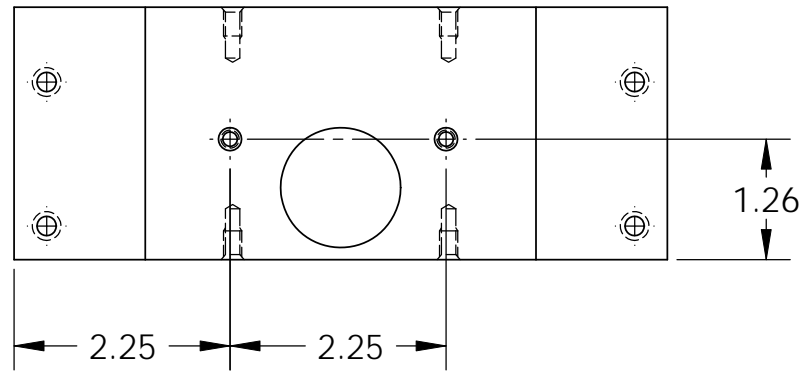
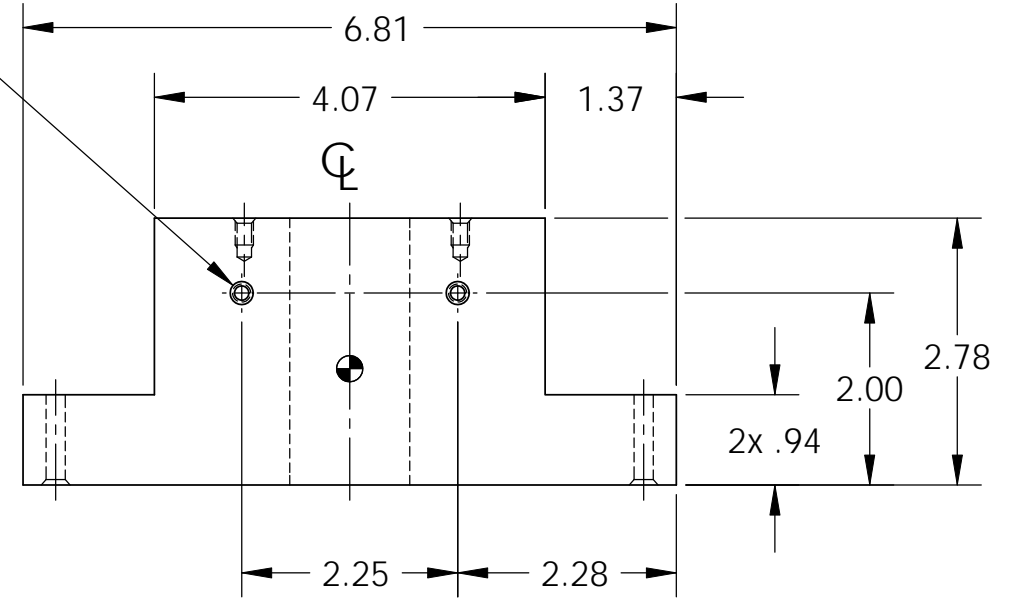
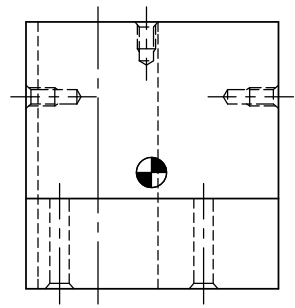
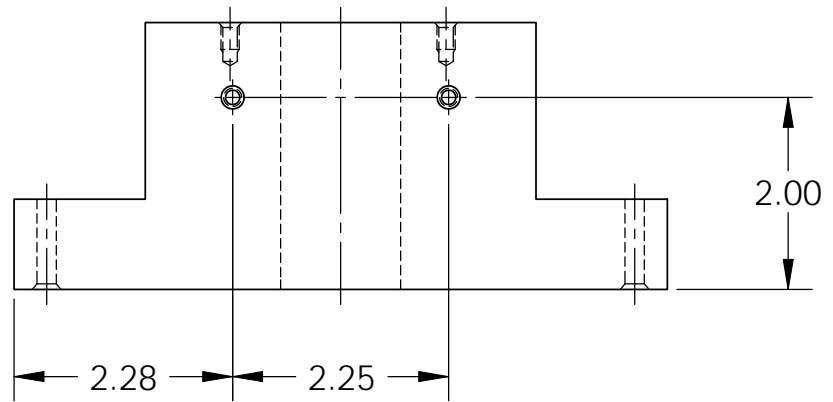


REV.	DATE	DCN #	DRAWING TREE #
v1	JUN-29-2010	E1000234	
v2	SEP-03-2010	E1000388	
v3	JUN 26 2011	E1100351	

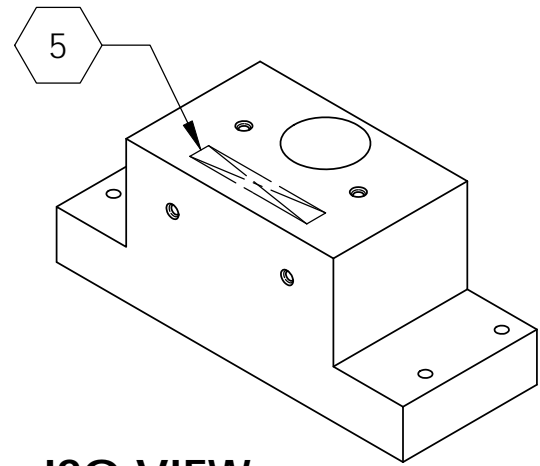
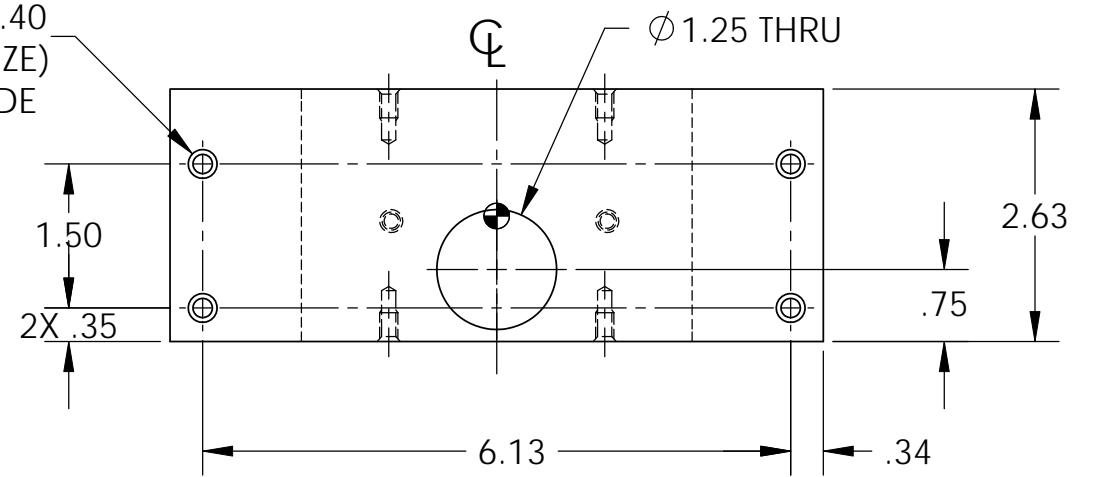
- NOTES CONTINUED:
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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
 4. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE TECHNIQUES IS NOT ALLOWED.
 3. DO NOT USE SANDPAPER, SCOTCH BRITE OR SIMILAR PRODUCTS.
 2. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364
 1. CENTER OF GRAVITY (CG) SHOWN FOR INTERNAL REFERENCE ONLY



6X TOTAL
 DRILL $\nabla .53$, 10-24 UNC - 2B $\nabla .30$
 MIN FULL THREAD, H11 (.005 OVERSIZE)
 $\sphericalangle \phi .24 \times 82^\circ$



4X
 DRILL THRU ALL , & TAP 1/4-20 UNC - 2B $\nabla .40$
 MIN FULL THREAD, H11 (.005 OVERSIZE)
 $\sphericalangle \phi .30 \times 82^\circ$, NEAR SIDE



ISO VIEW

NOTE: WEIGHT 9.516 lbs.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX $\pm .01$.XXX $\pm .005$ ANGULAR $\pm 1^\circ$				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.		aLIGO AOS		SUB-SYSTEM TRANSMON		DESIGNER K. MAILAND 19 MAR 2010	
						MATERIAL S. STL. 304		FINISH 63 μ inch		NEXT ASSY D1000444	
								SCALE: 1:1		PROJECTION:	
								SHEET 1 OF 1			