
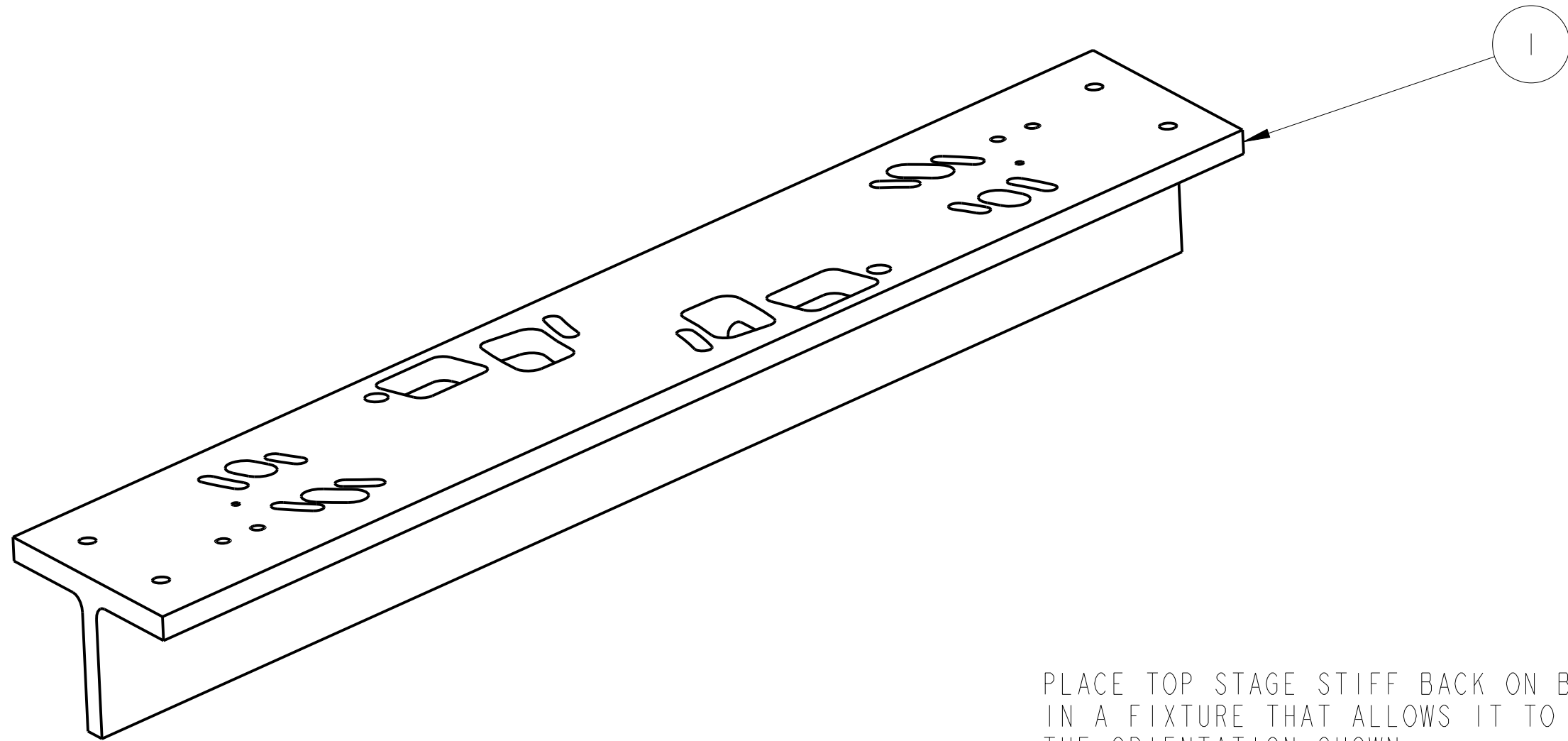


1	PLACE TOP STAGE STIFF BACK INTO JIG	D080081	1
2	ADD THREAD INSERTS INTO BLADE CLAMP BOTTOM	1-4_20X2D_UNC_THREAD_INSERT	6
		D080083	1
3	CLAMP TOGETHER BLADE ASSEMBLY	1-4_20_UNC_1-00INCH	4
		D080084	1
		D080513	1
4	ADD THREAD INSERTS INTO BLADE CLAMP BASE	1-4_20X2D_UNC_THREAD_INSERT	5
		D080085	1
5	ADD THREAD INSERTS INTO ADJUSTER ARM	1-4_20X1D_UNC_THREAD_INSERT	2
		D080086	1
6	ADD THREAD INSERT INTO ROTATIONAL BUSH	1-4_20X2D_UNC_THREAD_INSERT	1
		D080091	1
7	ASSY BLADE CLAMP BASE , ROTATIONAL BUSH AND ADJUSTER ARM	8-32_UNC_0-51NCH_SIL_PLT	2
		D080085	1
8	ASSEMBLE BLADE ASSEMBLY TO BLADE BASE ASSEMBLY	1-4_20_UNC_1-00INCH	2
		1-4_SPERICAL_WASHER	2
9	ADD BLADE ASSEMBLY TO STIFF BACK	1-4-20_WASHER	5
		1-4_20_UNC_0-75INCH	1
		1-4_20_UNC_1-00INCH	4
		1-4_20_UNC_2-00INCH_ROUND	1
		1-4_20_UNC_NUT_	1
10	ADD THREAD INSERT INTO ROTATIONAL ADJUSTER	1-4_20X2D_UNC_THREAD_INSERT	1
		D060325	1
11	ADD ROTATIONAL ADJUSTER BLOCK TO ASSEMBLY	1-4-20_WASHER	1
		1-4_20_UNC_1-25INCH	2
		1-4_20_UNC_1-51NCH	1
		1-4_20_UNC_2-00INCH_ROUND	1
12	ADD BLADE TIP STOP MOUNT TO ASSEMBLY	1-4-20_WASHER	5
		1-4_20_UNC_1-00INCH	10
		1-4_20_UNC_1-25INCH	2


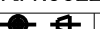
		1-4_20_UNC_1-51NCH	3
		1-4_20_UNC_2-00INCH_ROUND	4
		1-4_20_UNC_NUT_	3
		1-4_SPERICAL_WASHER	2
		D060325	1
		D080083	1
		D080084	1
		D080086	1
		D080090	1
		D080091	1
		D080513	1
13	STRAIGHTEN FIRST BLADE	8-32_UNC_NUT	2
		D080089	1
		D080090	1
		D080513_FLAT	1

NOTES: (UNLESS OTHERWISE SPECIFIED)		 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES	
1.		PROCESS PLAN TO BE USED FOR ASSEMBLY ONLY	
		NOT TO BE USED FOR MANUFACTURE	
		SYSTEM	ADVANCED LIGO
		SUB-SYSTEM	SUS
		NEXT ASSY	BS/FM SUSPENSION
		PART NAME	BS TOP STAGE
DRAWN	J O'DELL	DATE	02/12/09
CHECKED	J'OD	---	---
APPROVED	JOD	---	---
SIZE	B	DRG. NO.	D080080_ASSY_PROCEEDURE
SCALE	1:1	PROJECTION:	1ST ANGLE
		SHEET	1 OF 1

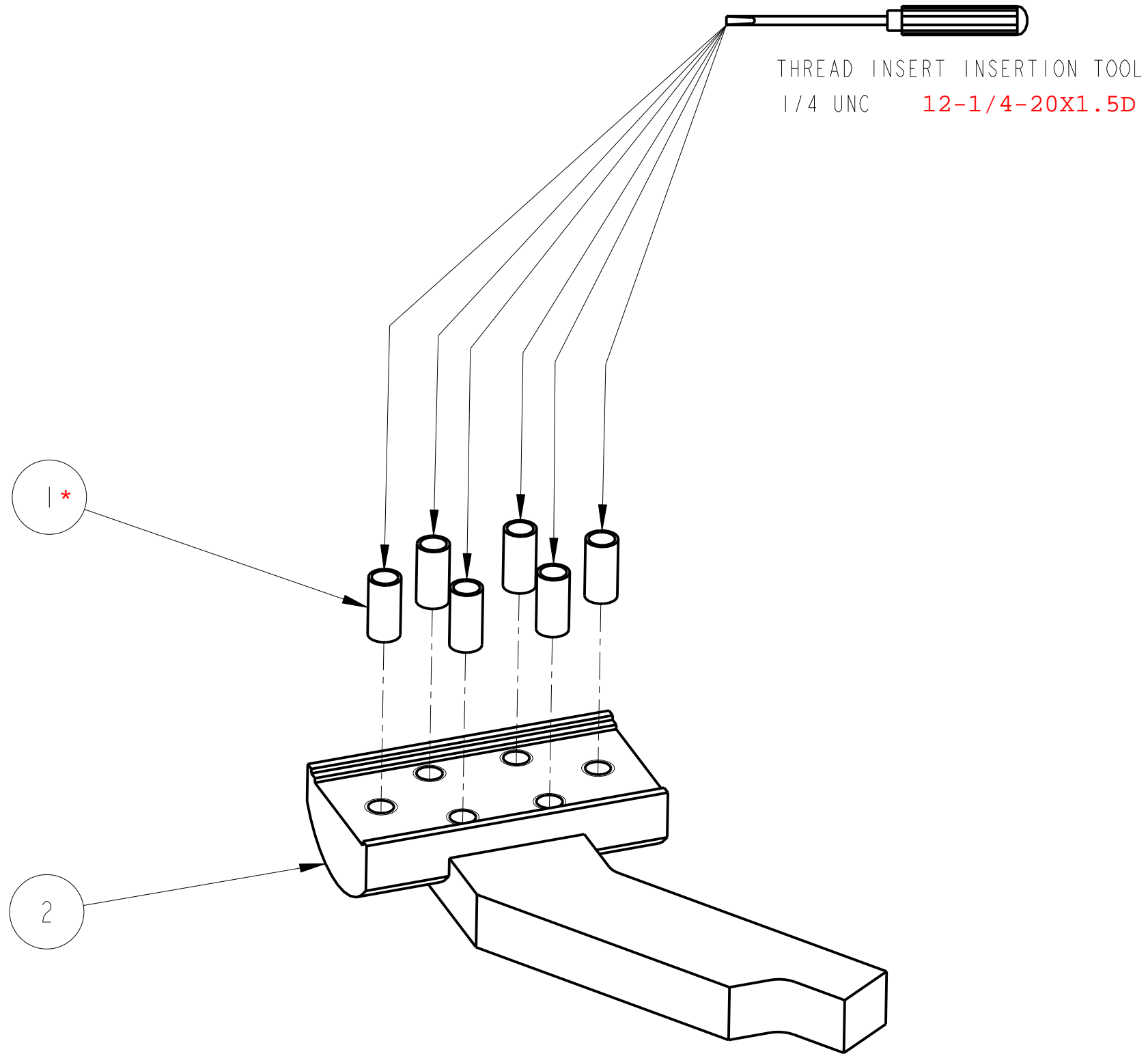
REV.	DATE	DCN #	DRAWING TREE #



PLACE TOP STAGE STIFF BACK ON BENCH  
IN A FIXTURE THAT ALLOWS IT TO STAND IN  
THE ORIENTATION SHOWN

1	D080081	TOP STAGE STIFF BACK	1
No.	PART NUMBER	PART DESCRIPTION	NO. REOD
NOTES: (UNLESS OTHERWISE SPECIFIED)		 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY 1GR, GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES	
1.		PROCESS PLAN TO BE USED FOR ASSEMBLY ONLY NOT TO BE USED FOR MANUFACTURE	
		SYSTEM <b>ADVANCED LIGO</b>	
		SUB-SYSTEM <b>SUS</b>	
		NEXT ASSY <b>BS/FM SUSPENSION</b>	
		PART NAME <b>BS TOP STAGE</b>	
	NAME	DATE	
DRAWN	J O'DELL	02/12/09	
CHECKED	J'OD	--/--/--	
APPROVED	JOD	--/--/--	
SCALE 1:2		PROJECTION: 	SHEET 2 OF 1
SIZE <b>B</b>		DRG. NO. <b>D080080_ASSY_PROCEEDURE</b>	REV <b>C.</b>

REV.	DATE	DCN #	DRAWING TREE #

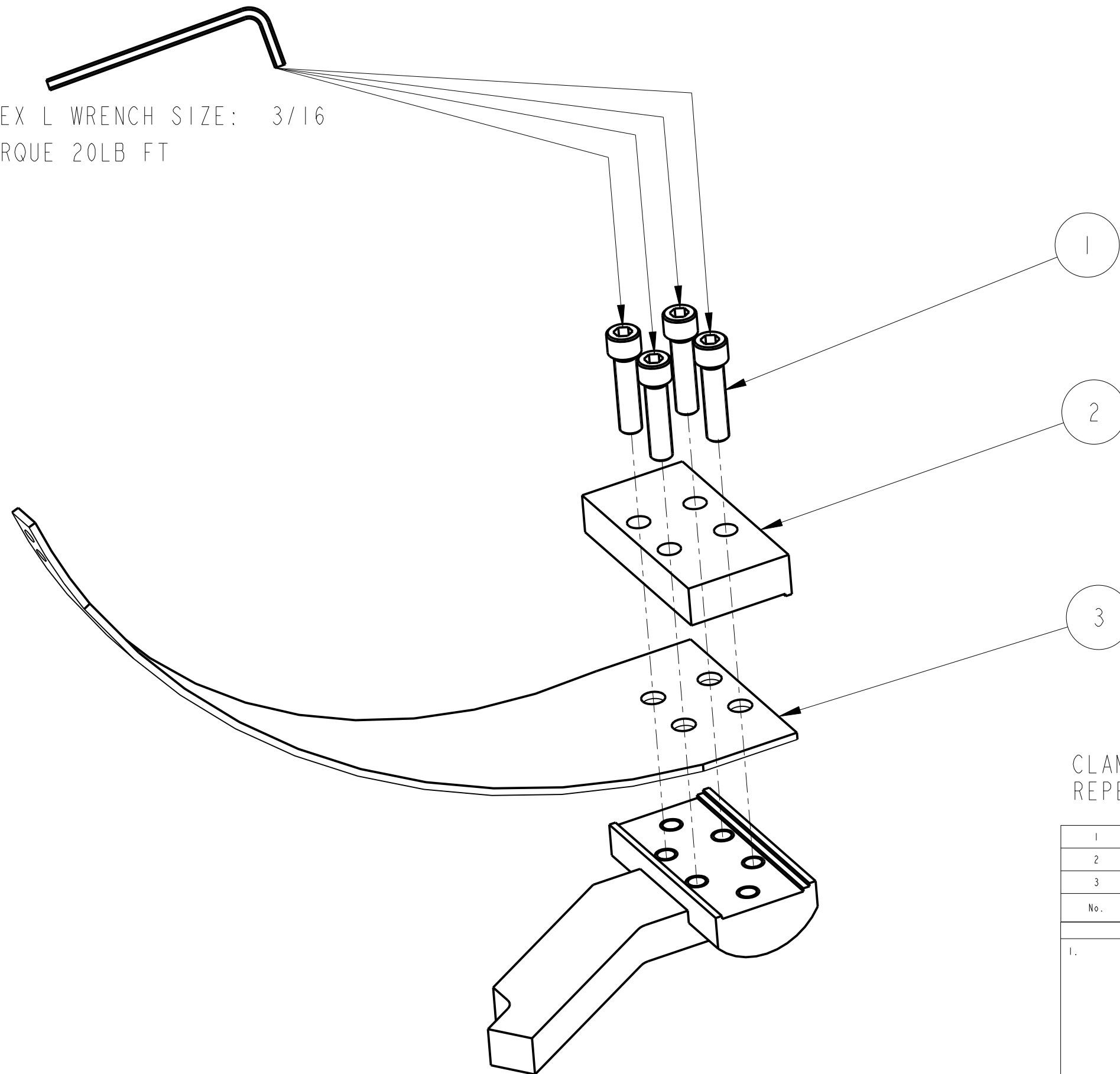


\*Run Helicoil almost to bottom of clamp.  
Bolt comes in from bottom.

ADD THREAD INSERTS INTO BLADE CLAMP BOTTOM  
REPEAT THIS STEP FOR SECOND BLADE BOTTOM

1	1-4_20X2D_UNC_THREAD_INSERT	1/4-20 x 2D UNC THREAD INSERT	6
2	D080083	BLADE CLAMP BOTTOM	1
No.	PART NUMBER	PART DESCRIPTION	NO. REOD
NOTES: (UNLESS OTHERWISE SPECIFIED)			
1.		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES	
		PROCESS PLAN TO BE USED FOR ASSEMBLY ONLY NOT TO BE USED FOR MANUFACTURE	
		SYSTEM <b>ADVANCED LIGO</b> SUB-SYSTEM <b>SUS</b> NEXT ASSY <b>BS/FM SUSPENSION</b> PART NAME <b>BS TOP STAGE</b>	
	NAME	DATE	
DRAWN	J O'DELL	02/12/09	
CHECKED	J'OD	--/--/--	
APPROVED	JOD	--/--/--	
SIZE	DRG. NO.		REV
<b>B</b>	<b>D080080_ASSY_PROCEEDURE</b>		<b>C.</b>
SCALE 1:1		PROJECTION:	SHEET 3 OF 1

HEX L WRENCH SIZE: 3/16  
TORQUE 20LB FT



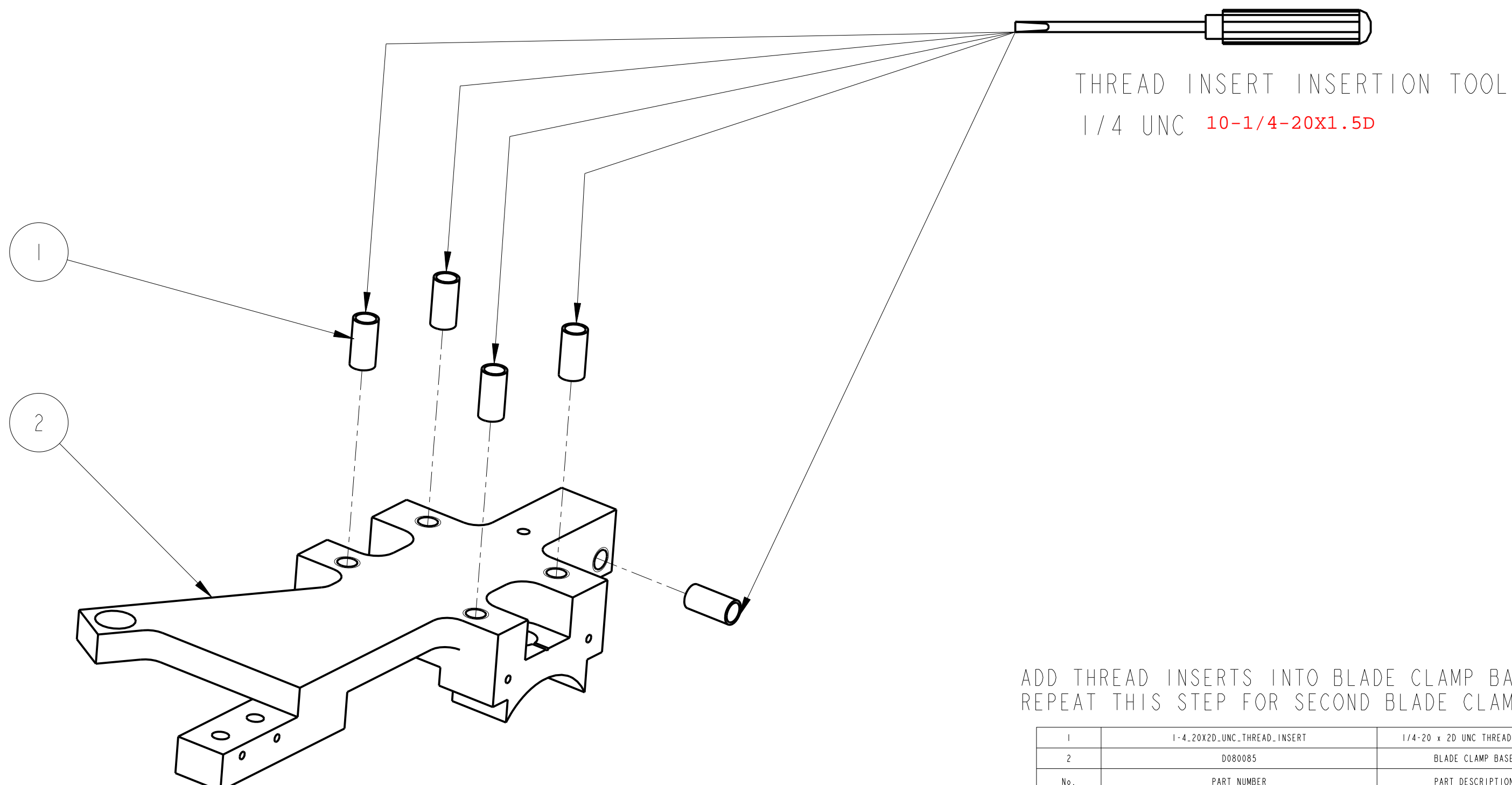
CLAMP TOGETHER BLADE ASSEMBLY  
REPEAT THIS STEP FOR SECOND BLADE ASSEMBLY

1	1-4.20 UNC. 1-00 INCH	1/4" 20 UNC X 1" CAP HEAD	4
2	D080084	BLADE CLAMP TOP	1
3	D080513	TOP STAGE BLADE SPRING	1
No.	PART NUMBER	PART DESCRIPTION	NO. REOD

NOTES: (UNLESS OTHERWISE SPECIFIED)

1.

PROCESS PLAN TO BE USED FOR ASSEMBLY ONLY NOT TO BE USED FOR MANUFACTURE		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES
		SYSTEM <b>ADVANCED LIGO</b>
		SUB-SYSTEM <b>SUS</b>
		NEXT ASSY <b>BS/FM SUSPENSION</b>
		PART NAME <b>BS TOP STAGE</b>
NAME	DATE	SIZE <b>B</b> DRG. NO. <b>D080080_ASSY_PROCEEDURE</b> REV. <b>C.</b> SCALE 4:5 PROJECTION:  SHEET 4 OF 1
DRAWN J O'DELL	02/12/09	
CHECKED J'OD	--/--/--	
APPROVED JOD	--/--/--	



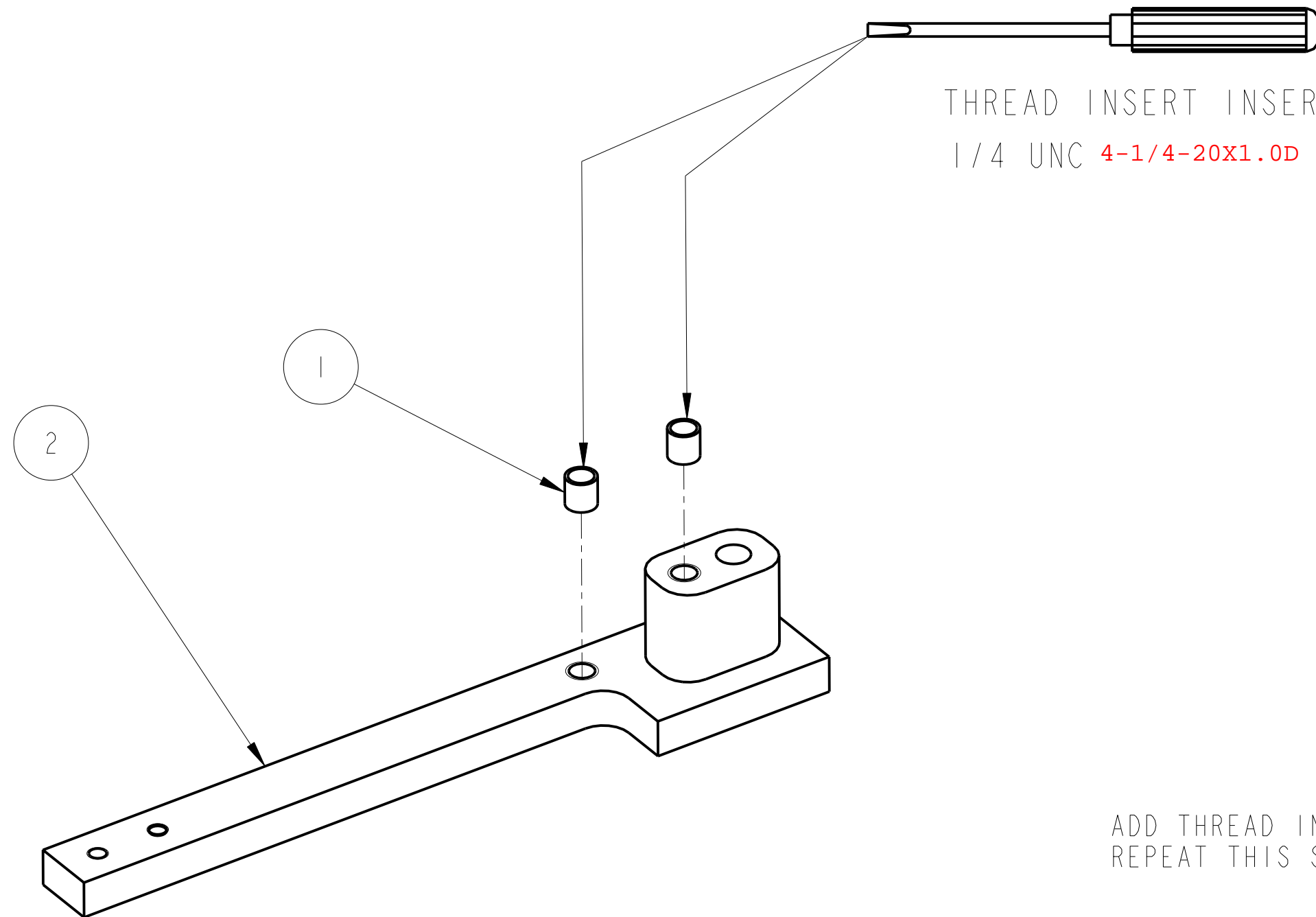
ADD THREAD INSERTS INTO BLADE CLAMP BASE  
REPEAT THIS STEP FOR SECOND BLADE CLAMP BASE

1	1-4_20X2D_UNC_THREAD_INSERT	1/4-20 x 2D UNC THREAD INSERT	5
2	D080085	BLADE CLAMP BASE	1
No.	PART NUMBER	PART DESCRIPTION	NO. REOD
NOTES: (UNLESS OTHERWISE SPECIFIED)			
1.		<p>PROCESS PLAN TO BE USED FOR ASSEMBLY ONLY NOT TO BE USED FOR MANUFACTURE</p> <p>CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY 1GR, GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES</p> <p>SYSTEM <b>ADVANCED LIGO</b> SUB-SYSTEM <b>SUS</b> NEXT ASSY <b>BS/FM SUSPENSION</b> PART NAME <b>BS TOP STAGE</b></p>	
	NAME	DATE	
DRAWN	J O'DELL	02/12/09	
CHECKED	J'OD	--/--/--	
APPROVED	JOD	--/--/--	
SCALE 1:1		PROJECTION:	SHEET 5 OF 1

CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY  
 1GR, GLASGOW UNIVERSITY GEO 600 GROUP  
 RUTHERFORD APPLETON LABORATORIES


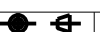
SYSTEM **ADVANCED LIGO**  
 SUB-SYSTEM **SUS**  
 NEXT ASSY **BS/FM SUSPENSION**  
 PART NAME **BS TOP STAGE**

SIZE **B** DRG. NO. **D080080\_ASSY\_PROCEEDURE** REV. **C.**

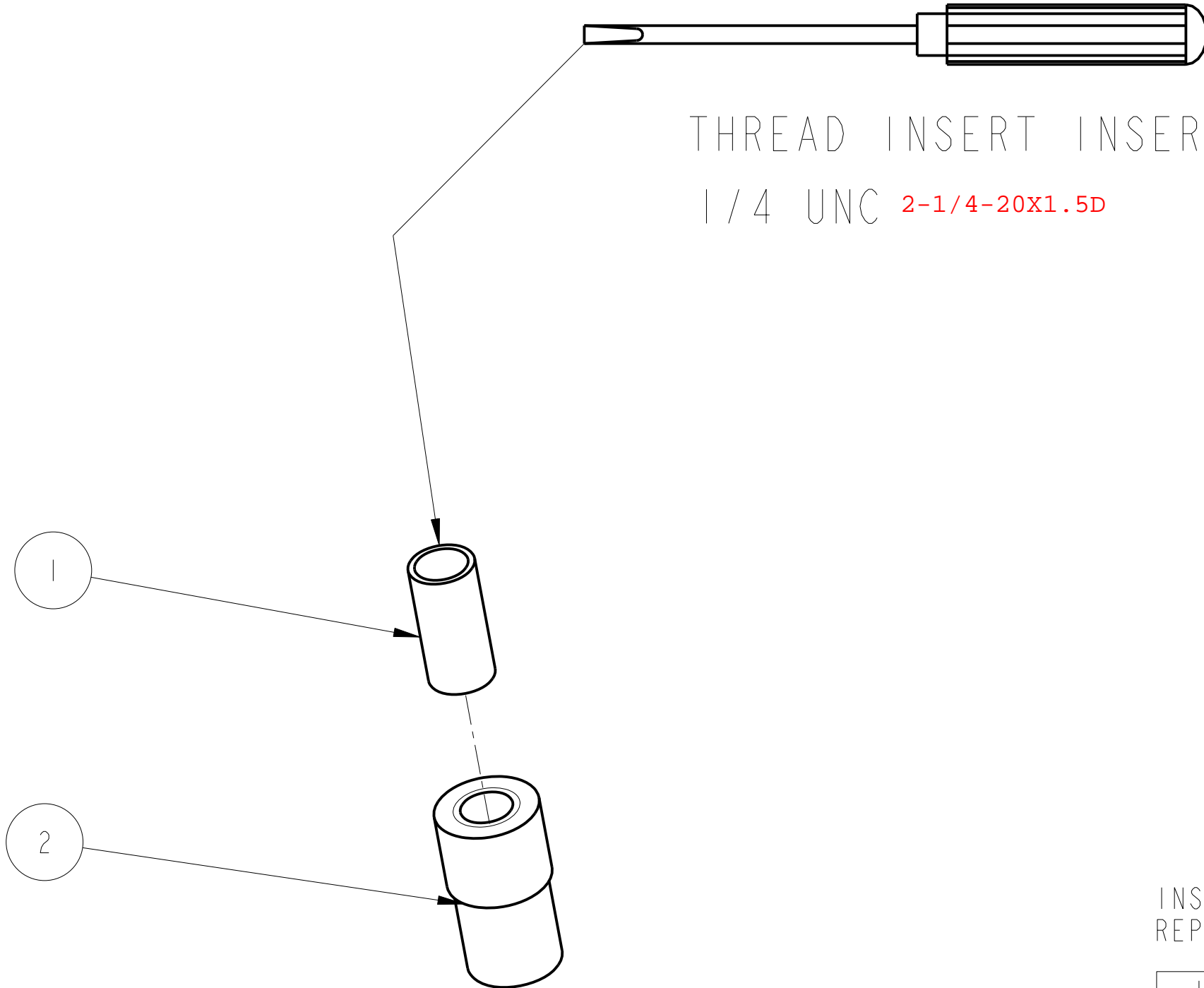


THREAD INSERT INSERTION TOOL  
 1/4 UNC 4-1/4-20X1.0D

ADD THREAD INSERTS INTO ADJUSTER ARM  
 REPEAT THIS STEP FOR SECOND ADJUSTER ARM


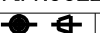
1	1-4_20X1D_UNC_THREAD_INSERT	1/4-20 x 1D UNC THREAD INSERT	2
2	D080086	ADJUSTER ARM	1
No.	PART NUMBER	PART DESCRIPTION	NO. REOD
NOTES: (UNLESS OTHERWISE SPECIFIED)		 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES	
1.		PROCESS PLAN TO BE USED FOR ASSEMBLY ONLY NOT TO BE USED FOR MANUFACTURE	
		SYSTEM <b>ADVANCED LIGO</b>	
		SUB-SYSTEM <b>SUS</b>	
		NEXT ASSY <b>BS/FM SUSPENSION</b>	
		PART NAME <b>BS TOP STAGE</b>	
	NAME	DATE	
DRAWN	J O'DELL	02/12/09	
CHECKED	J'OD	--/--/--	
APPROVED	JOD	--/--/--	
SIZE	DRG. NO. <b>D080080_ASSY_PROCEEDURE</b>		REV. <b>C.</b>
SCALE 1:1		PROJECTION: 	SHEET 6 OF 1

REV.	DATE	DCN #	DRAWING TREE #



THREAD INSERT INSERTION TOOL  
 1/4 UNC 2-1/4-20X1.5D

INSERT THREAD INSERT INTO ROTATIONAL BUSH  
 REPEAT THIS STEP FOR SECOND ROTATIONAL BUSH

1	1-4_20X2D_UNC_THREAD_INSERT	1/4-20 x 2D UNC THREAD INSERT	1
2	D080091	ROTATIONAL BUSH	1
No.	PART NUMBER	PART DESCRIPTION	NO. REOD
NOTES: (UNLESS OTHERWISE SPECIFIED)			
1.	PROCESS PLAN TO BE USED FOR ASSEMBLY ONLY NOT TO BE USED FOR MANUFACTURE	 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES	
		SYSTEM	ADVANCED LIGO
		SUB-SYSTEM	SUS
		NEXT ASSY	BS/FM SUSPENSION
		PART NAME	BS TOP STAGE
	NAME	DATE	
	DRAWN J O'DELL	02/12/09	
	CHECKED J'OD	--/--/--	
	APPROVED JOD	--/--/--	
	SCALE 2:1	PROJECTION: 	SHEET 7 OF 1

SIZE B DRG. NO. D080080\_ASSY\_PROCEEDURE REV. C.

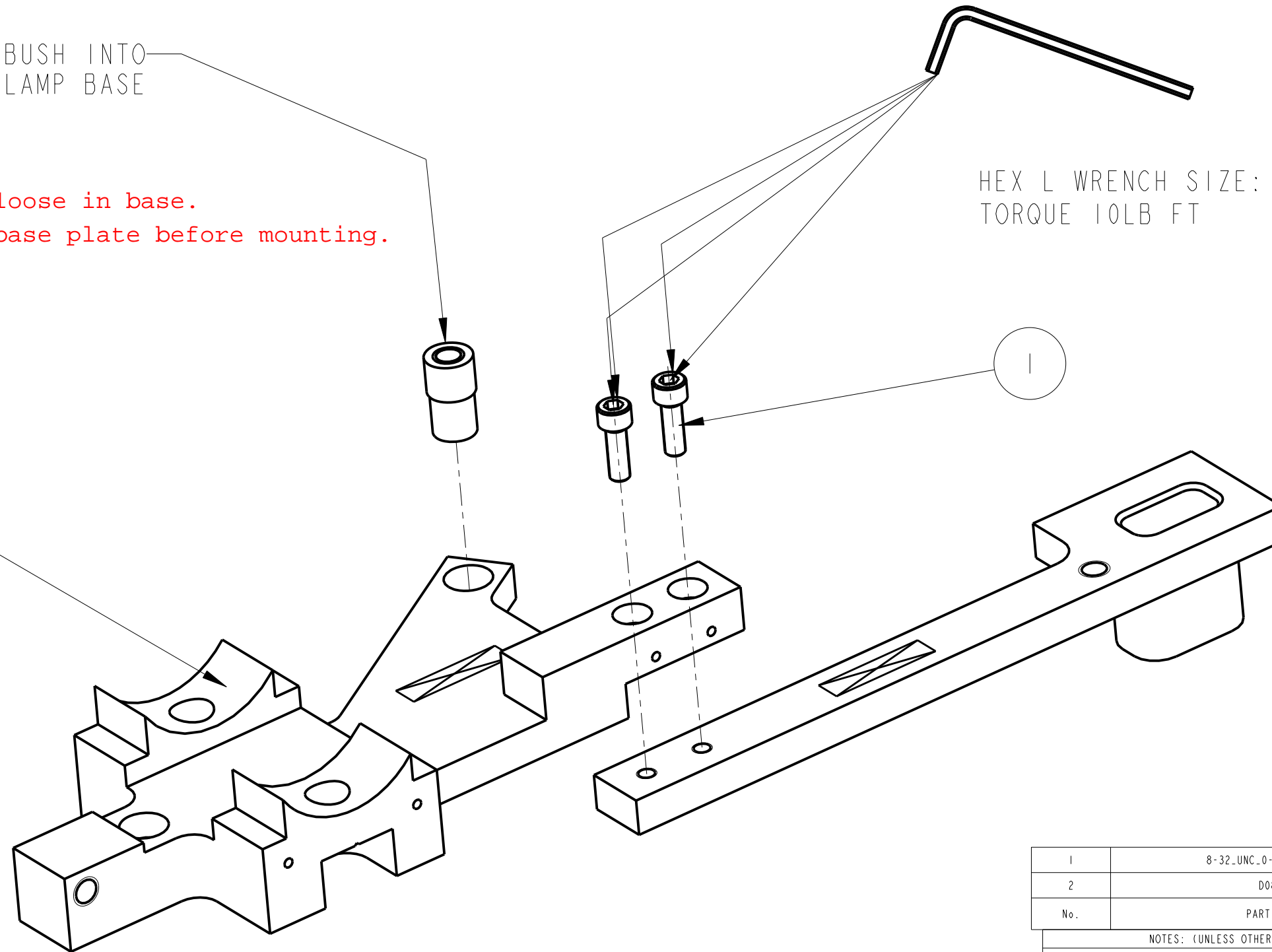
PRESS BUSH INTO  
BLADE CLAMP BASE

Bushing fits loose in base.  
Install into base plate before mounting.

HEX L WRENCH SIZE: 3/16  
TORQUE 10LB FT

2

1



ASSEMBLE TOGETHER BLADE CLAMP BASE, ROTATIONAL BUSH AND ADJUSTER ARM  
REPEAT THIS STEP FOR SECOND BLOCK CLAMP BASE, BUSH AND ADJUSTER ARM

1	8-32 UNC X 0.5 INCH SIL PLT	8-32 UNC X 0.5" CAP HEAD - SILVER PLATED	2
2	D080085	BLADE CLAMP BASE	1
No.	PART NUMBER	PART DESCRIPTION	NO. REOD

NOTES: (UNLESS OTHERWISE SPECIFIED)

1.		PROCESS PLAN TO BE USED FOR ASSEMBLY ONLY NOT TO BE USED FOR MANUFACTURE	
DRAWN	J O'DELL	DATE	02/12/09
CHECKED	J'OD		--/--/--
APPROVED	JOD		--/--/--

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY  
1GR, GLASGOW UNIVERSITY GEO 600 GROUP  
RUTHERFORD APPLETON LABORATORIES

SYSTEM **ADVANCED LIGO**

SUB-SYSTEM **SUS**

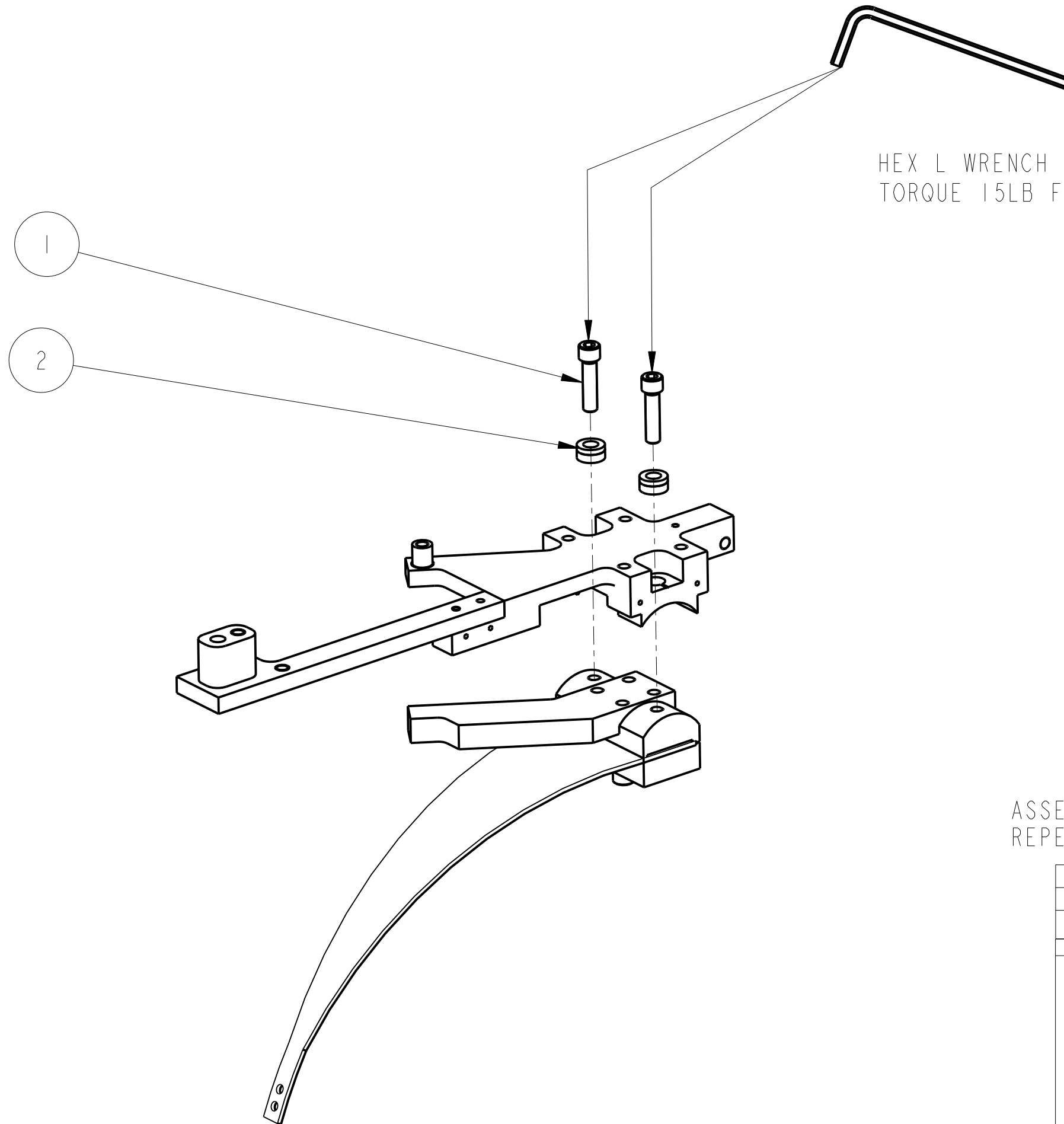
NEXT ASSY **BS/FM SUSPENSION**

PART NAME **BS TOP STAGE**

SCALE 1:1 PROJECTION: SHEET 8 OF 1

SIZE **B** DRG. NO. **D080080\_ASSY\_PROCEEDURE** REV. **C.**





HEX L WRENCH SIZE: 3/16  
TORQUE 15LB FT

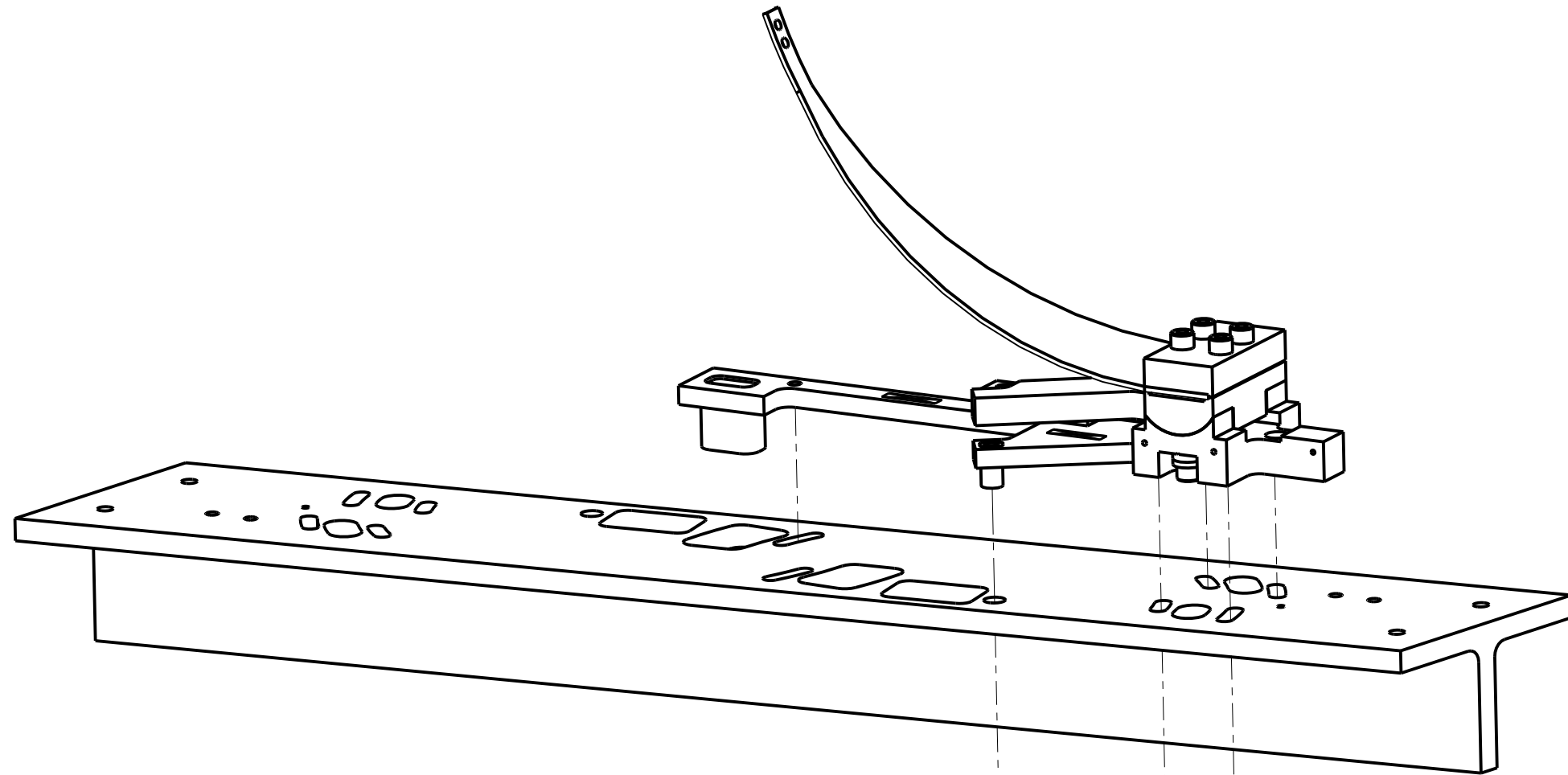
ASSEMBLE BLADE ASSEMBLY TO BLADE BASE ASSEMBLY  
REPEAT THIS STEP FOR SECOND BLADE ASSEMBLY

No.	PART NUMBER	PART DESCRIPTION	NO. REQD
1	1-4_20 UNC_1-001NCH	1/4" 20 UNC X 1" CAP HEAD	2
2	1-4_SPERICAL_WASHER	1/4 SPHERICAL WASHER	2

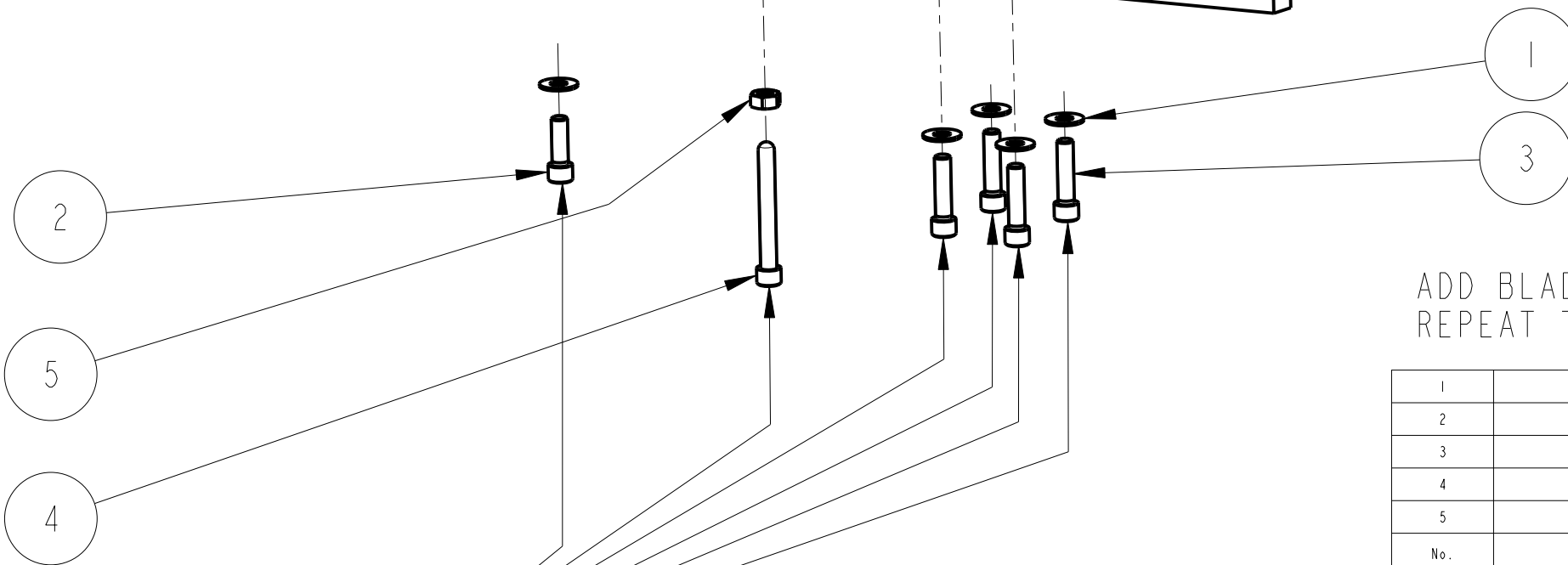
NOTES: (UNLESS OTHERWISE SPECIFIED)

1.

PROCESS PLAN TO BE USED FOR ASSEMBLY ONLY NOT TO BE USED FOR MANUFACTURE		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES
		SYSTEM <b>ADVANCED LIGO</b>
		SUB-SYSTEM <b>SUS</b>
		NEXT ASSY <b>BS/FM SUSPENSION</b>
		PART NAME <b>BS TOP STAGE</b>
NAME	DATE	SIZE <b>B</b> DRG. NO. <b>D080080_ASSY_PROCEEDURE</b> REV. <b>C.</b> SCALE 1:2 PROJECTION:  SHEET 9 OF 1
DRAWN J O'DELL	02/12/09	
CHECKED J'OD	--/--/--	
APPROVED JOD	--/--/--	



Roll onto side to install bottom bolts.



ADD BLADE ASSEMBLY TO STIFF BACK  
REPEAT THIS STEP FOR SECOND BLADE ASSEMBLY

No.	PART NUMBER	PART DESCRIPTION	NO. REQD
1	1-4-20_WASHER	1/4" 20 UNC WASHER	5
2	1-4-20_UNC_0-75INCH	1/4" 20 UNC X 0.75" CAP HEAD	1
3	1-4-20_UNC_1-00INCH	1/4" 20 UNC X 1" CAP HEAD	4
4	1-4-20_UNC_2-00INCH_ROUND	1/4" 20 UNC X 2" CAP HEAD, SPHERICAL TIP	1
5	1-4-20_UNC_NUT	1/4" 20 UNC NUT	1

HEX L WRENCH SIZE: 3/16  
TORQUE 10LB FT

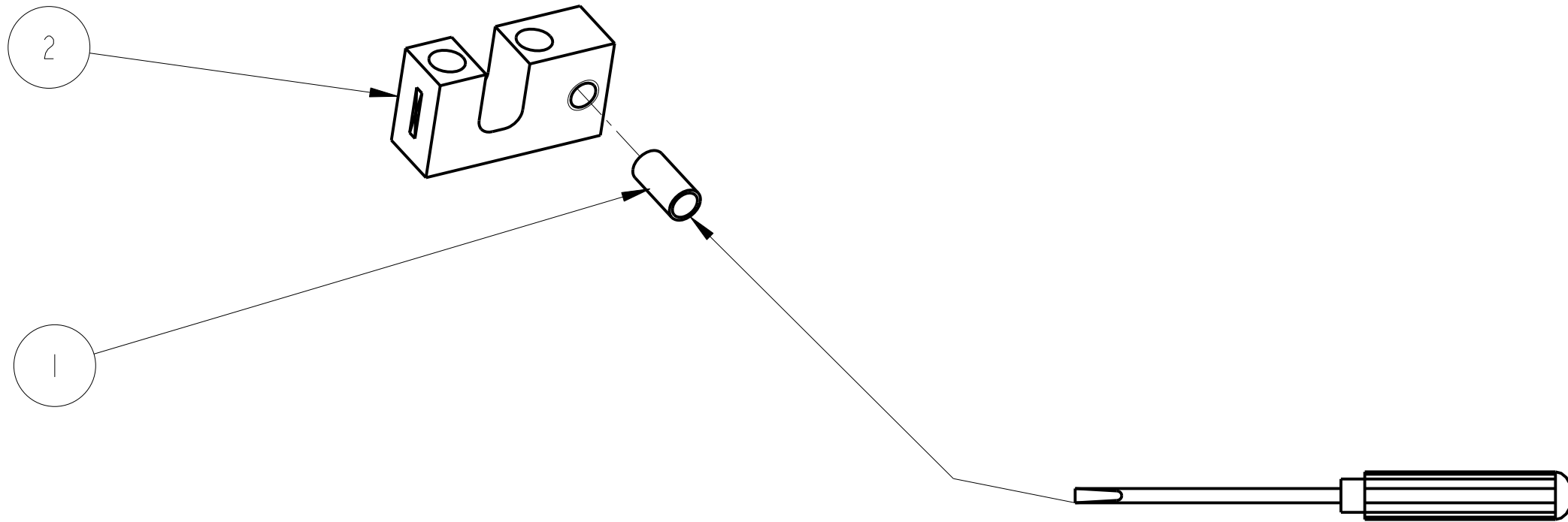
NOTES: (UNLESS OTHERWISE SPECIFIED)

1.

PROCESS PLAN TO BE USED FOR ASSEMBLY ONLY NOT TO BE USED FOR MANUFACTURE		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES
DRAWN	J O'DELL	02/12/09
CHECKED	J'OD	--/--/--
APPROVED	JOD	--/--/--

SIZE <b>B</b>	DRG. NO. <b>D080080_ASSY_PROCEEDURE</b>	REV <b>C.</b>
SCALE 2:5	PROJECTION:	SHEET 10 OF 14

REV.	DATE	DCN #	DRAWING TREE #



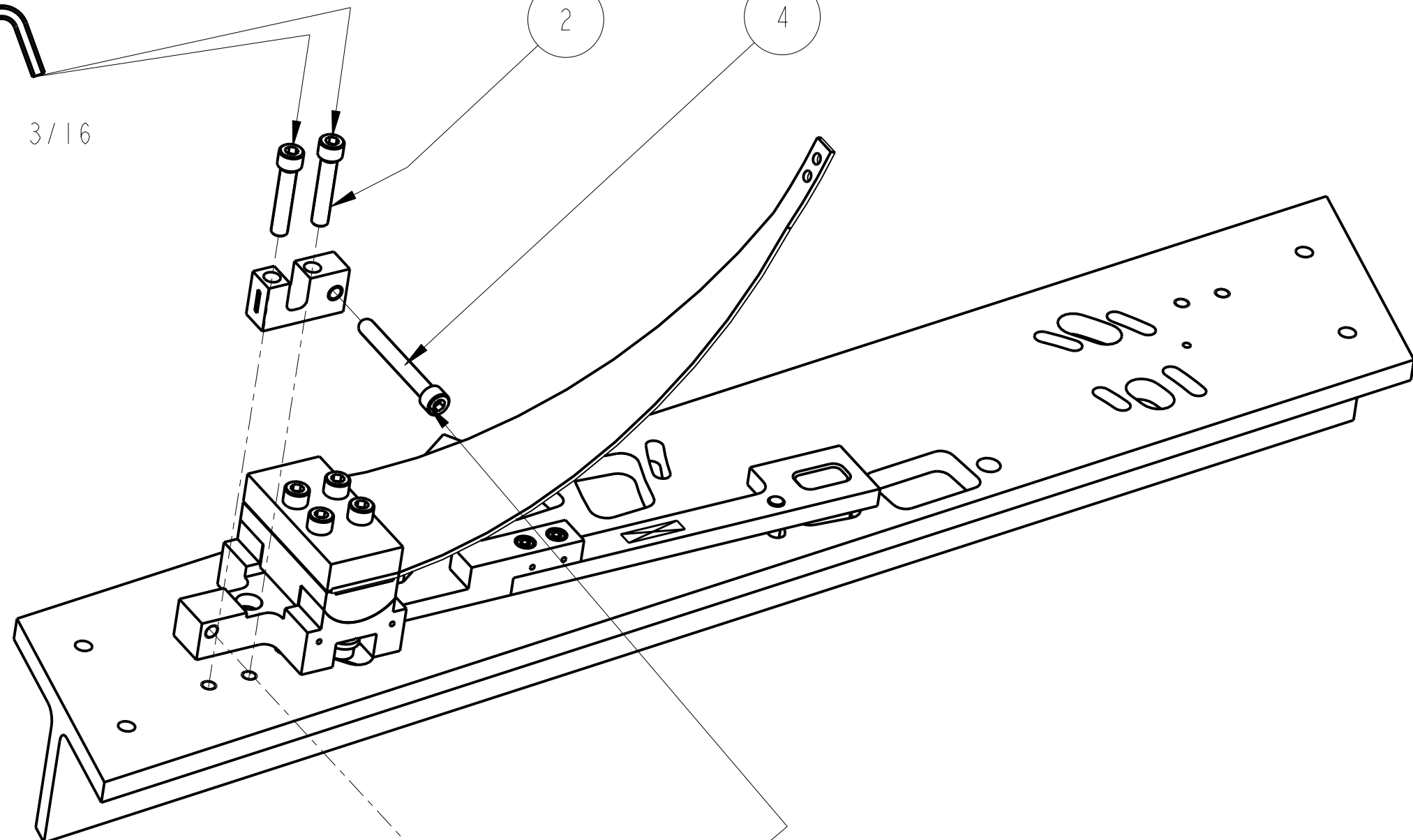
THREAD INSERT INSERTION TOOL  
 1/4 UNC 2-1/4-20X1.5D

ADD THREAD INSERT INTO ROTATIONAL ADJUSTER  
 REPEAT THIS STEP FOR SECOND ROTATIONAL ADJUSTER

1	1-4_20X2D_UNC_THREAD_INSERT	1/4-20 x 2D UNC THREAD INSERT	1
2	D060325	ROTATIONAL ADJUSTER	1
No.	PART NUMBER	PART DESCRIPTION	NO. REOD
NOTES: (UNLESS OTHERWISE SPECIFIED)			
1.	PROCESS PLAN TO BE USED FOR ASSEMBLY ONLY NOT TO BE USED FOR MANUFACTURE		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES
	SYSTEM <b>ADVANCED LIGO</b>		
	SUB-SYSTEM <b>SUS</b>		
	NEXT ASSY <b>BS/FM SUSPENSION</b>		
	PART NAME <b>BS TOP STAGE</b>		
	NAME	DATE	
DRAWN	J O'DELL	02/12/09	
CHECKED	J'OD	--/--/--	
APPROVED	JOD	--/--/--	
SIZE	DRG. NO. <b>D080080_ASSY_PROCEEDURE</b>		REV. <b>C.</b>
SCALE 1:1		PROJECTION:	SHEET 11 OF 4

\*1/4-20X1" SP SHCS

HEX L WRENCH SIZE: 3/16  
TORQUE 10LB FT



ADD ROTATIONAL ADJUSTER BLOCK TO ASSEMBLY  
REPEAT THIS STEP FOR SECOND ROTATIONAL ADJUSTER BLOCK

HEX L WRENCH SIZE: 3/16  
TORQUE 8LB FT

No.	PART NUMBER	PART DESCRIPTION	NO. REOD
1	1-4-20_WASHER	1/4" 20 UNC WASHER	1
2	1-4-20 UNC 1-25INCH	1/4" 20 UNC X 1.25" CAP HEAD	2
3	1-4-20 UNC 1-5INCH	1/4-20 UNC X 1.5" CAP HEAD	1
4	1-4-20 UNC 2-00INCH_ROUND	1/4" 20 UNC X 2" CAP HEAD, SPHERICAL TIP	1

NOTES: (UNLESS OTHERWISE SPECIFIED)

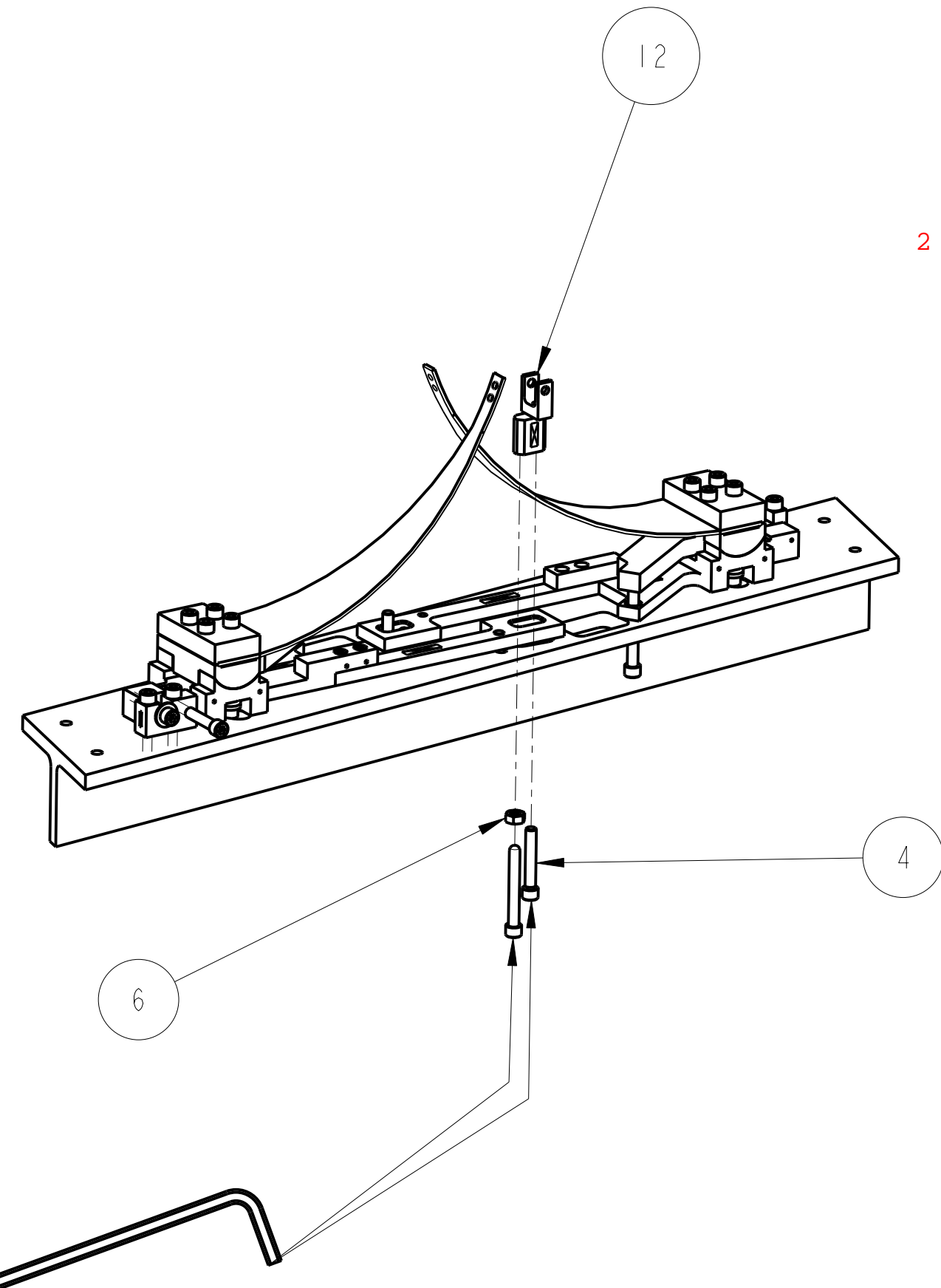
1. PROCESS PLAN TO BE USED FOR ASSEMBLY ONLY  
NOT TO BE USED FOR MANUFACTURE

NAME	DATE
DRAWN J O'DELL	02/12/09
CHECKED J'OD	--/--/--
APPROVED JOD	--/--/--

CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY  
1GR, GLASGOW UNIVERSITY GEO 600 GROUP  
RUTHERFORD APPLETON LABORATORIES

SYSTEM **ADVANCED LIGO**  
SUB-SYSTEM **SUS**  
NEXT ASSY **BS/FM SUSPENSION**  
PART NAME **BS TOP STAGE**

SCALE 1:2 PROJECTION: SHEET 12 OF 14



2 1/4-20X1/5D

ADD BLADE TIP STOP MOUNT TO ASSEMBLY  
REPEAT THIS STEP FOR SECOND BLADE TIP STOP MOUNT

HEX L WRENCH SIZE: 3/16  
TORQUE 6LB FT

1	1-4-20_WASHER	1/4" 20 UNC WASHER	5
2	1-4-20 UNC_1-00INCH	1/4" 20 UNC X 1" CAP HEAD	10
3	1-4-20 UNC_1-25INCH	1/4" 20 UNC X 1.25" CAP HEAD	2
4	1-4-20 UNC_1-5INCH	1/4-20 UNC X 1.5" CAP HEAD	3
5	1-4-20 UNC_2-00INCH_ROUND	1/4" 20 UNC X 2" CAP HEAD, SPHERICAL TIP	4
6	1-4-20 UNC_NUT	1/4" 20 UNC NUT	3
7	1-4 SPERICAL WASHER	1/4 SPHERICAL WASHER	2
8	D060325	ROTATIONAL ADJUSTER	1
9	D080083	BLADE CLAMP BOTTOM	1
10	D080084	BLADE CLAMP TOP	1
11	D080086	ADJUSTER ARM	1
12	D080090	BLADE TIP STOP MOUNT	1
13	D080091	ROTATIONAL BUSH	1
14	D080513	TOP STAGE BLADE SPRING	1
No.	PART NUMBER	PART DESCRIPTION	NO. REOD

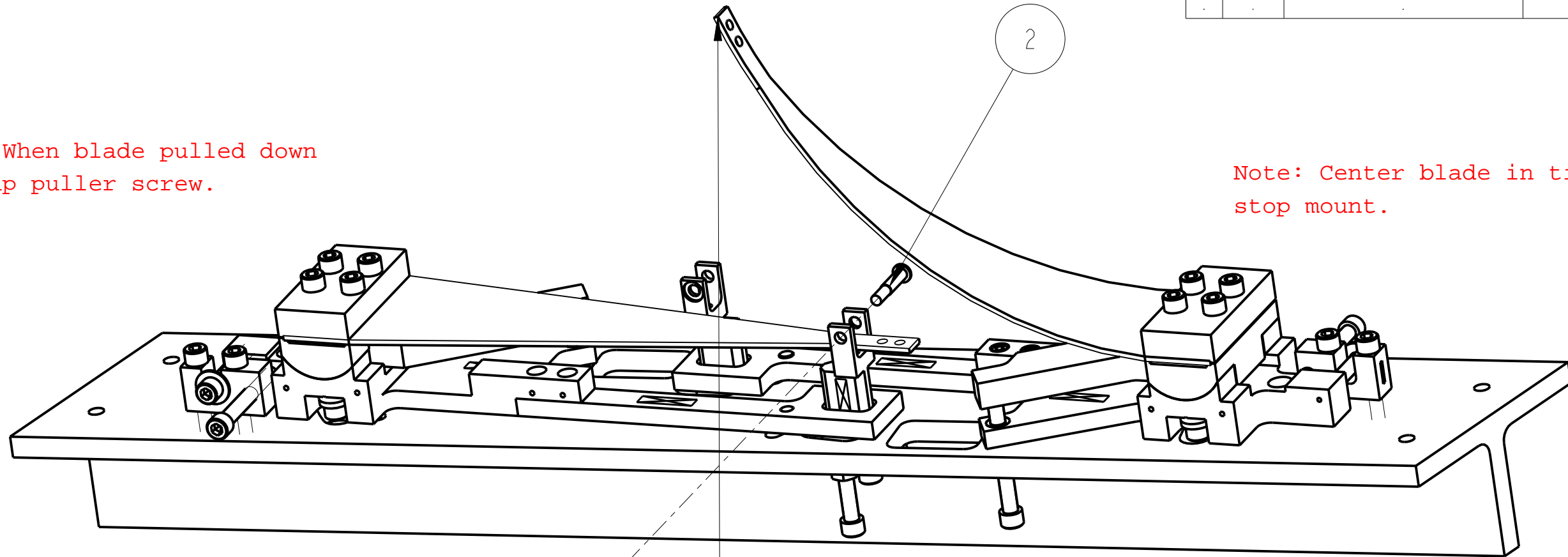
NOTES: (UNLESS OTHERWISE SPECIFIED)

1.

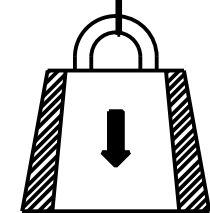
PROCESS PLAN TO BE USED FOR ASSEMBLY ONLY NOT TO BE USED FOR MANUFACTURE		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES
SYSTEM <b>ADVANCED LIGO</b>		
SUB-SYSTEM <b>SUS</b>		
NEXT ASSY <b>BS/FM SUSPENSION</b>		
PART NAME <b>BS TOP STAGE</b>		SIZE <b>B</b> DRG. NO. <b>D080080_ASSY_PROCEEDURE</b> REV. <b>C</b>
DRAWN J O'DELL 02/12/09 CHECKED J'OD APPROVED JOD	SCALE 3:10 PROJECTION:	SHEET 13 OF 14

Note: When blade pulled down take up puller screw.

Note: Center blade in tip stop mount.



STRAIGHTEN FIRST BLADE  
 PULL THE FIRST BLADE FLAT BY HANGING MASS FROM THE TIP  
 ENSURE THAT THE ASSEMBLY IS SECURELY CLAMPED TO A ROBUST TABLE DURING THIS PROCEEDURE  
 INSERT BLADE STOP PIN AND ATTACH LOCKING NUTS  
 REPEAT THIS STEP FOR SECOND BLADE



1	8-32 UNC NUT	8-32 UNC X NUT	2
2	D080089	BLADE STOP PIN	1
3	D080090	BLADE TIP STOP MOUNT	1
4	D080513_FLAT	TOP STAGE BLADE SPRING	1
No.	PART NUMBER	PART DESCRIPTION	NO. REOD

NOTES: (UNLESS OTHERWISE SPECIFIED)

1. PROCESS PLAN TO BE USED FOR ASSEMBLY ONLY NOT TO BE USED FOR MANUFACTURE

NAME	DATE
DRAWN J O'DELL	02/12/09
CHECKED J'OD	--/--/--
APPROVED JOD	--/--/--

CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY  
 IGR, GLASGOW UNIVERSITY GEO 600 GROUP  
 RUTHERFORD APPLETON LABORATORIES

SYSTEM **ADVANCED LIGO**  
 SUB-SYSTEM **SUS**  
 NEXT ASSY **BS/FM SUSPENSION**  
 PART NAME **BS TOP STAGE**

SCALE 1:2 PROJECTION: SHEET 14 OF 14