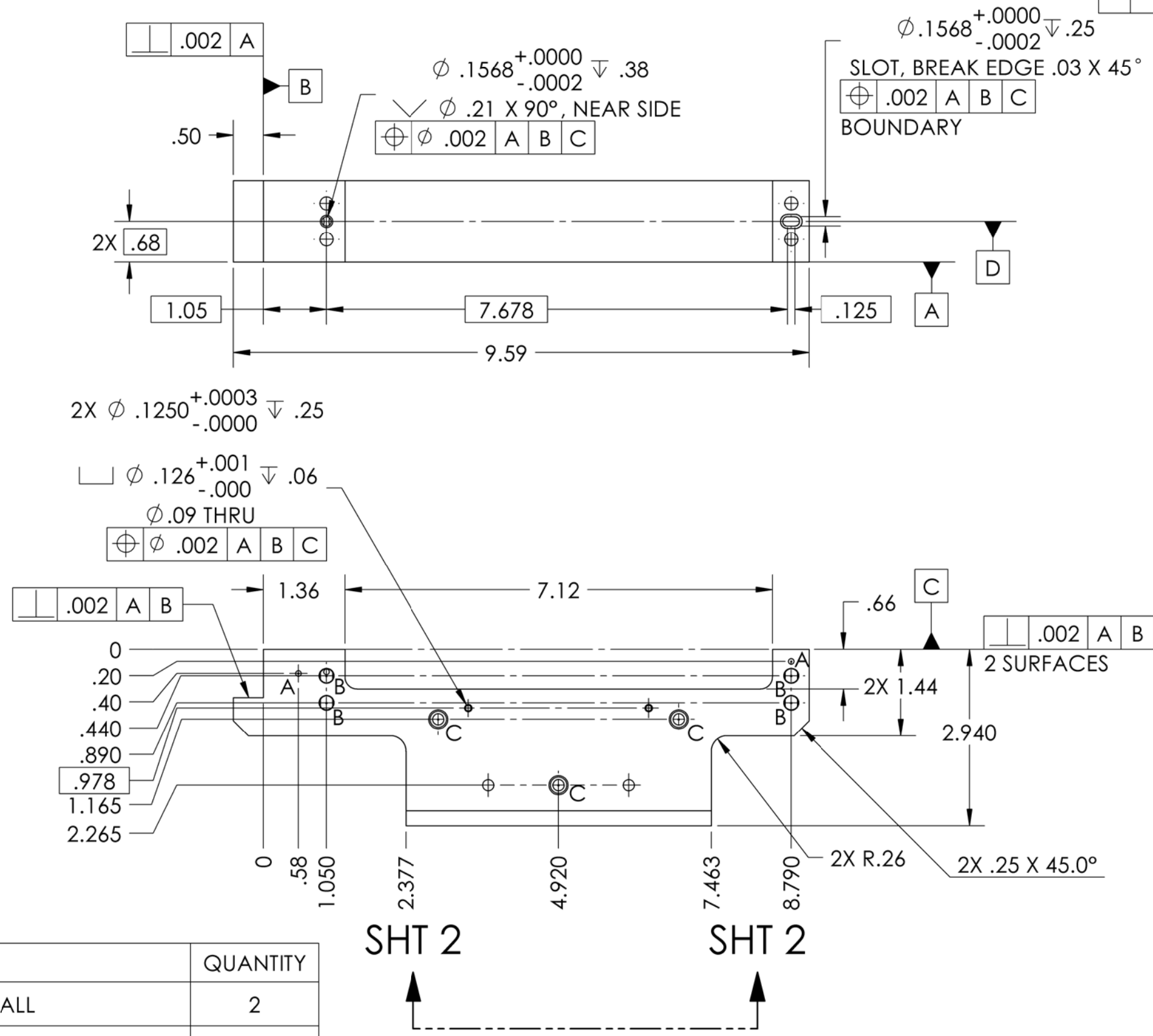


D0902426 Large Vert. Actuator Coil Bracket, Stage 0-1, aLIGO BSC ISI, PART PDM REV: X-011, DRAWING PDM REV: X-012

**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 = 2.012 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
v2	24 Aug. 2010	E1000353	E1000025

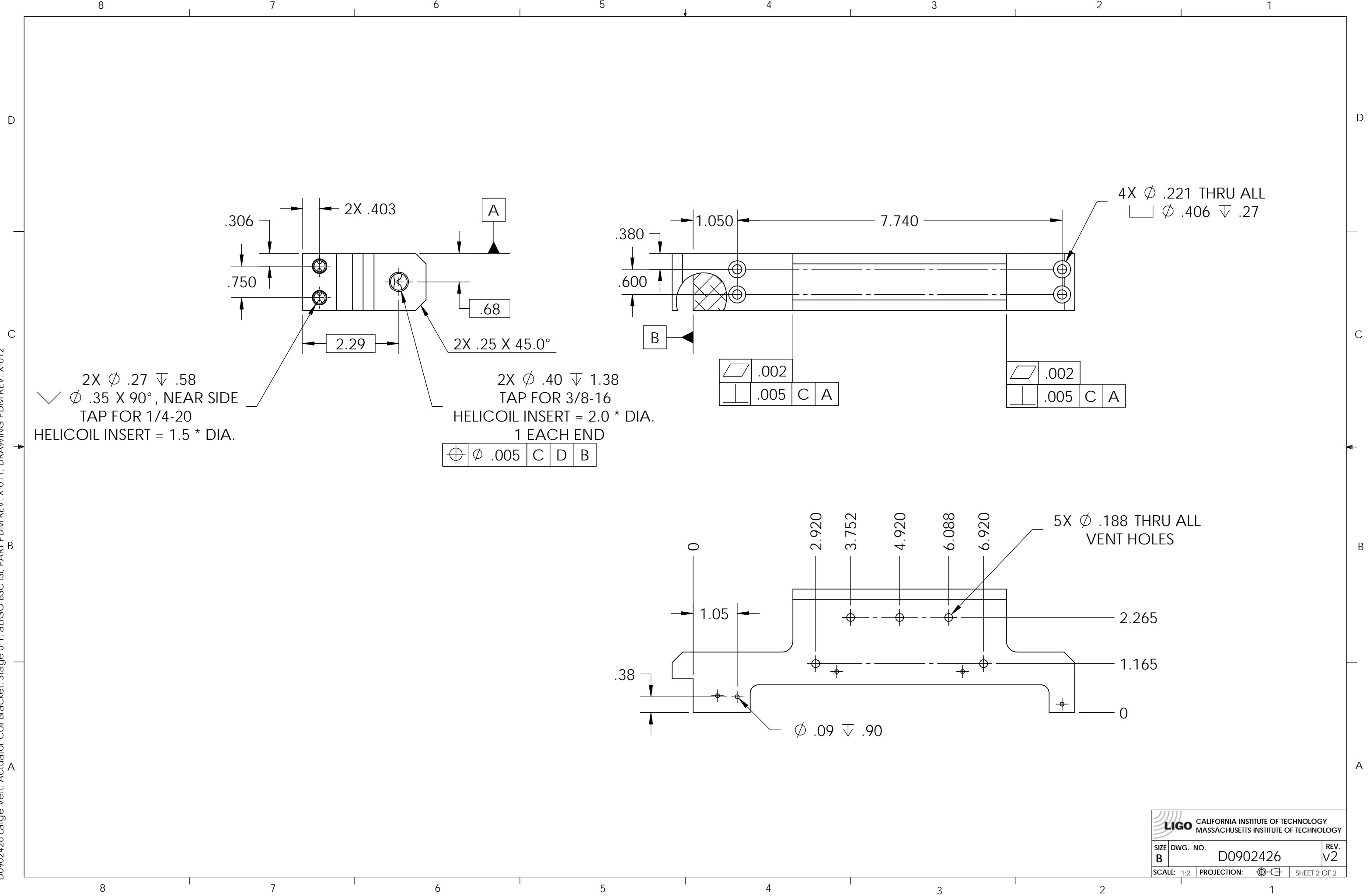


TAG	SIZE	QUANTITY
A	$\phi .09$ THRU ALL	2
B	$\phi .201$ THRU TAP FOR #10-32 HELICOIL INSERT = 1.5 * DIA.	4
C	$\phi .272$ $\nabla .94$ TAP FOR 1/4-20 HELICOIL INSERT = 2.0 * DIA.	3

**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.

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	DESIGNER S.BARNUM	DATE 22 Feb. 2010
NEXT ASSY D0901103	FINISH 63 $\mu$ inch	CHECKER F.MATICHARD	DATE 22 Feb. 2010
MATERIAL 6061-T6 Al	APPROVAL K.MASON	DATE 22 Feb. 2010	SCALE: 1:2
SIZE DWG. NO. <b>B</b> <b>D0902426</b>		REV. v2	SHEET 1 OF 2

D0902426 Large Vert. Actuator Coil Bracket, Stage 0-1, aLIGO BSC ISI, PART PDM REV: X-011, DRAWING PDM REV: X-012





2X  $\phi$  .27  $\nabla$  .58  
 $\checkmark$   $\phi$  .35 X 90°, NEAR SIDE  
TAP FOR 1/4-20  
HELICOIL INSERT = 1.5 \* DIA.

2X  $\phi$  .40  $\nabla$  1.38  
TAP FOR 3/8-16  
HELICOIL INSERT = 2.0 \* DIA.  
1 EACH END  

$\phi$	.005	C	D	B
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4X  $\phi$  .221 THRU ALL  
 $\square$   $\phi$  .406  $\nabla$  .27

5X  $\phi$  .188 THRU ALL  
VENT HOLES

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE B	DWG. NO. D0902426	REV. V2
SCALE: 1:2	PROJECTION: 	SHEET 2 OF 2