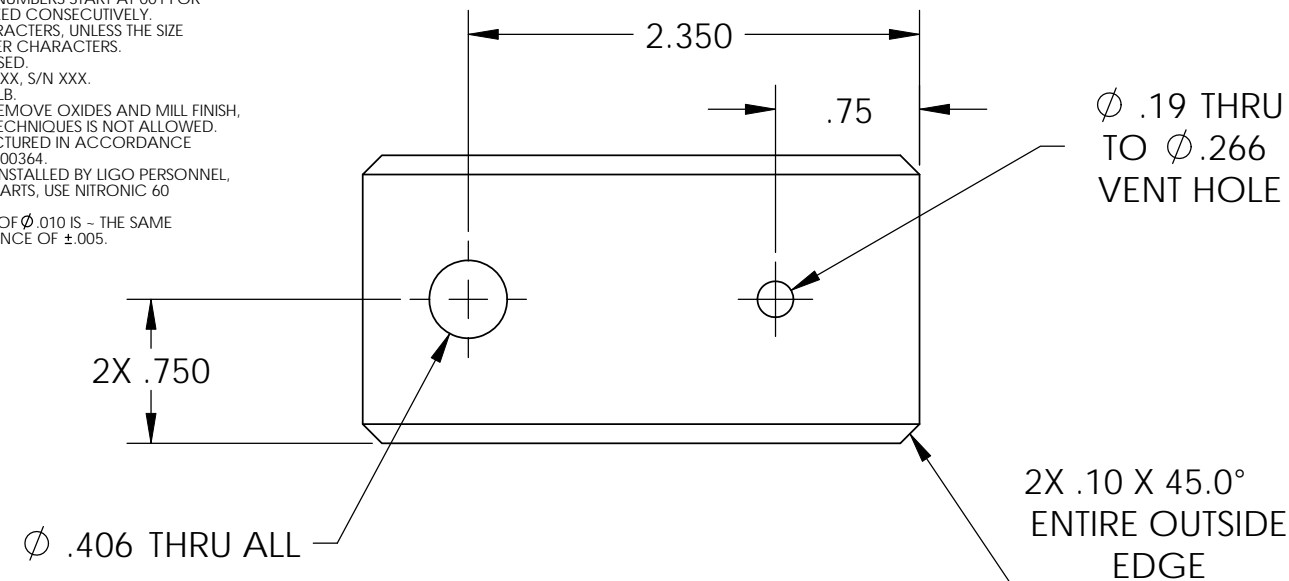


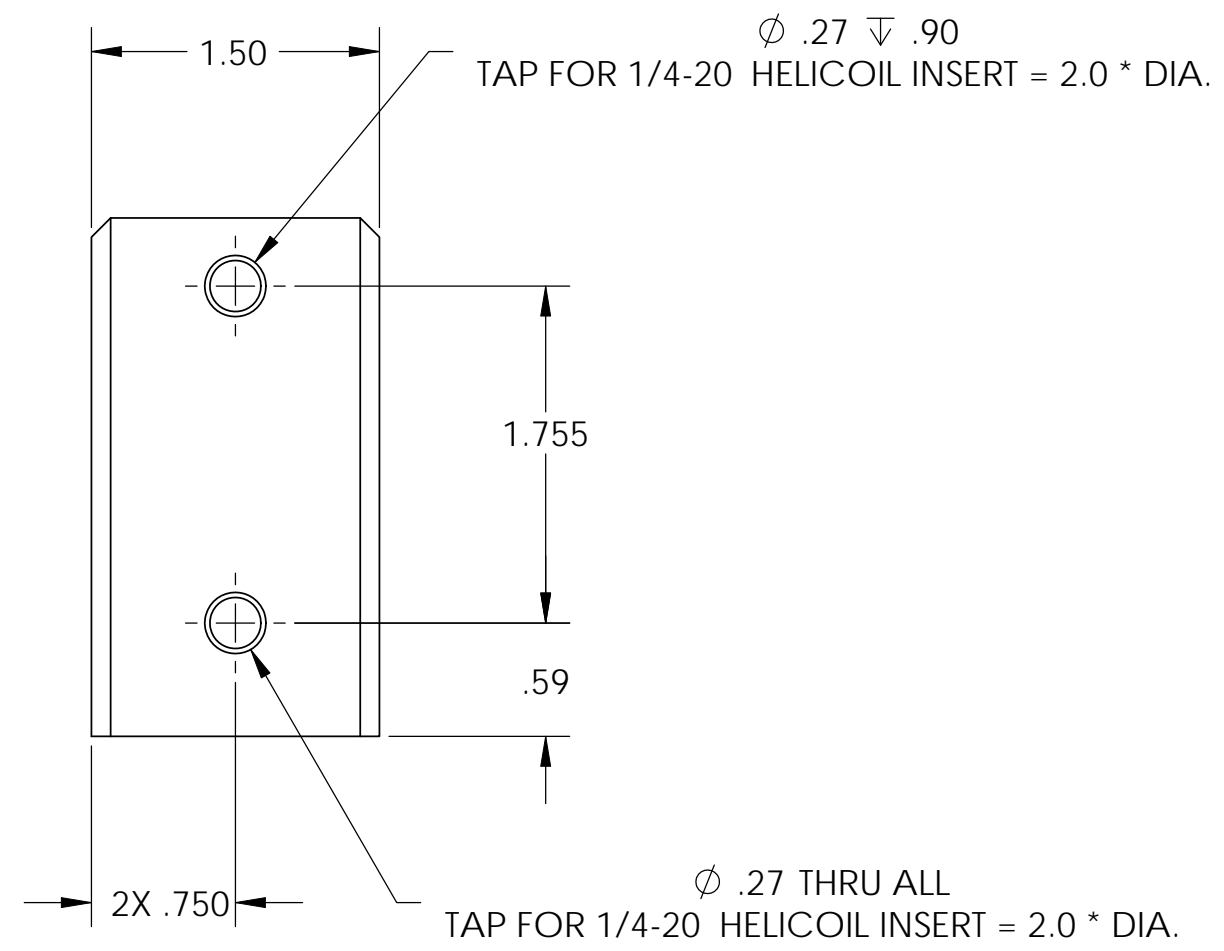
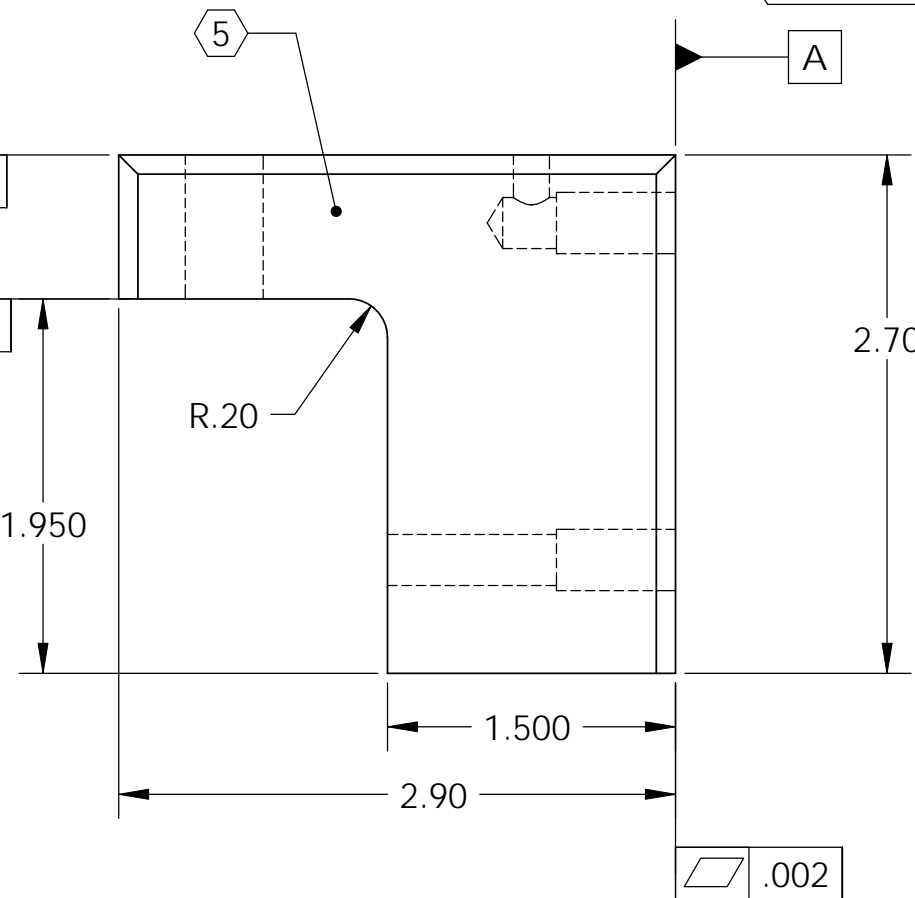
D0902424 Stage0-1 Horizontal Actuator L Connector, PART PDM REV: X-005, DRAWING PDM REV: X-005

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 DXXXXXX-VY, TYPE-XX, S/N XXX.
 - 6. APPROXIMATE WEIGHT = 0.71 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 TRUE POSITION TOLERANCE OF $\phi .010$ IS - THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.



	.002	
	.005	A
	.002	
	.005	A



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME HORIZONTAL ACTUATOR L CONNECTOR, STAGE 0-1, aLIGO BSC ISI	
DIMENSIONS ARE IN INCHES		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.		SYSTEM	ADVANCED LIGO	SUB-SYSTEM	SEI
TOLERANCES: .XX ± .015 .XXX ± .005		MATERIAL	6061-T6 Al	FINISH	63 μinch	NEXT ASSY	D0901102
ANGULAR ± 0.5°				DESIGNER	S.BARNUM	22 Feb. 2010	SIZE DWG. NO.
				DRAFTER	M.HILLADR	22 Feb. 2010	B D0902424
				CHECKER	F.MATICHARD	22 Feb. 2010	REV.
				APPROVAL	K.MASON	22 Feb. 2010	v1
				SCALE: 1:1		PROJECTION:	SHEET 1 OF 1