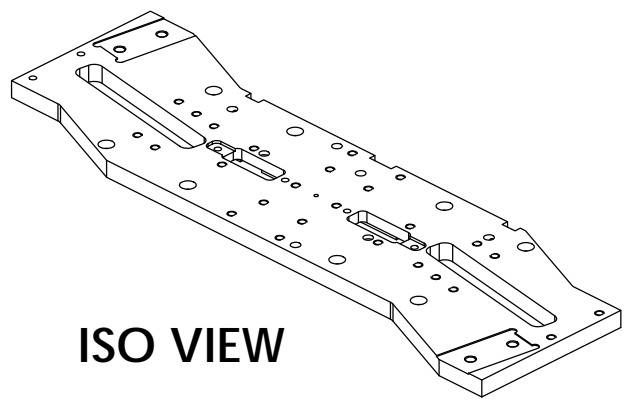
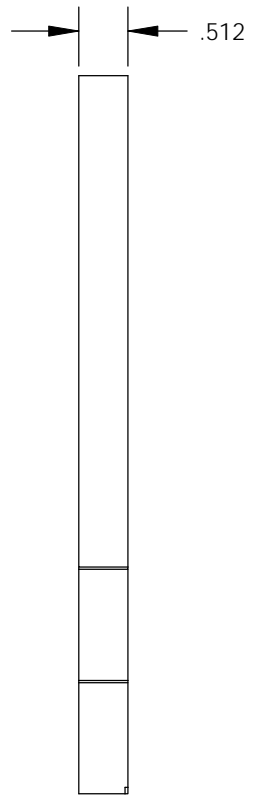
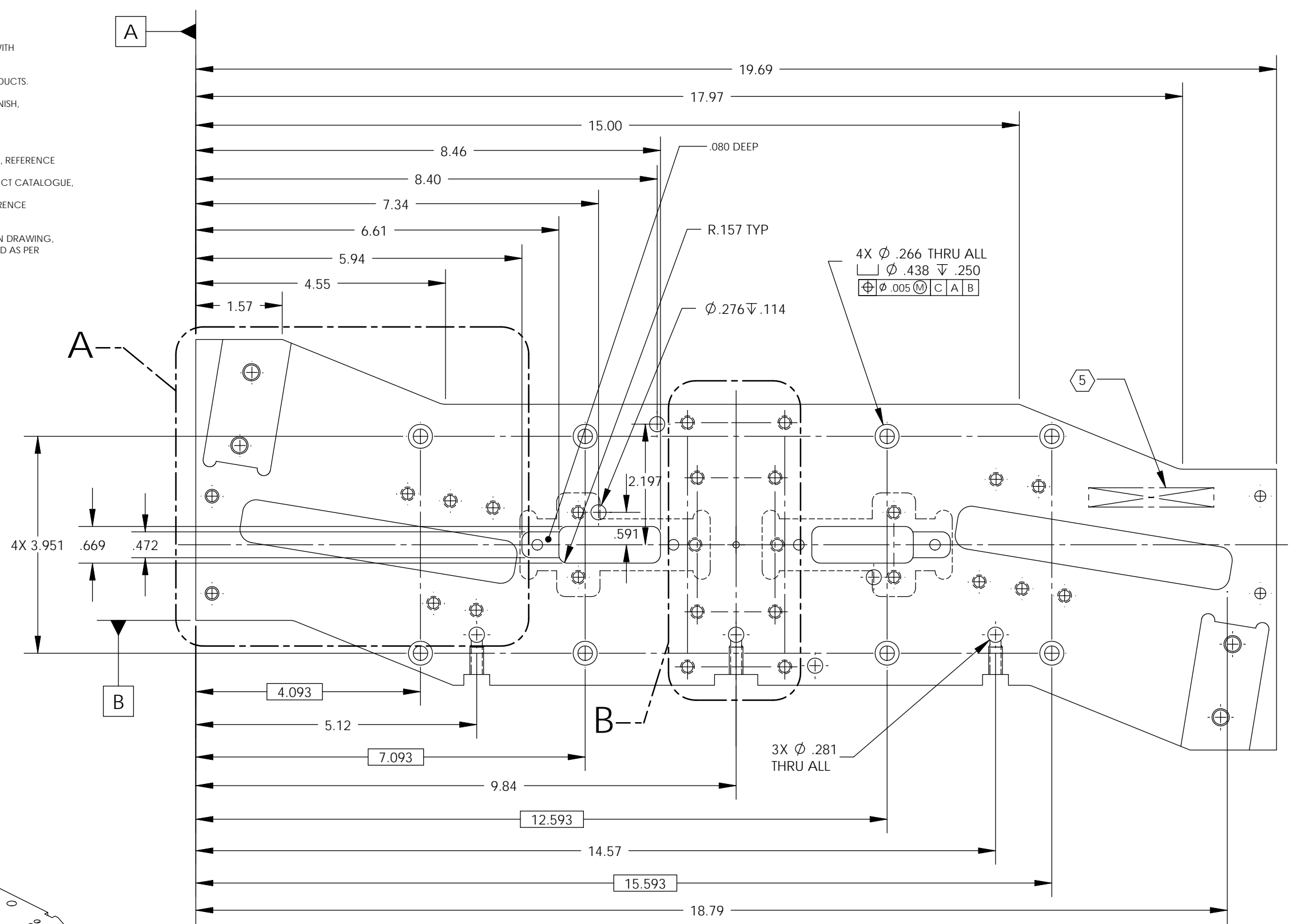


NOTES CONTINUED:

- 5 SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364
- 7. DO NOT USE SANDPAPER, SCOTCH BRITE OR SIMILAR PRODUCTS.
- 8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE TECHNIQUES IS NOT ALLOWED.
- 9 DRILL AND TAP ONLY
 - 9.1 DRILL PILOT HOLE FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELICOIL PRODUCT CATALOGUE, HC 2000
 - 9.2 COUNTERSINK HOLE 120°±5, REFERENCE HELICOIL PRODUCT CATALOGUE, HC 2000
 - 9.3 TAP HOLES FOR INSERT SPECIFIED ON THE DRAWING, REFERENCE HELICOIL PRODUCT CATALOGUE, HC 2000
 - 9.4 REMOVE ALL CHIPS
 - 9.5 GAGE THREADS WITH GAGE TOOL FOR INSERT SPECIFIED IN DRAWING, REFERENCE HELICOIL PRODUCT CATALOGUE, HC 2000 AND AS PER AGREED INSPECTION

REV.	DATE	DCN #	DRAWING TREE #
A	JUN-29-2010	E1000234	
v2	13 JUL 2011	E1100351	

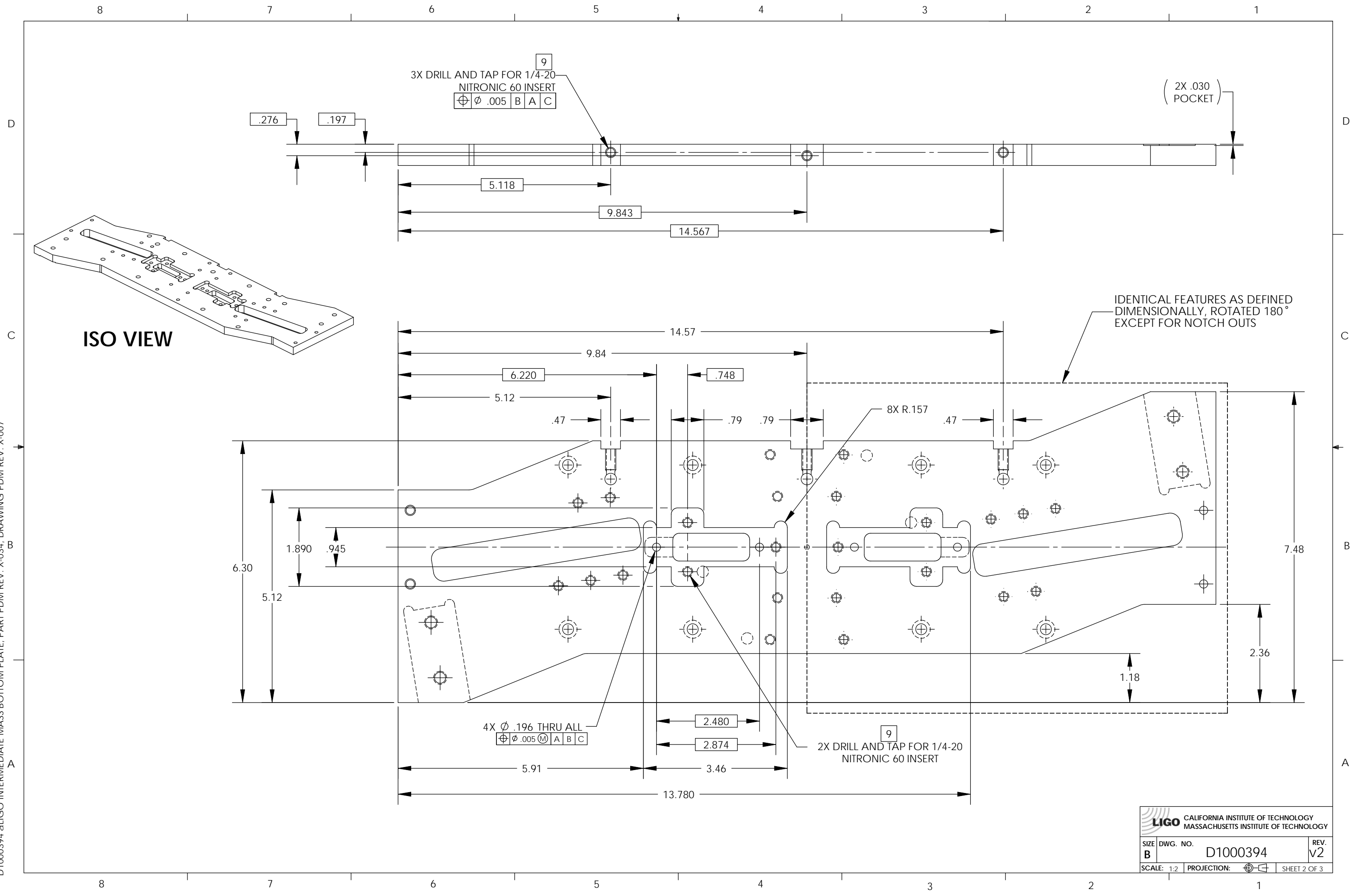


ISO VIEW

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME						
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.1°				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 SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.		aLIGO INTERMEDIATE MASS BOTTOM PLATE						
MATERIAL		FINISH		SYSTEM		SUB-SYSTEM		DESIGNER	DATE	SIZE	DWG. NO.	REV.
304 SSSL		32 µinch		ADVANCED LIGO		AOS		K. MAILAND	22 FEB 2010	B	D1000394	v2
NEXT ASSY				D1000442		CHECKER	APPROVAL	KMAILAND	4/14/10	SCALE: 1:2	PROJECTION:	SHEET 1 OF 3

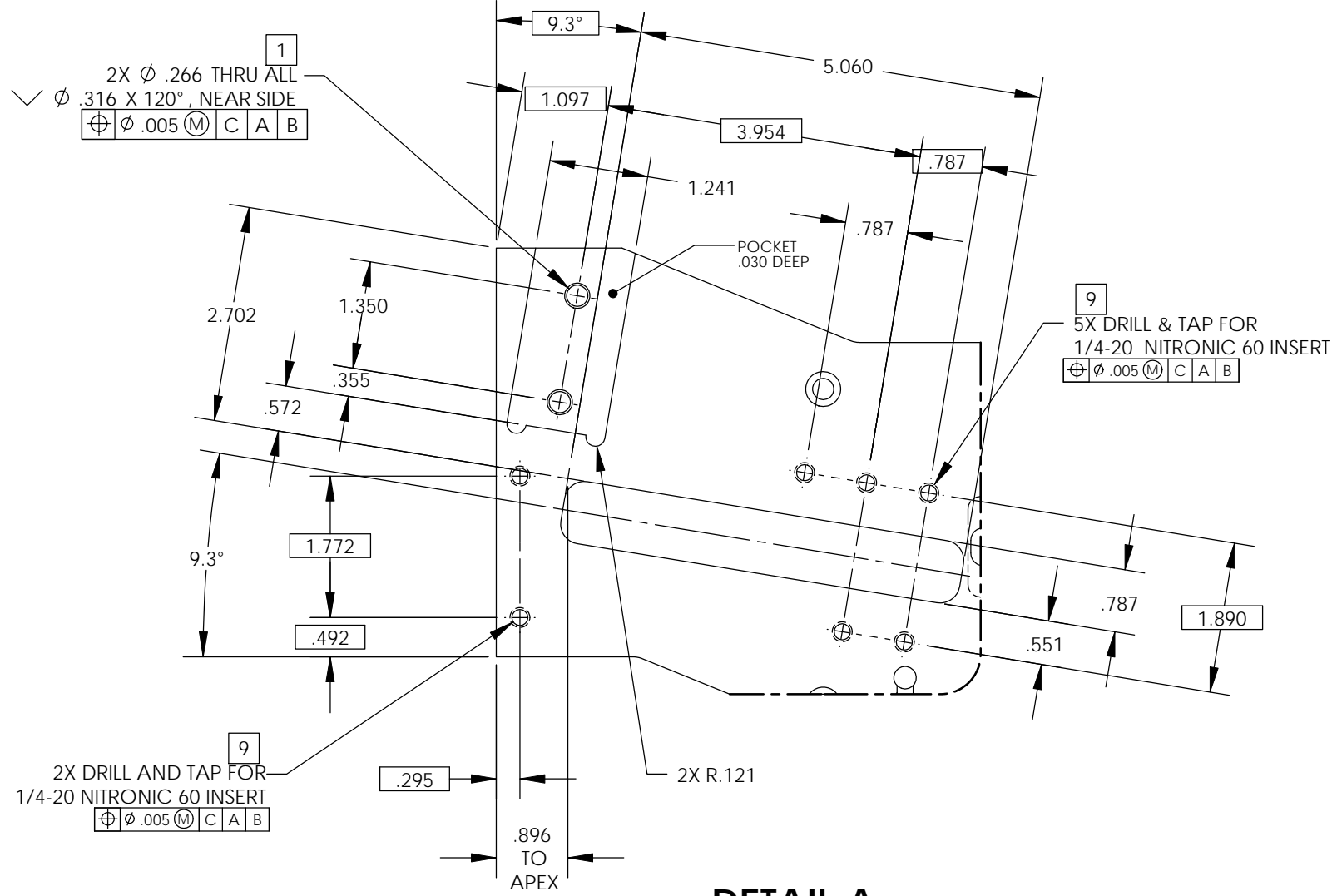
D1000394 aLIGO INTERMEDIATE MASS BOTTOM PLATE, PART PDM REV: X-034, DRAWING PDM REV: X-007

D1000394 aLIGO INTERMEDIATE MASS BOTTOM PLATE, PART PDM REV: X-034, DRAWING PDM REV: X-007

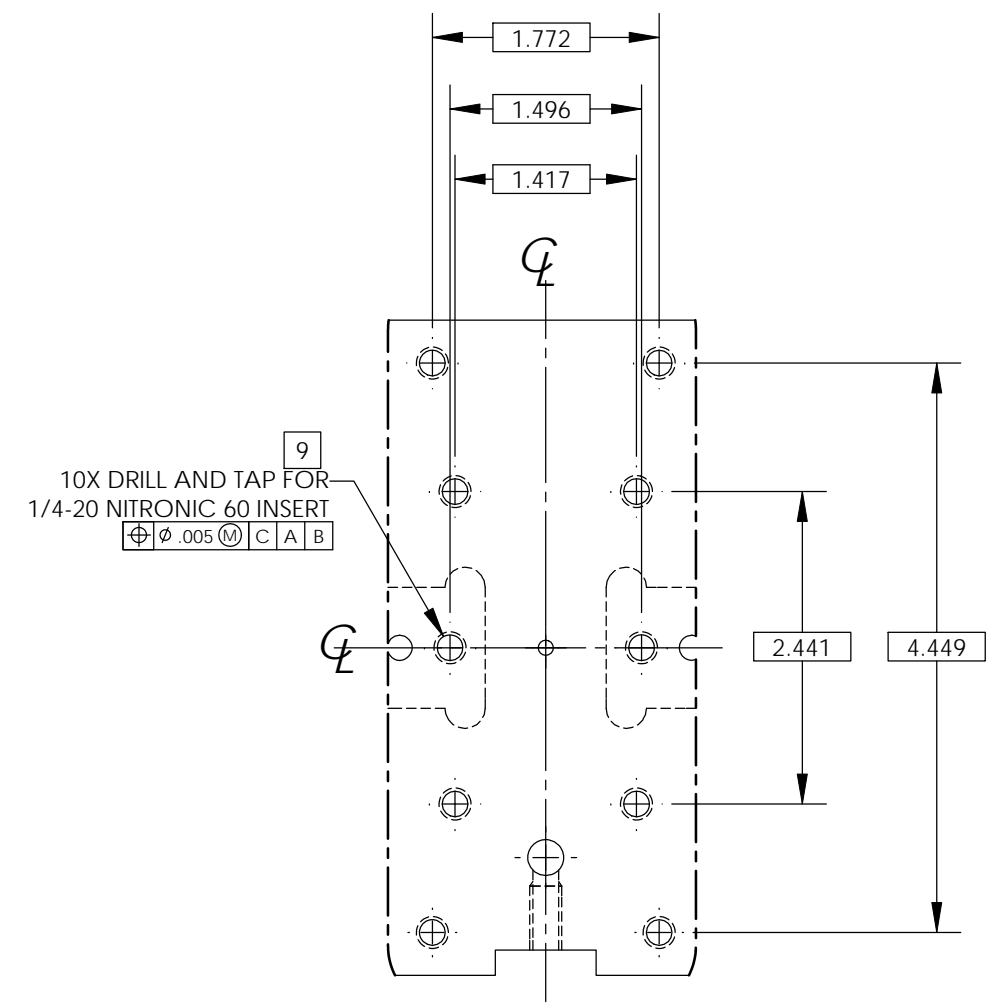


LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE B	DWG. NO. D1000394
SCALE: 1:2	PROJECTION: SHEET 2 OF 3
REV. v2	

D1000394 aLIGO INTERMEDIATE MASS BOTTOM PLATE, PART PDM REV: X-034, DRAWING PDM REV: X-007



**DETAIL A
2 PLACES**



**DETAIL B
SCALE 1 : 1.5**

		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE B	DWG. NO. D1000394	REV. v2	
SCALE: 1:2	PROJECTION:	SHEET 3 OF 3	