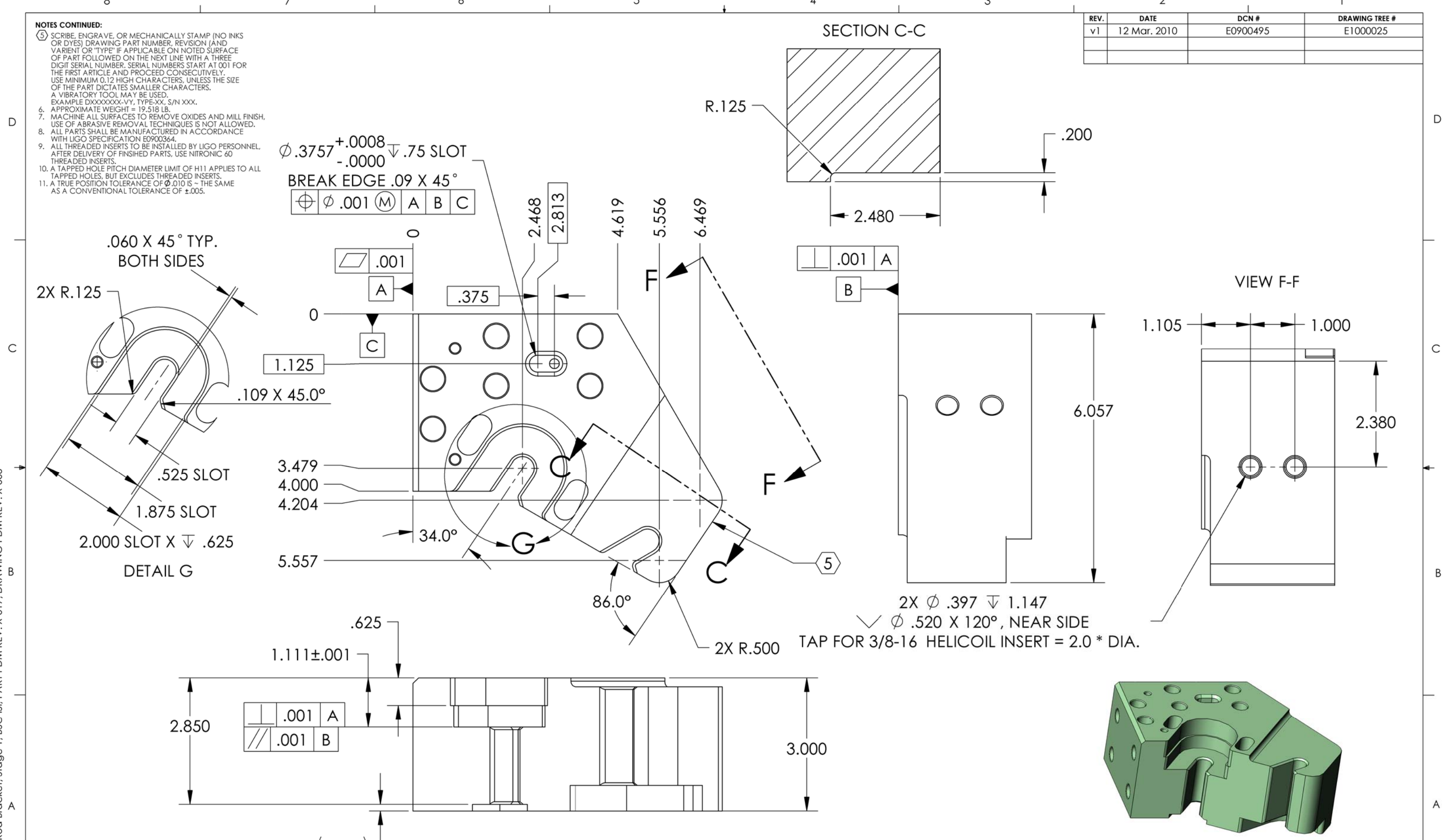


D0902276 Flexure Rod Bracket, Stage 1, BSC-ISI, PART PDM REV: X-017, DRAWING PDM REV: X-008

REV.	DATE	DCN #	DRAWING TREE #
v1	12 Mar. 2010	E0900495	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 = 19.518 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 TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES TO ALL TAPPED HOLES, BUT EXCLUDES THREADED INSERTS.
 11. A TRUE POSITION TOLERANCE OF $\phi .010$ IS - THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.

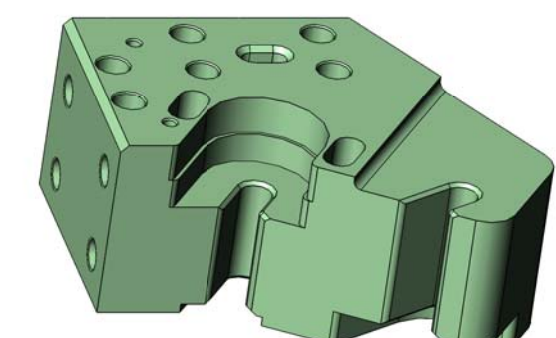


$\phi .3757^{+.0008}_{-.0000}$ $\nabla .75$ SLOT
 BREAK EDGE .09 X 45°
 $\oplus \phi .001$ (M) A B C

.060 X 45° TYP. BOTH SIDES
 2X R.125
 .109 X 45.0°
 .525 SLOT
 1.875 SLOT
 2.000 SLOT X $\nabla .625$
 DETAIL G

.625
 1.111 ± .001
 2.850
 .001 A
 .001 B
 3.000
 (.150)

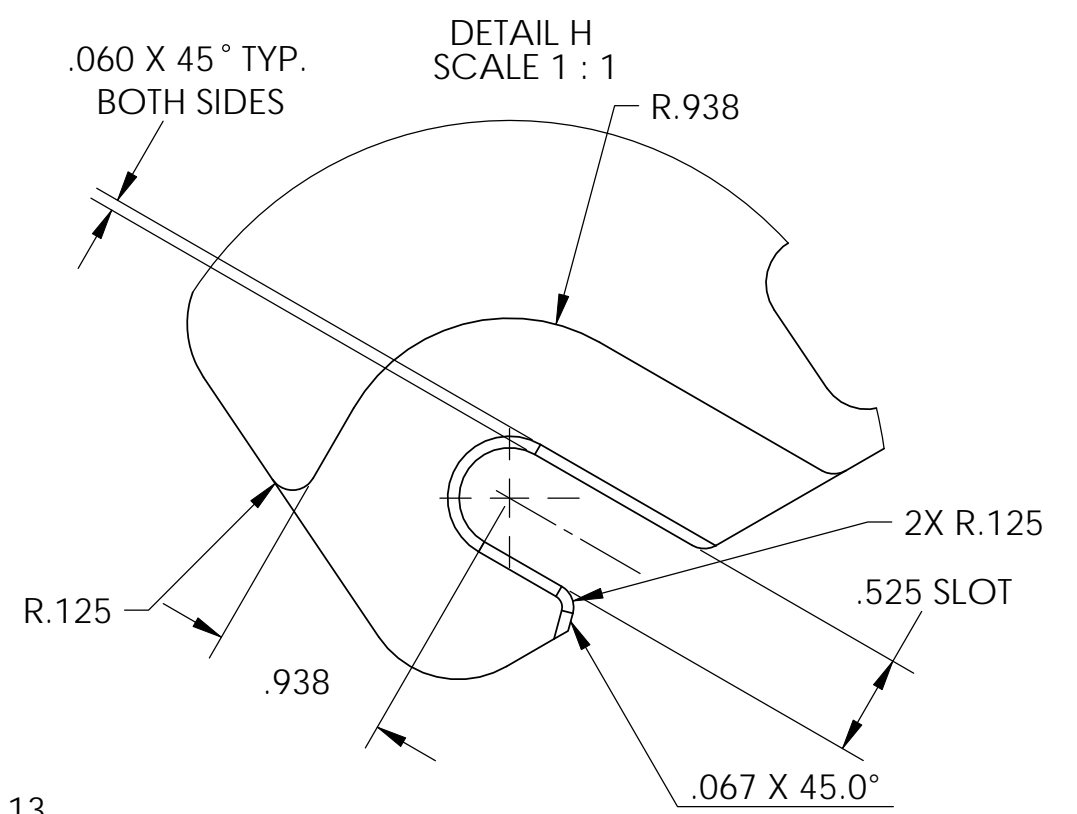
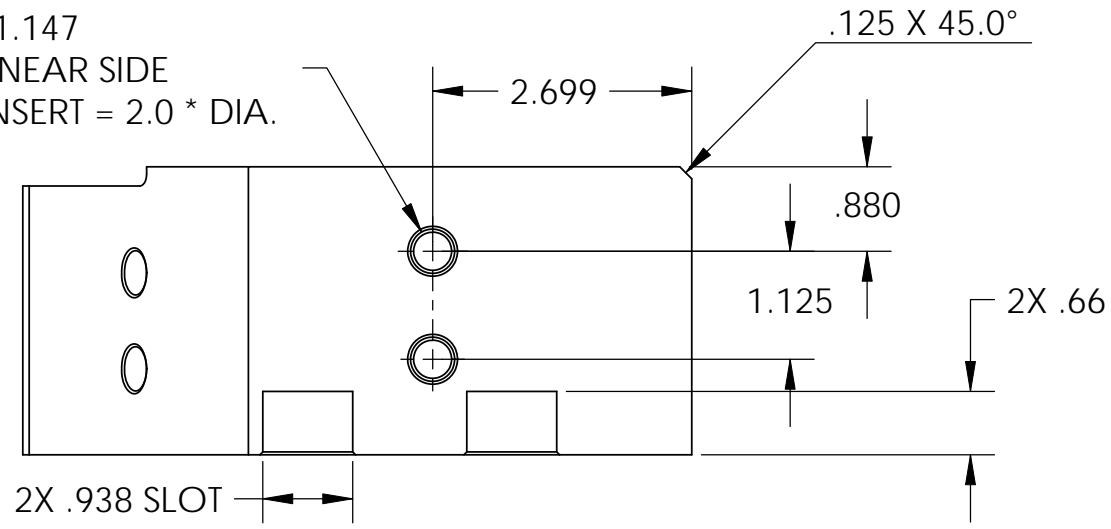
2X $\phi .397$ $\nabla 1.147$
 $\nabla \phi .520$ X 120°, NEAR SIDE
 TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA.



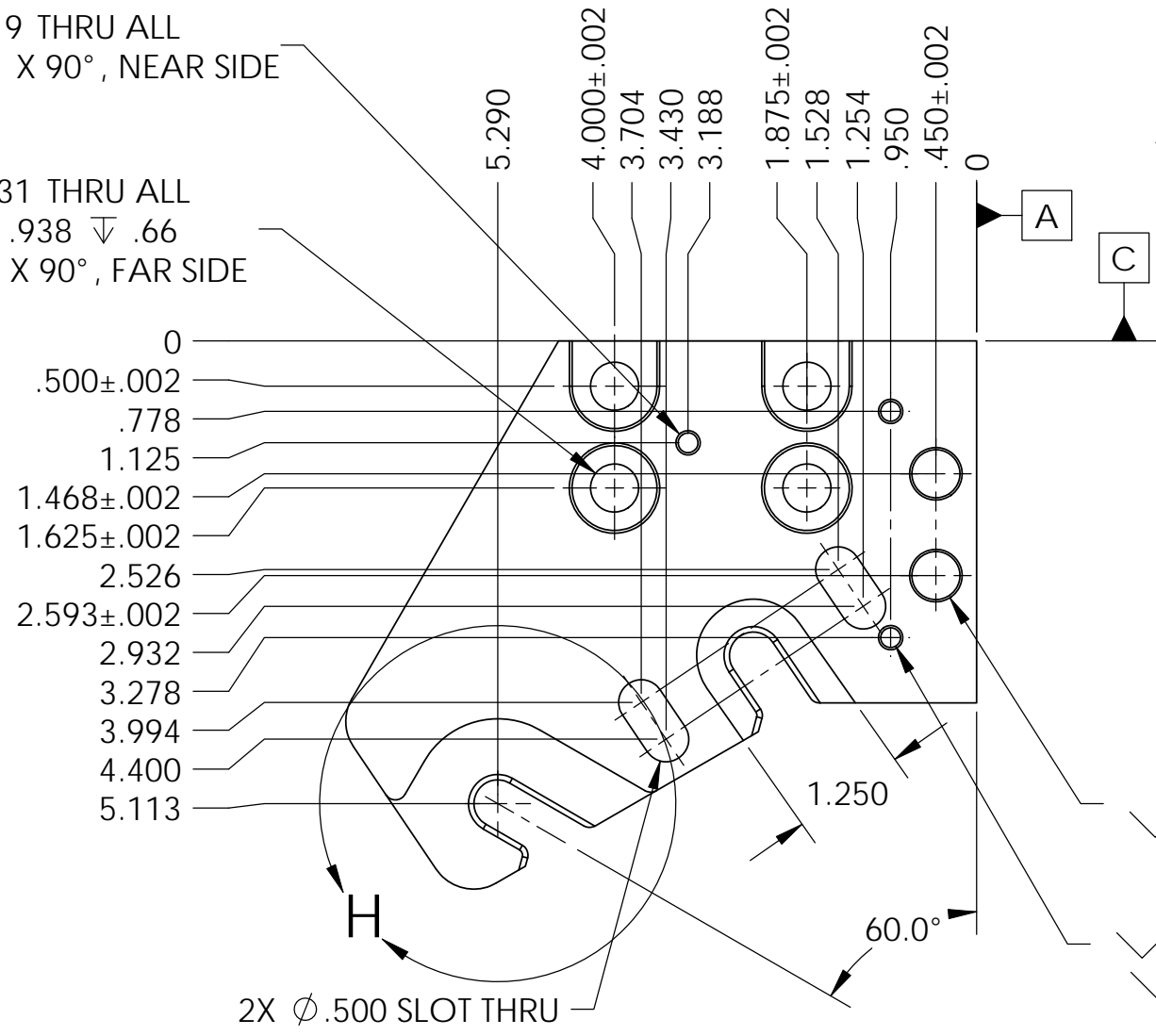
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± .5°				STAGE 1 FLEXURE ROD BRACKET	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.				ADVANCED LIGO SEI	
MATERIAL: AISI 304 FINISH: 63 μ inch				DESIGNER: F. MATICHARD 15 Jan. 2010 DRAFTER: M. HILLARD 15 Jan. 2010 CHECKER: A. STEIN 15 Jan. 2010 APPROVAL: K. MASON 15 Jan. 2010	
NEXT ASSY: D0901182				SIZE: B DWG. NO.: D0902276 REV.: v1	
SCALE: 1:2 PROJECTION:				SHEET 1 OF 2	

D0902276 Flexure Rod Bracket, Stage 1, BSC-ISI, PART PDM REV: X-017, DRAWING PDM REV: X-008

2X ϕ .397 ∇ 1.147
 ∇ ϕ .520 X 120°, NEAR SIDE
TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA.

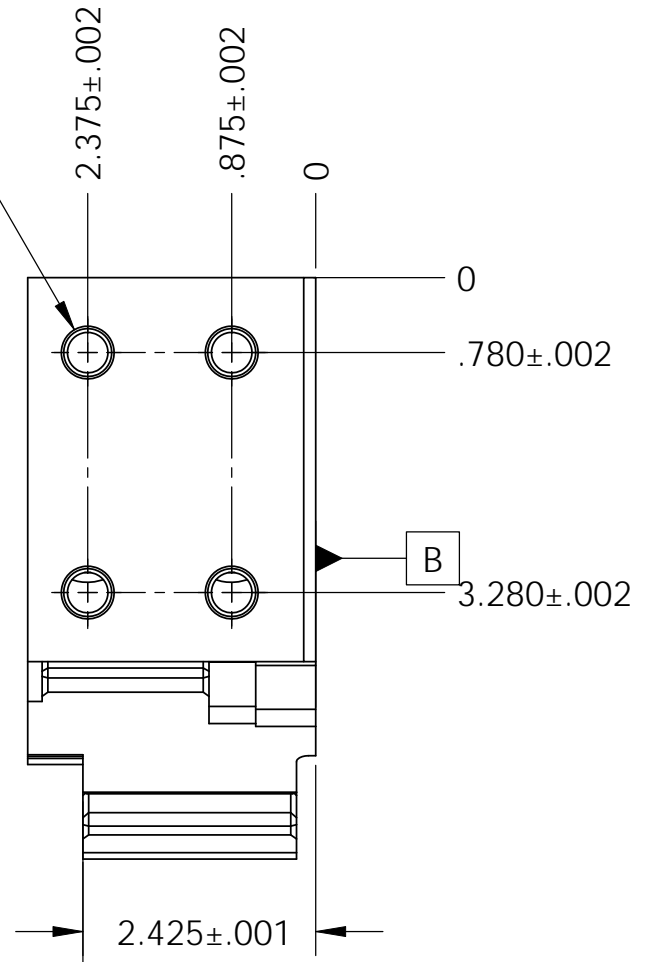


ϕ .219 THRU ALL
 ∇ ϕ .269 X 90°, NEAR SIDE
2X ϕ .531 THRU ALL
 ∇ ϕ .938 ∇ .66
 ∇ ϕ .581 X 90°, FAR SIDE



4X ϕ .422 ∇ 1.13
1/2-13 UNC ∇ .80
 ∇ ϕ .550 X 120°, NEAR SIDE

4X ϕ .531 THRU ALL
 ∇ ϕ .580 X 90°, FAR SIDE
2X ϕ .22 THRU ALL
 ∇ ϕ .269 X 90°, NEAR SIDE
 ∇ ϕ .269 X 90°, FAR SIDE



	.001	A
	.001	B

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D0902276	V1
SCALE: 1:2	PROJECTION:	SHEET 2 OF 2