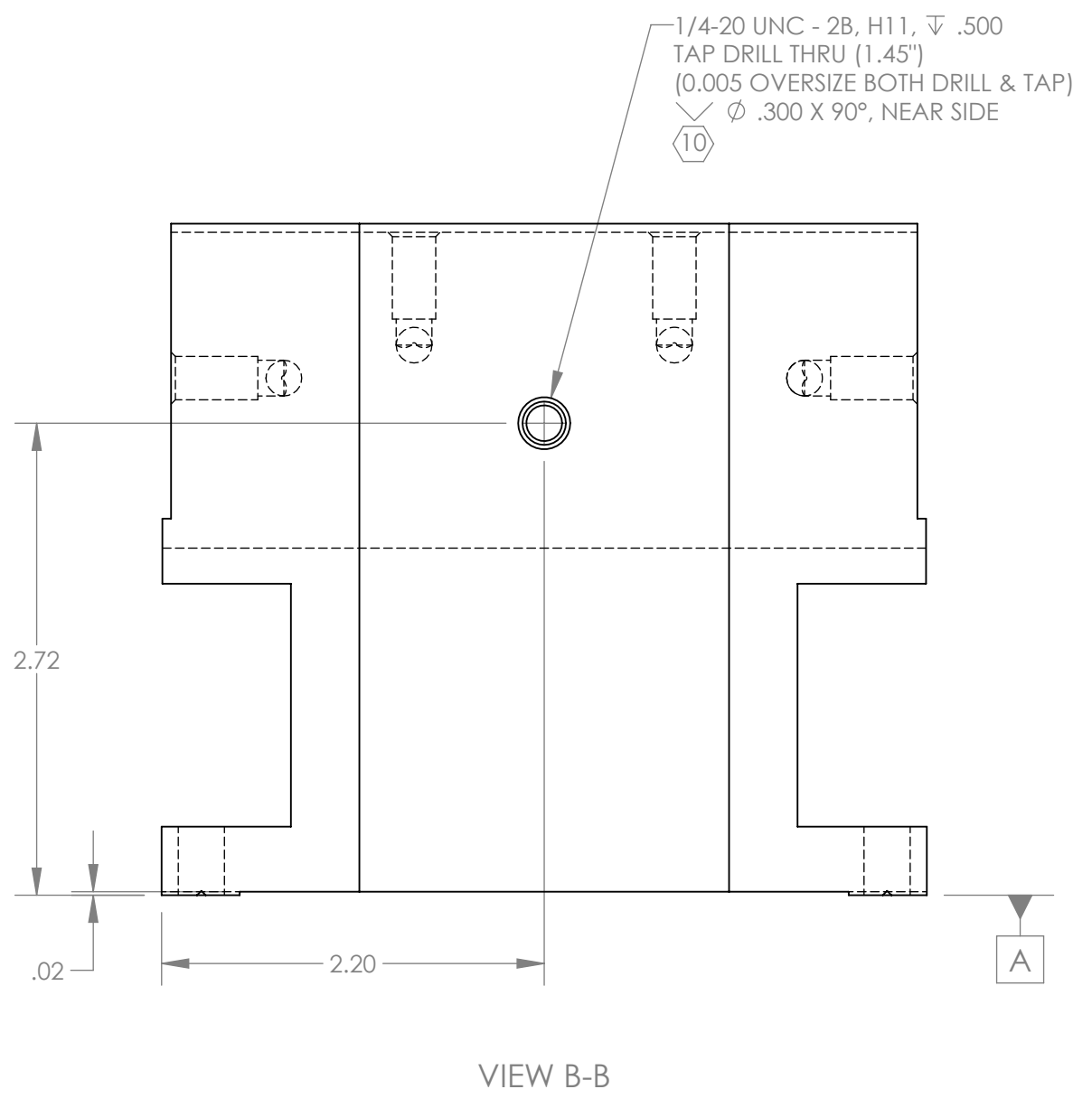
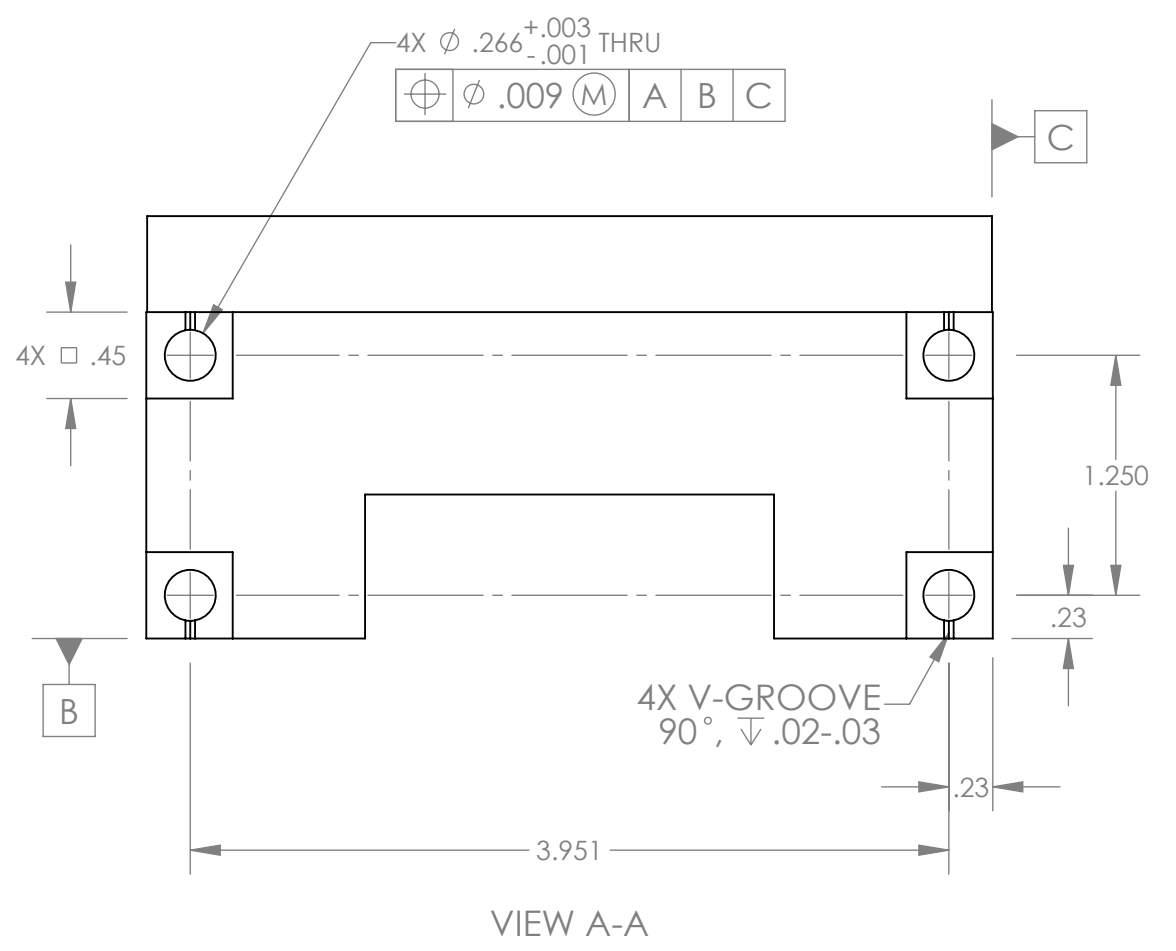
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SIZE	DWG. NO.	REV.
B	D1101519	v1
SCALE: NONE		PROJECTION:
		SHEET 2 OF 3

D1101519 dLIGO TMS Top Add Mass Tower, PART PDM REV: X-014, DRAWING PDM REV: X-000

8 7 6 5 4 3 2 1

D
C
B
A



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SIZE	DWG. NO.	REV.
B	D1101519	v1
SCALE: NONE		PROJECTION:
SHEET 3 OF 3		

8 7 6 5 4 3 2 1