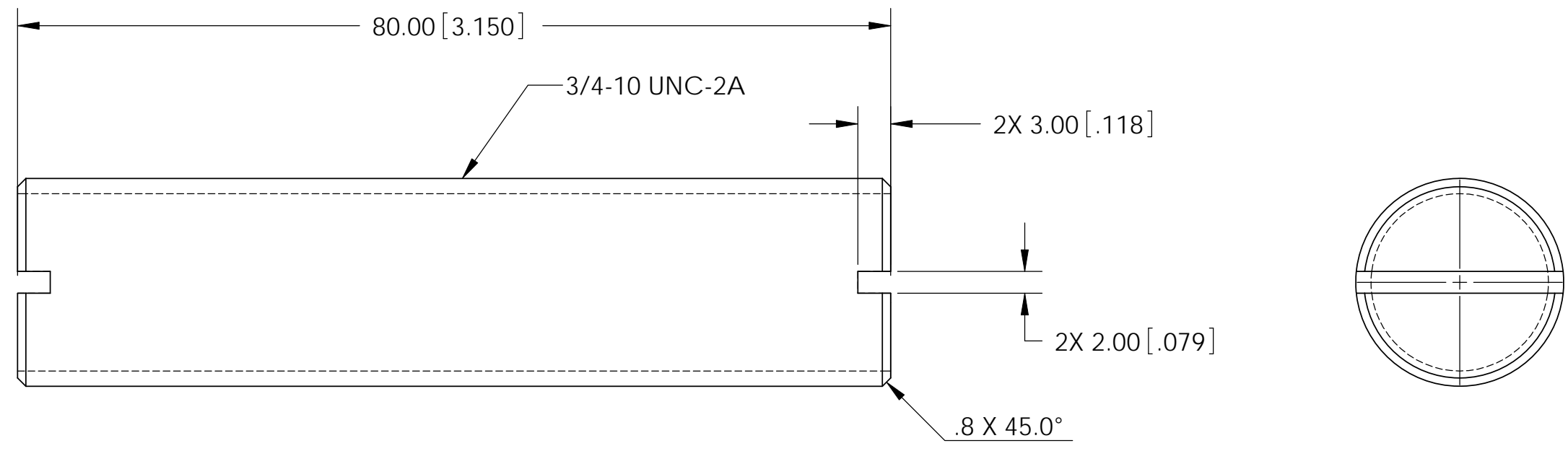


REV.	DATE	DCN #	DRAWING TREE #
v1	09 June 2011	E1100449	E1100450

NOTES CONTINUED:

4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
5. SCRIBE, ENGRAVE, 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. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
EXAMPLE (PART) : 001-V1
EXAMPLE (TAG) DXXXXXX-VY, TYPE-XX, S/N XXX QTY:TBD.
6. APPROXIMATE WEIGHT = 180 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES (INCLUDING SANDING OR SCOURING FOR MATTE FINISH) IS NOT ALLOWED. USE OF SCOTCH-BRITE OR SIMILAR PRODUCTS IS FORBIDDEN.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. ALL MATERIAL TO BE VIRGIN MATERIAL, (I.E. NOT WELD REPAIRS OR PLUGS) UNLESS APPROVED IN ADVANCE AND IN WRITING BY LIGO, REFER TO LIGO-E0900364.
10. 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 USED MUST BE VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF AND WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH THE MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.
11. MATERIAL PER ASTM A193 GRADE B8N REF MCMMASTER # 94400A175.



D1101080, PART PDM REV: X-002, DRAWING PDM REV: X-001

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN MM [INCHES]		1. INTERPRET DRAWING PER ASME Y14.5-1994.		SYSTEM		SUB-SYSTEM		DESIGNER		SIZE	
TOLERANCES: .XX ± .381[.015] .XXX ± .127[.005]		2. REMOVE ALL SHARP EDGES, .76[.03] x 45°.		ADVANCED LIGO		SUS		DRAFTER		DWG. NO.	
ANGULAR ± .5°		3. DO NOT SCALE FROM DRAWING.		MATERIAL		NEXT ASSY		CHECKER		REV.	
				316 SSSL SEE NOTE 11		D060375		J.LEWIS		B	
				FINISH				APPROVAL		SCALE: 2:1	
				63 μinch				J.ROMIE		PROJECTION:	
								09 June 2011		SHEET 1 OF 1	
								09 June 2011		D1101080	