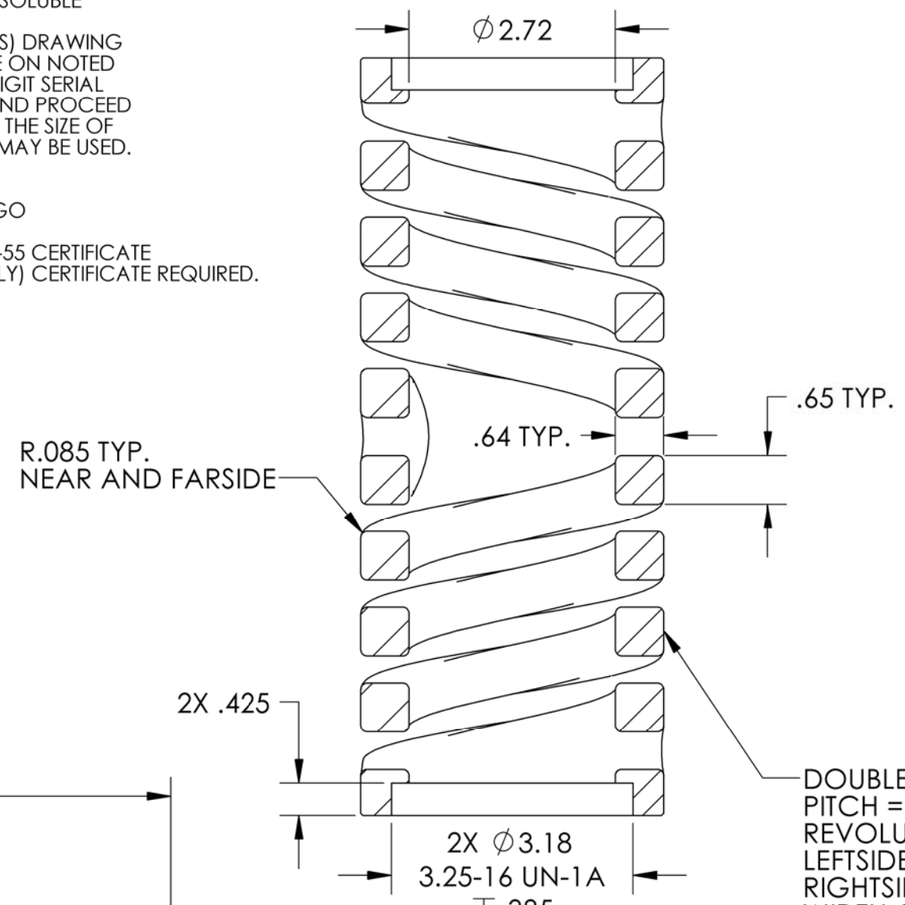
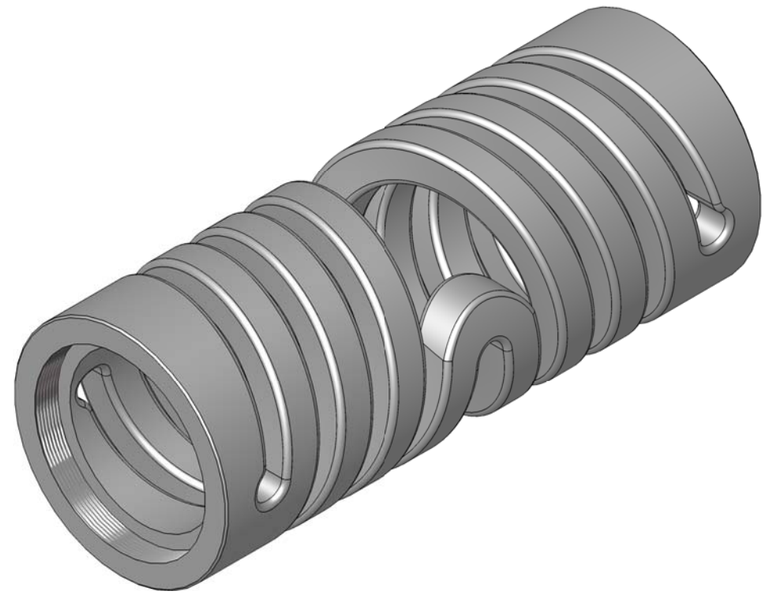
REV.	DATE	DCN #	DRAWING TREE #
v2	3 Feb. 2011	E1100015	E1100016

NOTES CONTINUED:

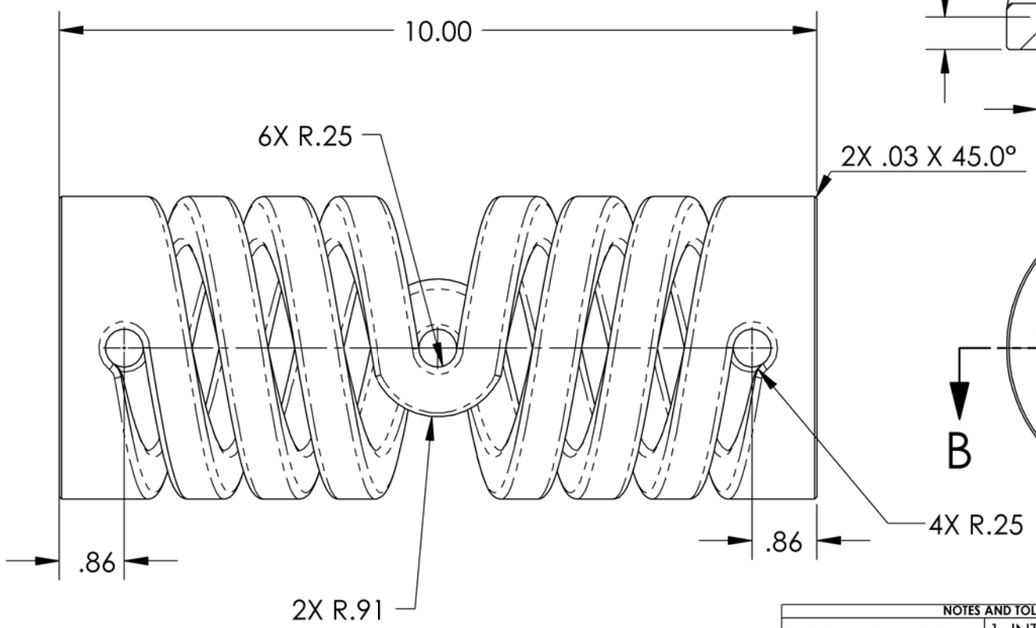
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE 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 DXXXXXXX-VY, TYPE-XX, S/N XXX.
6. APPROXIMATE WEIGHT = 12.03 LB.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. AGE C-300 FOR 6 HOURS @ 925°F, AIRCOOL. HARDEN TO RC 50-55 CERTIFICATE OF HEAT TREAT REQUIRED TEST FOR ROCKWELL HARDNESS (1 ONLY) CERTIFICATE REQUIRED.

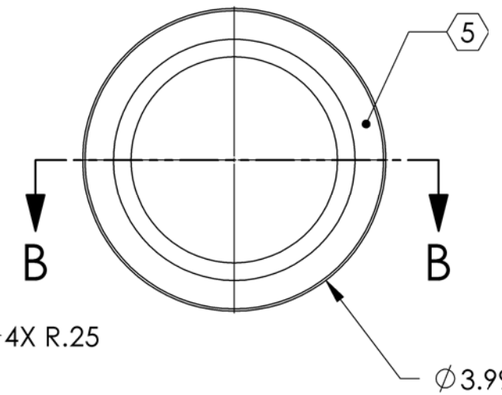
SECTION B-B

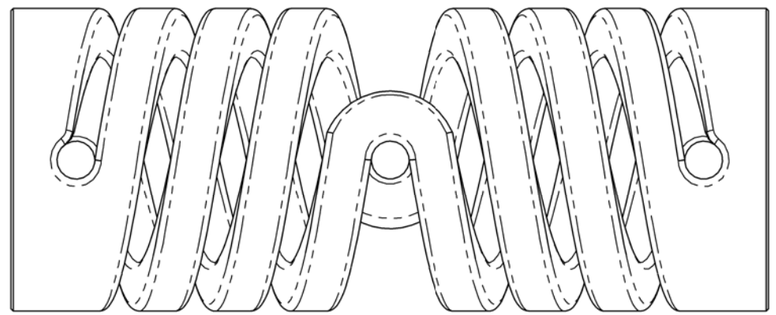




DOUBLE START PROFILE
PITCH = 2.00" NEARSIDE AND FARSIDE
REVOLUTIONS: 2
LEFTSIDE: CCW
RIGHTSIDE: CW
WIDTH OF CUT: .334







NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)										
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR± .5°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .03 x 45°. 3. DO NOT SCALE FROM DRAWING.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME DOUBLE START COUNTERWOUND SPRING					
	MATERIAL MARAGING 300	FINISH 32 µinch	SYSTEM ADVANCED LIGO	SUB-SYSTEM SEI	DESIGNER	M. HAMMOND	14 May, 2003	SIZE B	DWG. NO. D020406	REV. v2
			NEXT ASSY D020408		DRAFTER	M.HILLARD	3 Feb. 2011			
					CHECKER	A.STEIN	Aug. 2008			
					APPROVAL	K.MASON	3 Feb. 2011	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1

D020406_Double_Start_Counterwound_Spring, PART PDM REV: X-005, DRAWING PDM REV: X-000