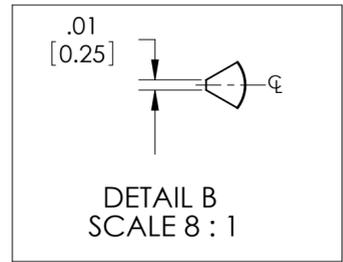
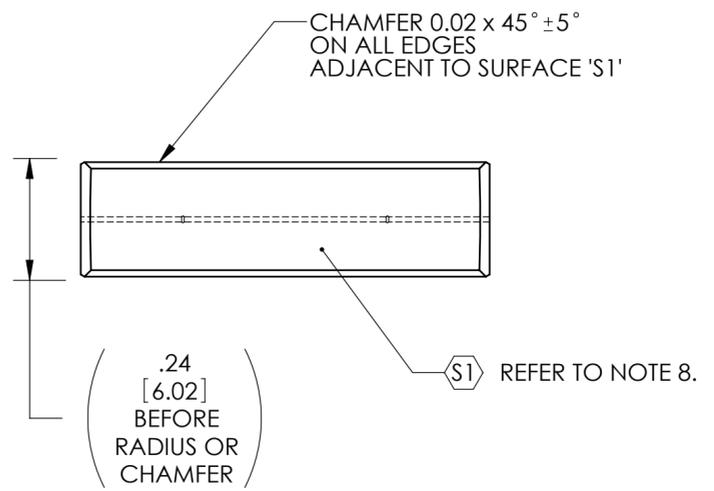
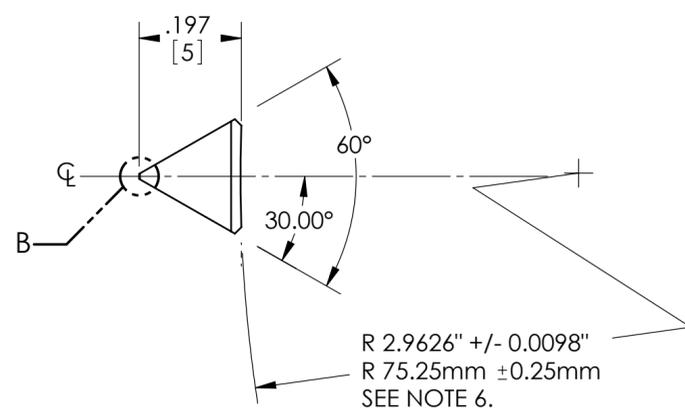
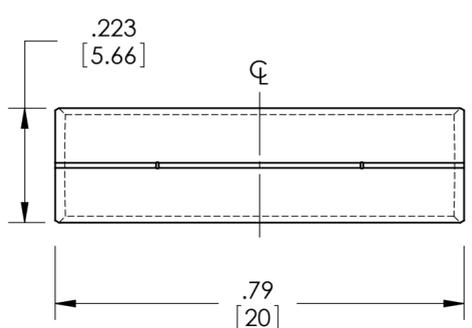
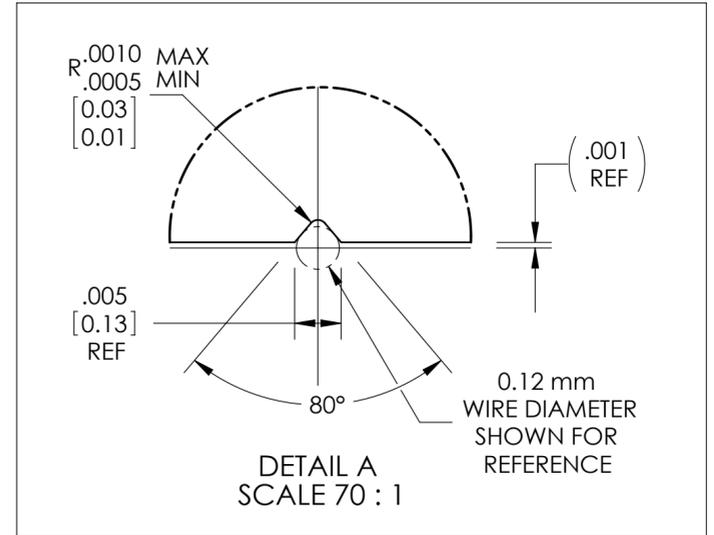
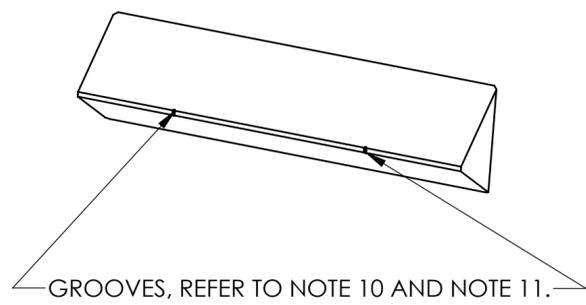
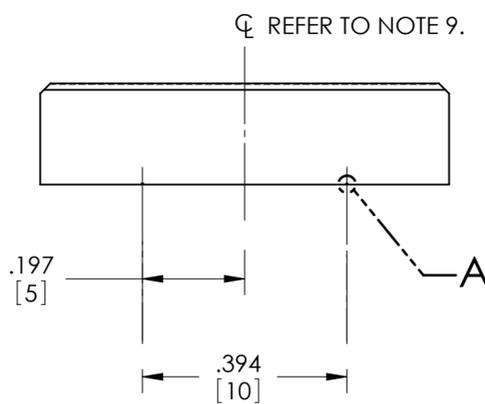


- NOTES:**
1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. DO NOT SCALE FROM DRAWING.
 3. MINIMIZE EDGE CHIPPING.
 4. REMOVE ALL SHARP EDGES.
 5. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.
 6. CYLINDRICAL RADIUS TO BE ADDED TO SURFACE 'S1'.
 7. PRISM NOT TO BE USED FOR OPTICAL PURPOSES.
 8. INSPECTION POLISH ALL FACES INCLUDING SURFACE 'S1'.
 9. STRADDLE ϕ WITHIN .004" [0.1 mm] T.I.R. (TOTAL INDICATED RUNOUT) OF FEATURE "A".
 10. IDENTICAL GROOVES TO LOCATE AND SEPARATE TWO (SPRING STEEL) WIRES.
 11. PLEASE USE LASER ABLATION TO CREATE GROOVES. A HIGH SURFACE QUALITY IS REQUIRED ON THE INTERNAL SURFACES OF THE GROOVES AND IN THE GENERAL VICINITY OF THE GROOVES. PLEASE DISCUSS BEST EFFORTS WITH LIGO STAFF.
 12. BAG AND TAG PARTS INDIVIDUALLY WITH THEIR DRAWING PART NUMBER, REVISION, AND SERIAL NUMBER. SERIAL NUMBERS START AT 500 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. EXAMPLE: DXXXXXX-VY, S/N XXX

REV.	DATE	DCN #	DRAWING TREE #
v1	02 FEB 2009	RFI USE ONLY (NO DCN)	-
v2	20 FEB 2009	E0900024	-
v3	31 MAR 2009	E0900099	-
v4	23 JUN 2010	E1000231	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES [MM]

TOLERANCES:
 .XX ± .01
 .XXX ± .005

ANGULAR ± 1.0°

MATERIAL	FINISH
SAPPHIRE	INSPECTION POLISH

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM	SUB-SYSTEM
ADVANCED LIGO	SUS
NEXT ASSY	HSTS LOWER MASS

PART NAME				HSTS LOWER MASS PRIMARY PRISM			
DESIGNER	C. TORRIE	11 DEC 2008	SIZE	DWG. NO.	D0810033	REV.	v4
DRAFTER	M. MEYER	24 AUG 2010	c				
CHECKER	J. ROMIE	24 AUG 2010					
APPROVAL			SCALE:	4:1	PROJECTION:	SHEET 1 OF 1	