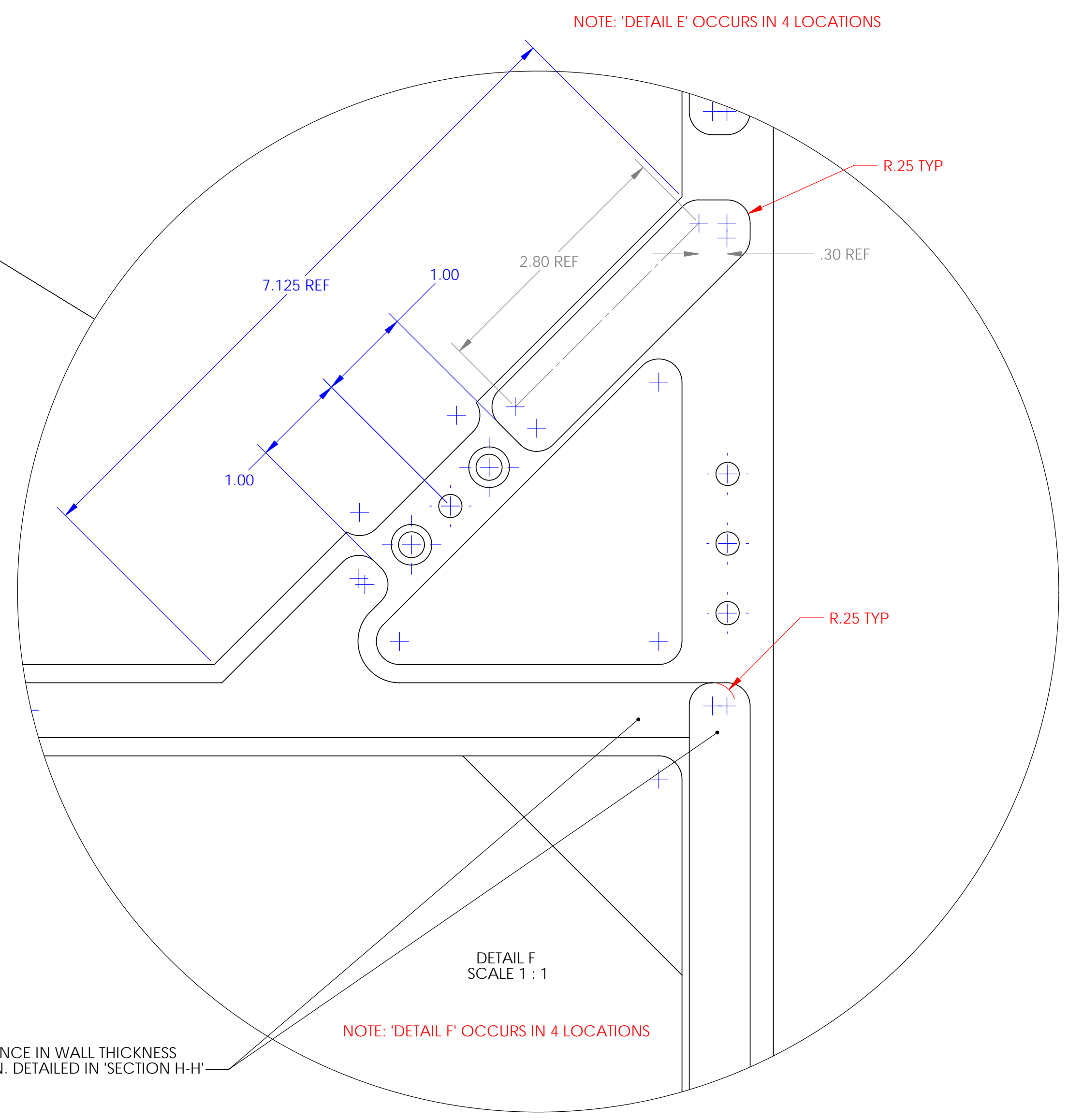
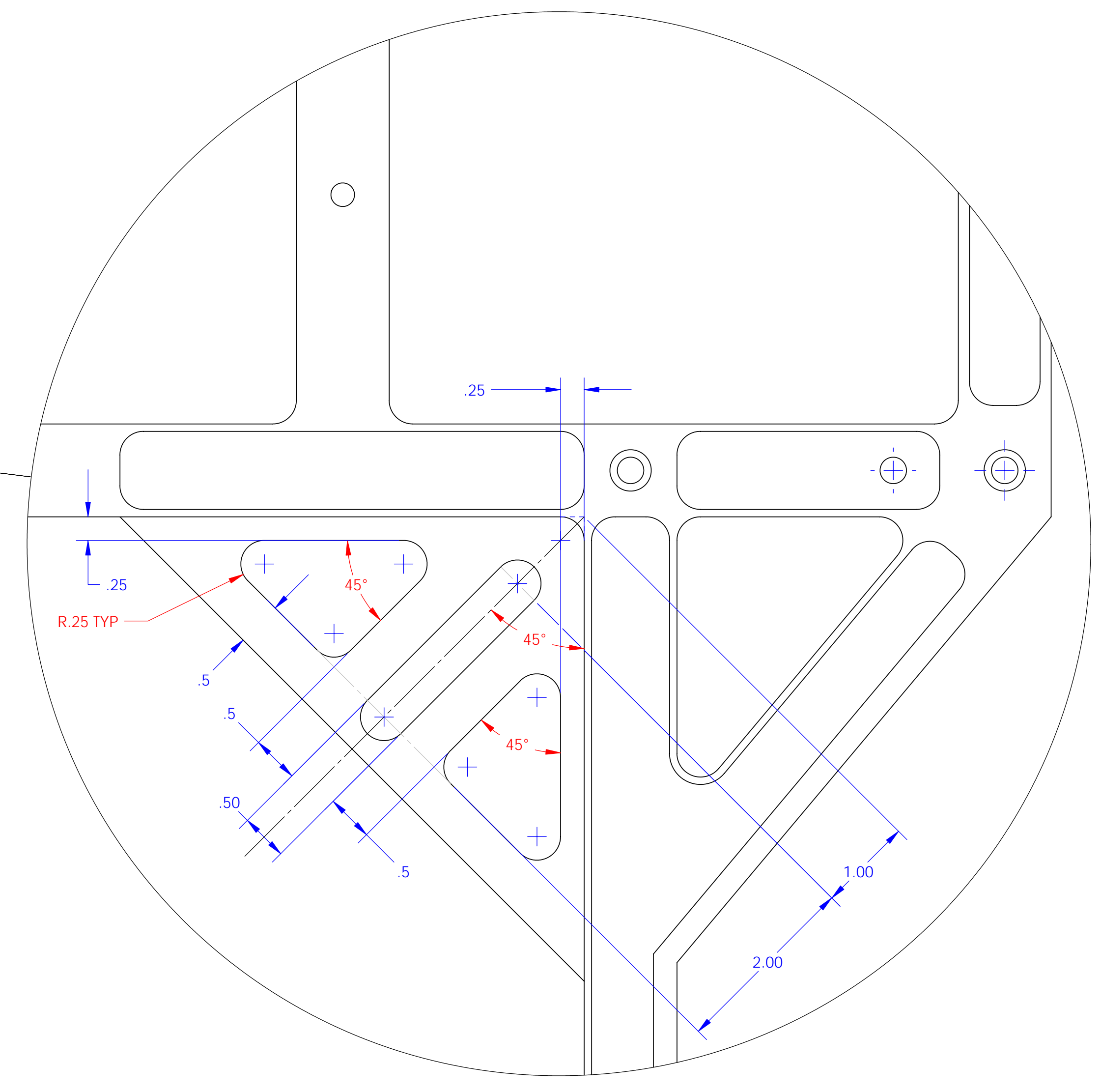
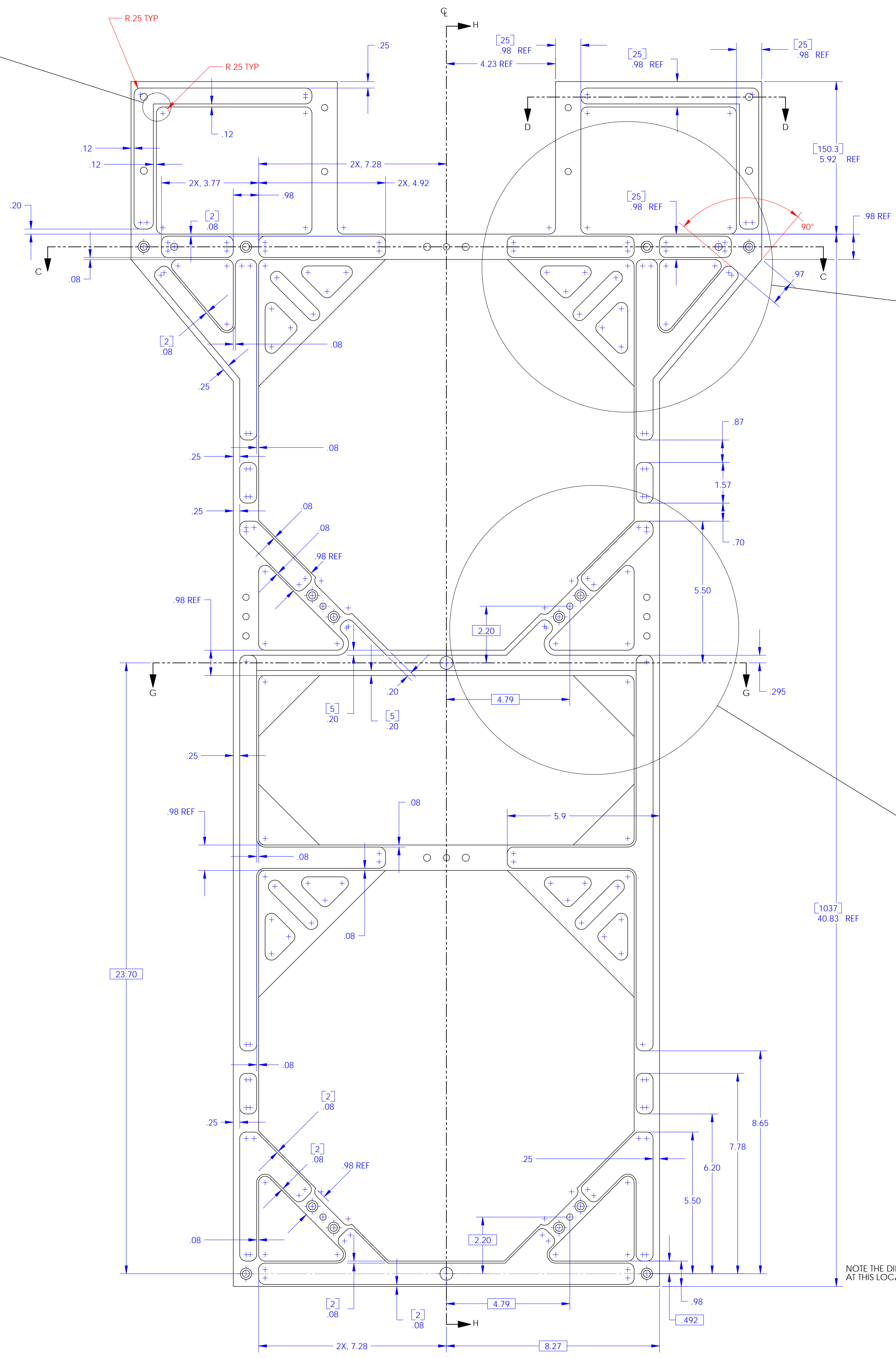
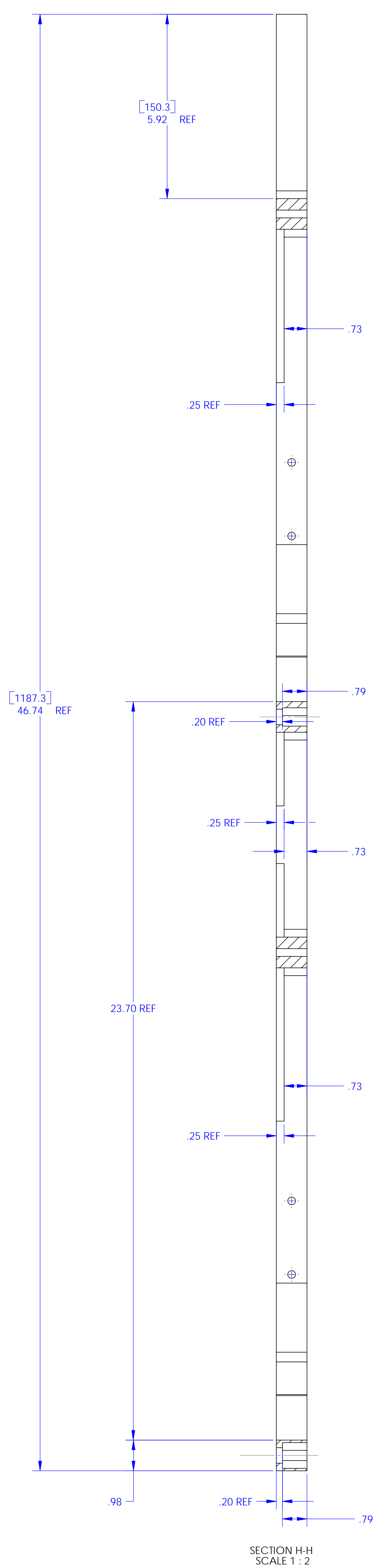
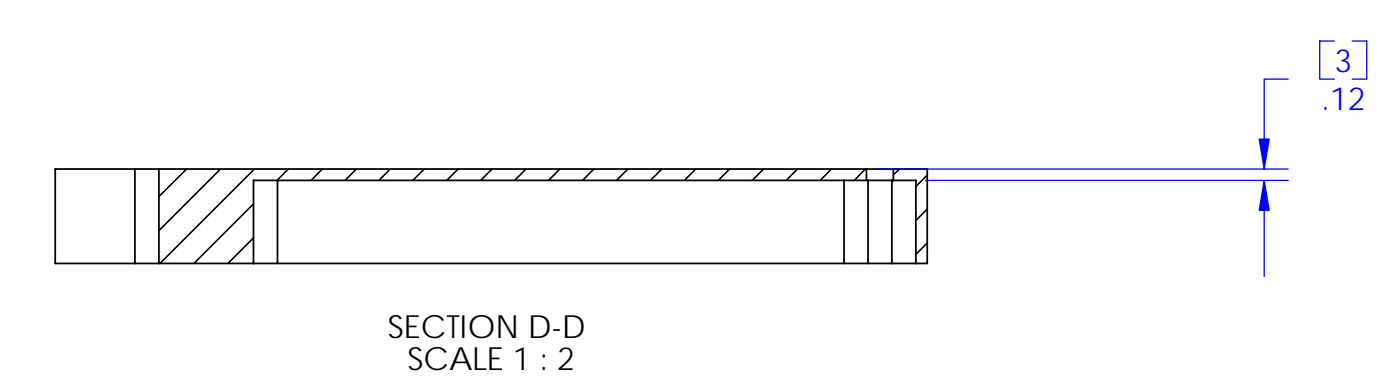
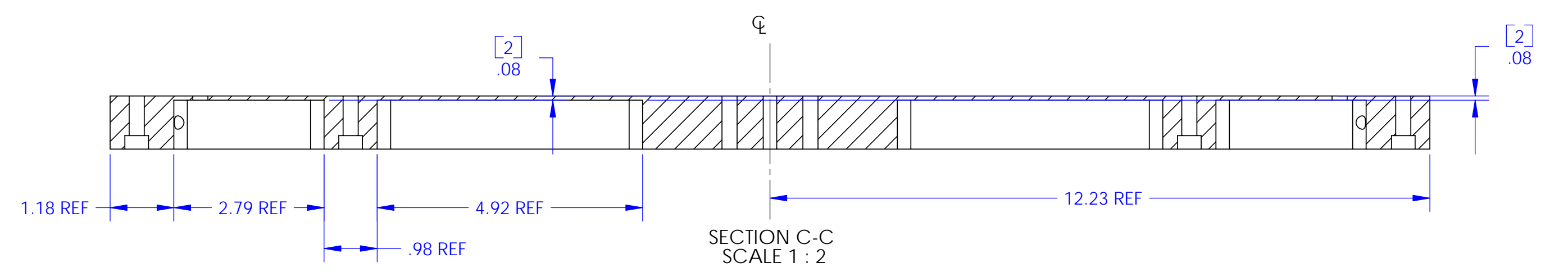
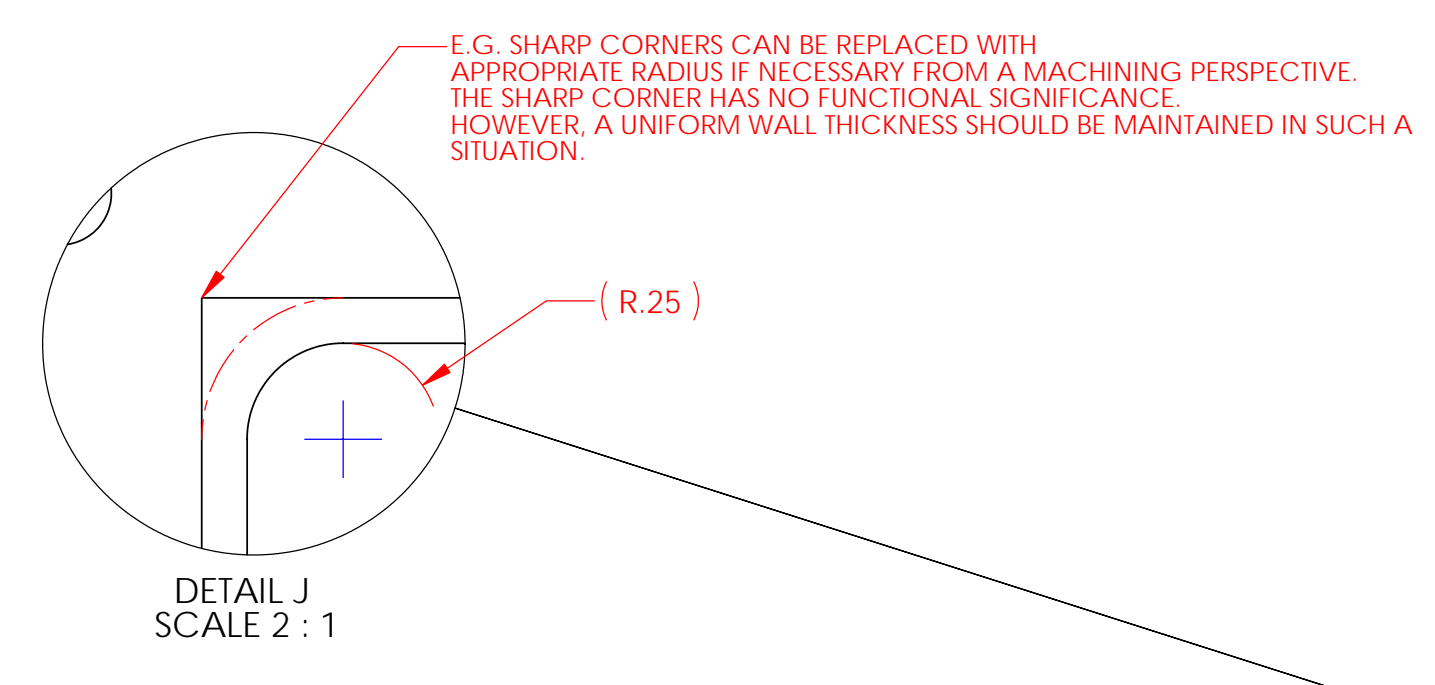
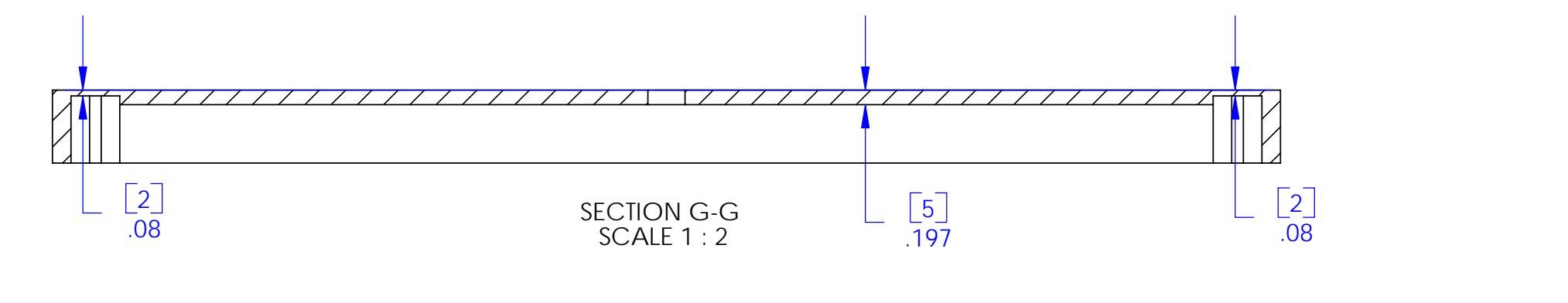


REV	DATE	DESCRIPTION	DRAWING TREE #



NOTE THE DIFFERENCE IN WALL THICKNESS AT THIS LOCATION. DETAILED IN SECTION H-H



GENERAL NOTES (UNLESS OTHERWISE SPECIFIED)

- DO NOT SCALE FROM DRAWING.
- REMOVE ALL SHARP EDGES. R.03 MIN.
- ALL MACHINING FLUES SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE.
- SCRIBE, ENGRAVE OR MECHANICALLY STAMP DRAWING (NO INKS OR DYES) PART NUMBER, REVISION, 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 12 HIGH CHARACTERS. AREA IS THE SIZE OF THE PART INDICATES SMALL CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: 0000000001 5/16/01
- THE COMPONENT IS SYMMETRIC ABOUT THE Q.
- DUAL DIMENSIONS (MILLIMETERS) APPEAR IN SQUARE BRACKETS. PRIMARILY FOR ADVANCED LEGAL TECHNICAL REFERENCE.
- BACKGROUND INFORMATION: INITIAL DIMENSIONS WITH MACHINISTS AT CALTECH INDICATED THAT WATER JET CUTTING WOULD BE USED TO ACHIEVE THE BASIC SHAPES, THEN ANY FINISHING WOULD BE DONE BY MILLING WITH A R.25 CUTTER.

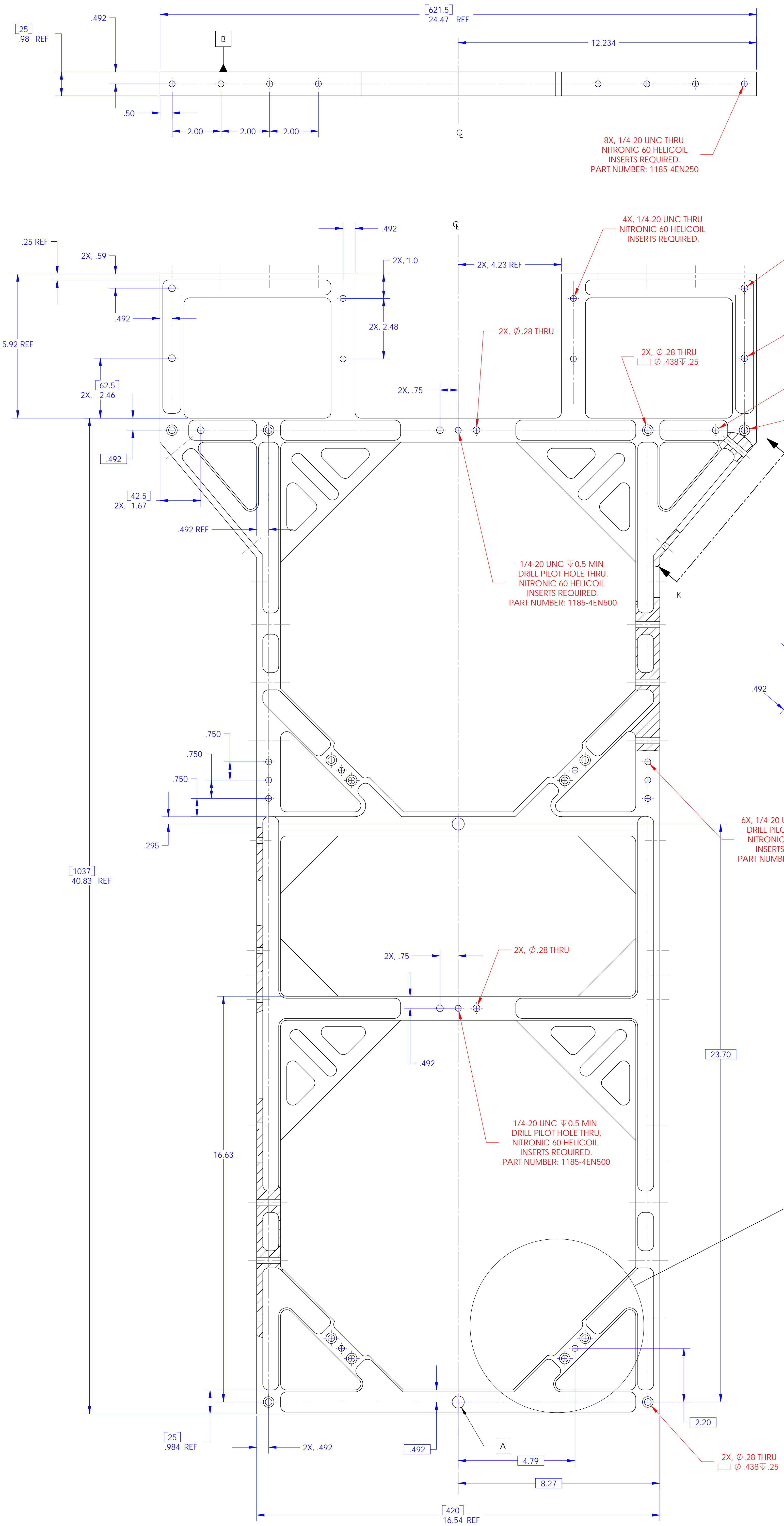
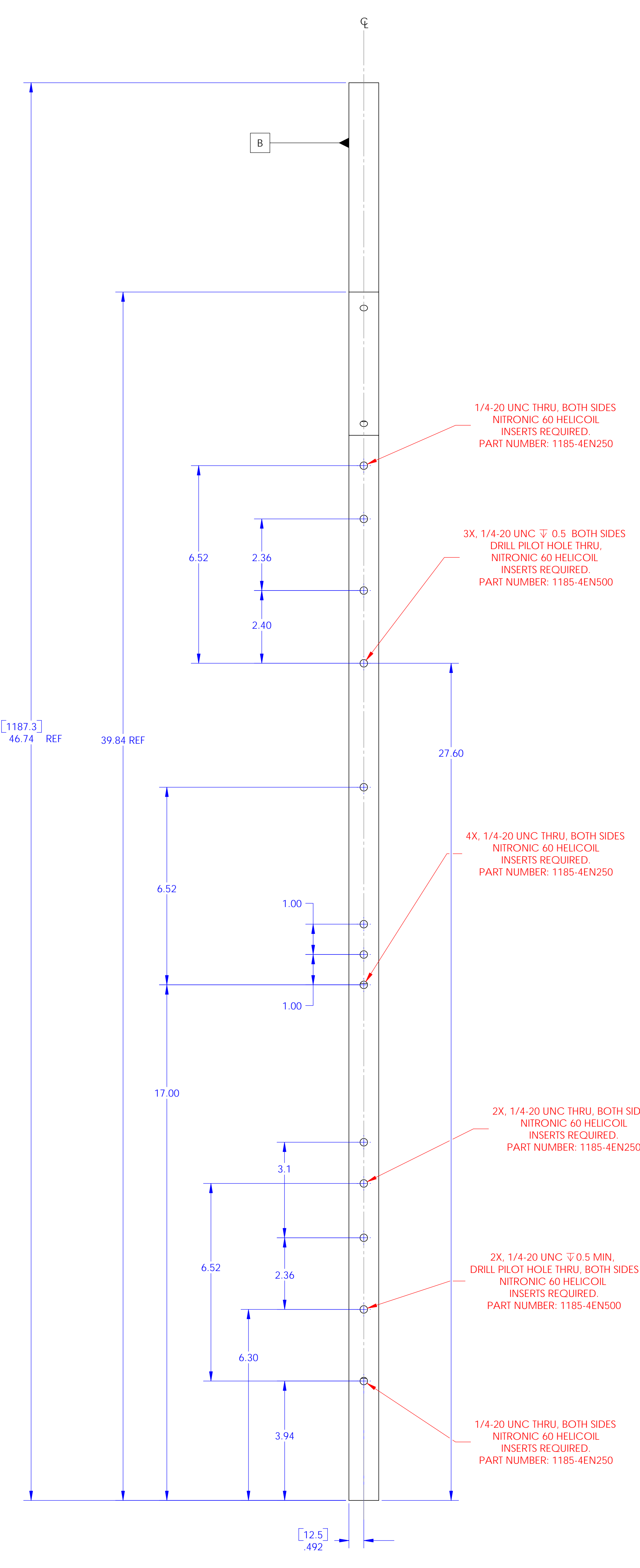
PARTS LIST

QTY	PART NAME	MATERIAL	FINISH	REV
1	FACEPLATE	6061-T6 Al		A

DRAWN: [] DATE: []
 CHECKED: [] DATE: []
 APPROVED: [] DATE: []

SCALE: 1:1 PROJECTION: [] SHEET: 3 OF 3

REV	DATE	DCN #	DRAWING TRF #



8X, 1/4-20 UNC THRU NITRONIC 60 HELICOIL INSERTS REQUIRED. PART NUMBER: 1185-4EN250

4X, 1/4-20 UNC THRU NITRONIC 60 HELICOIL INSERTS REQUIRED.

2X, ϕ .28 THRU

2X, ϕ .28 THRU \lfloor ϕ 438 ∇ .25

2X, ϕ .28 THRU \lfloor ϕ 438 ∇ .25

2X, 1/4-20 UNC ∇ 0.5 MIN. DRILL PILOT HOLE THRU, NITRONIC 60 HELICOIL INSERTS REQUIRED. PART NUMBER: 1185-4EN500

2X, 1/4-20 UNC THRU NITRONIC 60 HELICOIL INSERTS REQUIRED. PART NUMBER: 1185-4EN250

6X, 1/4-20 UNC ∇ 0.5 MIN. DRILL PILOT HOLE THRU, NITRONIC 60 HELICOIL INSERTS REQUIRED. PART NUMBER: 1185-4EN500

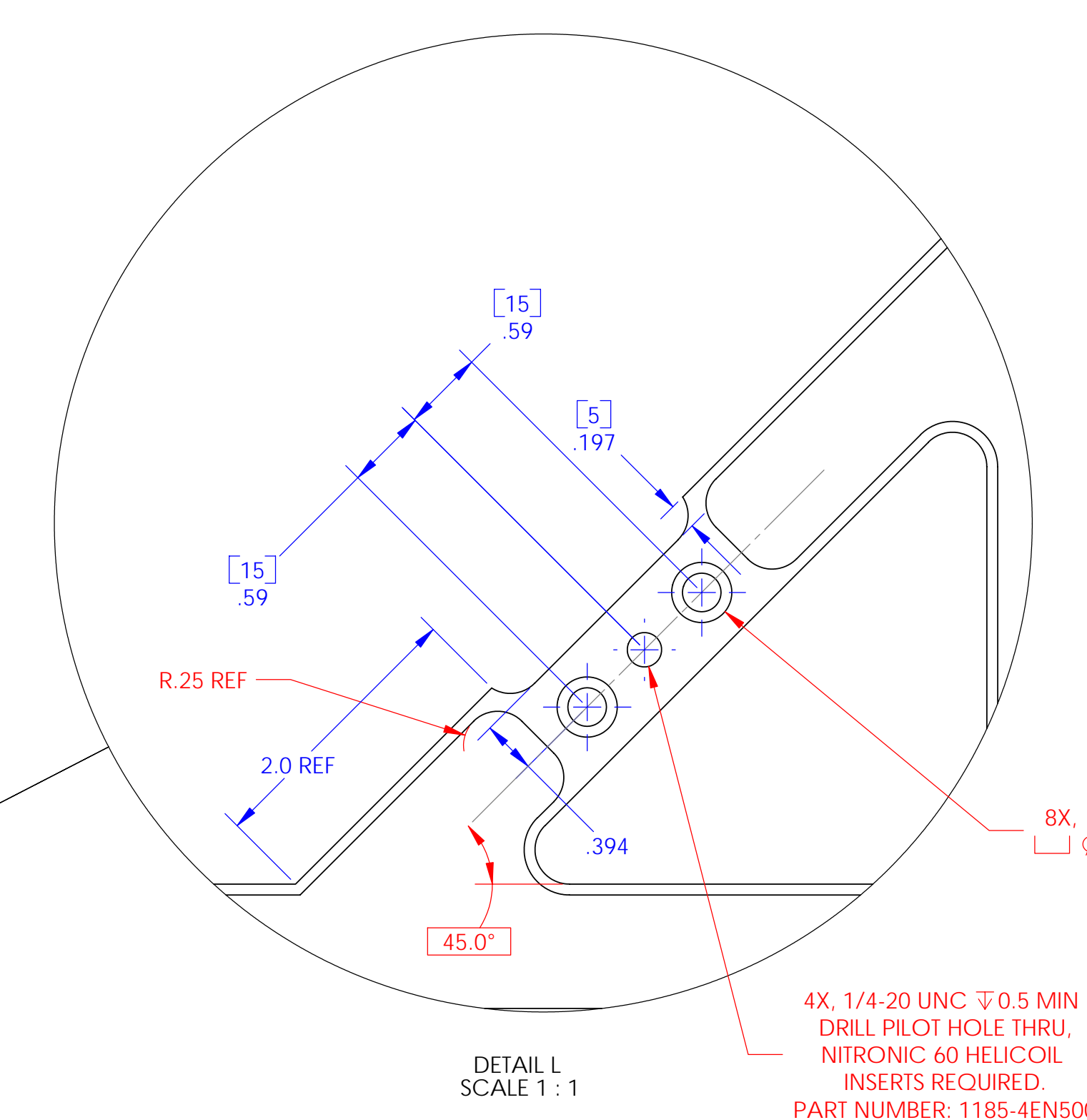
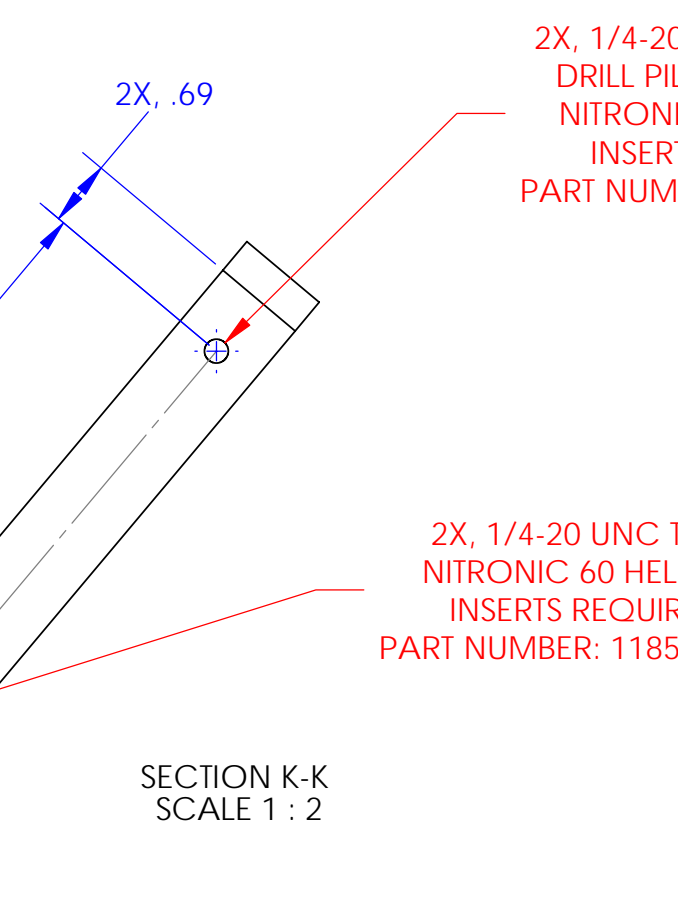
2X, ϕ .28 THRU

1/4-20 UNC ∇ 0.5 MIN. DRILL PILOT HOLE THRU, NITRONIC 60 HELICOIL INSERTS REQUIRED. PART NUMBER: 1185-4EN500

2X, 1/4-20 UNC ∇ 0.5 MIN. DRILL PILOT HOLE THRU, BOTH SIDES NITRONIC 60 HELICOIL INSERTS REQUIRED. PART NUMBER: 1185-4EN500

1/4-20 UNC THRU, BOTH SIDES NITRONIC 60 HELICOIL INSERTS REQUIRED. PART NUMBER: 1185-4EN250

2X, ϕ .28 THRU \lfloor ϕ 438 ∇ .25



NOTES (UNLESS OTHERWISE SPECIFIED)		PARTS LIST	
1. DO NOT SCALE FROM DRAWING	2. REMOVE ALL SHARP EDGES, R.02 MIN.	3. ALL MACHINING FLUDES SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE	4. SCRIBE, ENGRAVE OR MECHANICALLY STAMP DRAWING DIMENSIONS OR DIVISION PART NUMBER, REVISION, 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 INCREASE CONSECUTIVELY. USE 12 HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALL CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: D050035-A1 5/8 001
5. THE COMPONENT IS SYMMETRIC ABOUT THE ϕ	6. DIMENSIONS (MILLIMETERS) APPEAR IN SQUARE BRACKETS PRIMARILY FOR ADVANCED LIGO TECHNICAL REFERENCE	7. BACKGROUND INFORMATION: INITIAL DISCUSSIONS WITH MACHINISTS AT CALTECH INDICATED THAT WATER JET CUTTING WOULD BE USED TO ACHIEVE THE BASIC SHAPES, THEN ANY FINISHING WOULD BE DONE BY MILLING WITH A R.25° CUTTER.	8. SCALE: 1:1
<p>MANUFACTURER: 6061-T6 Al</p> <p>PART NAME: FACEPLATE</p> <p>SCALE: 1:1</p>		<p>ADVANCED LIGO</p> <p>ASSEMBLY SUB-SYSTEM</p> <p>ASSEMBLY SUB-SYSTEM</p> <p>ASSEMBLY SUB-SYSTEM</p> <p>ASSEMBLY SUB-SYSTEM</p>	