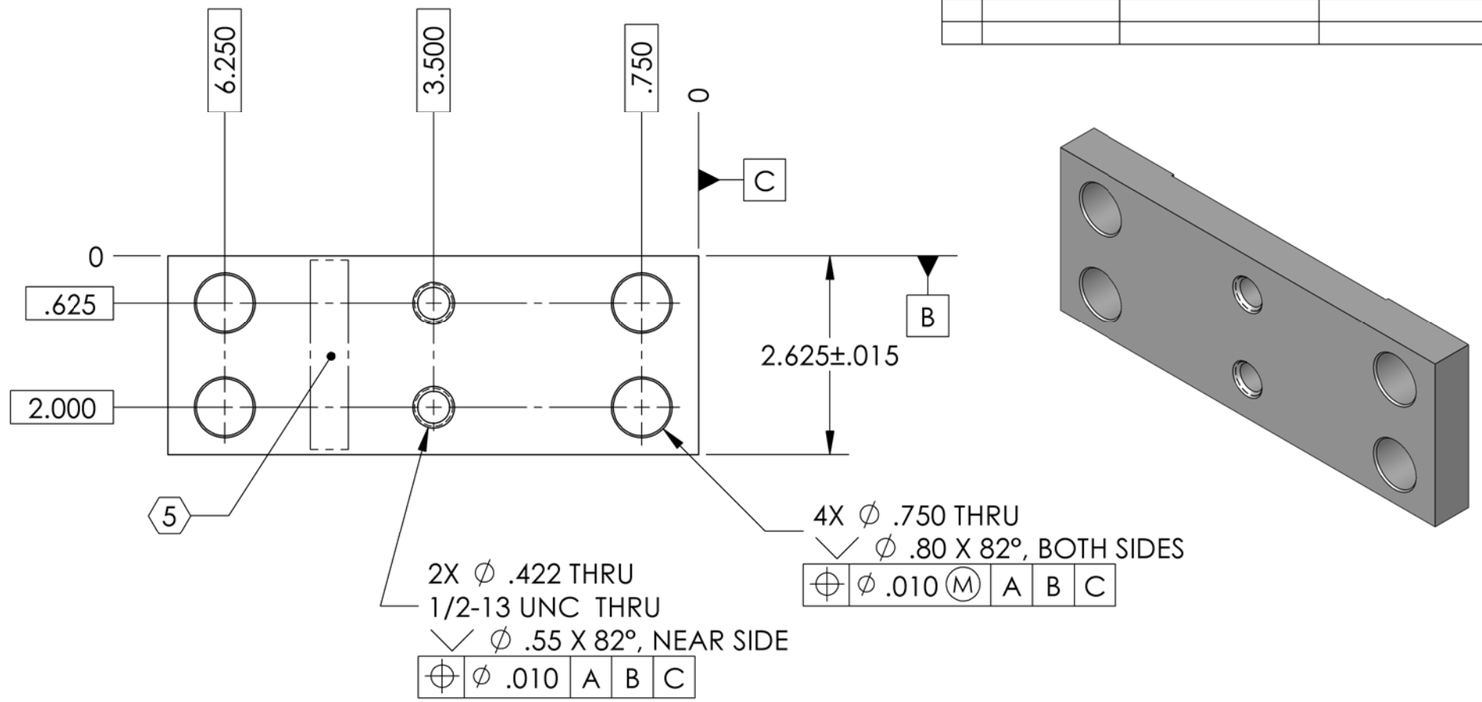
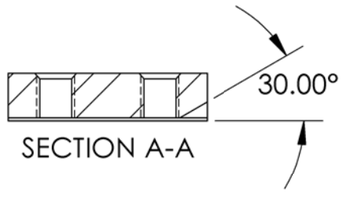
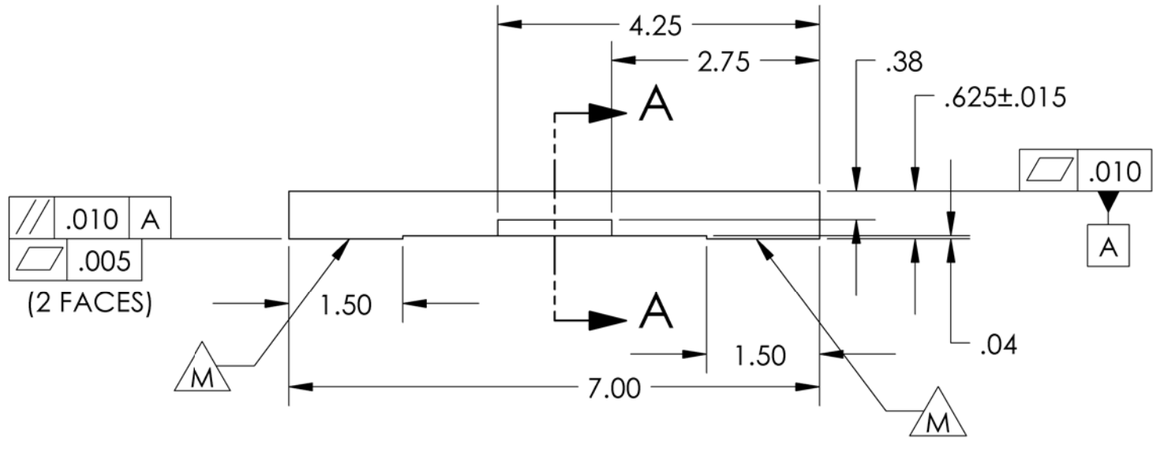
NOTES CONTINUED:

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. USE MINIMUM 0.12 HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXXX-VY, TYPE-XX, S/N XXX.
6. APPROXIMATE WEIGHT = 2.77 LB.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. PAINT: ALL VISIBLE SURFACES (exclude fastening hardware) EXCEPT AREAS IDENTIFIED BY M
   MEDIUM BLUE SHERWIN WILLIAMS (POLANE (R) T-PLUS POLYURETHANE ENAMEL) #SW-F63TX-L-2822-5864
   PRIME WITH SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER P60G2
9. "OXI SOLV RUST INHIBITOR" TO BE APPLIED PER MFG. INSTRUCTIONS TO ALL UNPAINTED SURFACES.
   BOTH TAPPED AND THRU HOLES WILL BE PLUGGED DURING APPLICATION.

REV.	DATE	DCN #	DRAWING TREE #
v2	11 Mar. 2011	E1100015	E1100016







NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)								
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± .5°	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 MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: HAM HEPI Caging Rear Plate			
	MATERIAL: AISI 1018 Steel, Cold Rolled	FINISH: 63 µinch	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: SEI	DESIGNER: A. STEIN 27 Jaan. 2009	SIZE: B	DWG. NO.: D080493	REV.: v2
			NEXT ASSY: D080496		DRAFTER: M.HILLARD 11 Mar. 2011			
					CHECKER: A.STEIN 27 Aug. 2009			
					APPROVAL: K.MASON 11 Mar. 2011	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1

D080493_HAM_HEPI_Caging_Rear_Plate, PART PDM REV: X-002, DRAWING PDM REV: X-001