

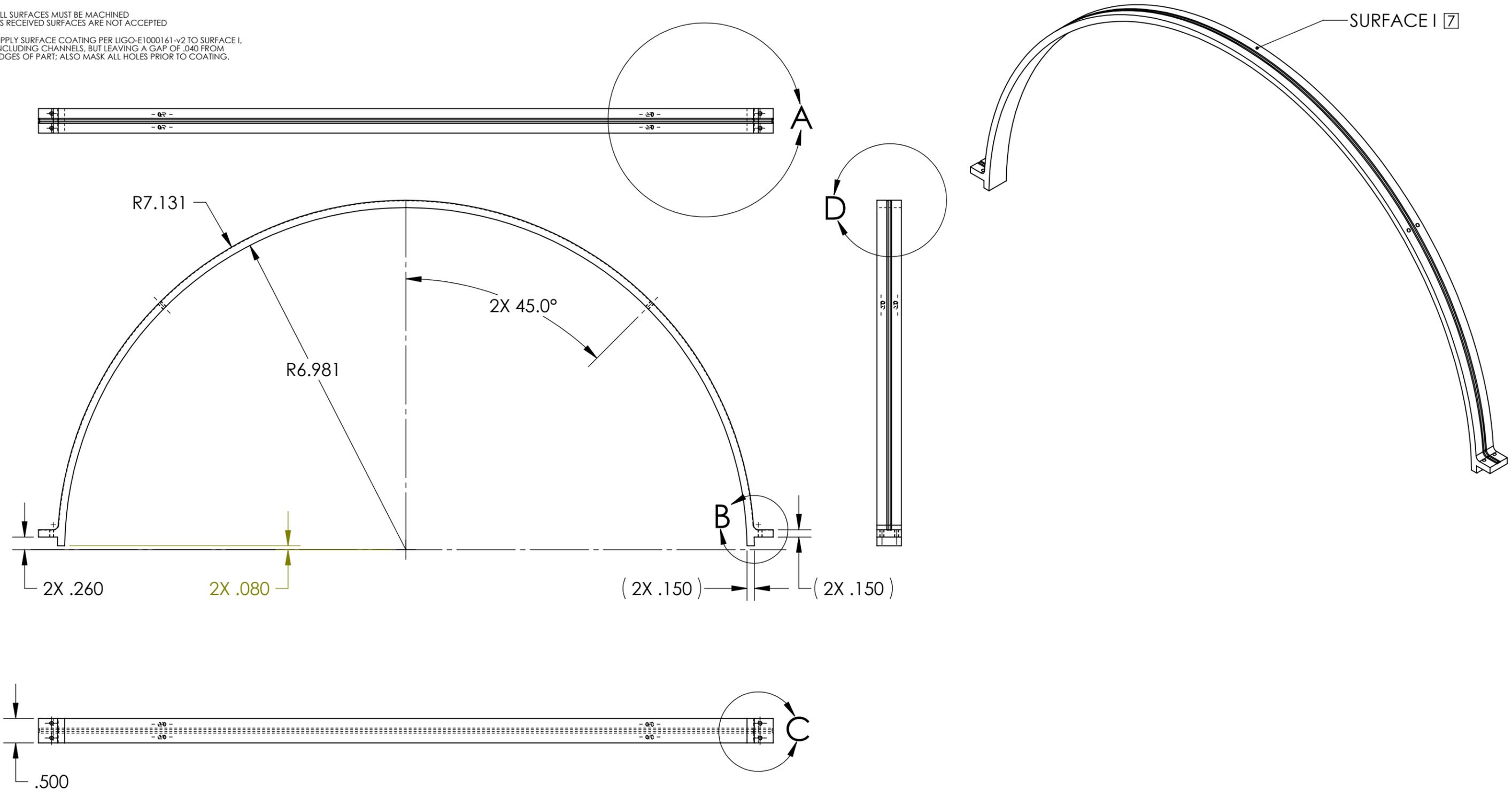
D1000943 ALIGO IO TEST MASS RING HEATER INNER RING, PART PDM REV: X-016, DRAWING PDM REV: X-010

**NOTES CONTINUED:**  
 5 SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.

6 ALL SURFACES MUST BE MACHINED AS RECEIVED SURFACES ARE NOT ACCEPTED

7 APPLY SURFACE COATING PER LIGO-E1000161-v2 TO SURFACE I, INCLUDING CHANNELS, BUT LEAVING A GAP OF .040 FROM EDGES OF PART; ALSO MASK ALL HOLES PRIOR TO COATING.

REV.	DATE	DCN #	DRAWING TREE #
v1	19 MAY 2010	E1000168-v1	-
-	-	-	-
-	-	-	-



**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

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, R.02 MIN.  
 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.

**MATERIAL** 6061 Alloy **FINISH** 32 μinch

**LIGO** UNIVERSITY OF FLORIDA  
 CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

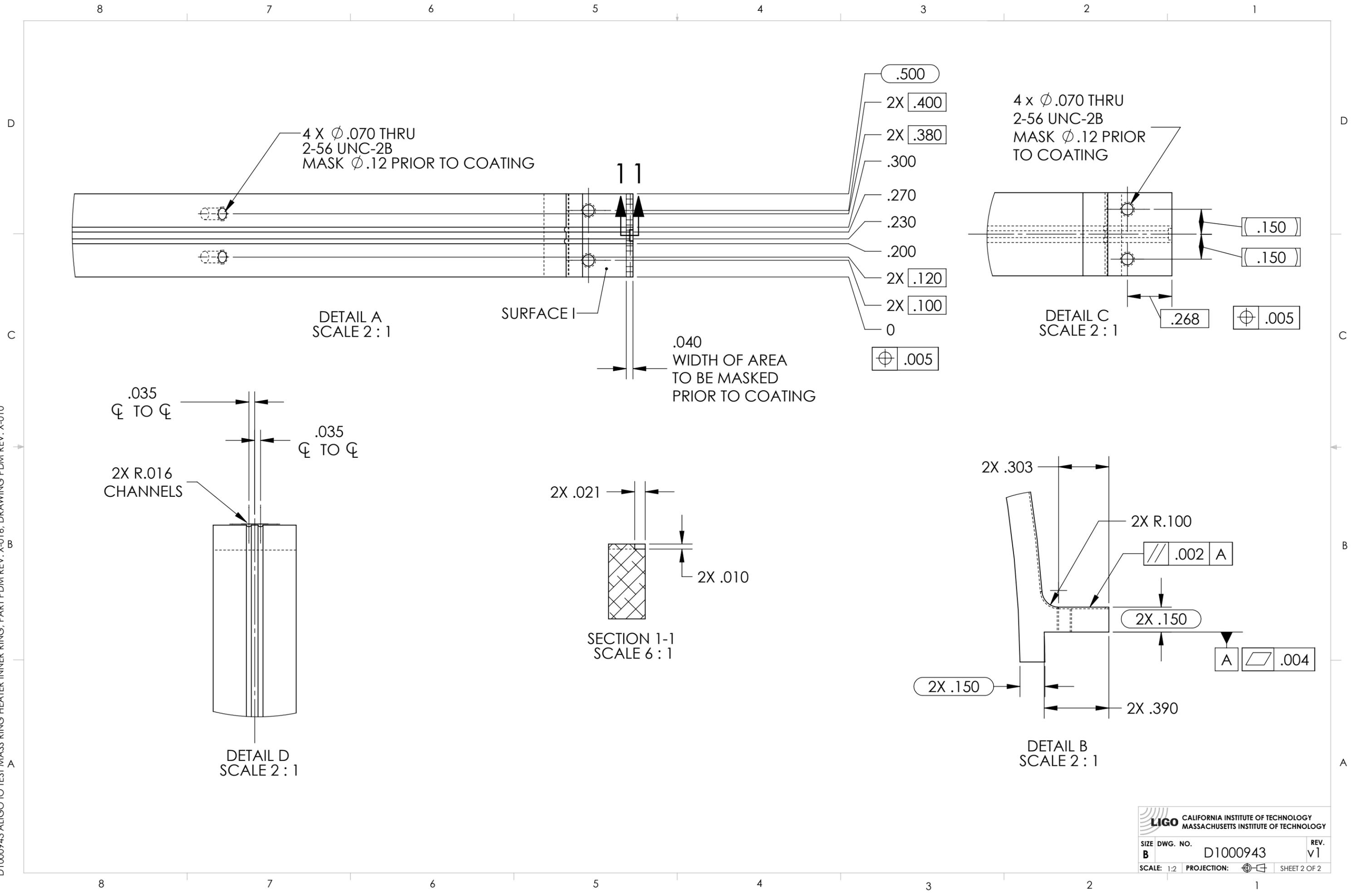
**SYSTEM** ADVANCED LIGO **SUB-SYSTEM** IOO

**NEXT ASSY** D1000945

**PART NAME** TEST MASS RING HEATER INNER RING

<b>DESIGNER</b> P. SAINATHAN	30 APR 2010	<b>SIZE</b> B	<b>DWG. NO.</b> D1000943	<b>REV.</b> v1
<b>DRAFTER</b> P. SAINATHAN	05 MAY 2010			
<b>CHECKER</b> M. JACOBSON	10 MAY 2010			
<b>APPROVAL</b> M. ARAIN	10 MAY 2010	<b>SCALE:</b> 1:2	<b>PROJECTION:</b>	<b>SHEET</b> 1 OF 2

D1000943 ALIGO IO TEST MASS RING HEATER INNER RING, PART PDM REV: X-016, DRAWING PDM REV: X-010



4 X  $\phi$ .070 THRU  
2-56 UNC-2B  
MASK  $\phi$ .12 PRIOR TO COATING

DETAIL A  
SCALE 2:1

SURFACE I

.040  
WIDTH OF AREA  
TO BE MASKED  
PRIOR TO COATING

4 x  $\phi$ .070 THRU  
2-56 UNC-2B  
MASK  $\phi$ .12 PRIOR TO  
TO COATING

DETAIL C  
SCALE 2:1

.035  
 $\phi$  TO  $\phi$

2X R.016  
CHANNELS

DETAIL D  
SCALE 2:1

2X .021

SECTION 1-1  
SCALE 6:1

2X .010

2X .303

2X R.100

/// .002 A

2X .150

A // .004

2X .150

2X .390

DETAIL B  
SCALE 2:1

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D1000943	v1
SCALE: 1:2	PROJECTION:	SHEET 2 OF 2