

D0902277 Flexure Rod Gusset, Stage 1, BSC-ISI, PART PDM REV: X-026, DRAWING PDM REV: X-010

REV.	DATE	DCN #	DRAWING TREE #
v1	12 Mar. 2010	E0900495	E1000025
v2	04 Aug 2010	E1000290	E1000025

- NOTES CONTINUED:**
- 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.
  - APPROXIMATE WEIGHT = 11.0 LB.
  - MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
  - ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
  - ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.
  - A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES TO ALL TAPPED HOLES EXCEPT THREADED INSERTS.
  - A TRUE POSITION TOLERANCE OF  $\pm .010$  IS THE SAME AS A CONVENTIONAL TOLERANCE OF  $\pm .005$ .

$\phi .3757^{+.0008} \downarrow .75$   
 $\phi .56 \times 90^\circ$ , NEAR SIDE  
 $\phi .002$  A B C

4X  $\phi .42 \downarrow 2.00$   
 1/2-13 UNC  $\downarrow 1.50$   
 $\phi .60 \times 120^\circ$ , NEAR SIDE

$\phi .3757^{+.0008} \downarrow .75$  SLOT  
 BREAK EDGE  $.09 \times 45^\circ$   
 $\phi .002$  A B C

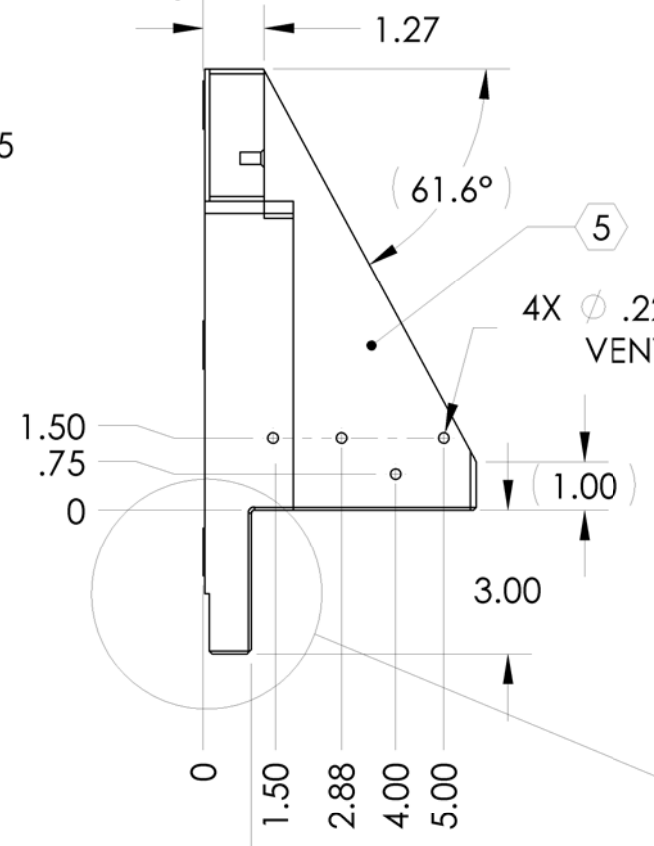
2X  $\phi .547$  THRU  
 $\phi .62 \times 90^\circ$ , NEAR SIDE

6X 1.00 SQ. PADS  
 CENTERED ON HOLES

2X  $\phi .547$  THRU  
 $\phi .938 \downarrow .55$   
 $\phi .62 \times 90^\circ$ , FAR SIDE

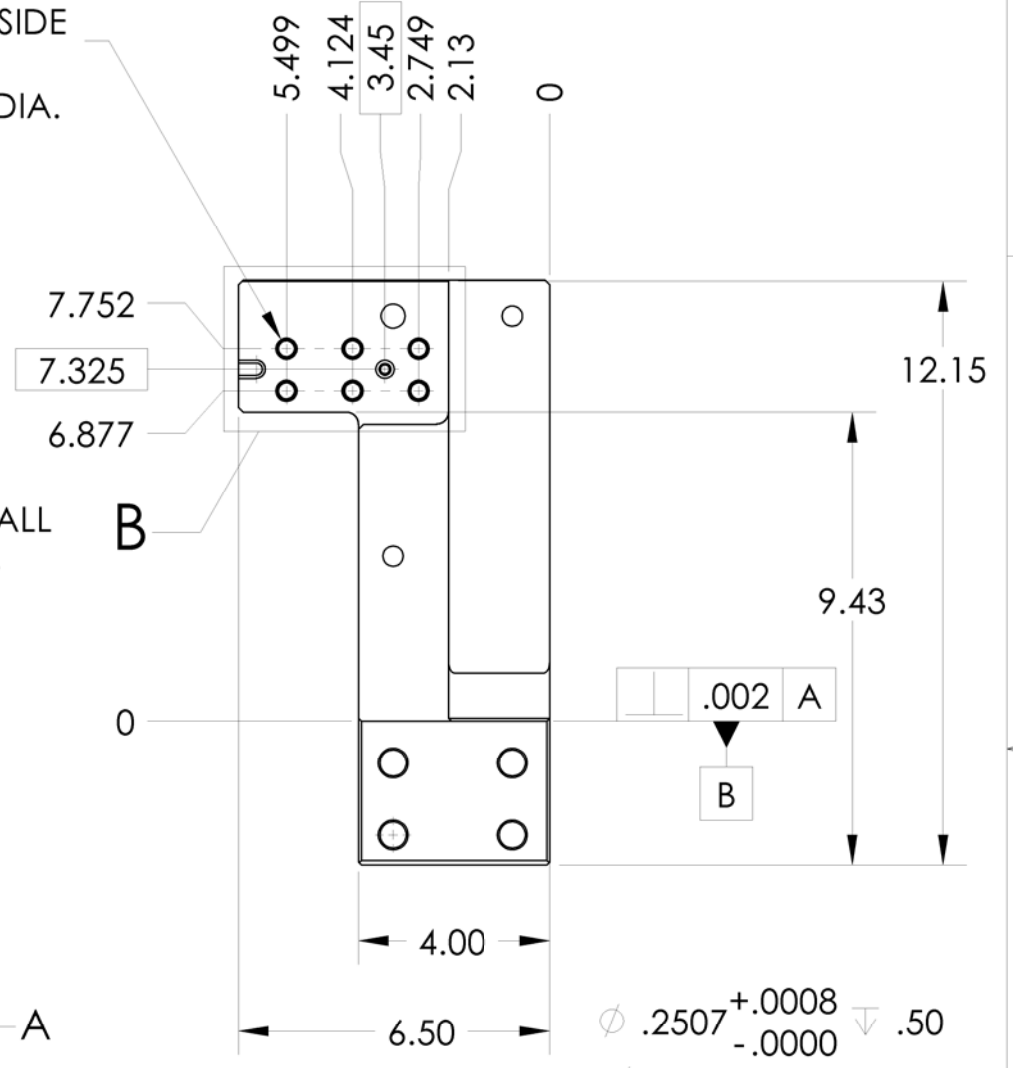
6X  $\phi .33$  THRU ALL  
 $\phi .44 \times 90^\circ$ , NEAR SIDE  
 TAP FOR 5/16-18  
 HELICOIL INSERT =  $2.0 \times \text{DIA.}$

$\phi .002$   
 A  
 4 PADS



$\phi .002$  A  
 $\phi .002$  B

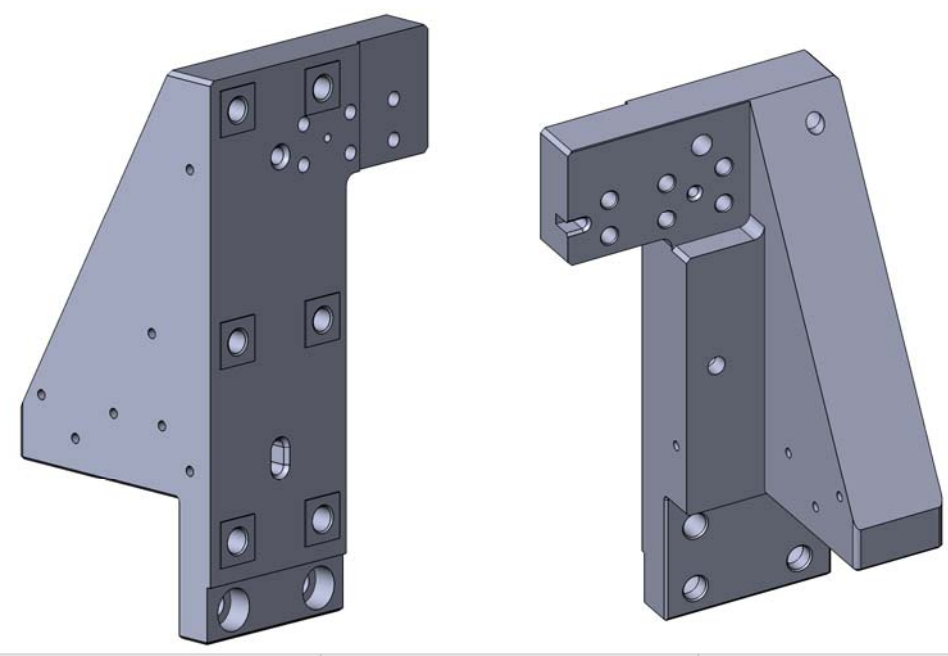
BOTTOM VIEW SEE SHEET 2  
 SCALE 1:3



$\phi .2507^{+.0008} \downarrow .50$   
 $\phi .38 \times 90^\circ$ , NEAR SIDE  
 $\phi .19$  THRU  
 $\phi .002$  A B C

$\phi .2507^{+.0008} \downarrow .50$   
 $\phi .50$  BREAK EDGE  
 $\phi .09 \times 45^\circ$   
 $\phi .002$  A B C

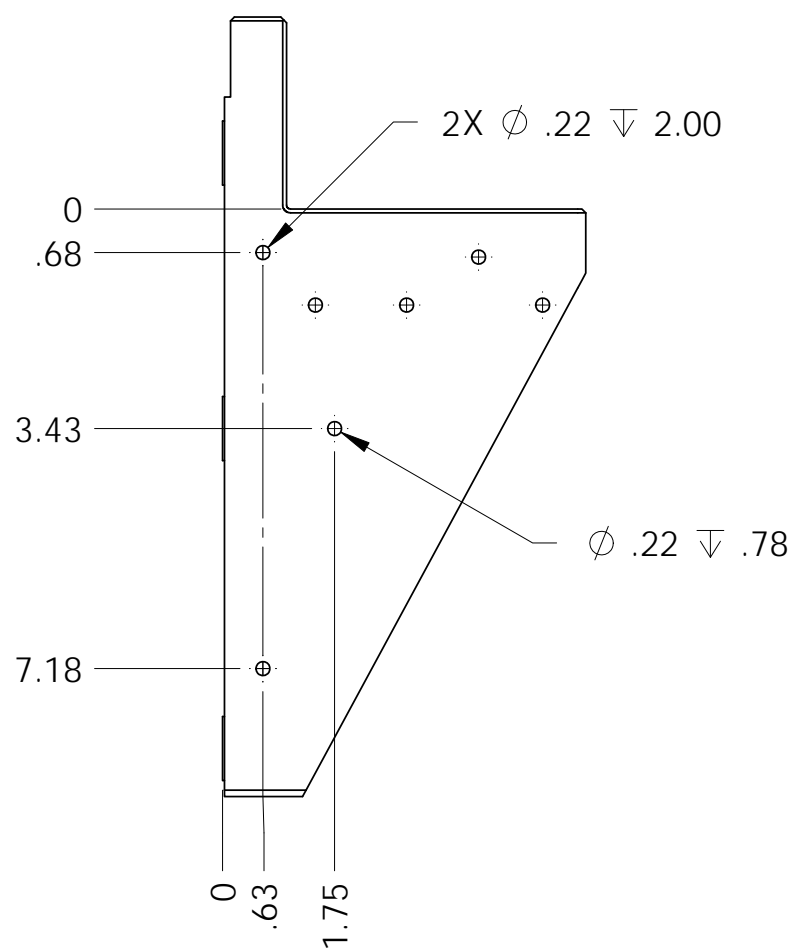
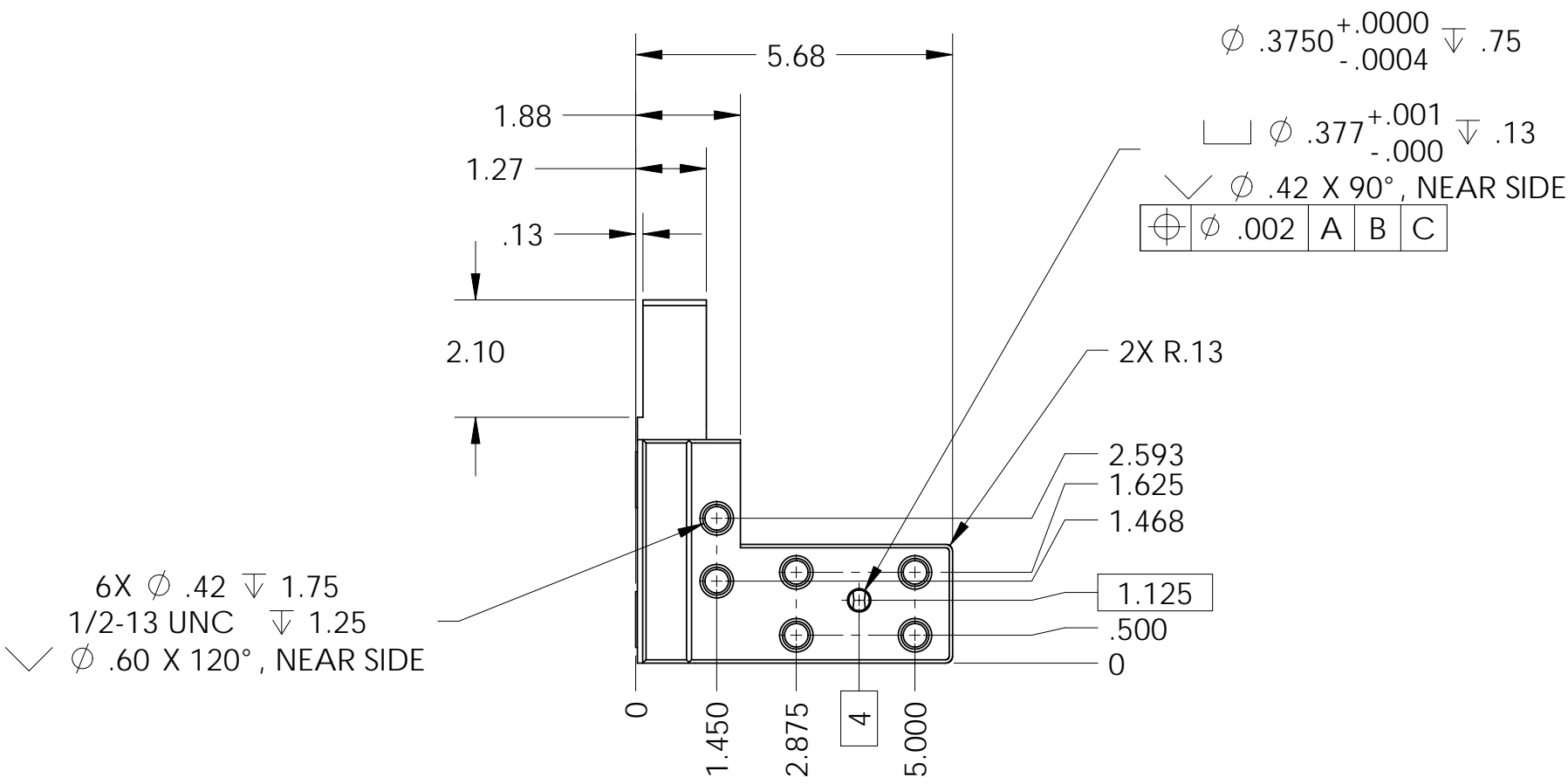
DETAIL B  
 SCALE 1:2



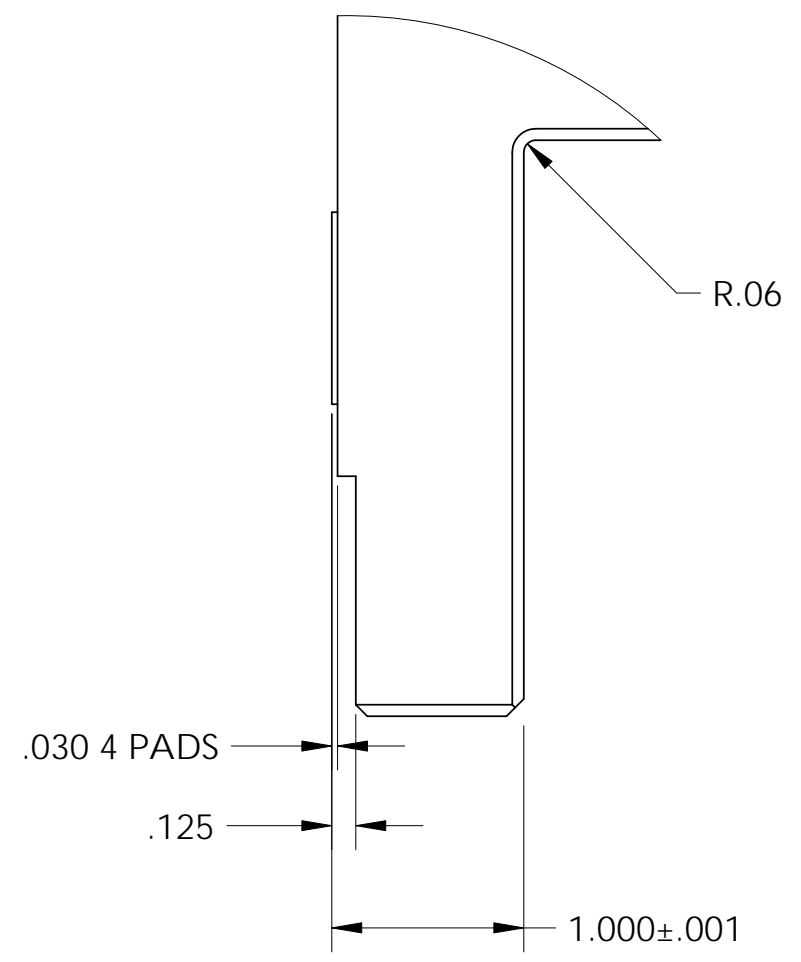
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		FLEXURE ROD GUSSET, STAGE 1, aLIGO BSC ISI	
TOLERANCES: .XX $\pm .015$ .XXX $\pm .005$				SEI		DESIGNER F.MATCHARD 15 Jan. 2010	
ANGULAR $\pm .5^\circ$				NEXT ASSY D0901180		DRAFTER M.HILLARD 15 Jan. 2010	
MATERIAL 6061-T6 Al				FINISH 63 $\mu\text{inch}$		CHECKER A.STEIN 15 Jan. 2010	
						APPROVAL K.MASON 15 Jan. 2010	
						SIZE DWG. NO. B D0902277	
						REV. v2	
						SCALE: 1:4 PROJECTION: SHEET 1 OF 2	

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### BOTTOM VIEW



### DETAIL A SCALE 1 : 1



		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE <b>B</b>	DWG. NO. D0902277	REV. v2	
SCALE: 1:3	PROJECTION:	SHEET 2 OF 2	