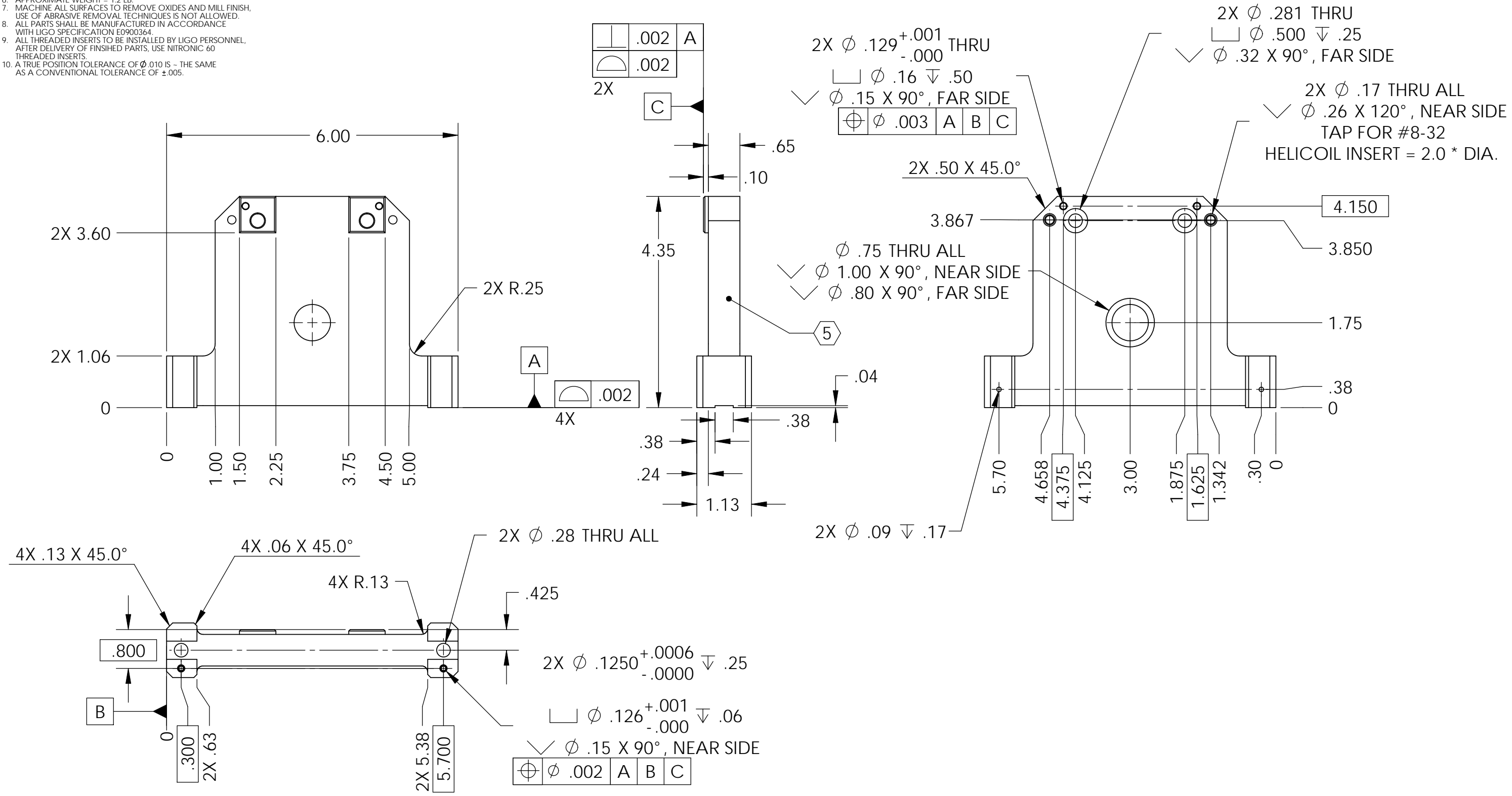


D0902136 Small Horizontal Actuator, Tooling Bracket, PART PDM REV: X-015, DRAWING PDM REV: X-002

REV.	DATE	DCN #	DRAWING TREE #
v1	19 Mar. 2010	E1000049	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 DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXX-VY, TYPE-XX, S/N XXX.
 6. APPROXIMATE WEIGHT = 1.2 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 $\phi .010$ IS - THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO		PART NAME	
DIMENSIONS ARE IN INCHES				CALIFORNIA INSTITUTE OF TECHNOLOGY		MAGNET ASSEMBLY TO BOBBIN	
TOLERANCES: .XX $\pm .015$.XXX $\pm .005$				MASSACHUSETTS INSTITUTE OF TECHNOLOGY		TOOLING BRACKET, aLIGO BSC ISI	
ANGULAR $\pm .5^\circ$				ADVANCED LIGO		SEI	
MATERIAL: 6061-T6 Al				FINISH: 63 μ inch		NEXT ASSY: D1000717	
1. INTERPRET DRAWING PER ASME Y14.5-1994.				DESIGNER: S.BARNUM		19 Mar. 2010	
2. BREAK ALL EDGES AND CORNERS .03 X 45°.				DRAFTER: M.HILLARD		19 Mar. 2010	
3. DO NOT SCALE FROM DRAWING.				CHECKER: F.MATICHARD		19 Mar. 2010	
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.				APPROVAL: K.MASON		19 Mar. 2010	
SCALE: 1:2				PROJECTION:		SHEET 1 OF 1	
SIZE: B				DWG. NO.: D0902136		REV.: v1	