

D0902118 Special Screw for BSC-ISI Stage 0-1 Safety Mechanism, PART PDM REV: X-010, DRAWING PDM REV: X-007

REV.	DATE	DCN #	DRAWING TREE #
v1	26 Feb. 2010	E1000022	E1000025
v2	22 June 2010	E1000226	E1000025

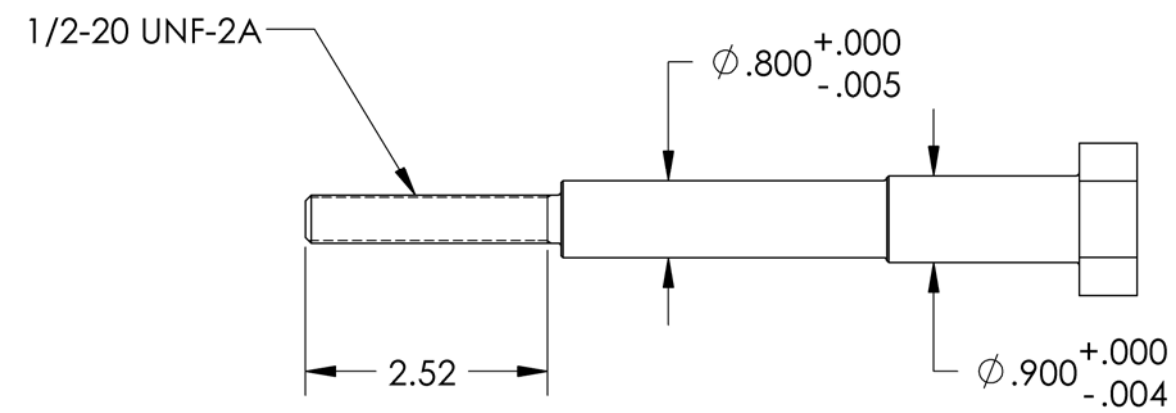
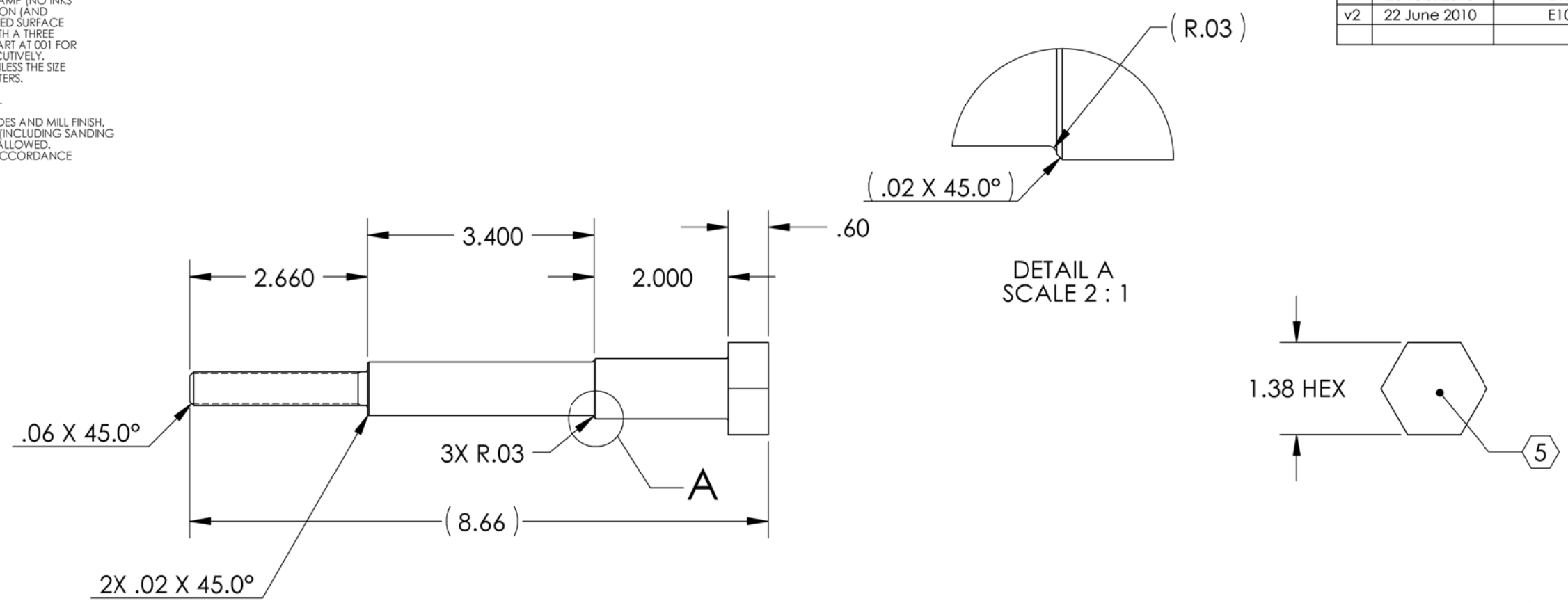
NOTES CONTINUED:

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 = 1.31 LB.

7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES (INCLUDING SANDING OR SCOURING FOR MATTE FINISH) IS NOT ALLOWED.

8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME			
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± 0.5°				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.		Special Screw for BSC-ISI Stage 0-1 Safety Mechanism			
						SYSTEM ADVANCED LIGO SUB-SYSTEM SEI		DESIGNER F.MATCHARD 01 Feb. 2010	SIZE B
MATERIAL 410 SST HARDEN TO BRINELL 390		FINISH 32 μinch		NEXT ASSY D0901872		CHECKER A.STEIN 01 Feb. 2010	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1
				APPROVAL K.MASON 01 Feb. 2010					