

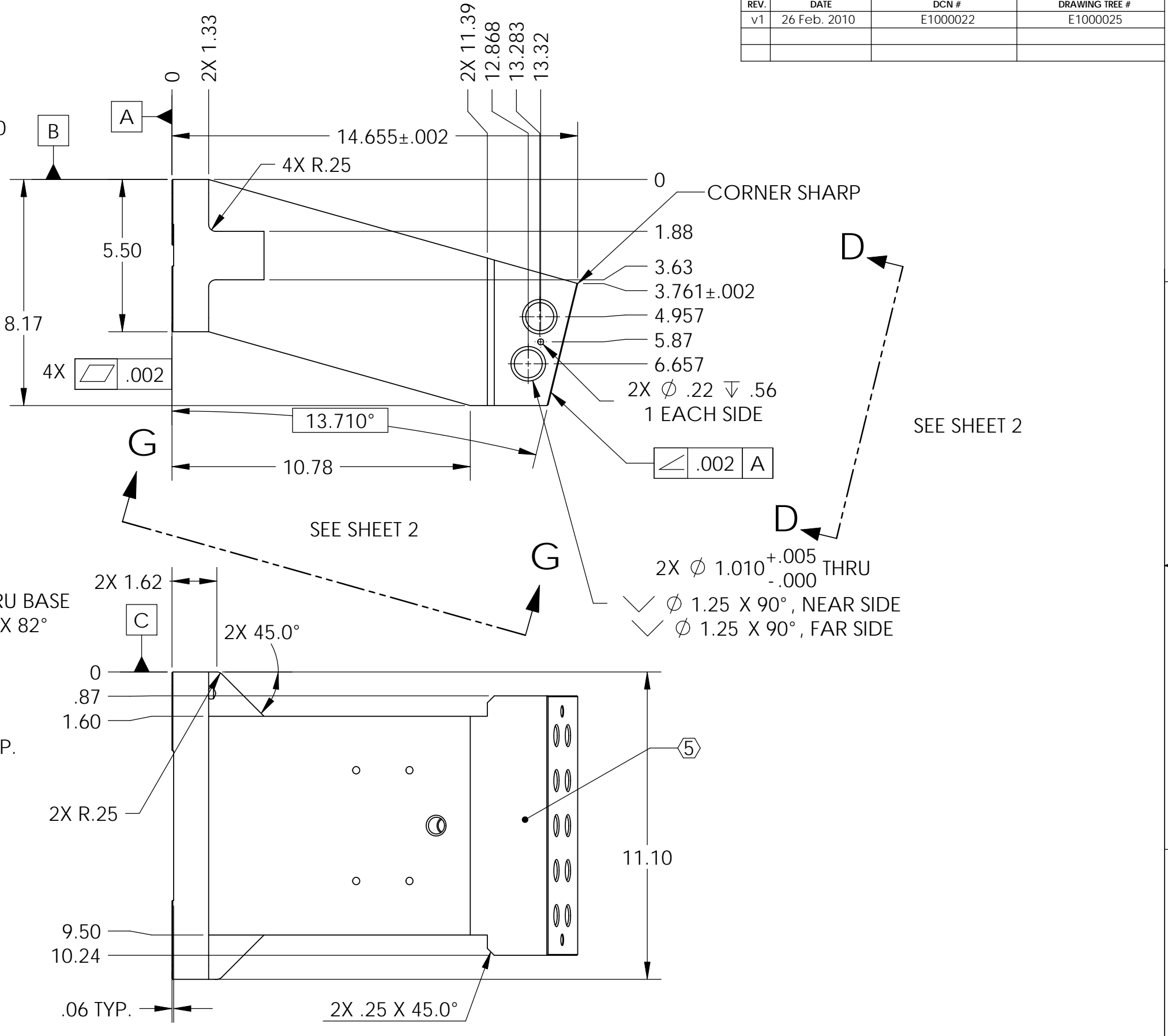
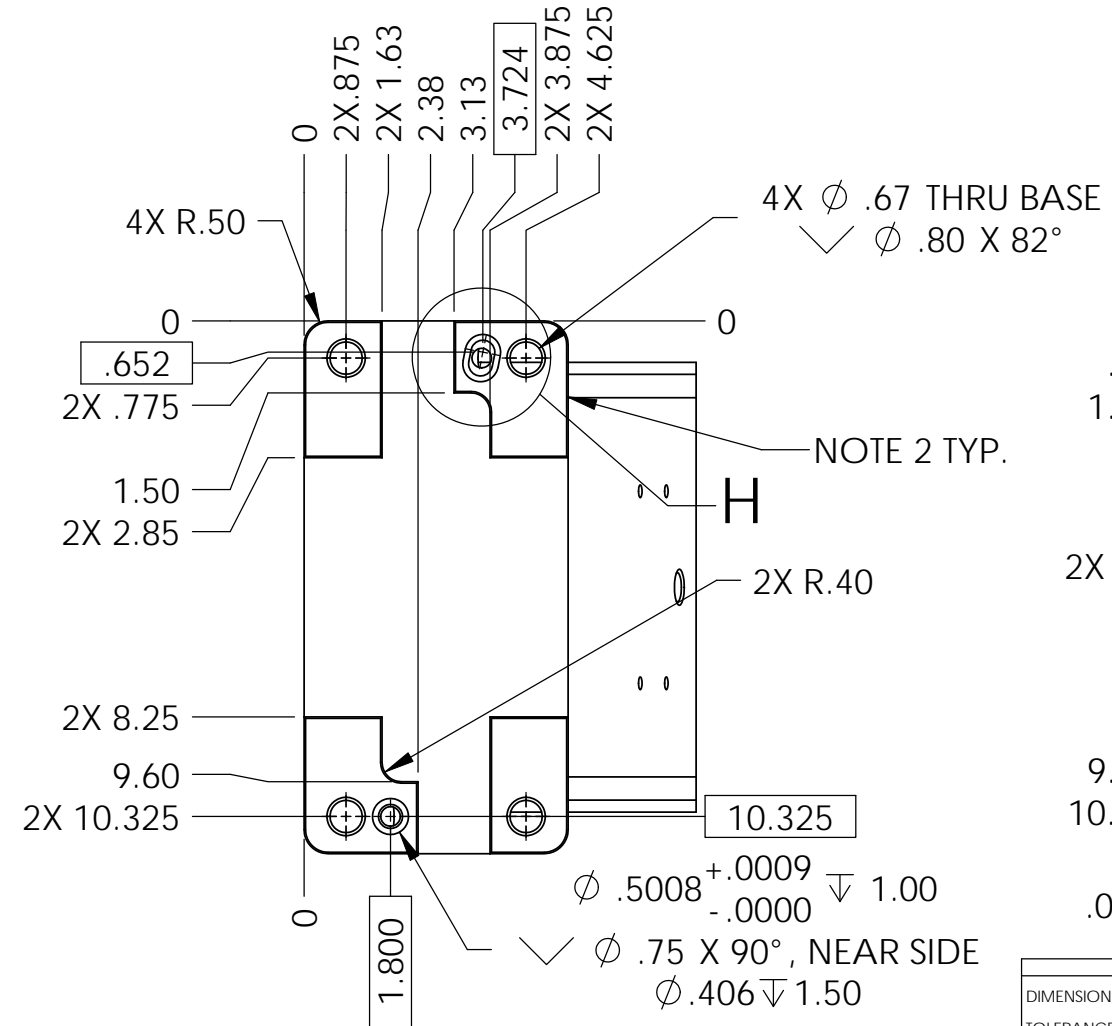
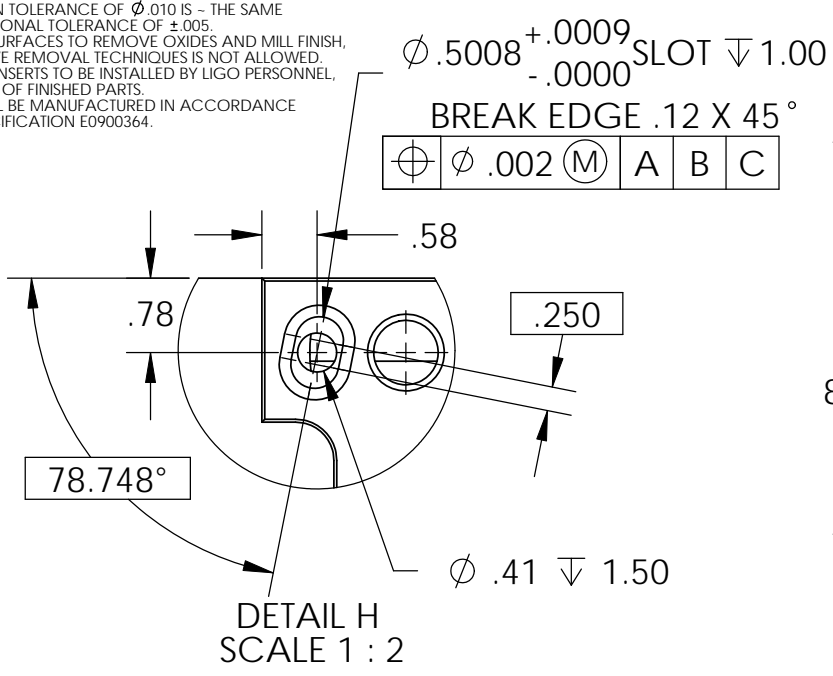
D0901499 Blade Spring Post Stage 0-1, PART PDM REV: X-020, DRAWING PDM REV: X-009

NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICAL AND PROCEED CONSECUTIVELY. USE .07 HIGH CHARACTERS. EXAMPLE DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.
- 6. APPROXIMATE WEIGHT = 60.8 LB.
- 7. A TRUE POSITION TOLERANCE OF $\phi .010$ IS - THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.
- 8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 9. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS.
- 10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	26 Feb. 2010	E1000022	E1000025

D
C
B
A



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ± .015
 .XXX ± .005
 ANGULAR ± .5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.	
2. BREAK ALL CORNERS AND EDGES .03 X 45°.	
3. DO NOT SCALE FROM DRAWING.	
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
MATERIAL	6061-T6 Al
FINISH	63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	SEI
NEXT ASSY	D0901197

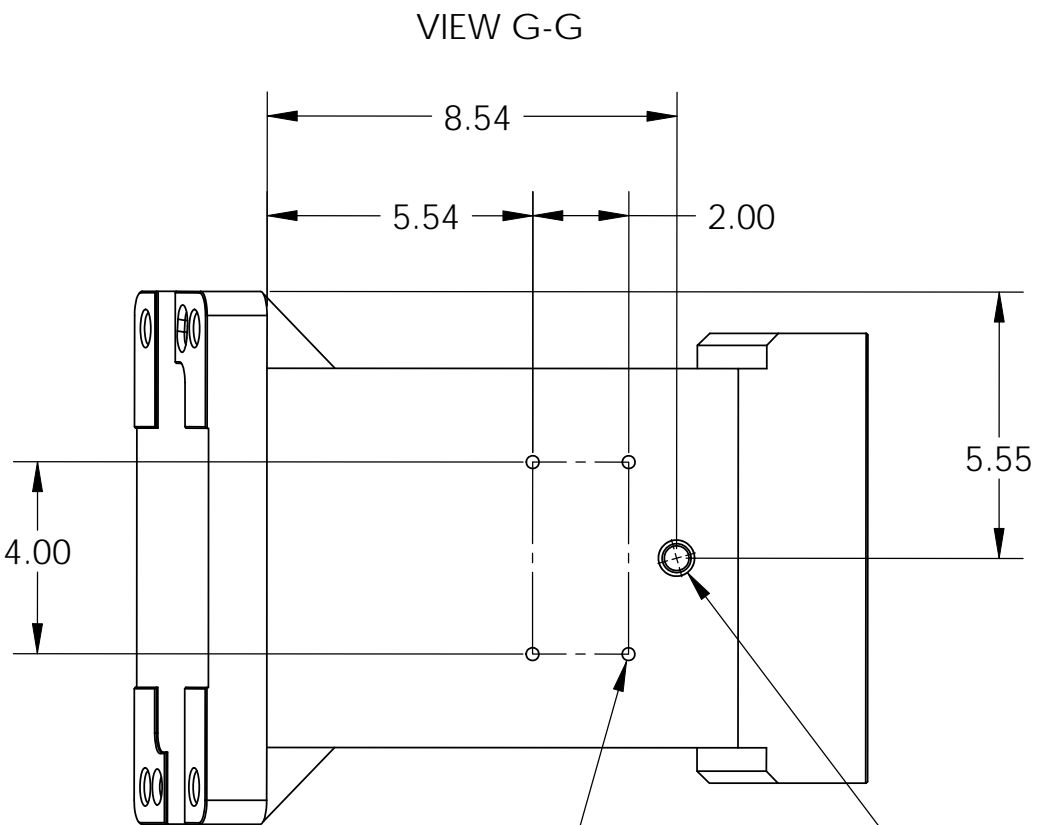
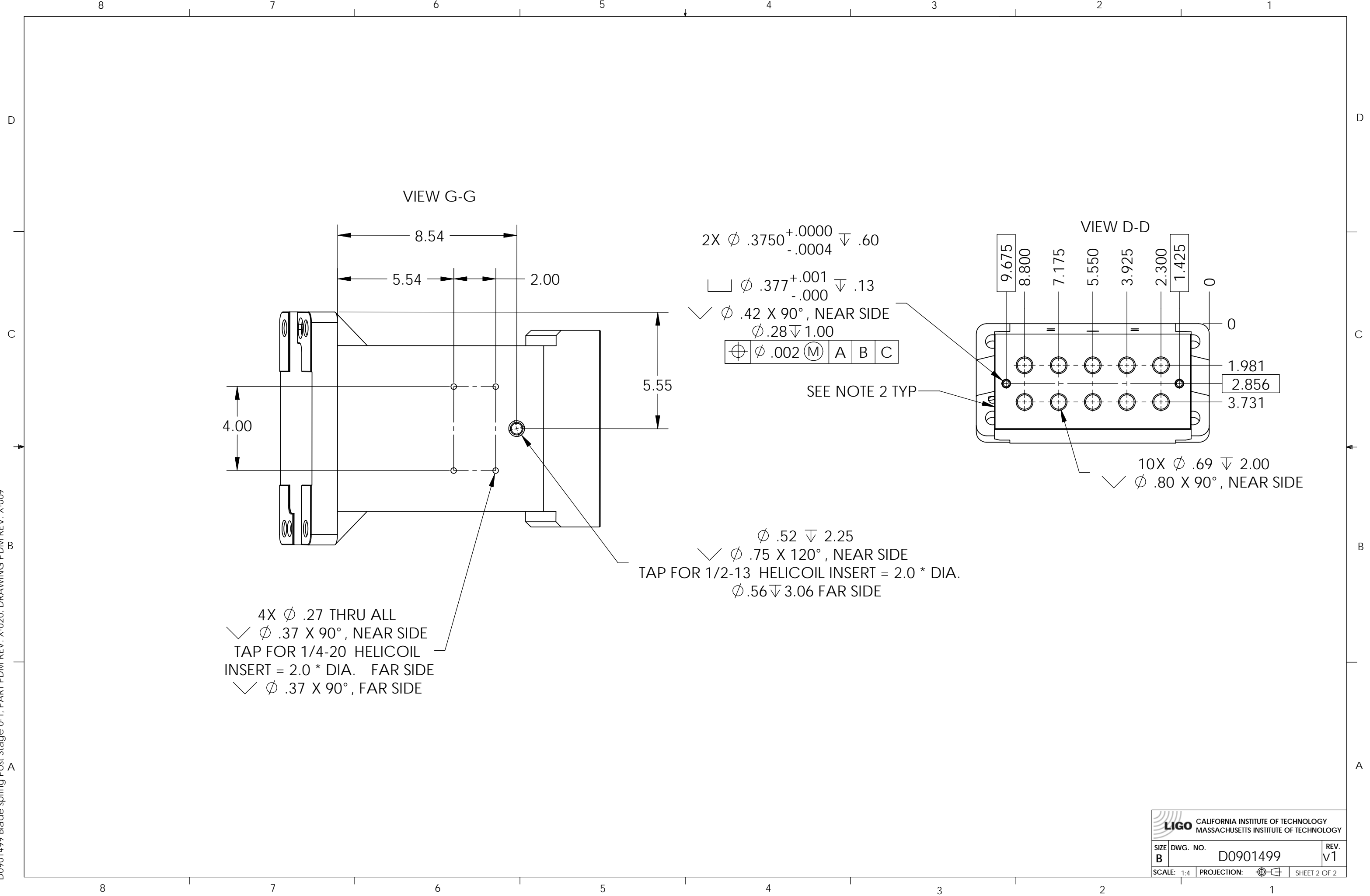
PART NAME BLADE POST,STAGE 0-1, aLIGO BSC ISI			
DESIGNER	A.STEIN	01 Feb. 2010	SIZE DWG. NO. B D0901499
DRAFTER	M.HILLARD	01 Feb. 2010	
CHECKER	F.MATICHARD	01 Feb. 2010	REV. v1
APPROVAL	K.MASON	01 Feb. 2010	
SCALE: 1:4		PROJECTION:	
SHEET 1 OF 2			

SEE SHEET 2

SEE SHEET 2

8 7 6 5 4 3 2 1

D0901499 Blade spring Post Stage 0-1, PART PDM REV: X-020, DRAWING PDM REV: X-009



2X $\phi .3750^{+.0000}_{-.0004} \nabla .60$

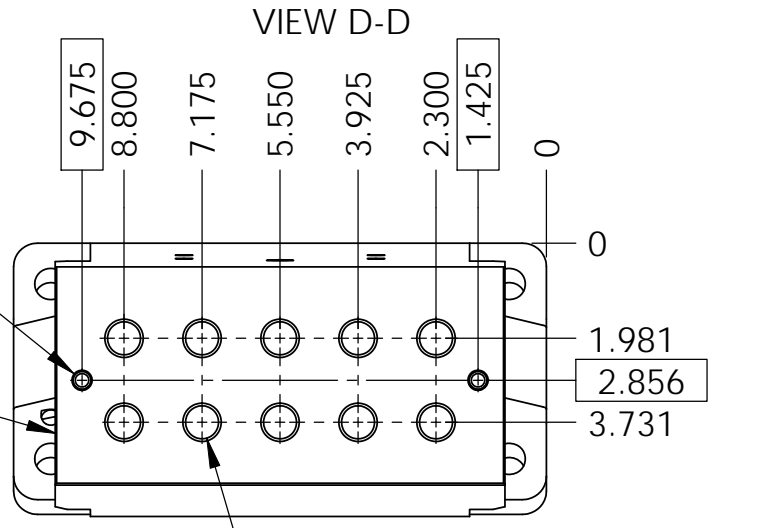
$\square \phi .377^{+.001}_{-.000} \nabla .13$

$\checkmark \phi .42 \times 90^\circ$, NEAR SIDE

$\phi .28 \nabla 1.00$

$\oplus \phi .002 \text{ (M) A B C}$

SEE NOTE 2 TYP



10X $\phi .69 \nabla 2.00$

$\checkmark \phi .80 \times 90^\circ$, NEAR SIDE

$\phi .52 \nabla 2.25$

$\checkmark \phi .75 \times 120^\circ$, NEAR SIDE

TAP FOR 1/2-13 HELICOIL INSERT = 2.0 * DIA.

$\phi .56 \nabla 3.06$ FAR SIDE

4X $\phi .27$ THRU ALL

$\checkmark \phi .37 \times 90^\circ$, NEAR SIDE

TAP FOR 1/4-20 HELICOIL INSERT = 2.0 * DIA. FAR SIDE

$\checkmark \phi .37 \times 90^\circ$, FAR SIDE

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SIZE	DWG. NO.	REV.
B	D0901499	V1
SCALE: 1:4	PROJECTION:	SHEET 2 OF 2