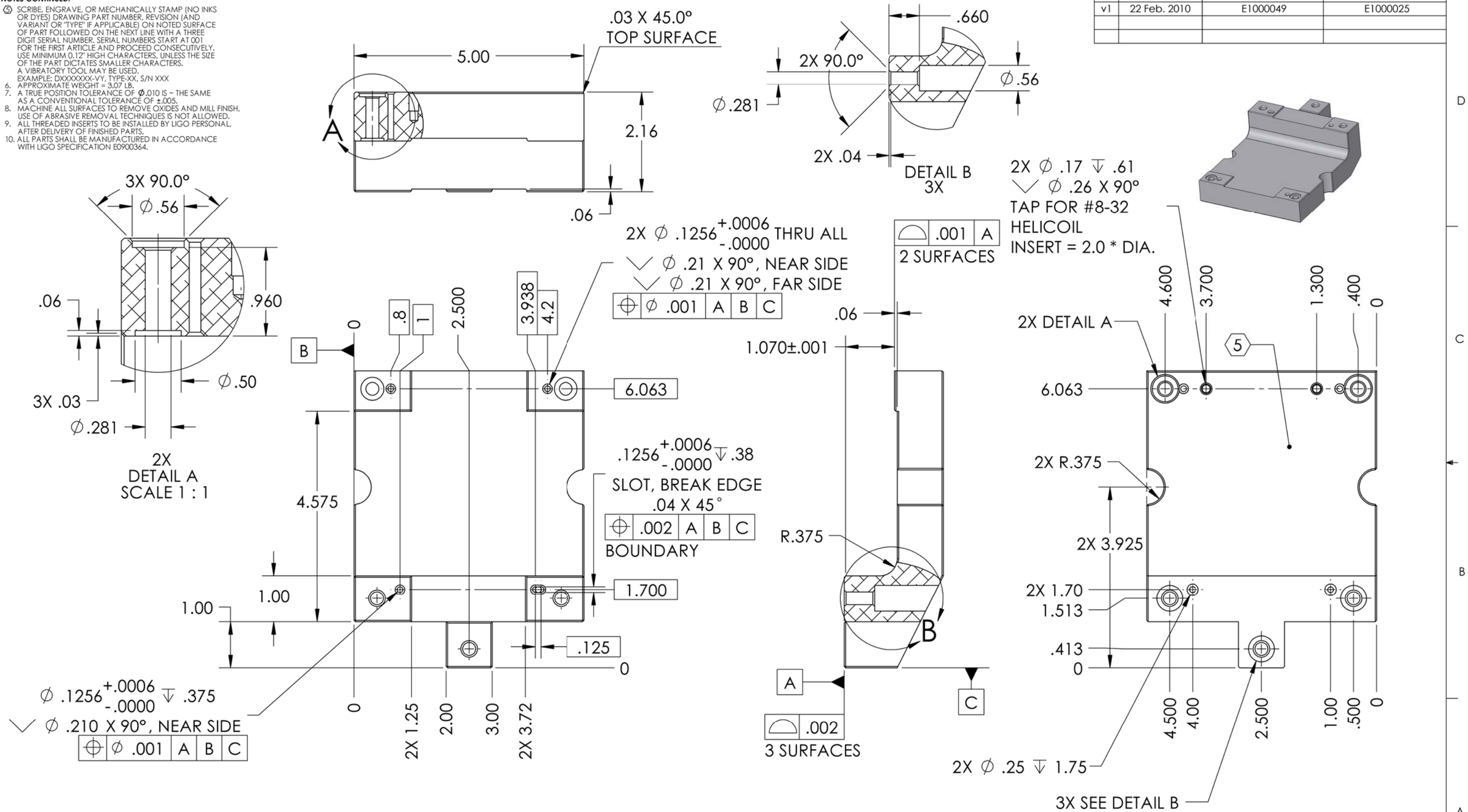
REV.	DATE	DCN #	DRAWING TREE #
v1	22 Feb. 2010	E1000049	E1000025

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: DXXXXXXX-VY, TYPE-XX, S/N XXX
6. APPROXIMATE WEIGHT = 3.07 LB.
7. A TRUE POSITION TOLERANCE OF Ø.010 IS ~ THE SAME AS A CONVENTIONAL TOLERANCE OF ±.005.
8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
9. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONAL, AFTER DELIVERY OF FINISHED PARTS.
10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .015
.XXX ± .005

ANGULAR ± 0.5°

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

MATERIAL: 6061-T6 Al
FINISH: 63 µinch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SEI
NEXT ASSY: D1000290

PART NAME: ACTUATOR TOOLING BAR, STAGE 0-1, aLIGO BSC ISI

DESIGNER	S.BARNUM	22 Feb. 2010
DRAFTER	M.HILLARD	22 Feb. 2010
CHECKER	F.MATICHARD	22 Feb. 2010
APPROVAL	K.MASON	22 Feb. 2010

SIZE: B — DWG. NO.: D0902342 — REV.: v1
SCALE: 1:2 — PROJECTION: — SHEET 1 OF 1

D0902342 Stage0-1 Actuator Tooling Bar, PART PDM REV: X-008, DRAWING PDM REV: X-004