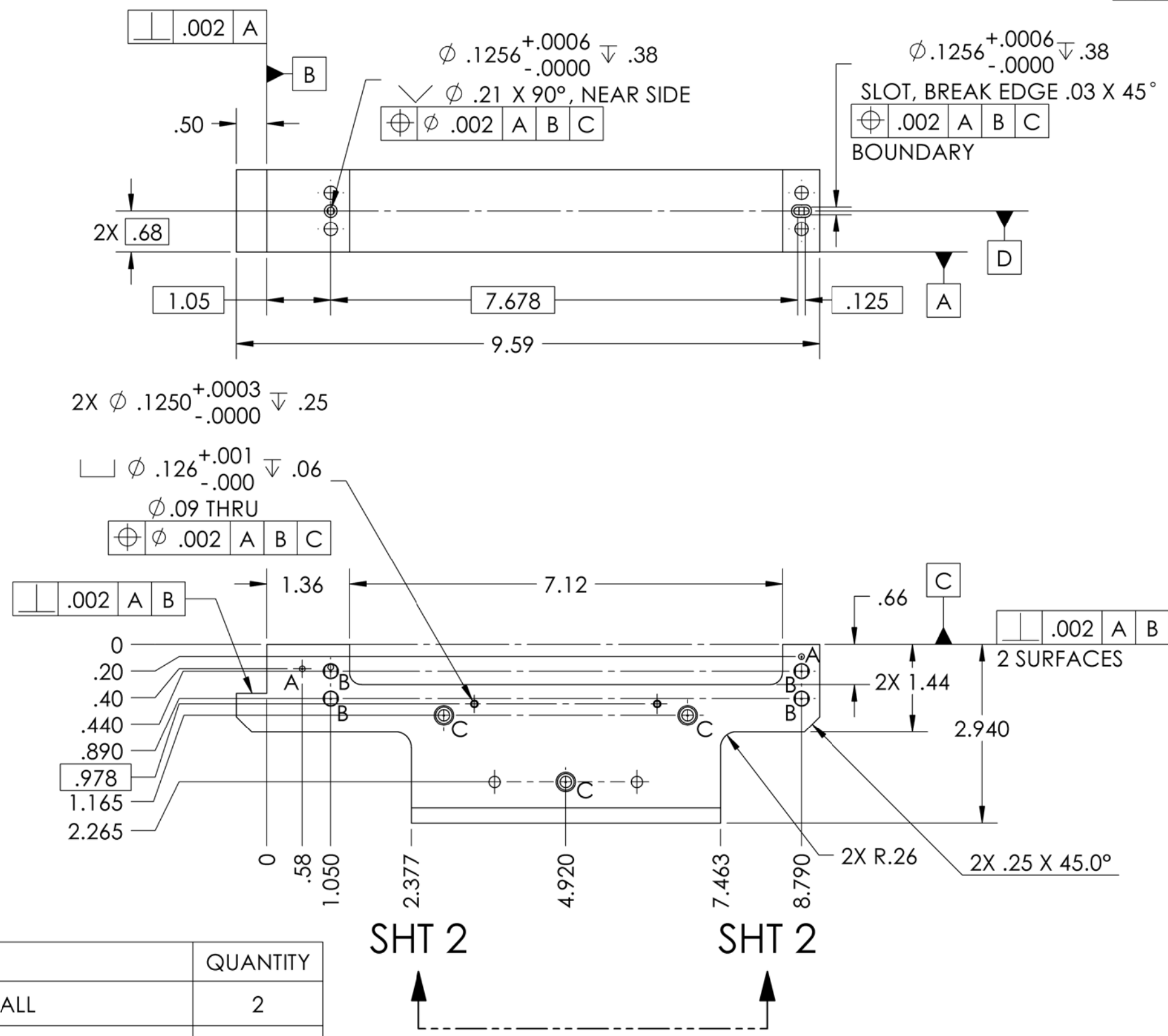


D0902426 Large Vert. Actuator Coil Bracket, Stage 0-1, aLIGO BSC ISI, PART PDM REV: X-008, DRAWING PDM REV: X-008

- 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 = 2.013 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 E090364.
 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 $\pm .005$.

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



TAG	SIZE	QUANTITY
A	$\phi .09$ THRU ALL	2
B	$\phi .201$ THRU $\phi .25$ X 90°, NEAR SIDE TAP FOR #10-32 HELICOIL INSERT = 1.5 * DIA.	4
C	$\phi .272$ $\nabla .94$ TAP FOR 1/4-20 HELICOIL INSERT = 2.0 * DIA.	3

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

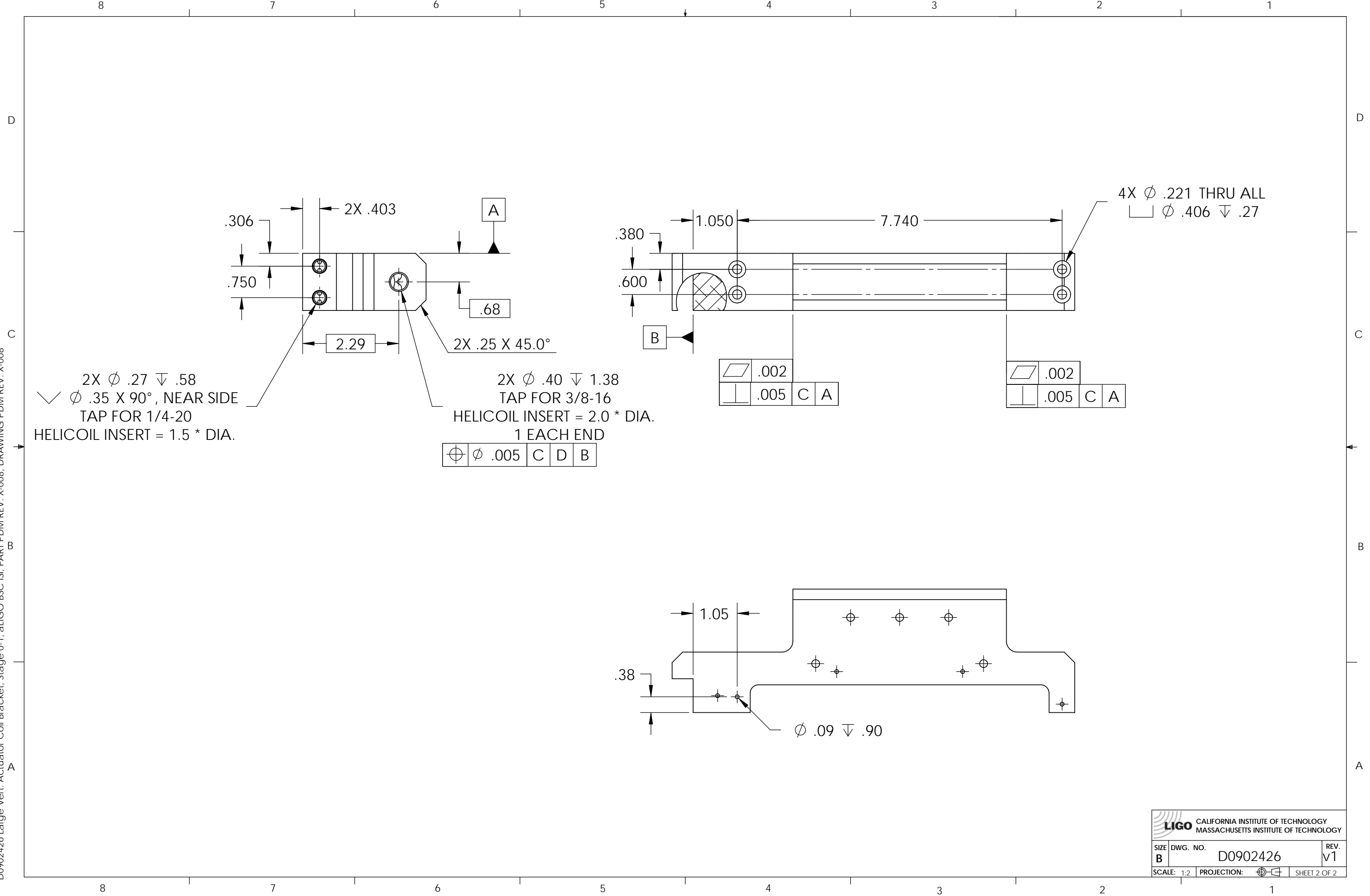
TOLERANCES:
 .XX $\pm .015$
 .XXX $\pm .005$
 ANGULAR $\pm 0.5^\circ$

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.

MATERIAL	6061-T6 Al	FINISH	63 μ inch
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME Large Vert. Actuator Coil Bracket, Stage 0-1, aLIGO BSC ISI	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	SEI
NEXT ASSY	D0901103	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	DWG. NO.	REV.	
B	D0902426	v1	
SCALE: 1:2	PROJECTION:	SHEET 1 OF 2	

D0902426 Large Vert. Actuator Coil Bracket, Stage 0-1, aLIGO BSC ISI, PART PDM REV: X-008, DRAWING PDM REV: X-008





2X ϕ .27 ∇ .58
 \surd ϕ .35 X 90°, NEAR SIDE
TAP FOR 1/4-20
HELICOIL INSERT = 1.5 * DIA.

2X ϕ .40 ∇ 1.38
TAP FOR 3/8-16
HELICOIL INSERT = 2.0 * DIA.
1 EACH END

ϕ	ϕ .005	C	D	B
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4X ϕ .221 THRU ALL
 \square ϕ .406 ∇ .27

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE B	DWG. NO. D0902426	REV. V1
SCALE: 1:2	PROJECTION: 	SHEET 2 OF 2