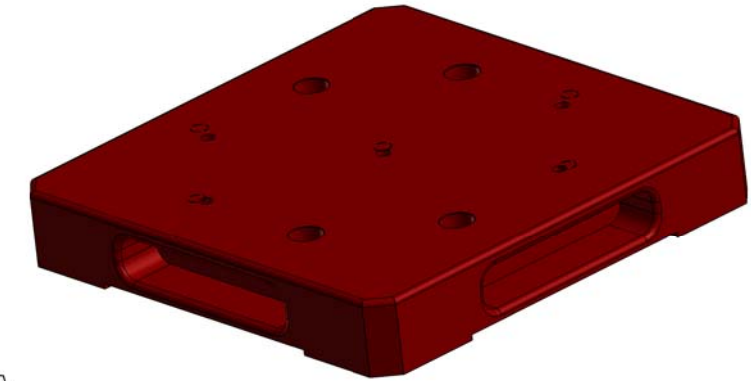


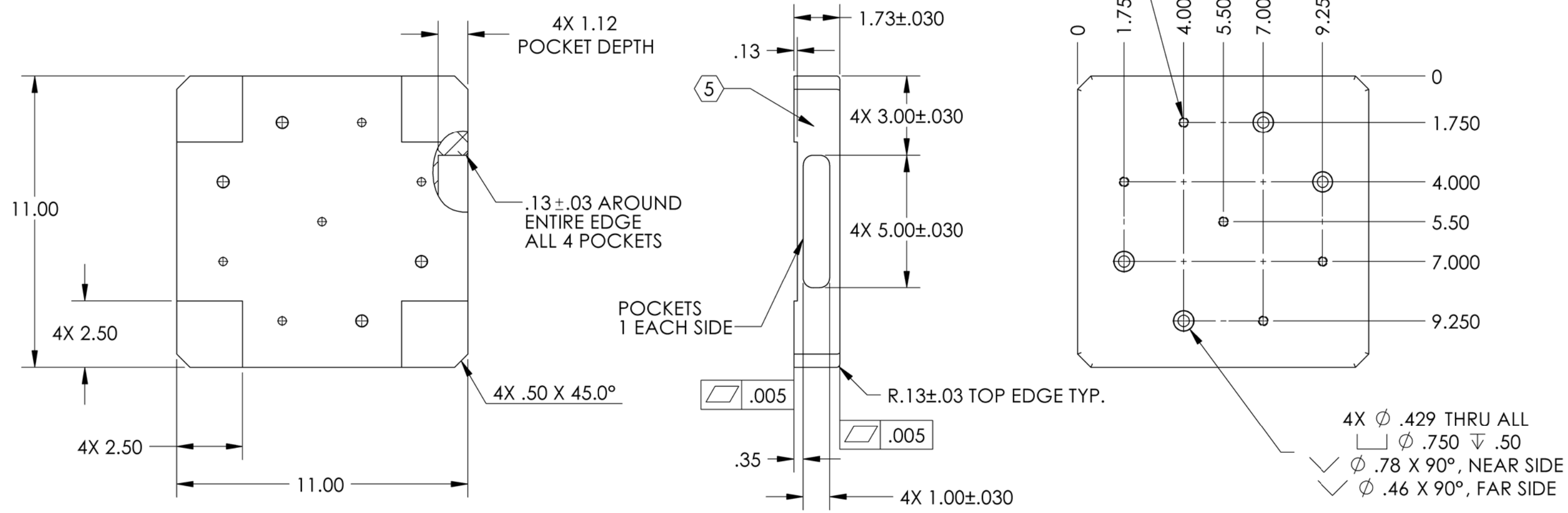
REV.	DATE	DCN #	DRAWING TREE #
v1	29 Nov. 2010	E1000758	E1000025

NOTES CONTINUED:

4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
5. SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXXX-VY, TYPE-XX, S/N XXX.
6. APPROXIMATE WEIGHT = 50 LB.=22.7 KG.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES (INCLUDING SANDING OR SCOURING FOR MATTE FINISH) IS NOT ALLOWED. USE OF SCOTCH-BRITE OR SIMILAR PRODUCTS IS FORBIDDEN.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NOT WELD REPAIRS OR PLUGS) UNLESS APPROVED IN ADVANCE AND IN WRITING BY LIGO, REFER TO LIGO-E0900364.
10. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE. THE MATERIAL USED MUST BE VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF AND WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH THE MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E09000364.



5X ϕ .31 THRU ALL
3/8-16 UNC ∇ .88



D1003136 BALLIST MASS, aLIGO BSC-ISI, PART PDM REV: X-004, DRAWING PDM REV: X-007

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				PART NAME		
DIMENSIONS ARE IN INCHES		1. INTERPRET DRAWING PER ASME Y14.5-1994.		BALLAST MASS, aLIGO BSC-ISI		
TOLERANCES: .XX ± .015 .XXX ± .005		2. REMOVE ALL SHARP EDGES, .03 x 45°.		DESIGNER	M.HILLARD 29 Nov. 2010	
ANGULAR ± .5°		3. DO NOT SCALE FROM DRAWING.		DRAFTER	M.HILLARD 29 Nov. 2010	
MATERIAL		304, 316 OR 302 SSSL	FINISH	63 μ inch	CHECKER	F.MATICHARD 29 Nov. 2010
NEXT ASSY				APPROVAL	K.MASON 29 Nov. 2010	
				SCALE	1:4	
				PROJECTION		
				DWG. NO.	D1003136	
				REV.	v1	
				SHEET	1 OF 1	