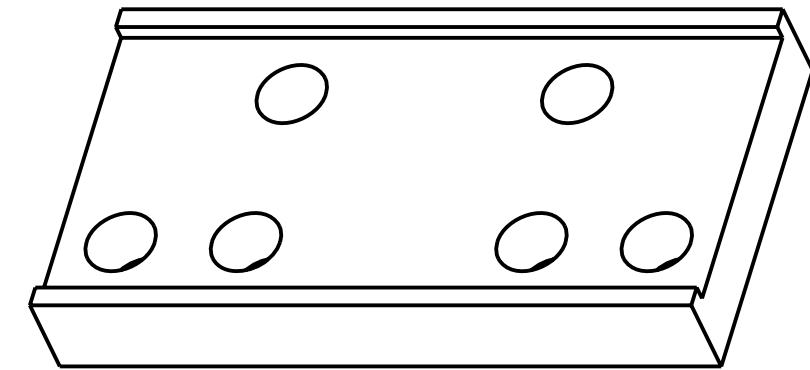
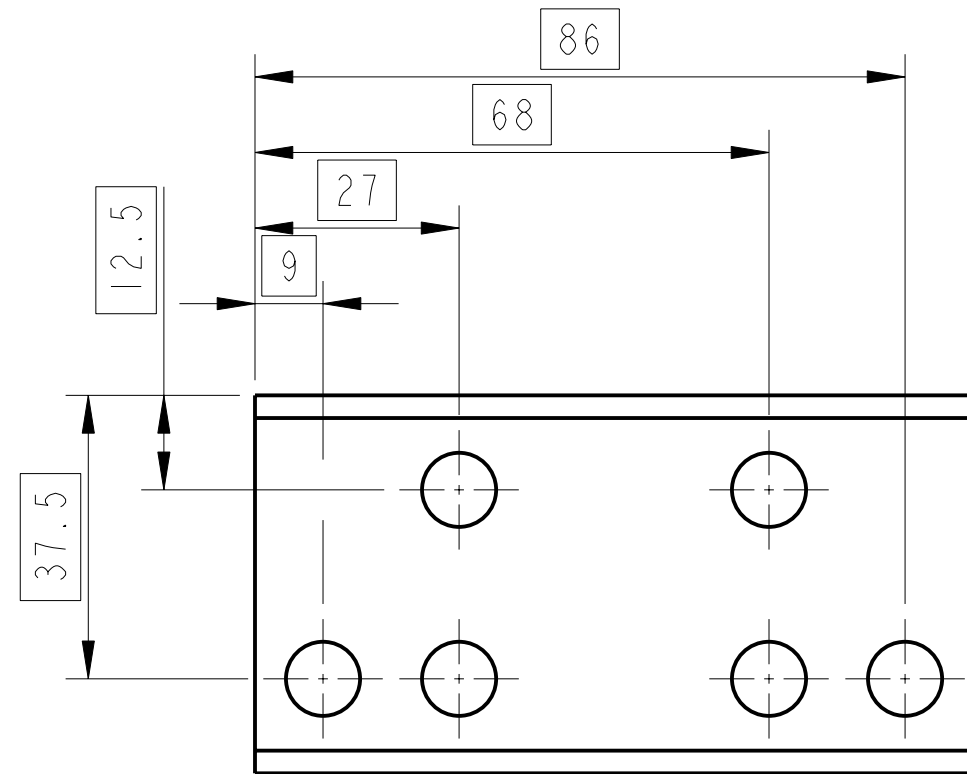
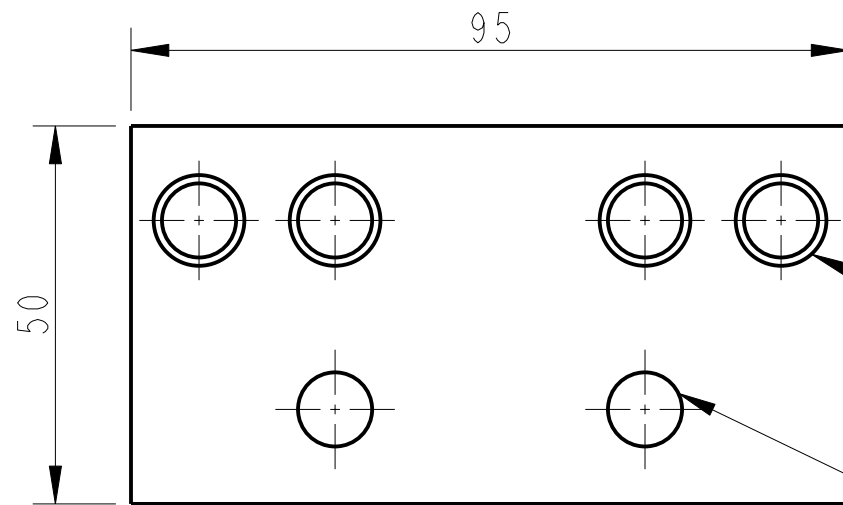
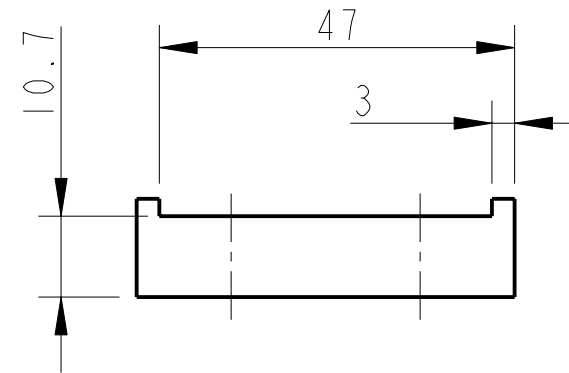
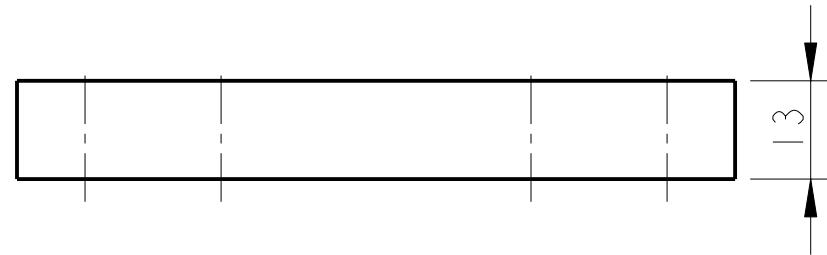


STAGE I MACHINING

REV.	DATE	DCN #	DRAWING TREE #
A	13/OCT/06	E060238	
E	15/JULY/08	E080367	



3D VIEW



DRILL 4 HOLES $\varnothing 9.8$ THRU
C'SINK $\varnothing 12$

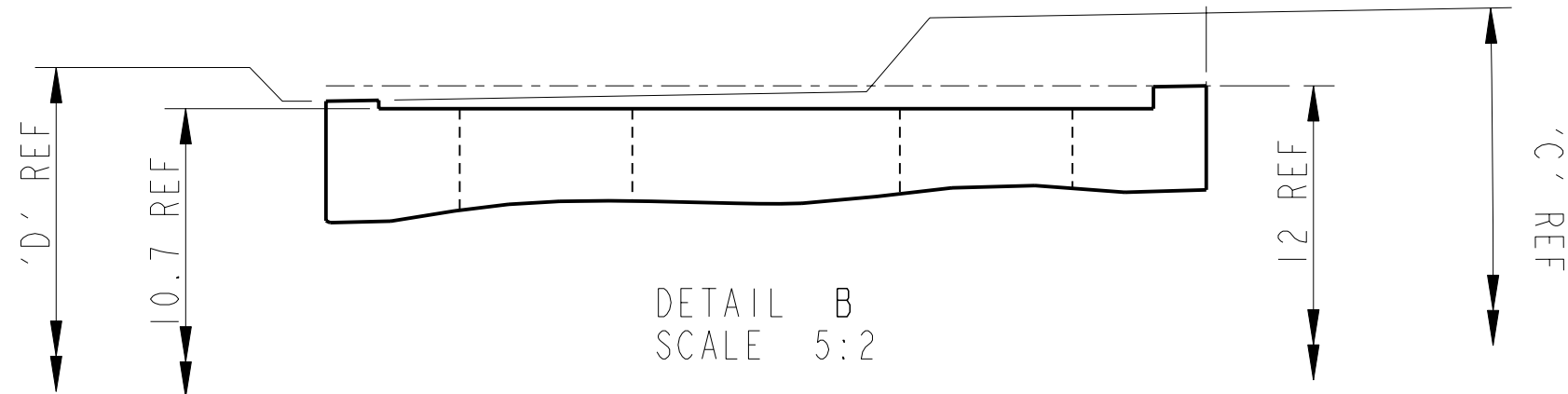
$\varnothing 0.2$

DRILL 2 HOLES $\varnothing 9.8$ THRU

$\varnothing 0.2$

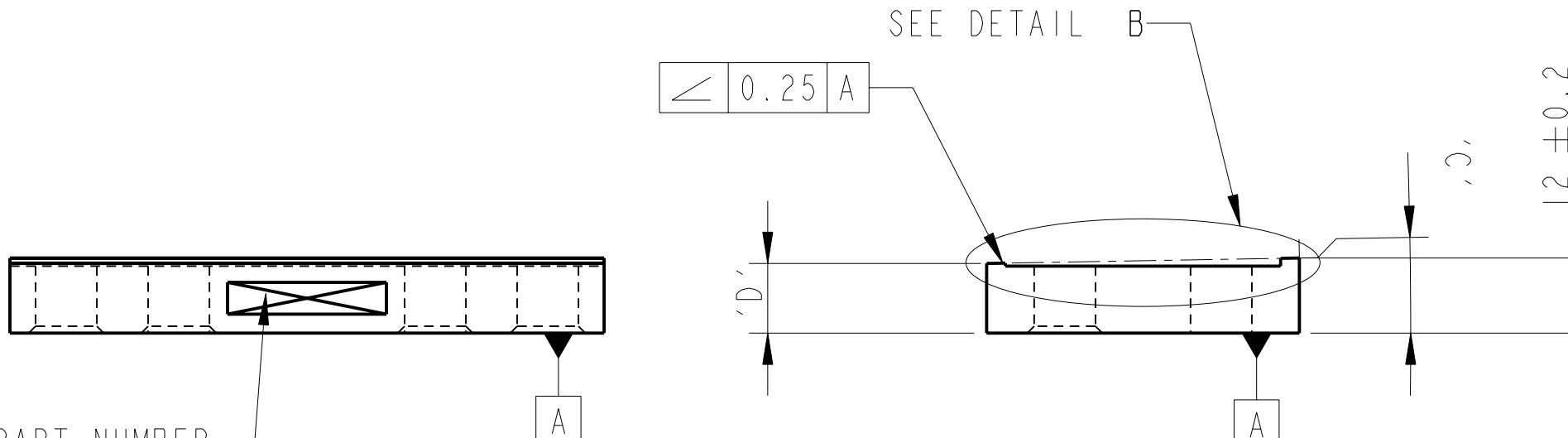
NOTES: (UNLESS OTHERWISE SPECIFIED)			CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES	
1. REMOVE ALL SHARP EDGES, R.02 MIN. 2. DO NOT SCALE FROM DRAWING. 3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL) 4. SCRIBE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: D020188- 001. A VIBRATORY TOOL MAY BE USED.	DIMENSIONS ARE IN mm [INCHES]		SYSTEM ADVANCED LIGO	
	TOLERANCES:		SUB-SYSTEM SUS	
	X.XX ± 0.25 mm		NEXT ASSY QUAD N-PTYPE TOP STAGE	
	ANGULAR $\pm 0.25^\circ$		PART NAME BLADE CLAMP (BTM HALF)	
MATERIAL: ST STEEL 304/316		FINISH: CLEAN AND DEGREASED $\sqrt{\mu m}$ [μin] Ra = 1.6 [63]		SCALE 1:1
DRAWN I WILMUT 05/Oct/06		CHECKED AJB 5MAY08		PROJECTION:
APPROVED AJB 15/JULY/08		APPROVED AJB 15/JULY/08		SHEET 1 OF 2

STAGE 2 MACHINING



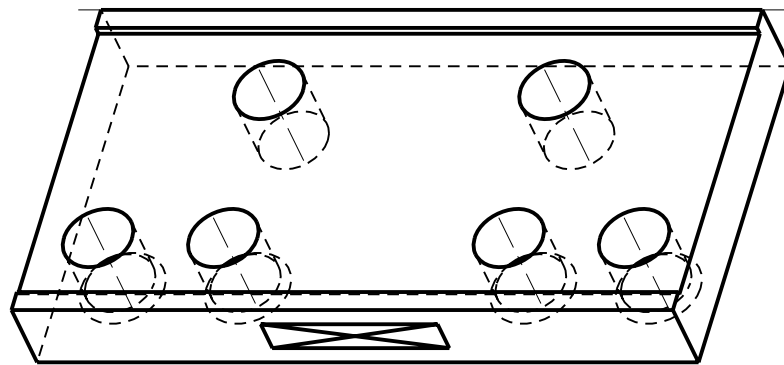
DETAIL B
SCALE 5:2

VARIANT	ANGLE C	DIM D
0	0°	12 REF
1	0.109°	11.90 REF
2	0.218°	11.80 REF
3	0.327°	11.71 REF
4	0.437°	11.62 REF
5	0.546°	11.52 REF
6	0.655°	11.43 REF
7	0.764°	11.33 REF
8	0.837°	11.27 REF
9	0.982°	11.14 REF
10	1.091°	11.05 REF



ENGRAVE PART NUMBER
SEE NOTE 4

FOR DIMS C AND
D SEE TABLE



3D VIEW

NOTES: (UNLESS OTHERWISE SPECIFIED)

- REMOVE ALL SHARP EDGES, R.02 MIN.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)
- SCRIBE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: D020188- 001. A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN mm [INCHES]
TOLERANCES:
X.XX ±0.25 mm
ANGULAR ±0.25 °

MATERIAL: ST STEEL 304/316

FINISH: CLEAN AND DEGREASED
√μm [μin] Ra = 1.6 [63]

	NAME	DATE
DRAWN	I WILMUT	05/Oct/06
CHECKED	AJB	5MAY08
APPROVED	AJB	15/JULY/08

SYSTEM **ADVANCED LIGO**

SUB-SYSTEM **SUS**

NEXT ASSY **QUAD N-P-TYPE TOP STAGE**

PART NAME **BLADE CLAMP (BTM HALF)**

SIZE **B** DRG. NO. **D060327** REV **E.**

SCALE 1:1 PROJECTION: SHEET 2 OF 2