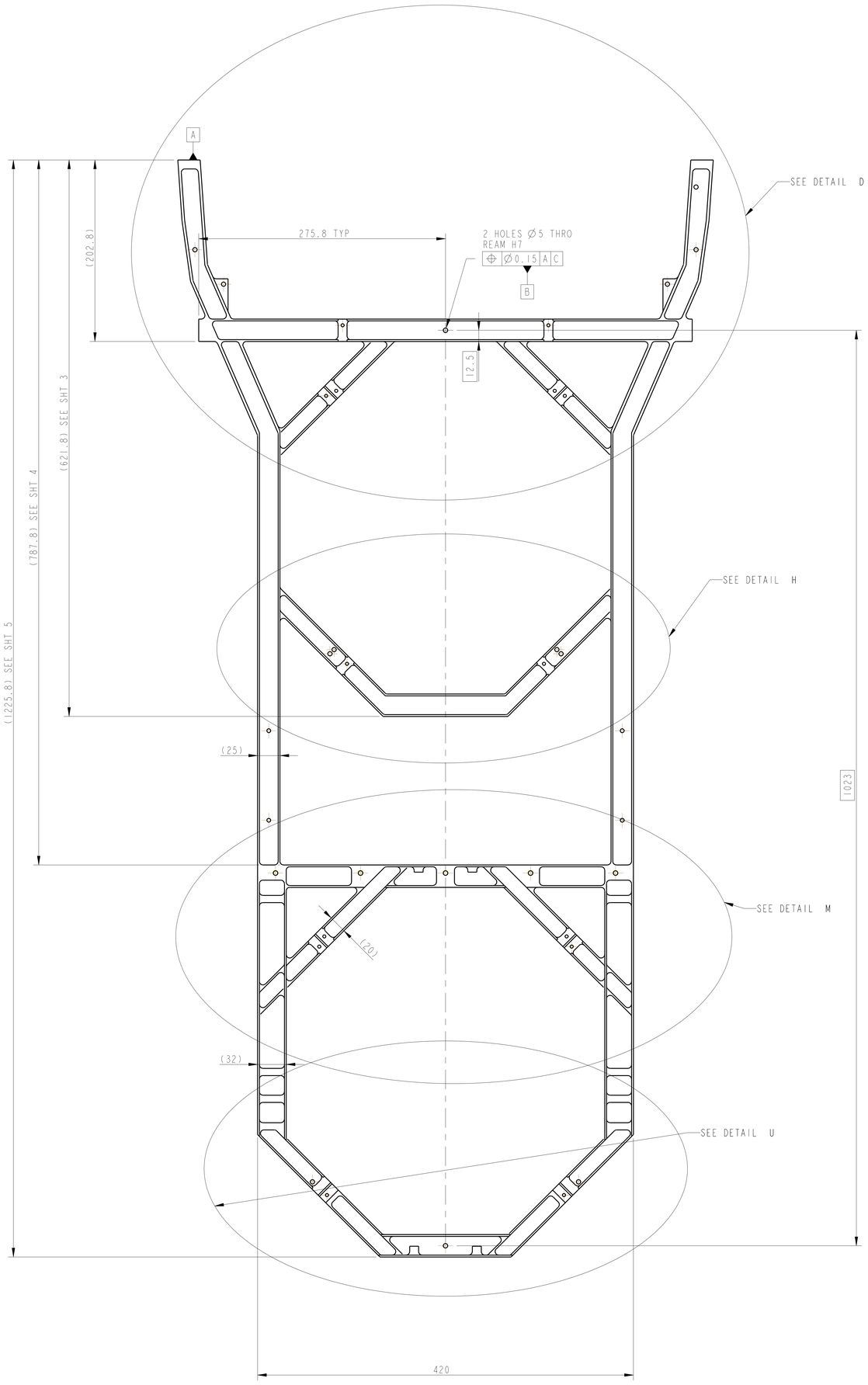
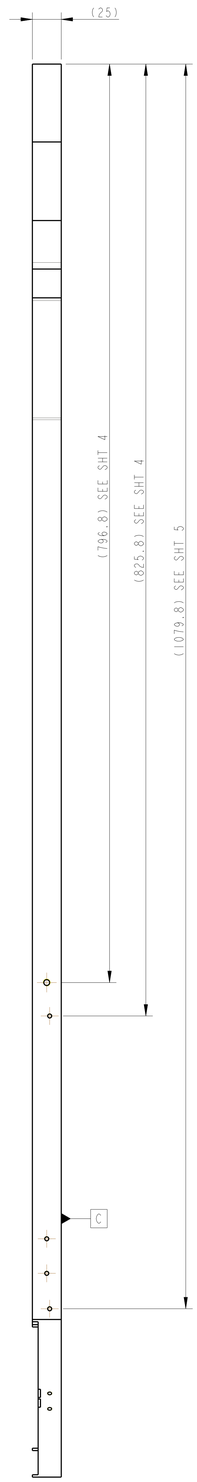
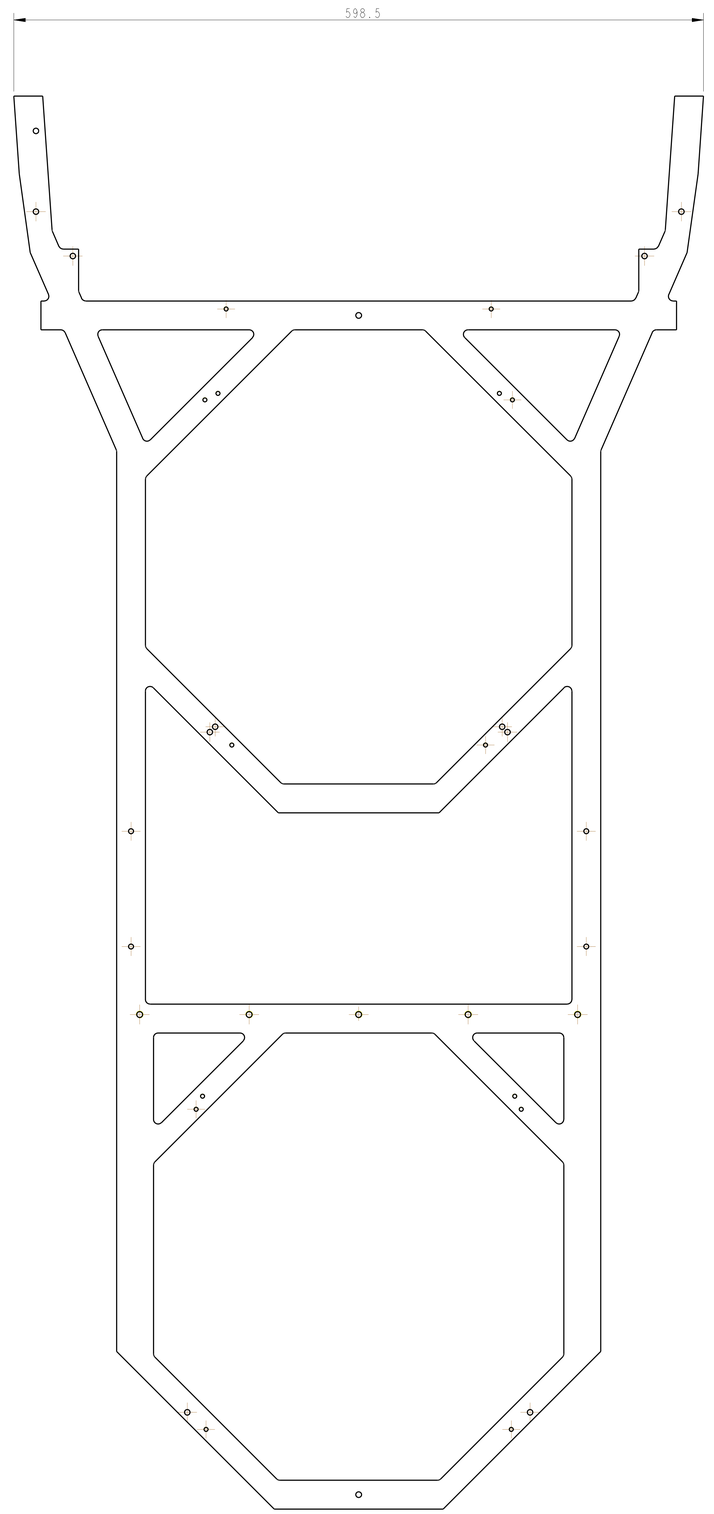
INTRALINK NAME: D060434

REV.	DATE	DCN #	DRAWING TREE #
A	30-OCT-06	E060260-00	.
B	21/DEC/07	E060260-B	.
C	28/JULY/08	E080405	
D	9/SEPT/08	E080473	







NOTES: (UNLESS OTHERWISE SPECIFIED)

1. REMOVE ALL SHARP EDGES, R.02 MIN.
2. DO NOT SCALE FROM DRAWING.
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)
4. SCRIBE, ENGRAVE OR STAMP DRAWING PARTNUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE 13" HIGH CHARACTERS. EXAMPLE: D020180-001. A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X.XX ±0.2 mm (INCHES)
ANGULAR ±0.25°

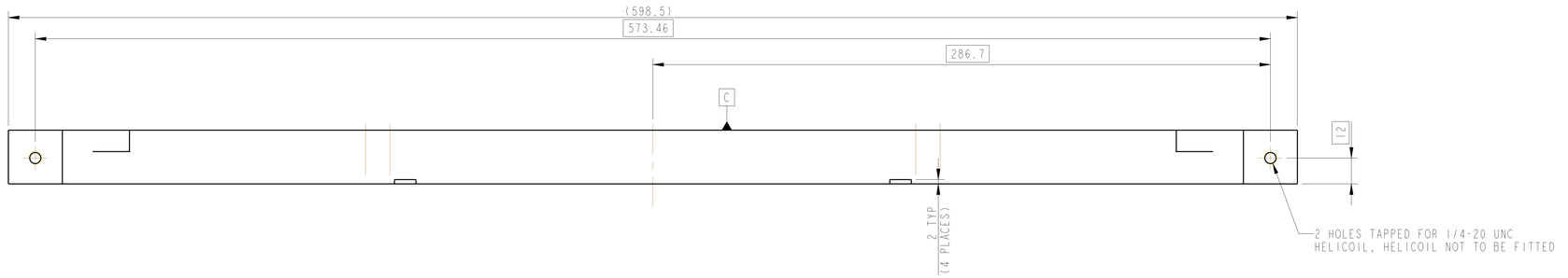
MATERIAL: ALUMINIUM ALLOY 6082

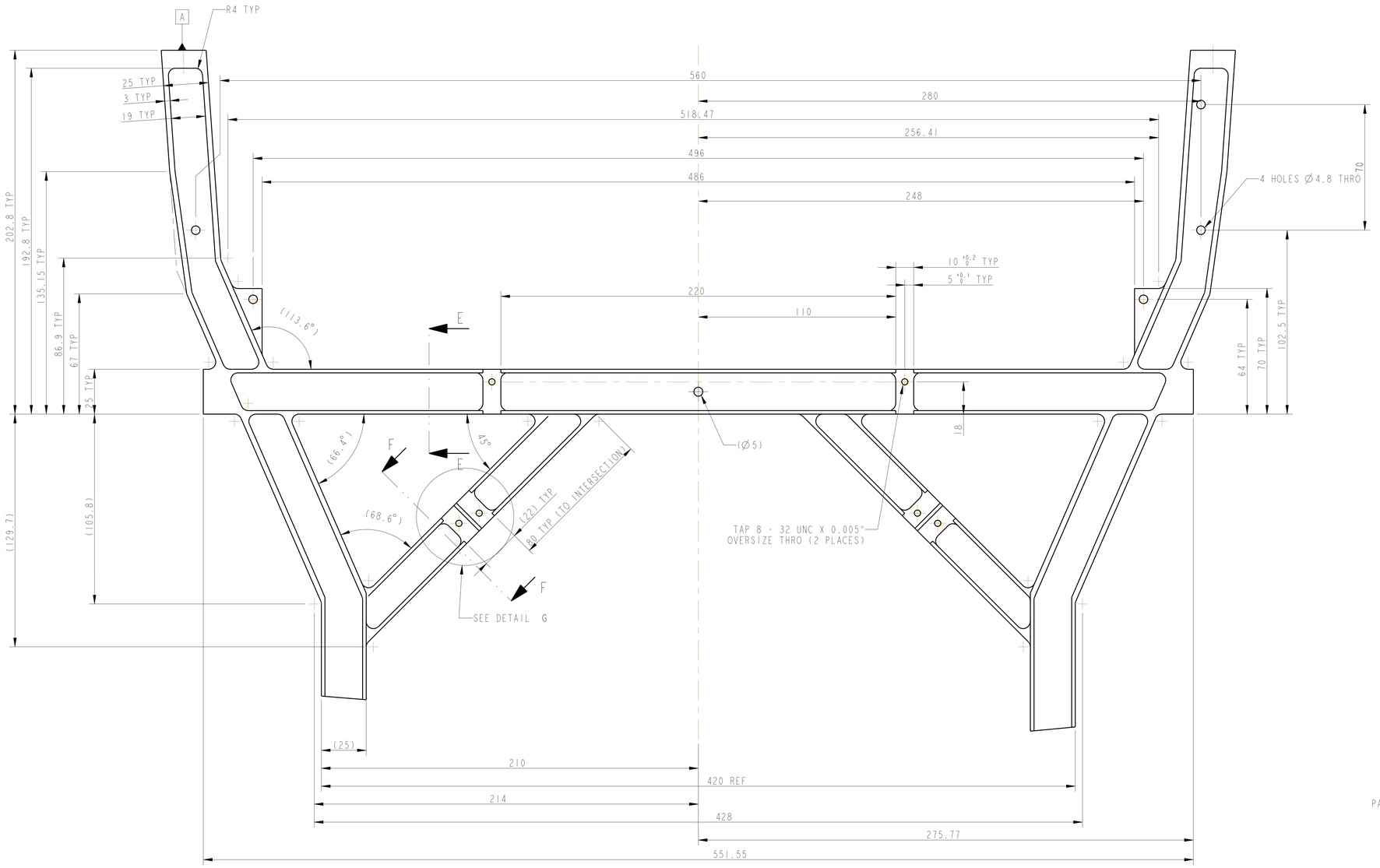
FINISH: m (µin) Ra = 3.2

	NAME	DATE
DRAWN	S DUTTERWORTH	08/04/04
CHECKED	KJB	9/SEPT/08
APPROVED	KW	-/-/-/-

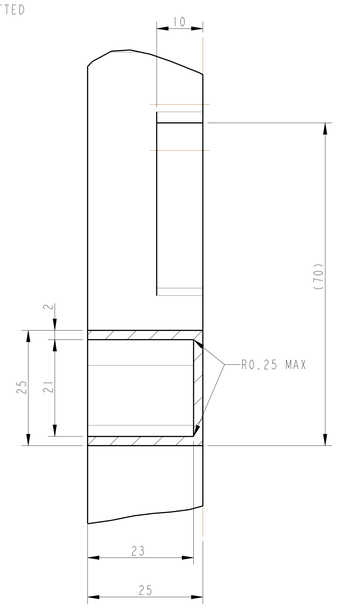
CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
IGR, GLASGOW UNIVERSITY GEO 600 GROUP
RUTHERFORD APPLETON LABORATORIES

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: QUAD NPTYPE LOWER STRUCTURE
PART NAME: OUTER FACE PLATE LOWER STRUCTURE
SIZE: E
DWG. NO.: D060434
REV: D.
SCALE 1:2 PROJECTION
SHEET 1 OF 1

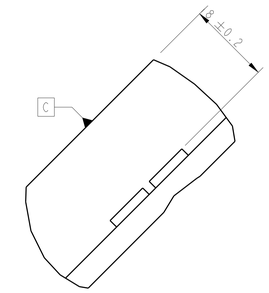




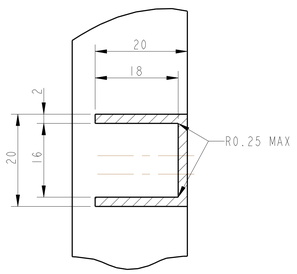
DETAIL D
(SEE SHT 1)
SCALE 1:1



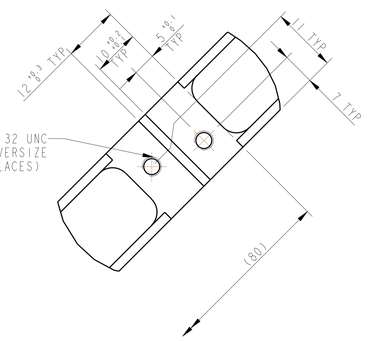
SECTION E-E
SHOWING DEPTH OF SECTION
SCALE 2:1



PARTIAL VIEW OF PROJECTION
OF SECTION G



PARTIAL SECTION F-F
SHOWING DEPTH OF SECTION
SCALE 2:1



DETAIL G
SHOWING HOLE DETAILS
SCALE 2:1

NOTES: (UNLESS OTHERWISE SPECIFIED)
1. REMOVE ALL SHARP EDGES. 0.10 MIN.
2. DO NOT SCALE FROM DRAWING
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE. SUCH AS CIMPERIAL 8865 OR EQUIV.
4. SERIES, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START WITH 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: D021150-001. A VIBRATORY TOOL MAY BE USED.

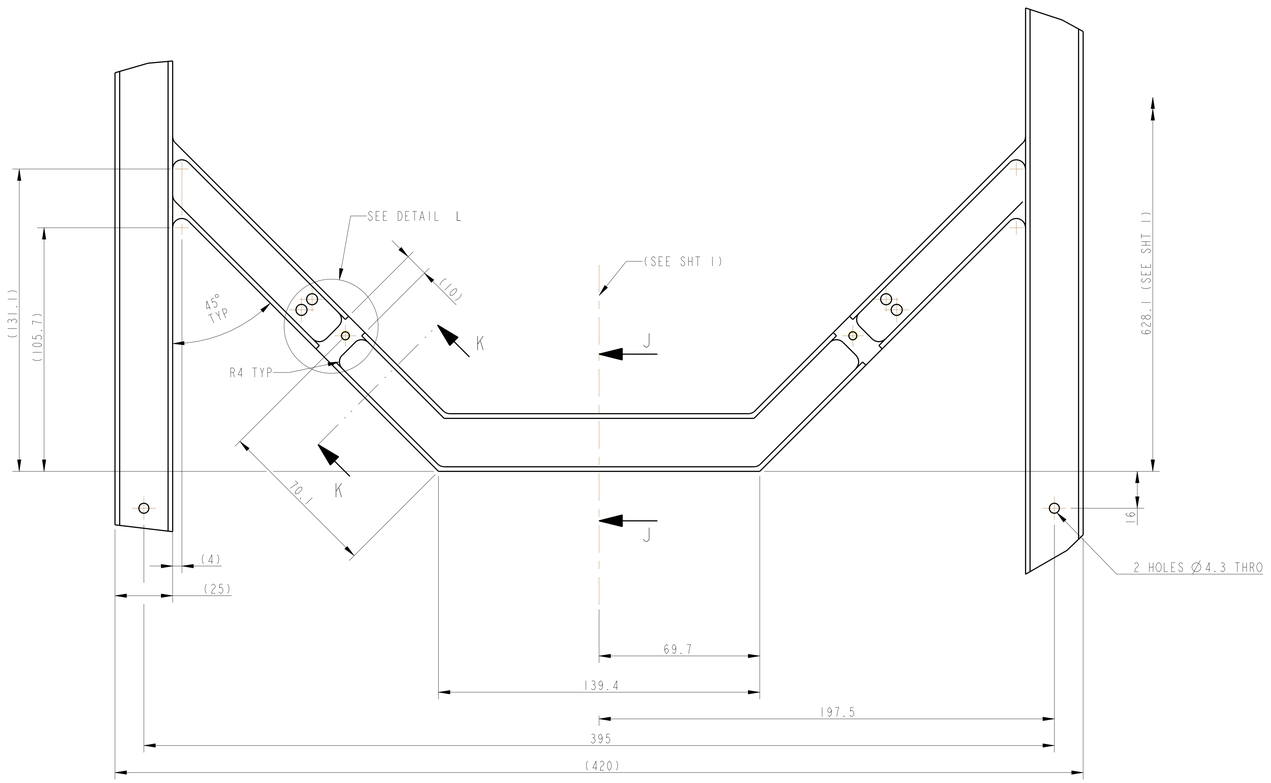
DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X.XX ±0.2 mm (.XXINCH)
ANGULAR ±0.25
MATERIAL: ALUMINIUM ALLOY 6082
FINISH: m (µm) Ra 3.2

	NAME	DATE
DRAWN	S.SUTTER	MON/NOV/04
CHECKED	A.JR	9:15PM
APPROVED	I.M	

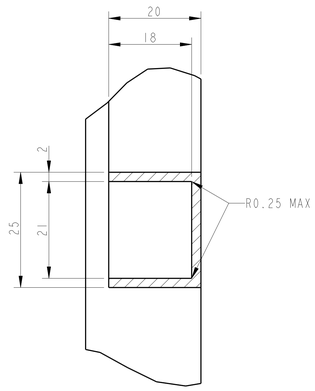
LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY, LIVINGSTON OBSERVATORY, HANFORD OBSERVATORY, RUTHERFORD APPLETON LABORATORIES

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: QUAD NPTYPE LOWER STRUCTURE
PART NAME: OUTER FACE PLATE LOWER STRUCTURE
SIZE: E
DRG. NO.: D060434
REV: D.
SCALE: 1/2 PROJECTION
SHEET 2 OF 3

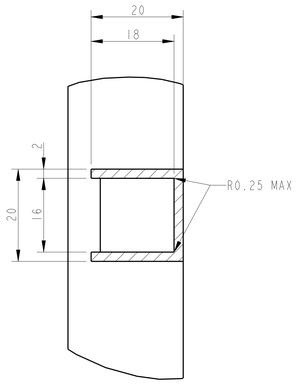
INITIALINK NAME: D060434



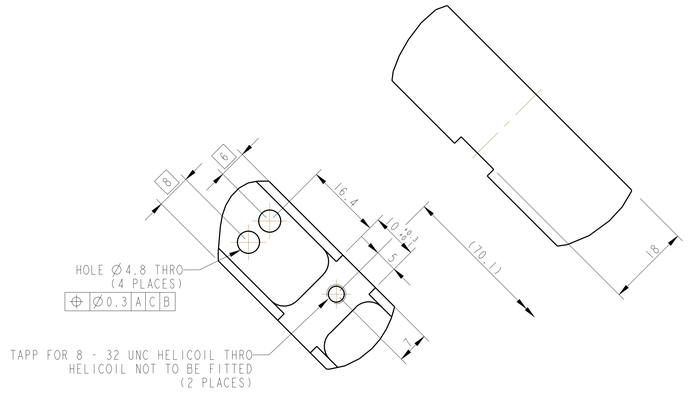
DETAIL H
(SEE SHT 1)
SCALE 1:1



PARTIAL SECTION J-J
SHOWING DEPTH OF SECTION
SCALE 2:1



TYPICAL
PARTIAL SECTION K-K
SHOWING DEPTH OF SECTION
SCALE 2:1



TYPICAL DETAIL L
SHOWING HOLE DETAILS
SCALE 2:1

NOTES: (UNLESS OTHERWISE SPECIFIED)
1. REMOVE ALL SHARP EDGES, 0.02 MIN.
2. DO NOT SCALE FROM DRAWING
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410, ISTAINLESS STEEL)
4. ENTER, ENGRAVE OR STAMP DRAWING PART/NUMBER ON NOTED SURFACE OF PART. LOCATE AS SHOWN. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .25" HIGH CHARACTERS.
5. PARTS SPECIFIED - 001 & VIBRATORY TUMBLING MAY BE USED.

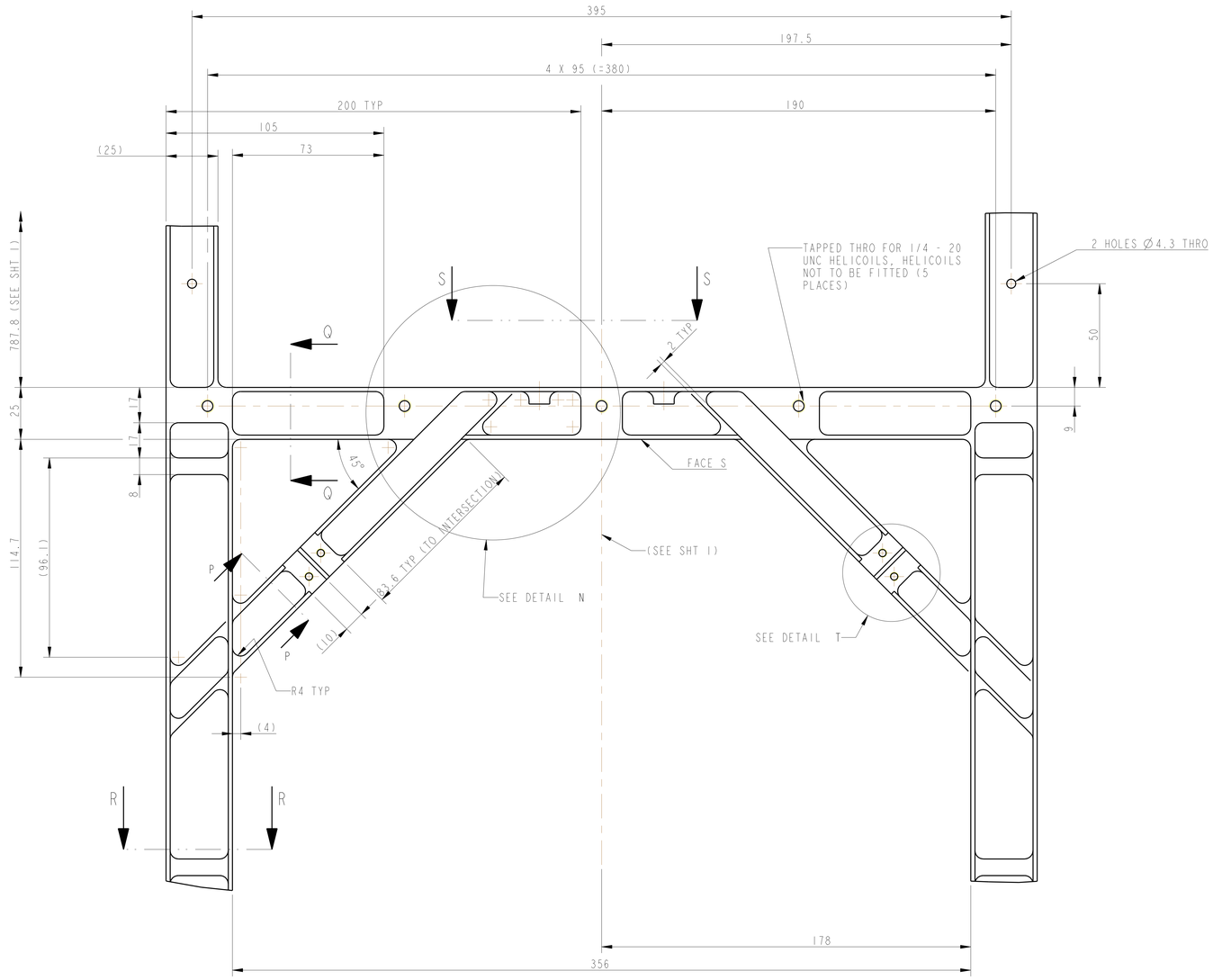
DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X.XX ±(TOL mm [INCHES])
ANGULAR ±(ANG °)
MATERIAL: MATERIAL
MATERIAL SPEC
FINISH: FINISH
m 1µm Ra - SURFACE TEXTURE

	NAME	DATE
DRAWN	DRAWN BY	ISSUE DATE
CHECKED	CHK BY	CHK DATE
APPROVED	APP BY	APP DATE

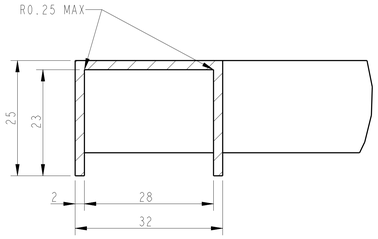
LIGO
CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
LIGO LABORATORY
UNIV. GLASGOW UNIVERSITY GEO 600 GROUP
RUTHERFORD APPLETON LABORATORIES

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: QUAD NPTYPE LOWER STRUCTURE
PART NAME: TITLE 1
TITLE 2
DRG. NO.: D060434
REV: E
SCALE DRAWING REDUCED BY: ◆
SHEET: 1 OF 2 SHEETS

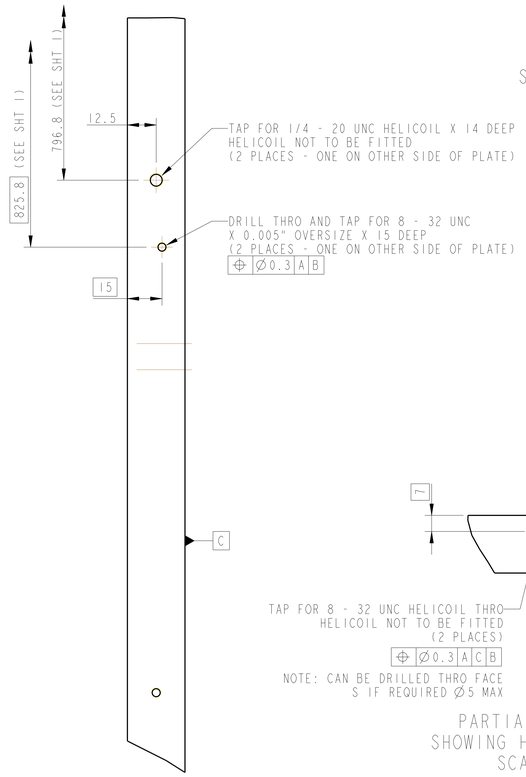
PRODUCTION DRG

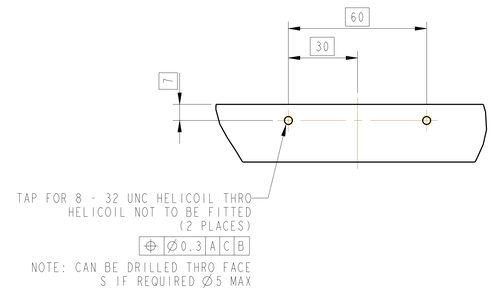


DETAIL M
(SEE SHT 1)
SCALE 1:1

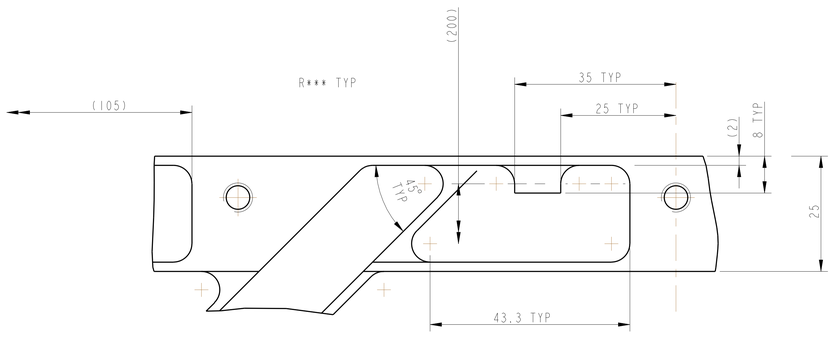


PARTIAL SECTION R-R
SHOWING DEPTH OF SECTION
SCALE 2:1

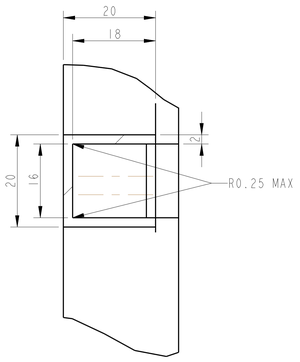




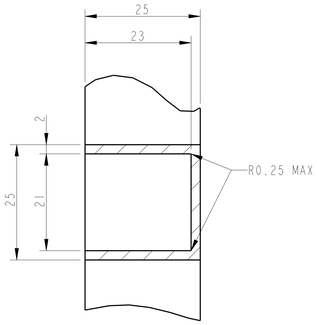
PARTIAL VIEW S-S
SHOWING HOLE POSITIONS
SCALE 1:1



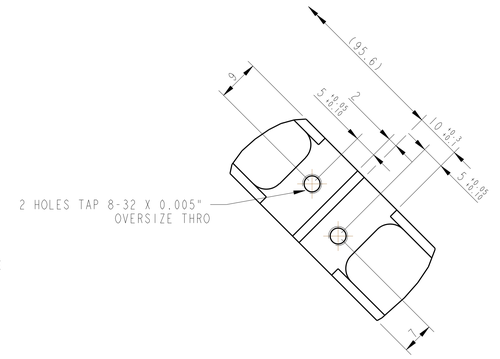
DETAIL N
SCALE 2:1



SECTION P-P
SCALE 2:1



PARTIAL SECTION Q-Q
SHOWING DEPTH OF SECTION
SCALE 2:1



TYPICAL DETAIL T
SHOWING HOLE POSITIONS
SCALE 2:1

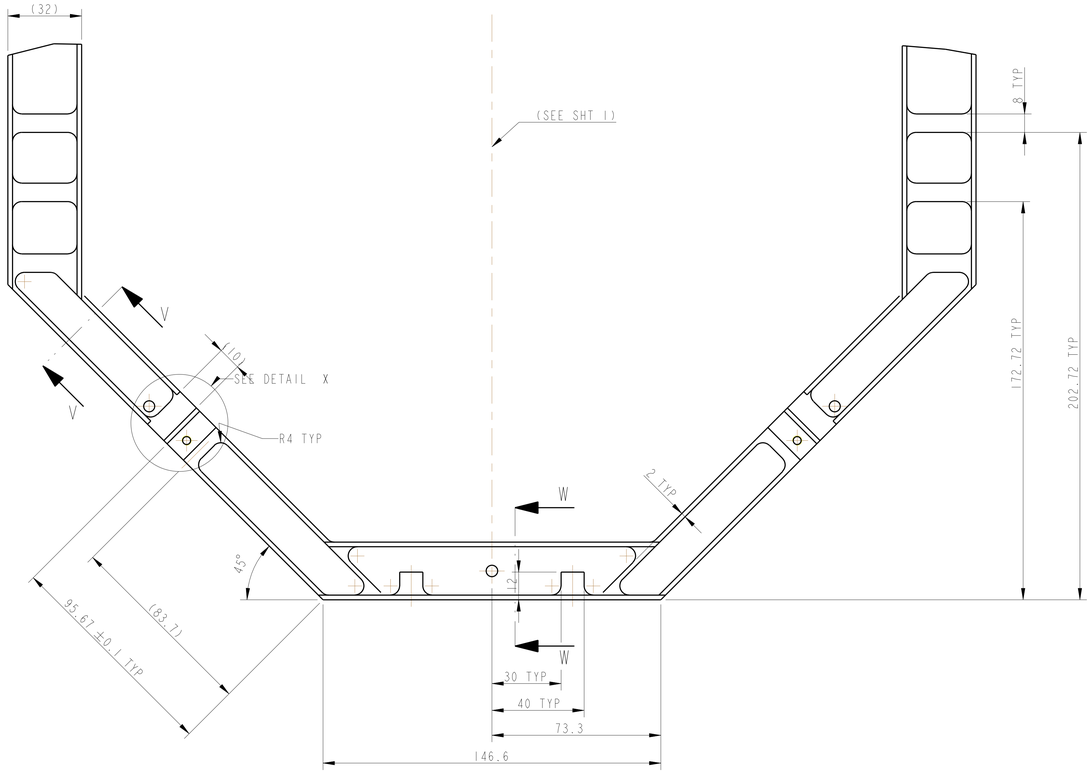
NOTES: (UNLESS OTHERWISE SPECIFIED)
1. REMOVE ALL SHARP EDGES, 0.02 MIN.
2. DO NOT SCALE FROM DRAWING
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 810. (STAINLESS STEEL)
4. SERIAL, EMBARGO OR STAMP DRAWING PARTNUMBER ON NOTED SURFACE (IF ANY) AND ALL SERIAL NUMBERS. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE 10 MIL MIN CHARACTERS.
5. ALL PARTS TO BE DRY, & VIBRATORY TUMBLED. MAY BE USED.

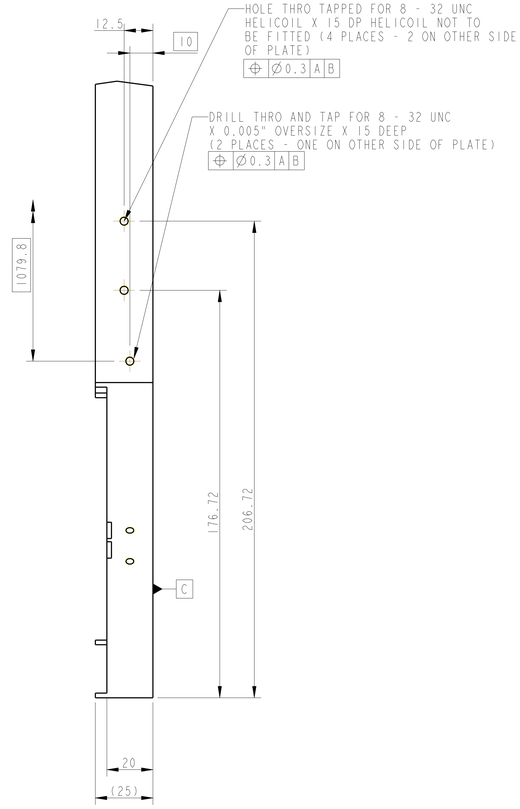
DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X.XX ±0.2 mm (INCHES)
ANGULAR ±0.25
MATERIAL: ALUMINIUM ALLOY 6082
FINISH:
m (µm) Ra : 3.2

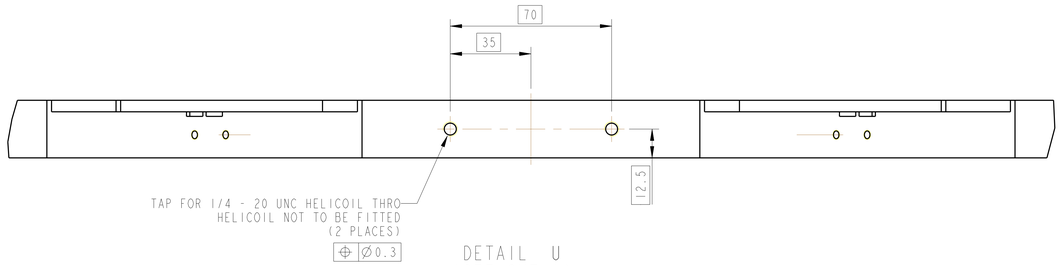
	NAME	DATE
DRAWN	S.SUTTER	08/03/06
CHECKED	R.JIE	9/SEP/06
APPROVED	J.M	/ /

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY, UNIV. GLASGOW, UNIVERSITY OF GEO HIGH GROUP, RUTHERFORD APPLETON LABORATORIES

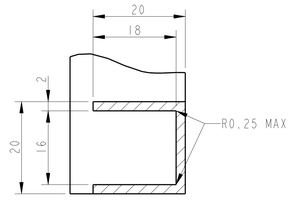
SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: QUAD NPTYPE LOWER STRUCTURE
PART NAME: OUTER FACE PLATE
LOWER STRUCTURE
DRG. NO. D060434
SIZE: E
REV: D.
SCALE (1:2) PROJECTION
SHEET 4 OF 4



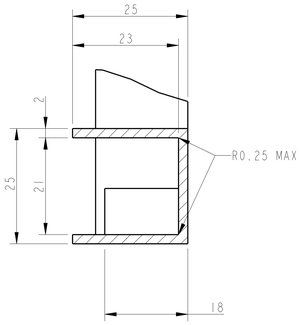




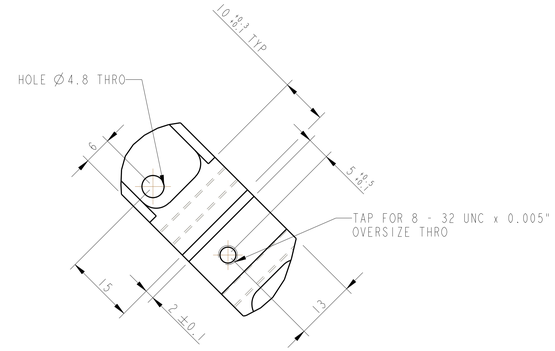
DETAIL U
(SEE SHT 1)
SCALE 1:1



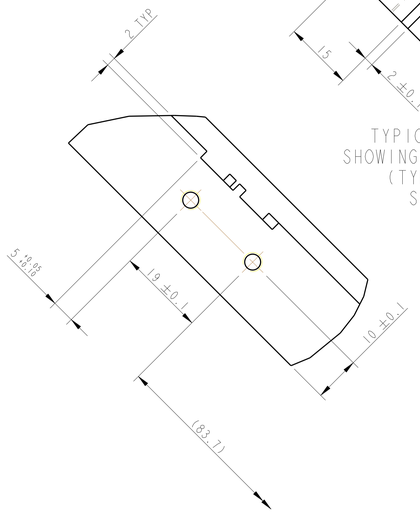
PARTIAL SECTION V-V
SHOWING DEPTH OF SECTION
SCALE 2:1



PARTIAL SECTION W-W
SHOWING DEPTH OF SECTION
SCALE 2:1



TYPICAL DETAIL X
SHOWING HOLE POSITIONS
(TYP 2 PLACES)
SCALE 2:1



NOTES: (UNLESS OTHERWISE SPECIFIED)
1. REMOVE ALL SHARP EDGES, 0.02 MIN.
2. DO NOT SCALE FROM DRAWING
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND CHLORINE, SULFUR AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)
4. SERIAL, EMBOSS OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OR AS CLOSE AS POSSIBLE TO PART NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE 1/2" HIGH CHARACTERS. USE STAMP 2-005-001. A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X.XX ±0.2 mm (INCHES)
ANGULAR ±0.25
MATERIAL: ALUMINIUM ALLOY 6082
FINISH: As Turned Ra 3.2

	NAME	DATE
DRAWN	S.SUTTER	MEMBRANE
CHECKED	R.JUE	TYPE
APPROVED	J.M.	-

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY, UNIV. GLASGOW, UNIVERSITY OF WESTERN AUSTRALIA, RUTHERFORD APPLETON LABORATORIES

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: QUAD NPTYPE LOWER STRUCTURE
PART NAME: OUTER FACE PLATE LOWER STRUCTURE
DWG. NO.: D060434
REV: D.
SIZE: E
SCALE: 1:2 PROJECTION
SHEET 2 OF 2