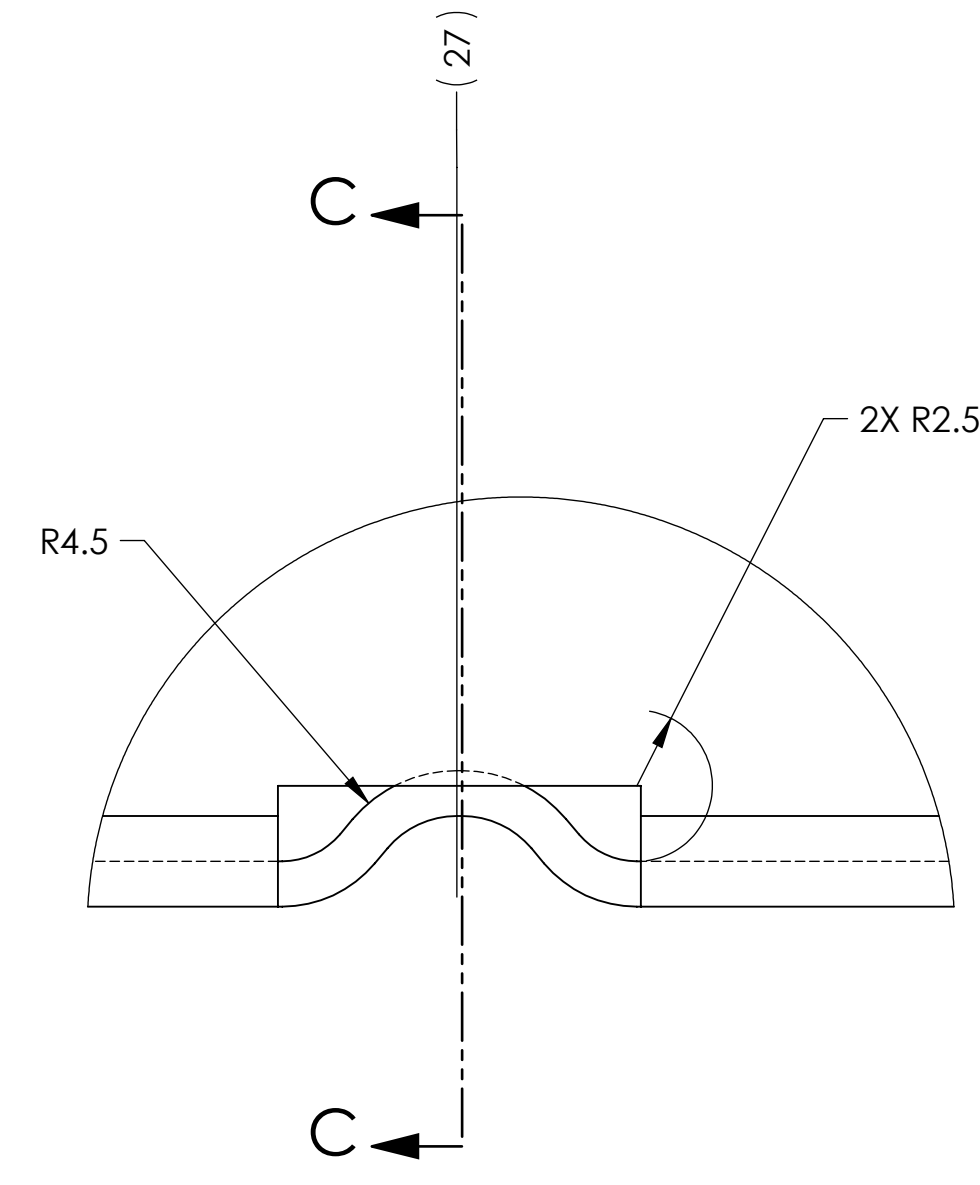
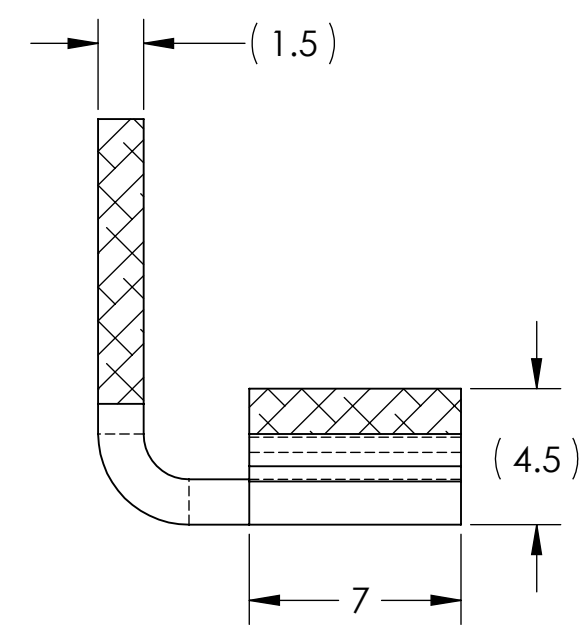


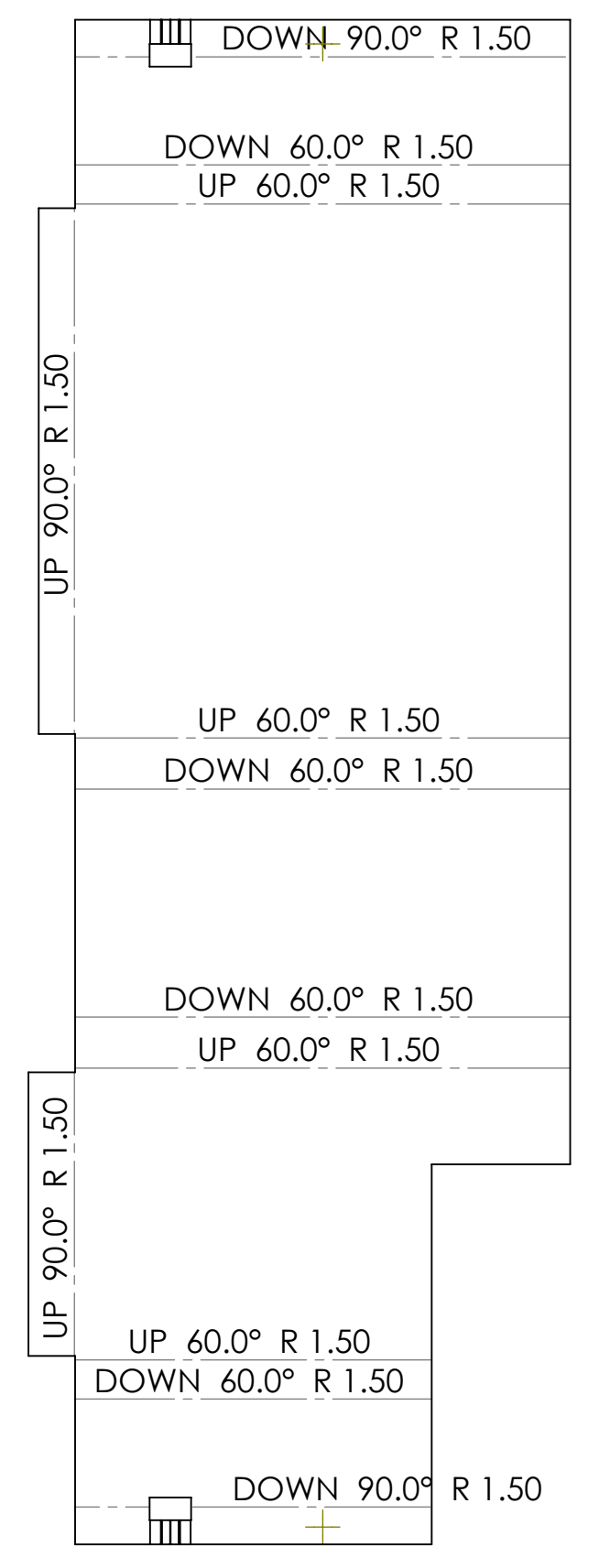
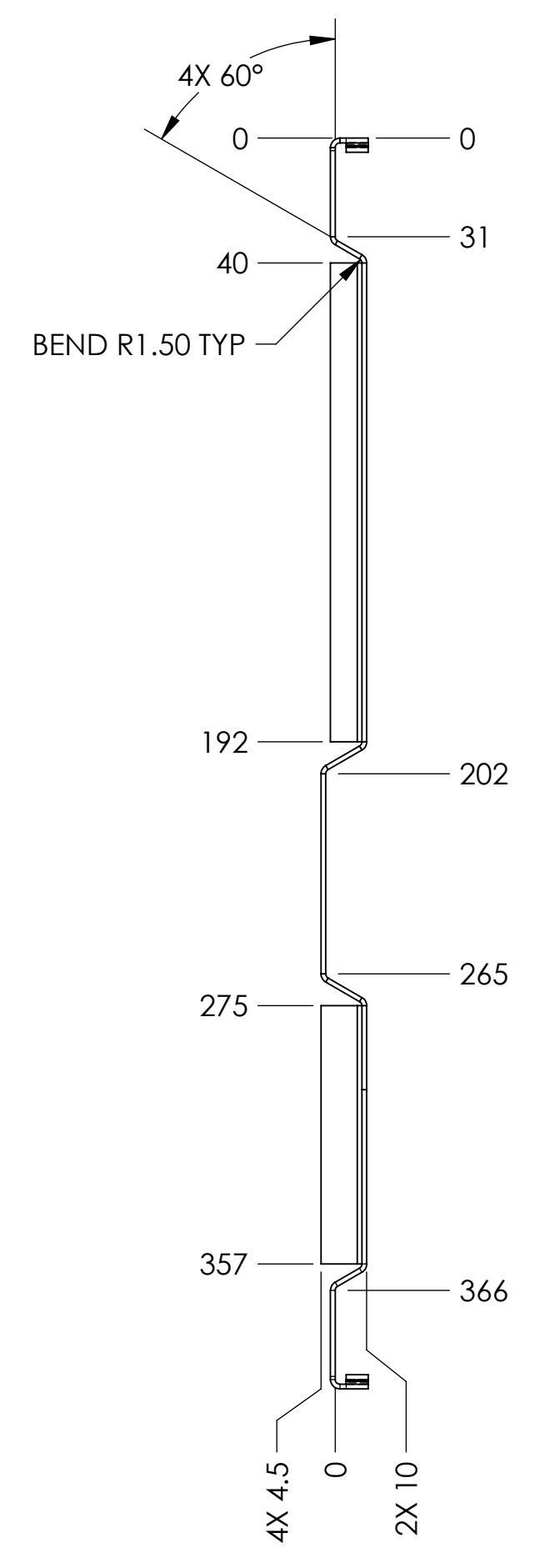
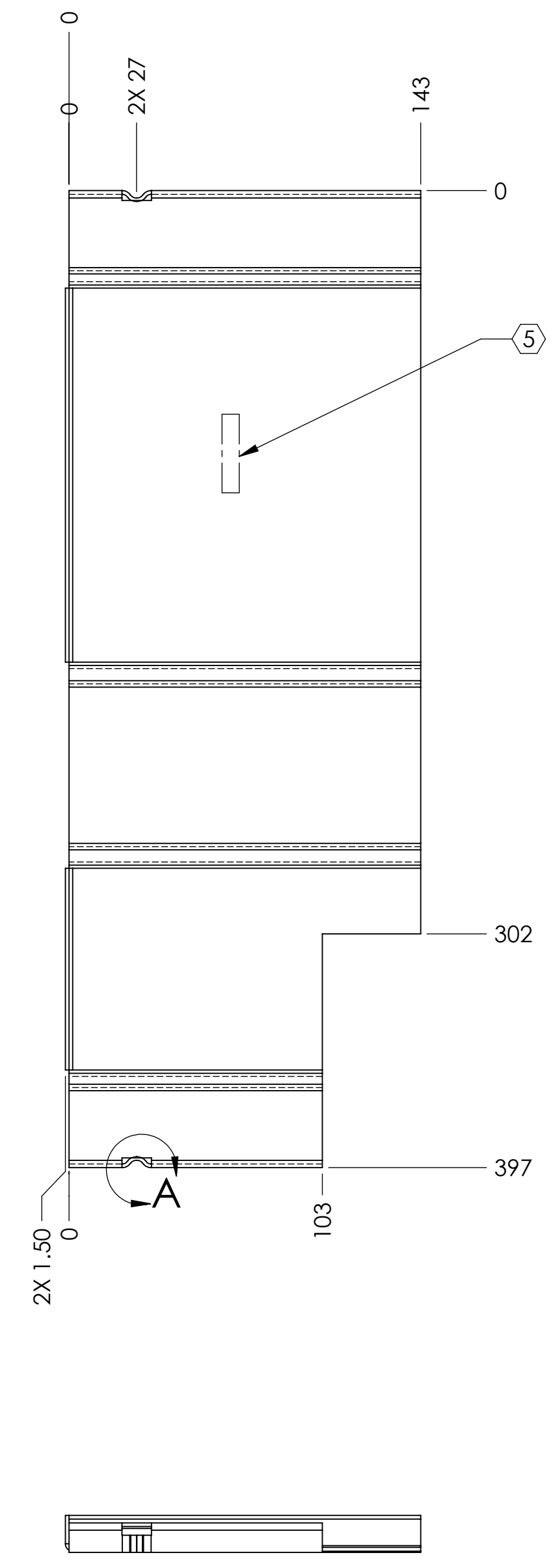
- NOTES CONTINUED:**
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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. APPROXIMATE WEIGHT = 0.54 LB.
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 8. 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.
 9. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
 10. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.



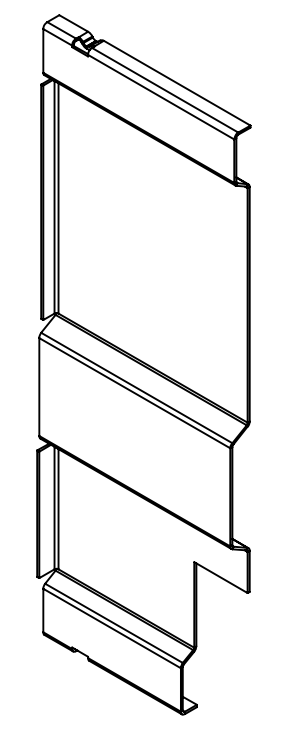
DETAIL A
SCALE 4 : 1
2X



SECTION C-C
SCALE 4 : 1
2X



FLAT PATTERN - REF



<p>NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)</p> <p>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.</p>				<p>LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY</p>		<p>PART NAME LOWER QUAD SHIELD - RH</p>	
<p>DIMENSIONS ARE IN MILLIMETERS</p> <p>TOLERANCES: .XX ± .25 .XXX ± .13</p> <p>ANGULAR ± .5°</p>		<p>MATERIAL 16 GAUGE (1.5mm THK) 5052-H32</p>		<p>FINISH 63 μinch</p>		<p>SYSTEM ADVANCED LIGO</p>	
		<p>SUB-SYSTEM SUS</p>		<p>DESIGNER K. BUCKLAND 10 JAN 2011</p>		<p>SIZE DWG. NO. D 1100054</p>	
		<p>CHECKER</p>		<p>DRAFTER K. BUCKLAND 14 JAN 2011</p>		<p>REV. v2</p>	
		<p>APPROVAL</p>		<p>SCALE: 1:2</p>		<p>PROJECTION: </p>	
				<p>SHEET 1 OF 1</p>			

D1100054.dwg, SUS, LOWER QUAD SHIELD - RH, PART PDM, REV-X,002, DRAWING PDM, REV, X,001