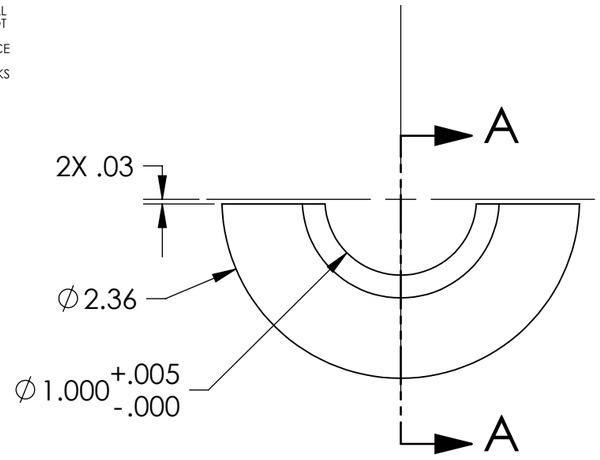
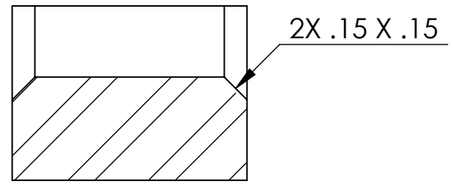
REV.	DATE	DCN #	DRAWING TREE #
v1	22 JUN 2009	E0900173	E080191
v2	28 JUN 2010	E1000236	E080191
-	-	-	-

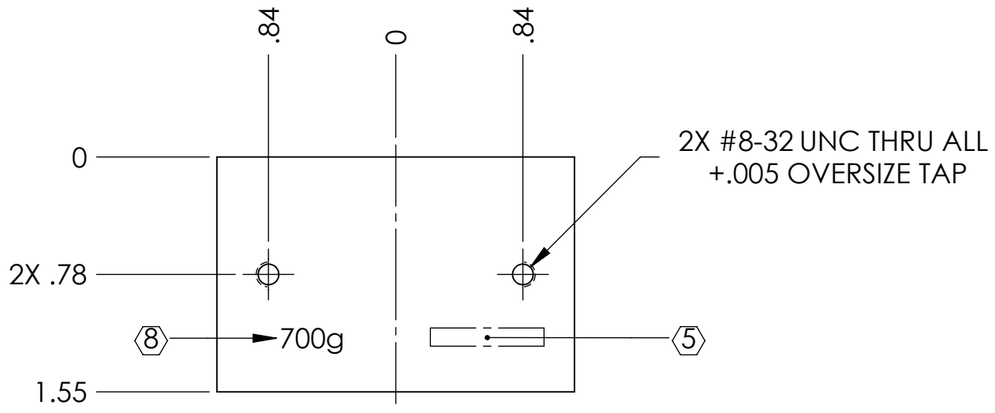
NOTES CONTINUED:

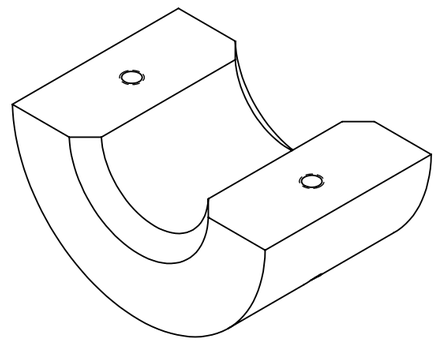
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) AS MARKED ON NOTED SURFACE OF PART. USE .12" HIGH CHARACTERS.





SECTION A-A





NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)							
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°	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: COLLAR, LOWER, 700g		
	MATERIAL: 304 SSTL	FINISH: 32 µinch	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: SUS	DESIGNER: D. BRIDGES 29 AUG 2008	SIZE: B	DWG. NO.: D080236 REV: v2
			NEXT ASSY: INT. MASS CHANGER		DRAFTER: R. BIEDENHARN 29 OCT 2010		
					CHECKER: D. BRIDGES 04 NOV 2010		
					APPROVAL	SCALE: 1:1	PROJECTION: SHEET 1 OF 1

D080236_Advanced_LIGO_SUS_HLTS_Collar_Lower_700g_Intermediate_Mass, PART PDM REV: V1, DRAWING PDM REV: V1-001