

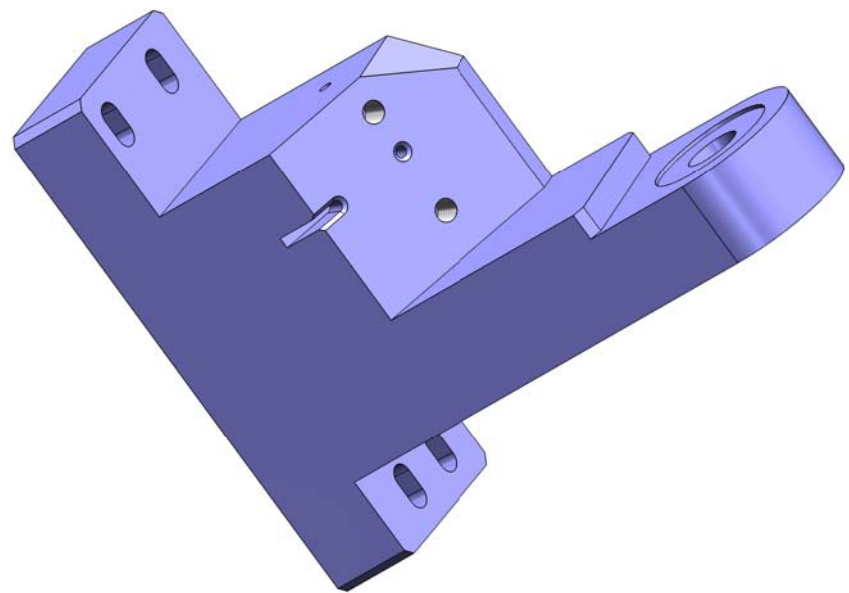
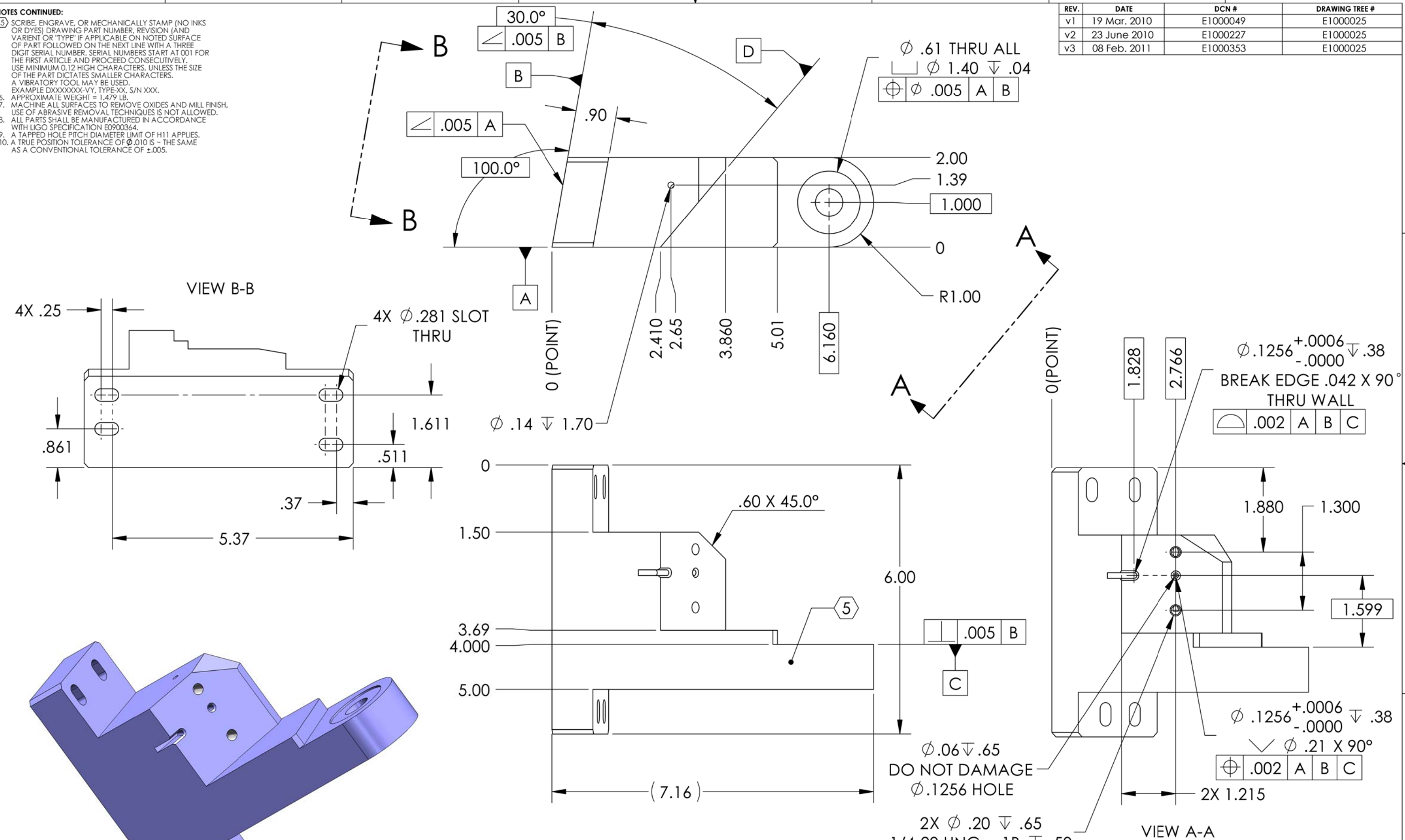
D0902236 Small Actuator Vertical bracket, PART PDM REV: X-016, DRAWING PDM REV: X-007

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 = 1.479 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. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES.
 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	23 June 2010	E1000227	E1000025
v3	08 Feb. 2011	E1000353	E1000025

D
C
B
A

D
C
B
A



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- INTERPRET DRAWING PER ASME Y14.5-1994.
- BREAK ALL EDGES AND CORNERS .03 X 45°.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX $\pm .015$
 .XXX $\pm .005$
 ANGULAR $\pm .5^\circ$

MATERIAL	6061-T6 Al	FINISH	63 μ inch
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LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME SMALL ACTUATOR VERTICAL BRACKET, aLIGO BSC ISI	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	SEI
DESIGNER	S.BARNUM	DATE	19 Mar. 2010
DRAFTER	M.HILLARD	DATE	19 Mar. 2010
CHECKER	F.MATICHARD	DATE	19 Mar. 2010
APPROVAL	K.MASON	DATE	19 Mar. 2010
SIZE	B	DWG. NO.	D0902236
REVISION	v3	SCALE	1:2
NEXT ASSY		D0901182	PROJECTION:
		SHEET 1 OF 1	

8 7 6 5 4 3 2 1