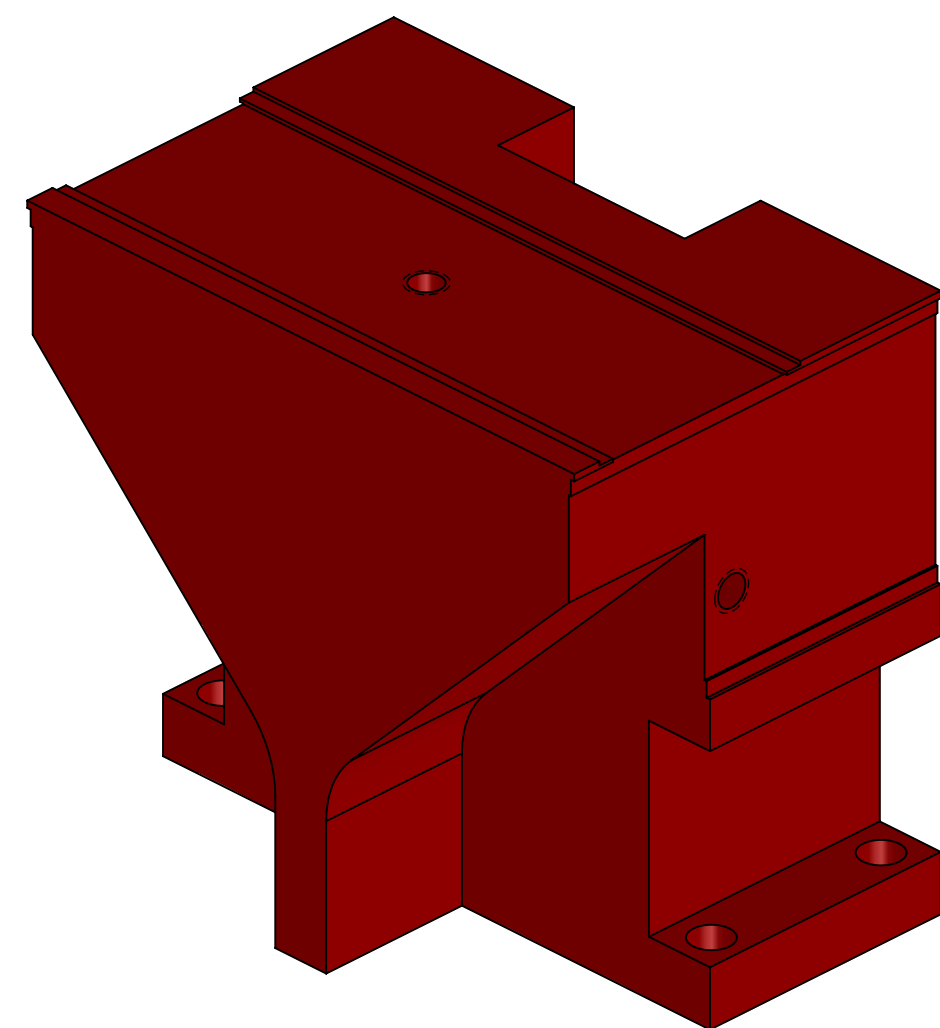


**NOTES CONTINUED:**

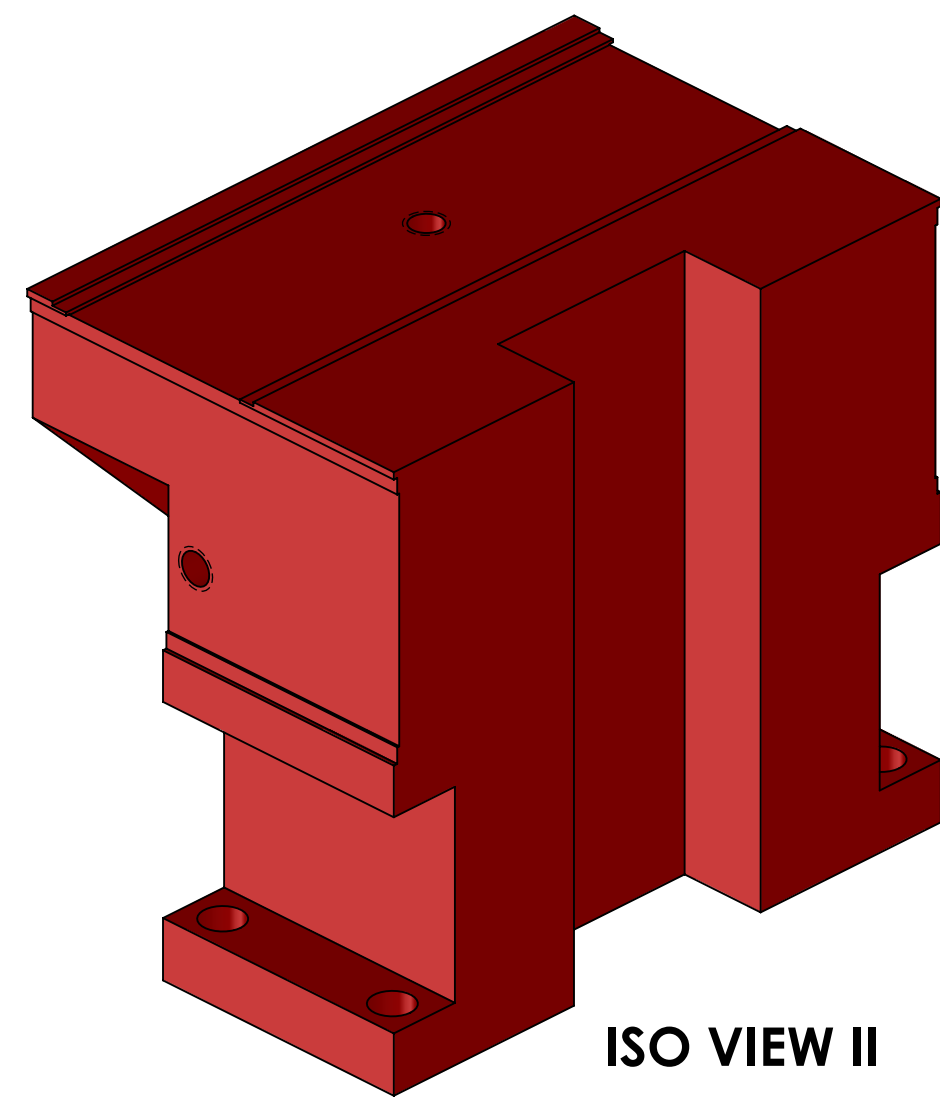
⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE 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. MASS: 7.978 LB [3.619 KG].
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
- 10. CENTER OF GRIVITY (CG) DIMENSIONS SHOWN FOR INTERNAL REFERENCE ONLY.

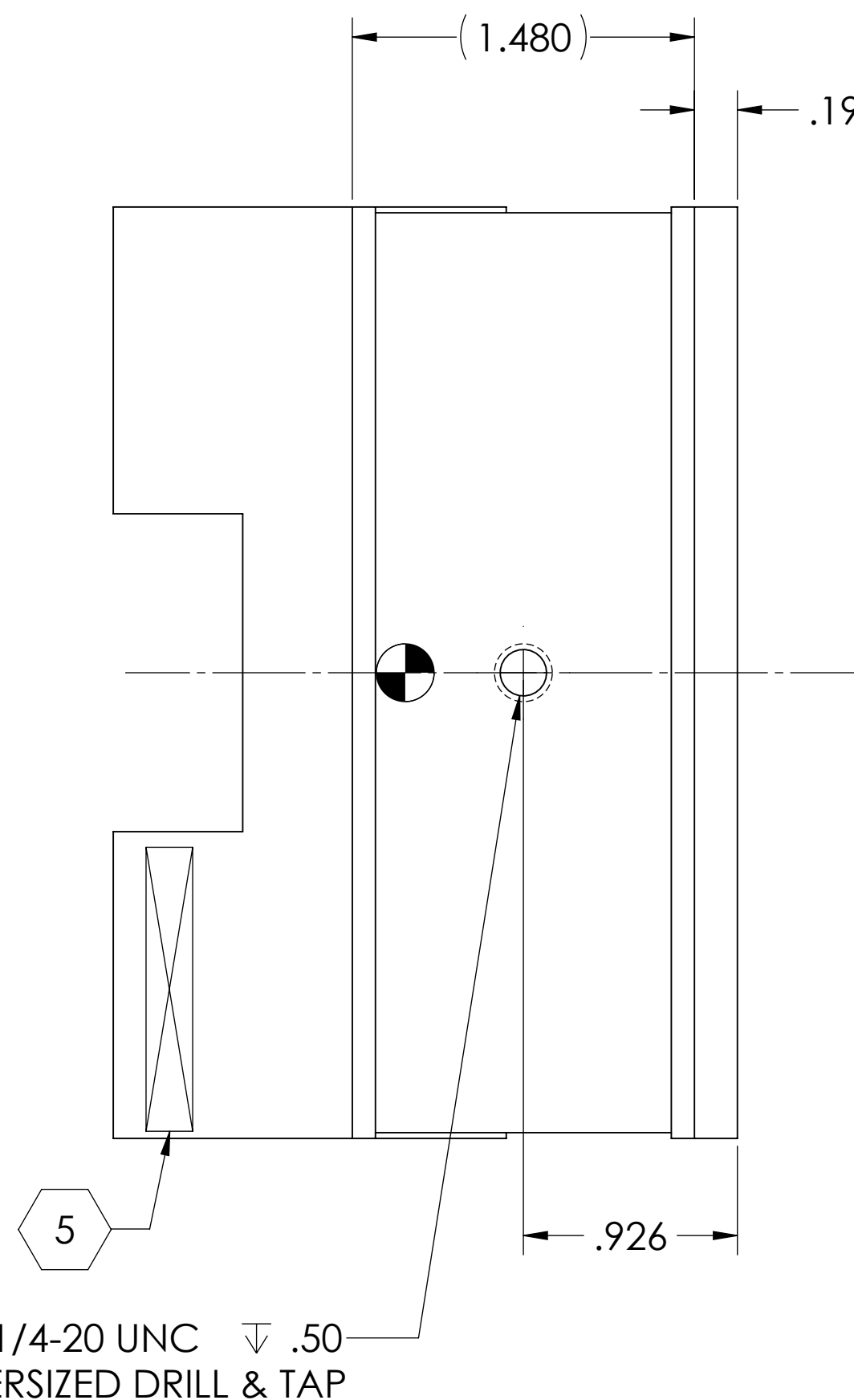
REV.	DATE	DCN #	DRAWING TREE #
v1	JUN-29-2010	E1000234	
v2	SEP-03-2010	E1000388	



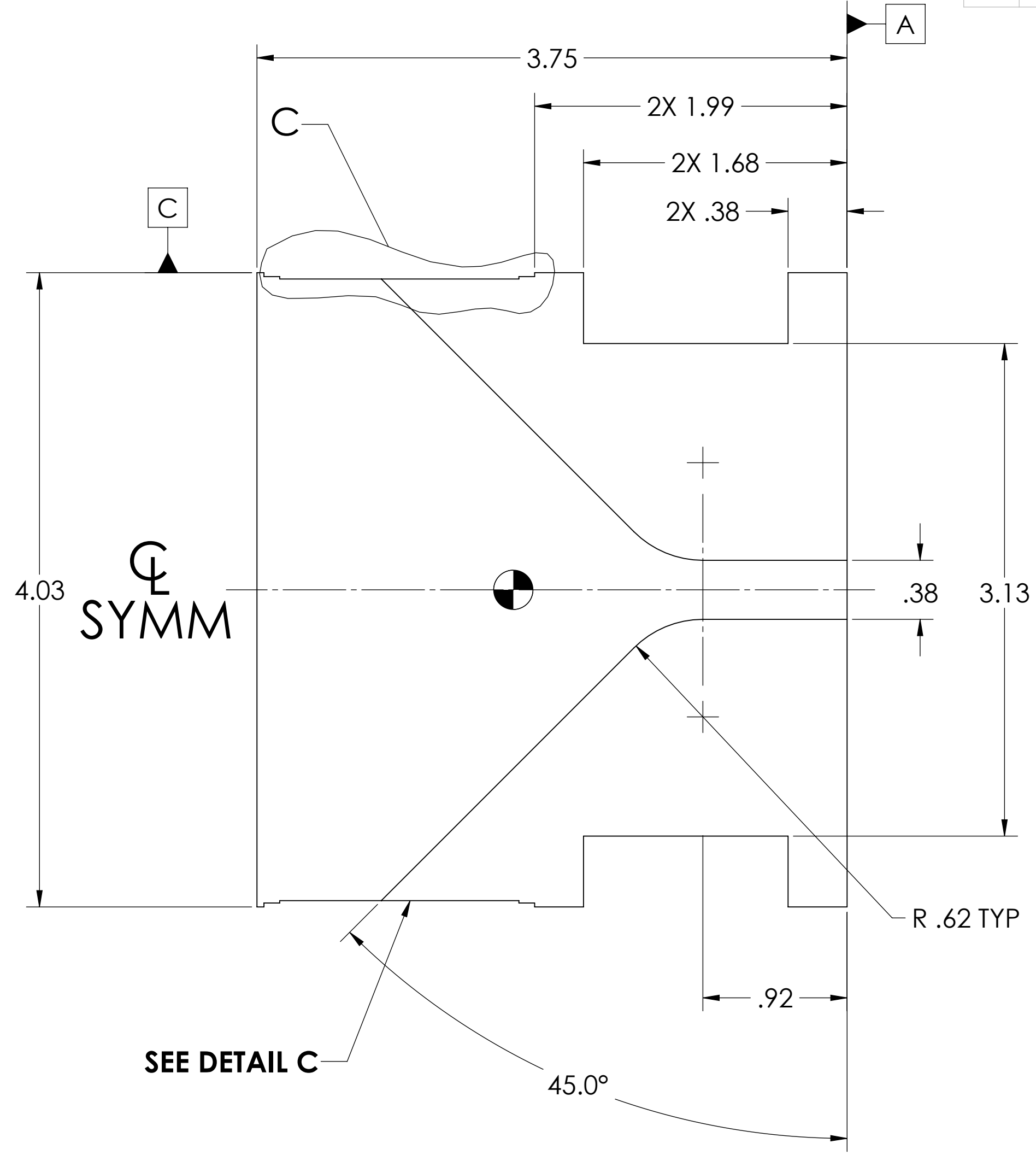
ISO VIEW



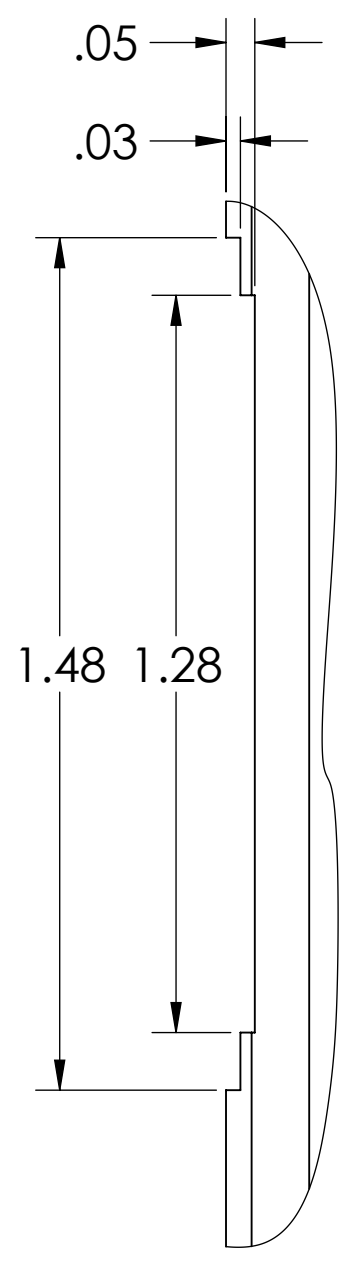
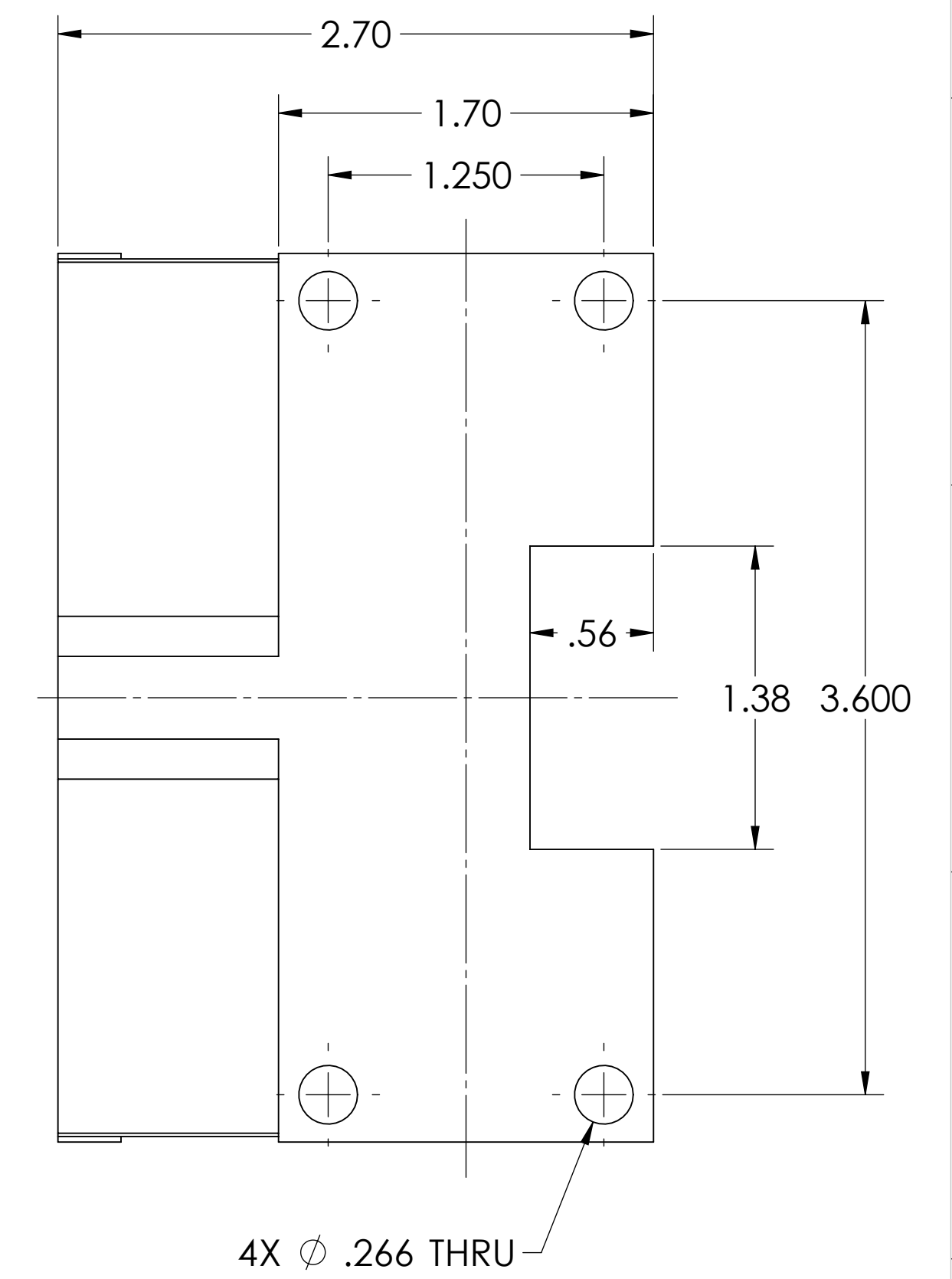
ISO VIEW II



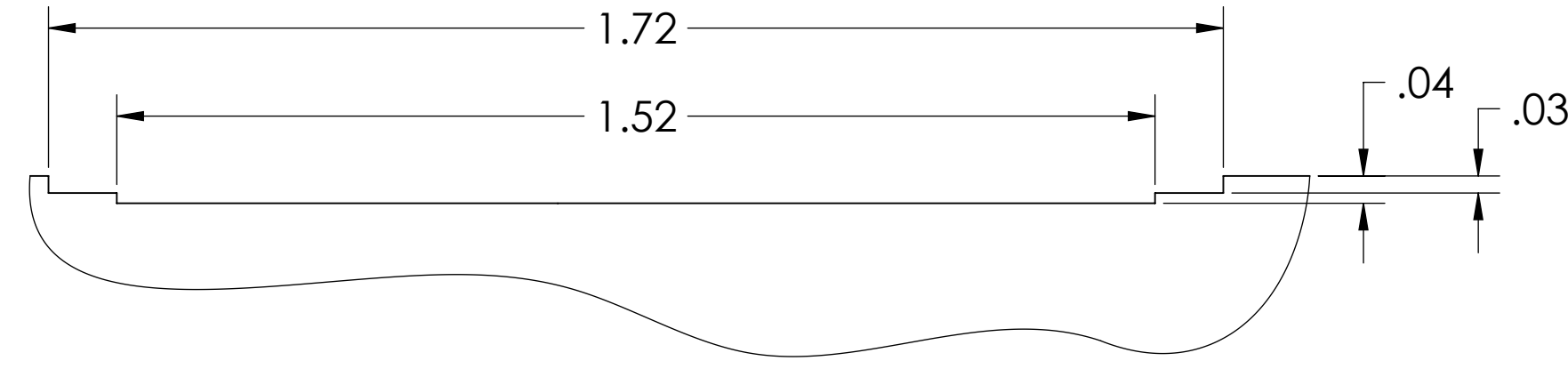
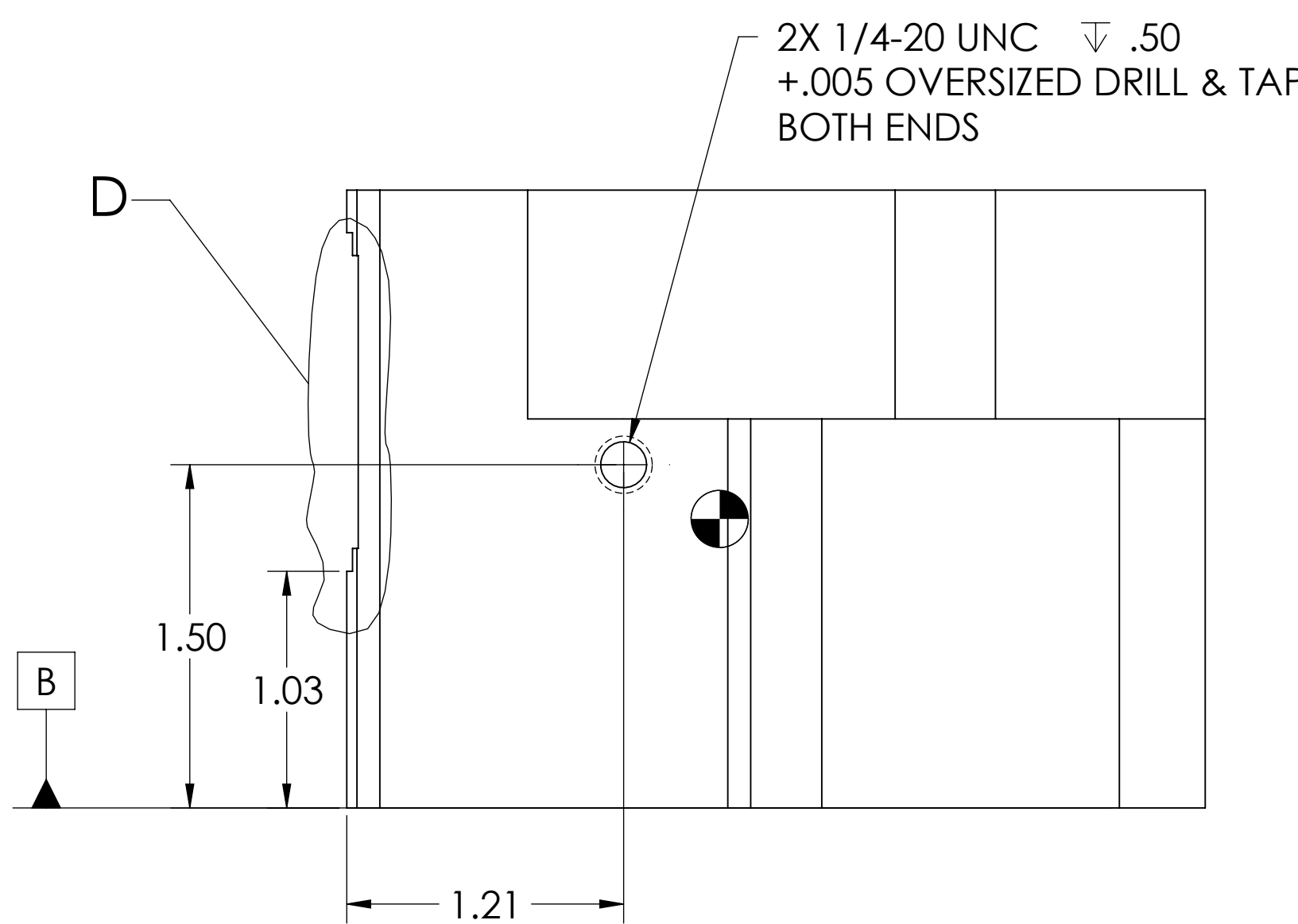
1/4-20 UNC  $\nabla$  .50  
+.005 OVERSIZED DRILL & TAP



SEE DETAIL C



DETAIL D  
SCALE 3 : 1



DETAIL C  
SCALE 4 : 1

DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX $\pm$ .01 .XXX $\pm$ .005	
ANGULAR $\pm$ 1.0°	
MATERIAL	FINISH
304 SSSL	63 $\mu$ inch Ra

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
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.	
SYSTEM	NEXT ASSY
ADVANCED LIGO	D1000444

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
DESIGNER	K. MAILAND
DRAFTER	C CONLEY
CHECKER	K. MAILAND
APPROVAL	K. MAILAND

PART NAME		aLIGO TOP ADD MASS TOWER	
DESIGNER	K. MAILAND	19 MAR 2010	SIZE DWG. NO.
DRAFTER	C CONLEY	02 SEP 2010	D
CHECKER	K. MAILAND	02 SEP 2010	D1000631
APPROVAL	K. MAILAND	02 SEP 2010	SCALE: 1:1
PROJECTION:		SHEET 1 OF 1	

D1000631 aLIGO TOP ADD MASS TOWER PART PDM REV. X-039 DRAWING PDM REV. X-014