

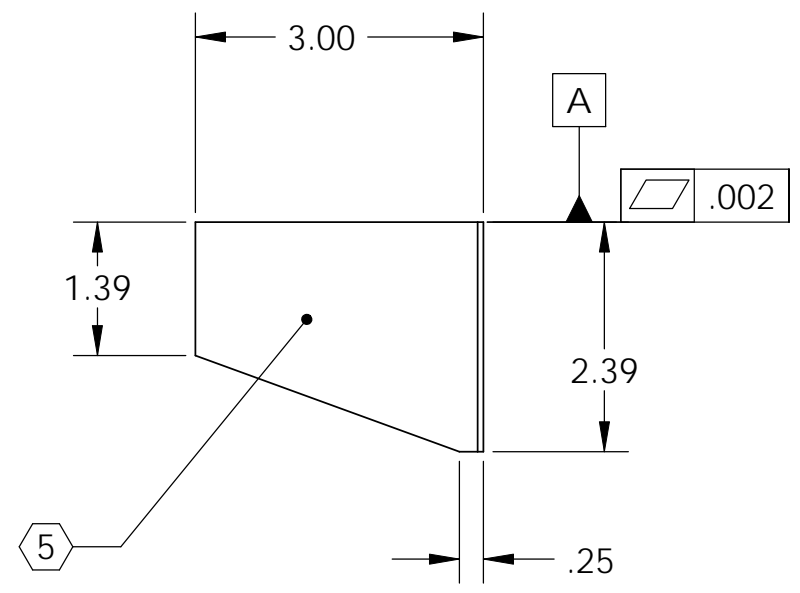
D0901183 Large Vert. Actuator Post Bridge, Stage 0-1, aLIGO BSC ISI, PART PDM REV: X-010, DRAWING PDM REV: X-002

- NOTES CONTINUED:**
- 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 DXXXXXX-VY, TYPE-XX, S/N XXX.
 - 6. APPROXIMATE WEIGHT = 4.01 LB.
 - 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 - 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - 9. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
 - 10. A TRUE POSITION TOLERANCE OF ϕ .010 IS - THE SAME AS A CONVENTIONAL TOLERANCE OF \pm .005.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 Feb. 2010	E1000049	E1000025

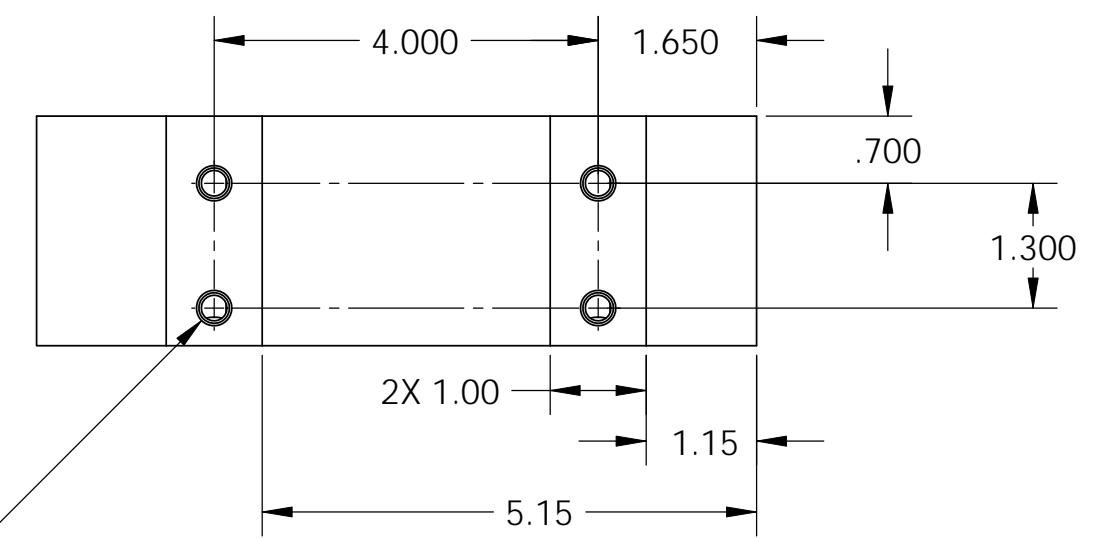
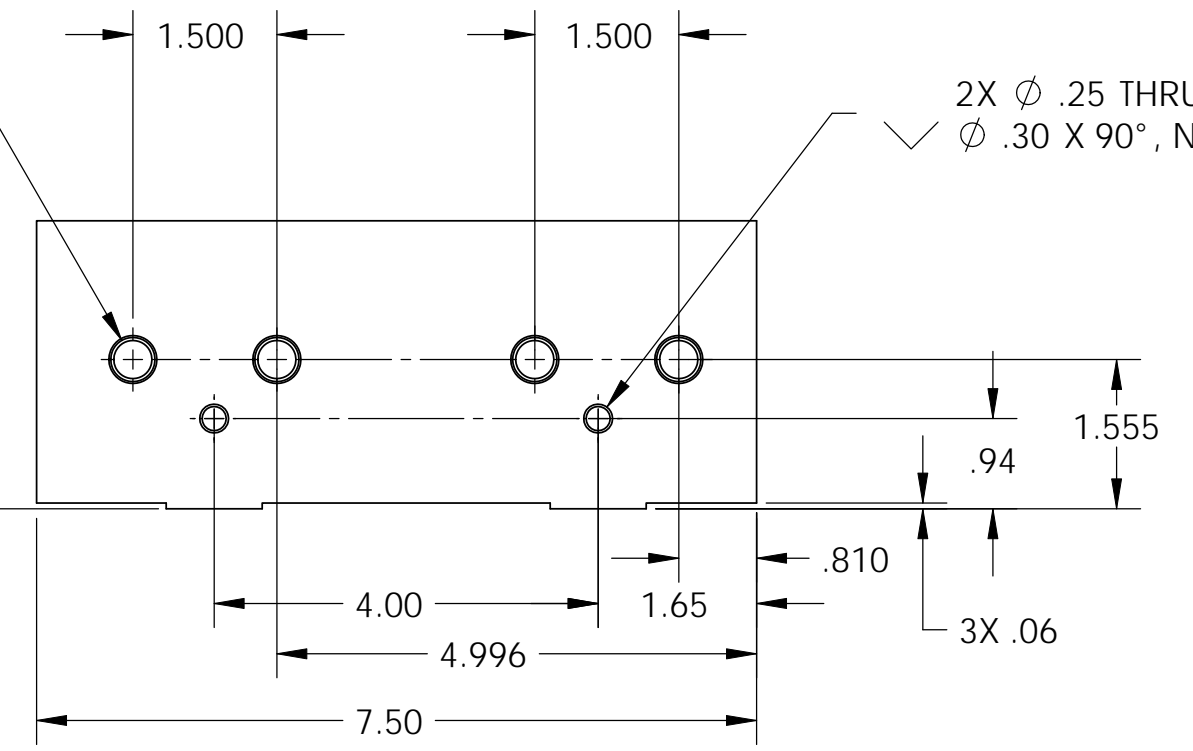
4X ϕ .40 THRU ALL
 \surd ϕ .50 X 90°, NEAR SIDE
 TAP FOR 3/8-16 HELICOIL INSERT = 2.5 * DIA.

2X ϕ .25 THRU ALL
 \surd ϕ .30 X 90°, NEAR SIDE



4X ϕ .27 ∇ .94
 \surd ϕ .37 X 90°, NEAR SIDE
 TAP FOR 1/4-20 HELICOIL INSERT = 2.0 * DIA.

\surd .002 A
 2 SURFACES



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX \pm .015 .XXX \pm .005 ANGULAR \pm .5°				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.		LARGE VERT. ACTUATOR POST BRIDGE, STAGE 0-1, aLIGO BSC ISI	
MATERIAL		FINISH		NEXT ASSY		DESIGNER	
6061-T6 Al		N/A μ inch		D0901103		S.BARNUM 22 Feb. 2010	
						DRAFTER	
						M.HILLARD 22 Feb. 2010	
						CHECKER	
						F.MATICHARD 22 Feb. 2010	
						APPROVAL	
						K.MASON 22 Feb. 2010	
						SIZE DWG. NO.	
						B D0901183	
						REV.	
						v1	
						SCALE: 1:2 PROJECTION: SHEET 1 OF 1	