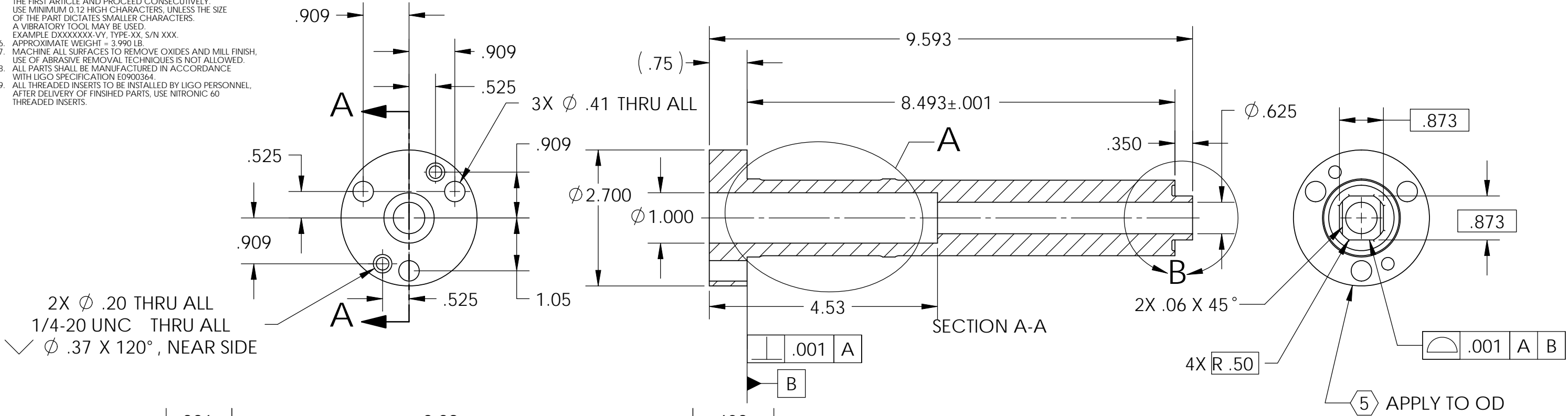


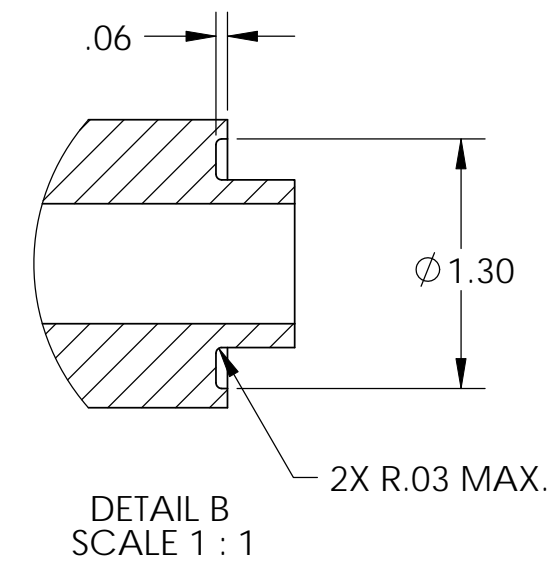
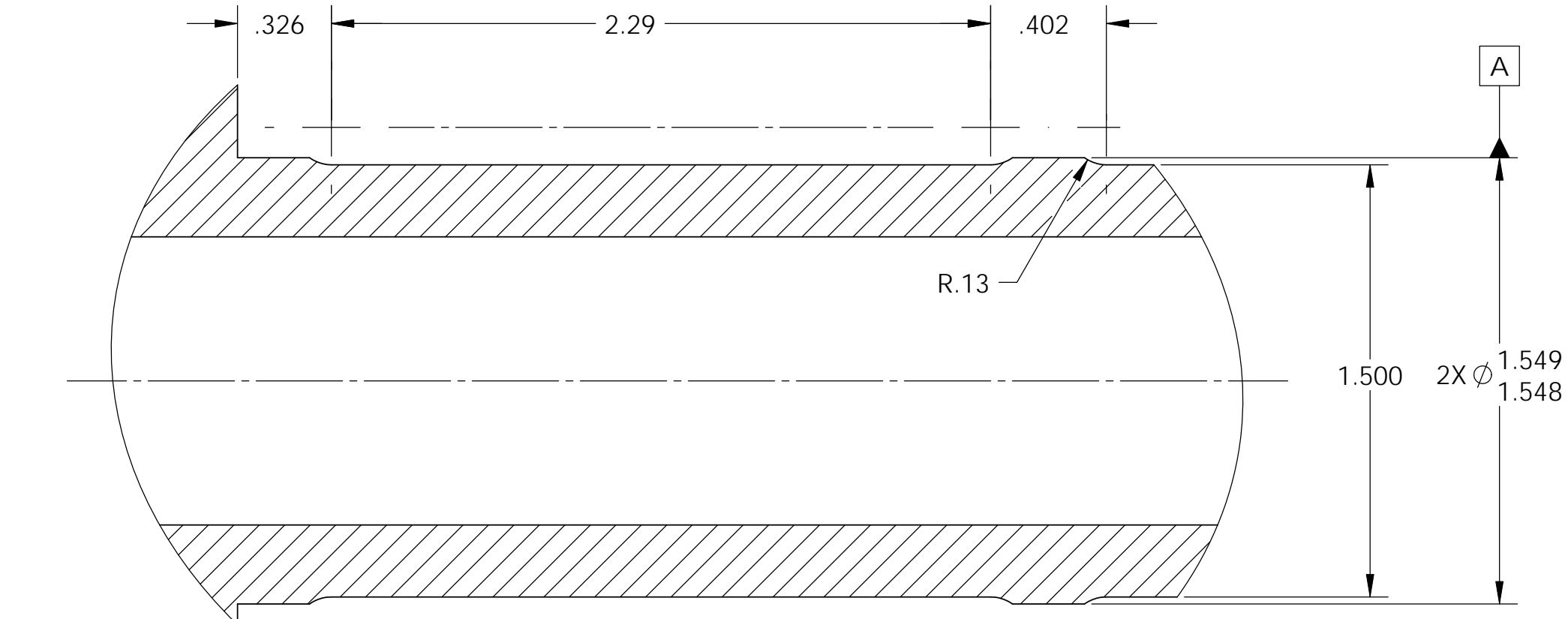
8 7 6 5 4 3 2 1

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 = 3.990 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 ED900364.
 9. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	12 Dec. 2005		
v2	10 May 2010	E1000155	E1000025
v3	03 Aug. 2010	E1000288	E1000025



2X ϕ .20 THRU ALL
 1/4-20 UNC THRU ALL
 \checkmark ϕ .37 X 120°, NEAR SIDE



DETAIL A
 SCALE 2 : 1

DETAIL B
 SCALE 1 : 1

D050452 Stage0-2 Alignment Pin, PART PDM REV: X-006, DRAWING PDM REV: X-005

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES				1. INTERPRET DRAWING PER ASME Y14.5-1994.		STAGE 0-2 ALIGNMENT PIN					
TOLERANCES: .XX ± .015 .XXX ± .005				2. BREAK ALL EDGES AND CORNERS .03 X 45°.		DESIGNER	ASI	12 Dec. 2005	SIZE	DWG. NO.	REV.
ANGULAR ± .5°				3. DO NOT SCALE FROM DRAWING.		DRAFTER	M.HILLARD	06 May. 2010	B	D050452	v3
				4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		CHECKER	F.MATICHARD	06 May 2010	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1
MATERIAL		FINISH		NEXT ASSY		APPROVAL	K.MASON	06 May 2010			
17-4 PH SSSL, H 1150		63 μ inch		D1001110							

8 7 6 5 4 3 2 1