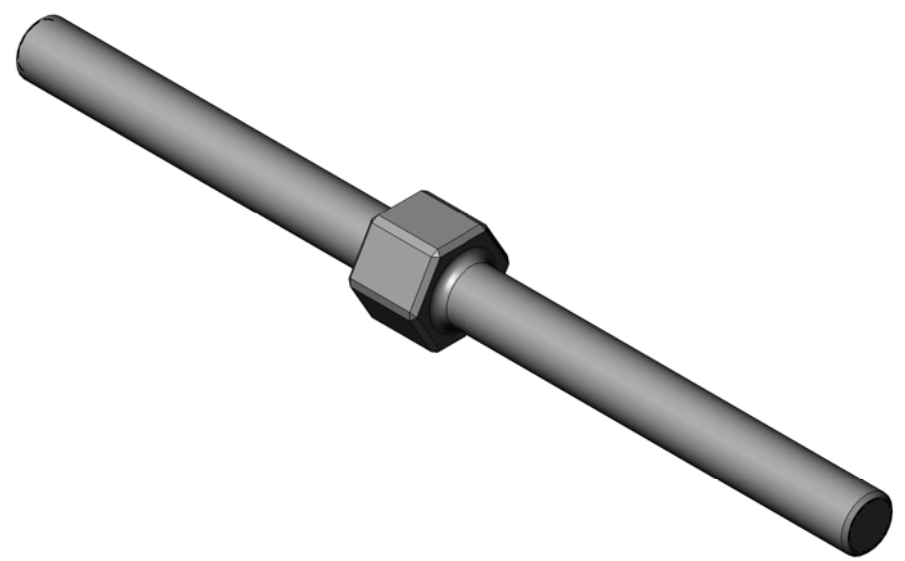
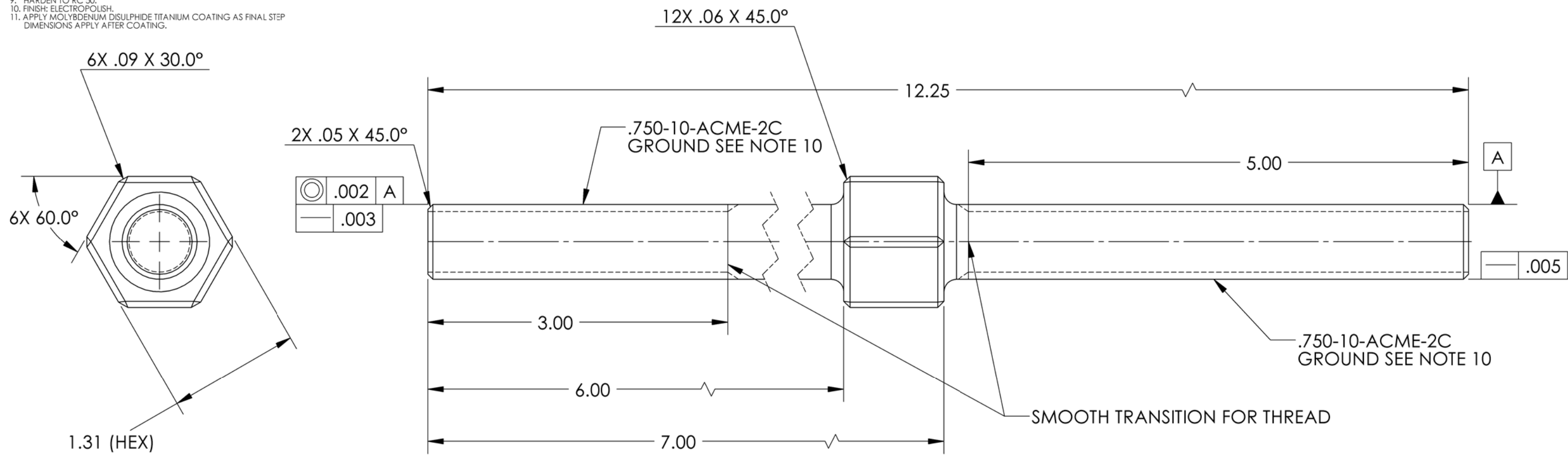


D0902193 Spring Preload Puller Bolt, Blade Puller Assy, Stage 1-2, aLIGO BSC ISI, PART PDM REV: X-009, DRAWING PDM REV: X-005

- 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 = 1.82 LB.
  7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH.
  8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
  9. HARDEN TO RC 50.
  10. FINISH: ELECTROPOLISH.
  11. APPLY MOLYBDENUM DISULPHIDE TITANIUM COATING AS FINAL STEP DIMENSIONS APPLY AFTER COATING.

REV.	DATE	DCN #	DRAWING TREE #
v1	19 Feb. 2010	E0900391	E1000025



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME SPRING BLADE PULLER BOLT, BLADE PULLER ASSY, STAGE 1-2, aLIGO BSC ISI						
DIMENSIONS ARE IN INCHES				1. INTERPRET DRAWING PER ASME Y14.5-1994.		SYSTEM ADVANCED LIGO		SUB-SYSTEM SEI		DESIGNER S.BARNUM 09 Feb. 2010	SIZE DWG. NO. B D0902193	REV. v1
TOLERANCES: .XX ± .015 .XXX ± .005				2. REMOVE ALL SHARP EDGES, R.02 MIN.		MATERIAL 420 SSSL SEE NOTE 11		FINISH 63 μinch		DRAFTER M.HILLARD 19 Feb. 2010		SCALE: 1:1
ANGULAR ± 0.5°				3. DO NOT SCALE FROM DRAWING.		NEXT ASSY D0902454		CHECKER F.MATICHARD 19 Feb. 2010		PROJECTION: 1st Angle		
				4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		APPROVAL K.MASON 19 Feb. 2010		SHEET 1 OF 1				