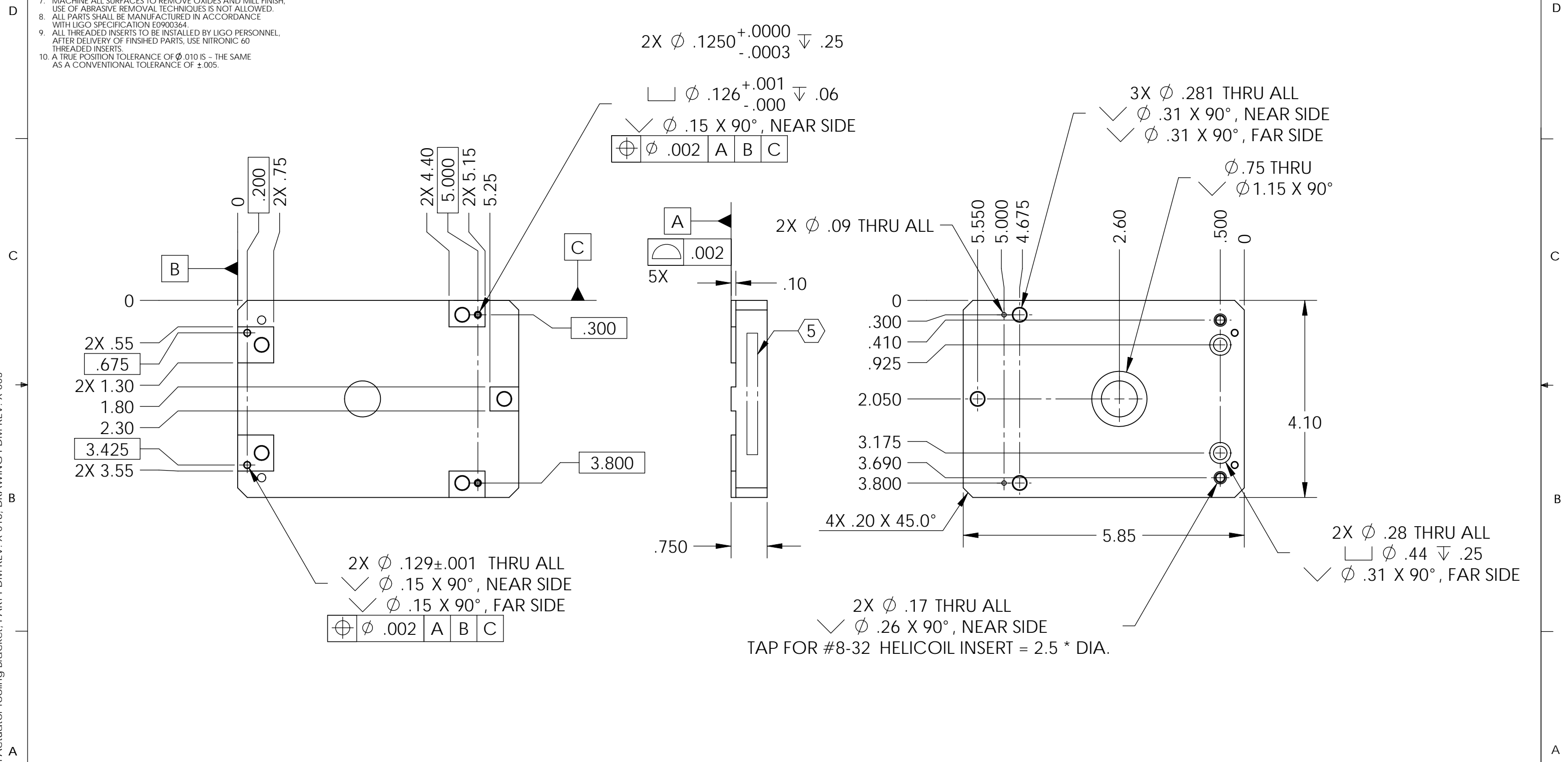


D0902137 Small vertical Actuator Tooling Bracket, PART PDM REV: X-016, DRAWING PDM REV: X-003

- 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 = 0.666 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  $\pm .005$ .

| REV. | DATE         | DCN #    | DRAWING TREE # |
|------|--------------|----------|----------------|
| v1   | 19 Mar. 2010 | E1000049 | E1000025       |
| v2   | 28 July 2010 | E1000339 | E1000025       |
| v3   | 19 Aug 2010  | E1000353 | E1000025       |



| NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)  |  |                                     |  | LIGO  |  | PART NAME  |  |
|---|--|-------------------------------------|--|---|--|--|--|
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>.XX $\pm .015$<br>.XXX $\pm .005$<br>ANGULAR $\pm .5^\circ$  |  |                                     |  | CALIFORNIA INSTITUTE OF TECHNOLOGY<br>MASSACHUSETTS INSTITUTE OF TECHNOLOGY |  | MAGNET ASSEMBLY TO BOBBIN TOOLING<br>BRACKET VERTICAL, aLIGO BSC ISI |  |
| 1. INTERPRET DRAWING PER ASME Y14.5-1994.<br>2. BREAK ALL EDGES AND CORNERS .03 X 45°.<br>3. DO NOT SCALE FROM DRAWING.<br>4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. |  |                                     |  | SYSTEM<br><b>ADVANCED LIGO</b>  |  | SUB-SYSTEM<br><b>SEI</b>   |  |
| MATERIAL<br><b>6061-T6 Al</b>   |  |                                     |  | FINISH<br><b>63 <math>\mu</math>inch</b>                                    |  | NEXT ASSY<br><b>D1000642</b>   |  |
|   |  | DESIGNER<br>S.BARNUM 19 Mar. 2010   |  | SIZE<br><b>B</b>  |  | DWG. NO.<br><b>D0902137</b>  |  |
|   |  | DRAFTER<br>M.HILLARD 19 Mar. 2010   |  | SCALE: 1:2  |  | PROJECTION:  |  |
|   |  | CHECKER<br>M.MATICHARD 19 Mar. 2010 |  | SHEET 1 OF 1  |  | REV.<br><b>v3</b>  |  |
|   |  | APPROVAL<br>K.MASON 19 Mar. 2010    |  |   |  |  |  |