



SEE DETAIL A

PART NO. (SEE NOTE 4)
TO BE ETCHED OR STAMPED
IN APPROX POSITION SHOWN.

- ADDITIONAL NOTES:
- MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 - ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - ALL HELICOIL HOLES TO BE PREPARED ACCORDING TO EMHART HELICOIL PRODUCT CATALOG, HC2000, REV 4.
 - ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.
 - 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 SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF/WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICERS REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

1. REMOVE ALL SHARP EDGES. 2. DO NOT SCALE FROM DRAWING. 3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE. SUCH AS CINCINNATI MISCROW'S CIMTECH 410 (STAINLESS STEEL). 4. SCRIBE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE 01* HIGH CHARACTERS. EXAMPLE: 0020105-001: A VIBRATOR TOOL MAY BE USED.		DIMENSIONS ARE IN mm (INCHES) TOLERANCES: X.XX ±.01 ANGULAR ±0.25° MATERIAL: AL ALLOY NAME: 5083 OR 6061-T6 FINISH: CLEAN AND DEGREASED Ra = 1.6 (63 MICRO INCH)	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IOP, GLASGOW UNIVERSITY GEC ROF GROUP RUTHERFORD APPLTON LABORATORIES SYSTEM: aLIGO SUB-SYSTEM: SUS NEXT ASSY: ITM QUAD PART NAME: HALF MASS (DUMMY HALF ITM CP)
DRAWN: J O'BELL CHECKED: J'OD APPROVED: NAR	DATE: 24/AUG/10 DATE: 01/DEC/10 DATE: 02/DEC/10	DRG. NO.: D1002205 SCALE: 1:1 PROJECTION:	BY: D SHEET 1 OF 1