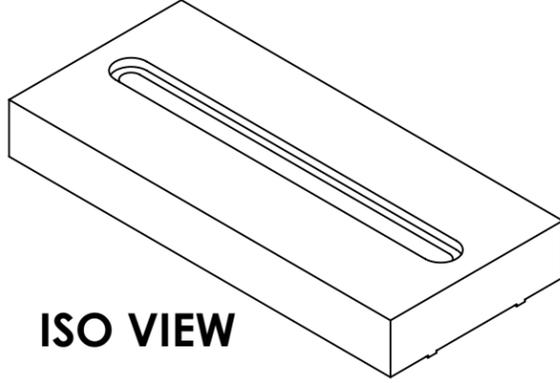


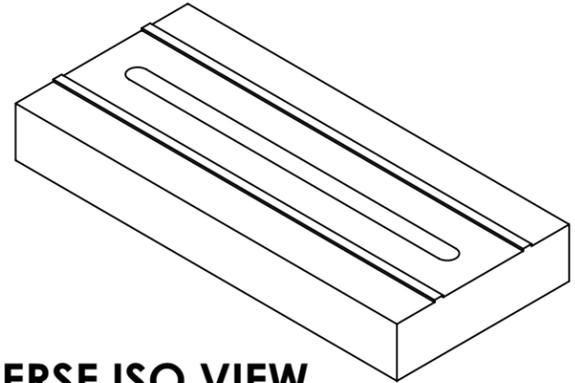
**NOTES (CONTINUED):**

- 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: 1.422 KG [3.134 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.

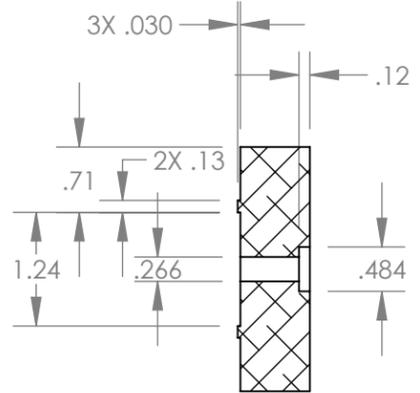
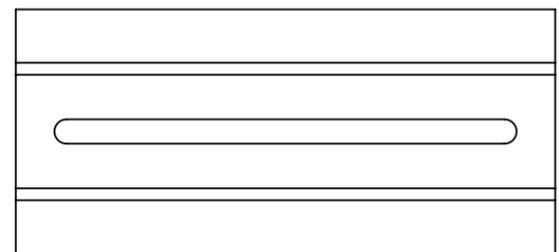
REV.	DATE	DCN #	DRAWING TREE #
v1	23 MAR 2012	E1101214	
v2	11 APR 2012	E1101214	



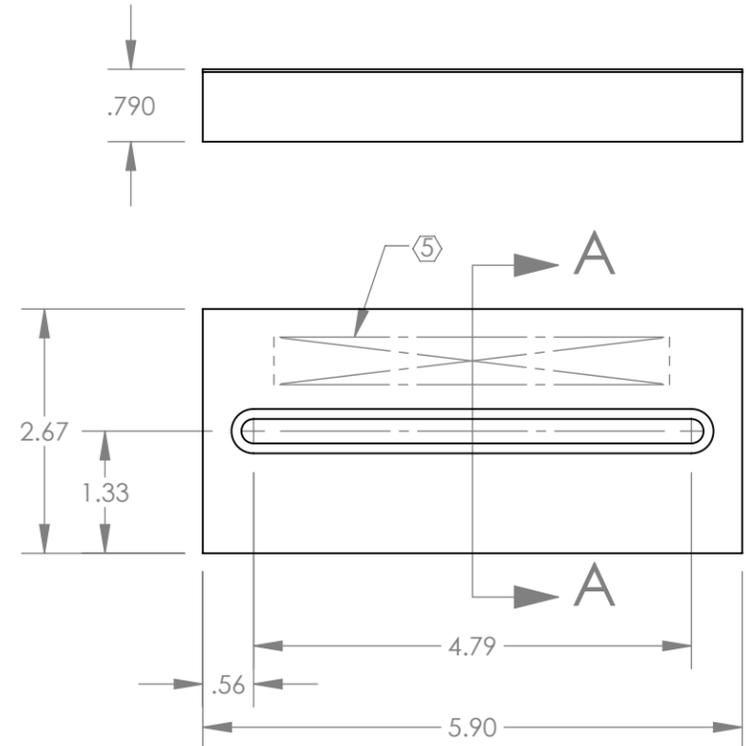
**ISO VIEW**



**REVERSE ISO VIEW**



**SECTION A-A**



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		aLIGO TMS UPPER ROLL TRIM MASS	
TOLERANCES: .XX ± .01 .XXX ± .005				SUB-SYSTEM AOS		DESIGNER	K. MAILAND 28 JUL 2011
ANGULAR ± 0.1°				NEXT ASSY D1101526		DRAFTER	C. CONLEY 23 MAR 2012
MATERIAL 304 SSTL				FINISH 63 μinch Ra		CHECKER	SEE DCN
						APPROVAL	SEE DCN
						SIZE	DWG. NO. B D1101520
						REV.	v2
						SCALE	NONE
						PROJECTION	AS SHOWN
						SHEET 1 OF 1	

D1101520 aLIGO TMS Upper Roll Trim Mass, PART PDM REV: X-016, DRAWING PDM REV: X-003