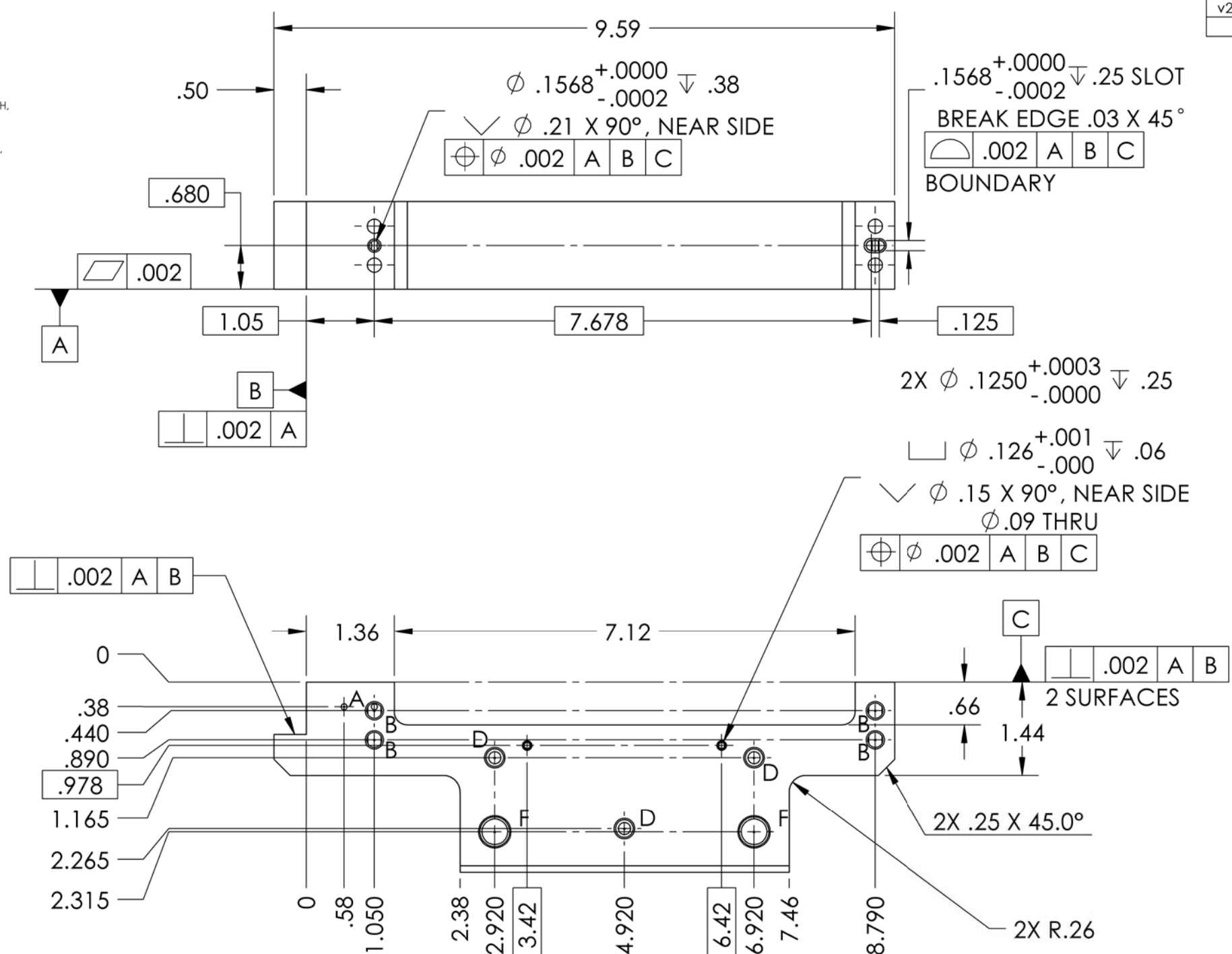


D0902427 Stage0-1 Actuator Coil Bracket - Horizontal, PART PDM REV: X-010, DRAWING PDM REV: X-011

- 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 = 2.046 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 $\pm .005$.

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	1
B	$\phi .201 \downarrow .42$ $\phi .28 \times 90^\circ$, NEAR SIDE TAP FOR #10-32 HELICOIL INSERT = 1.5 * DIA.	4
D	$\phi .272 \downarrow .94$ TAP FOR 1/4-20 HELICOIL INSERT = 2.0 * DIA.	3
F	$\phi .40 \downarrow 1.36$ $\phi .50 \times 90^\circ$, NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA.	2



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

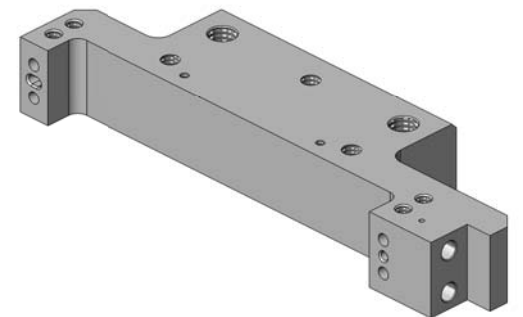
DIMENSIONS ARE IN INCHES

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

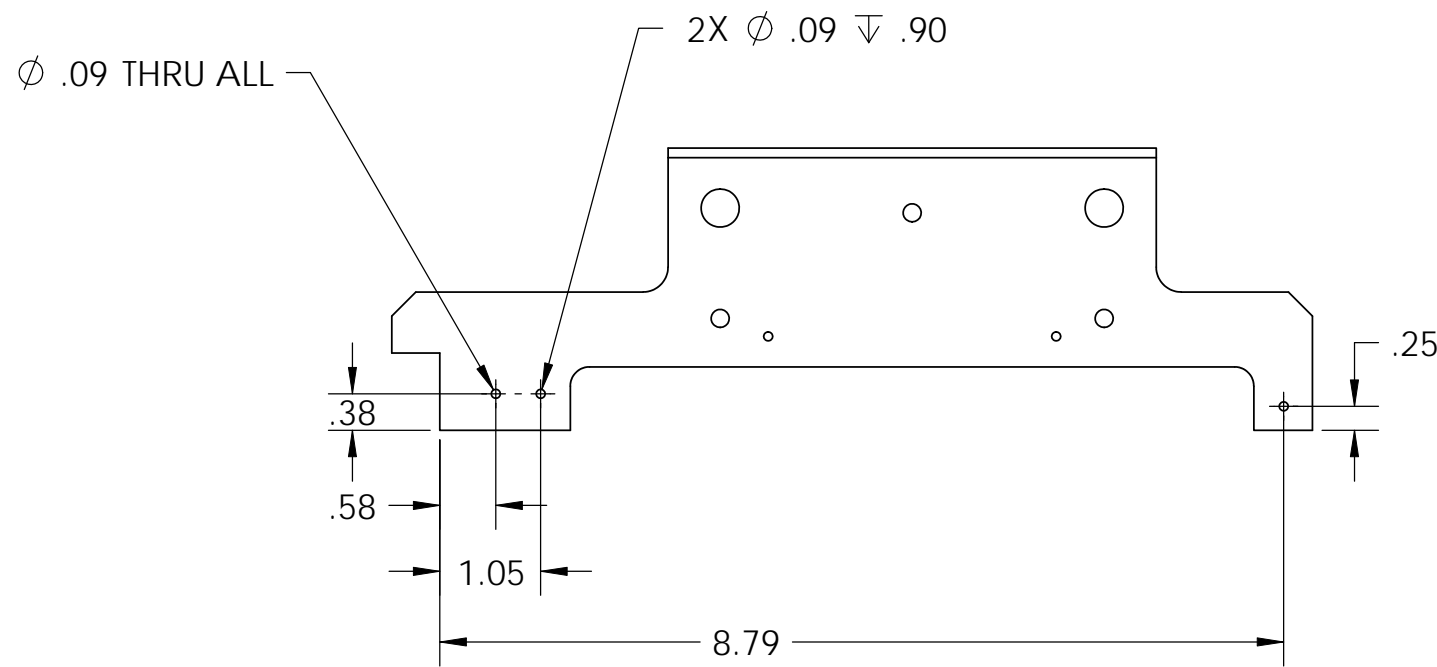
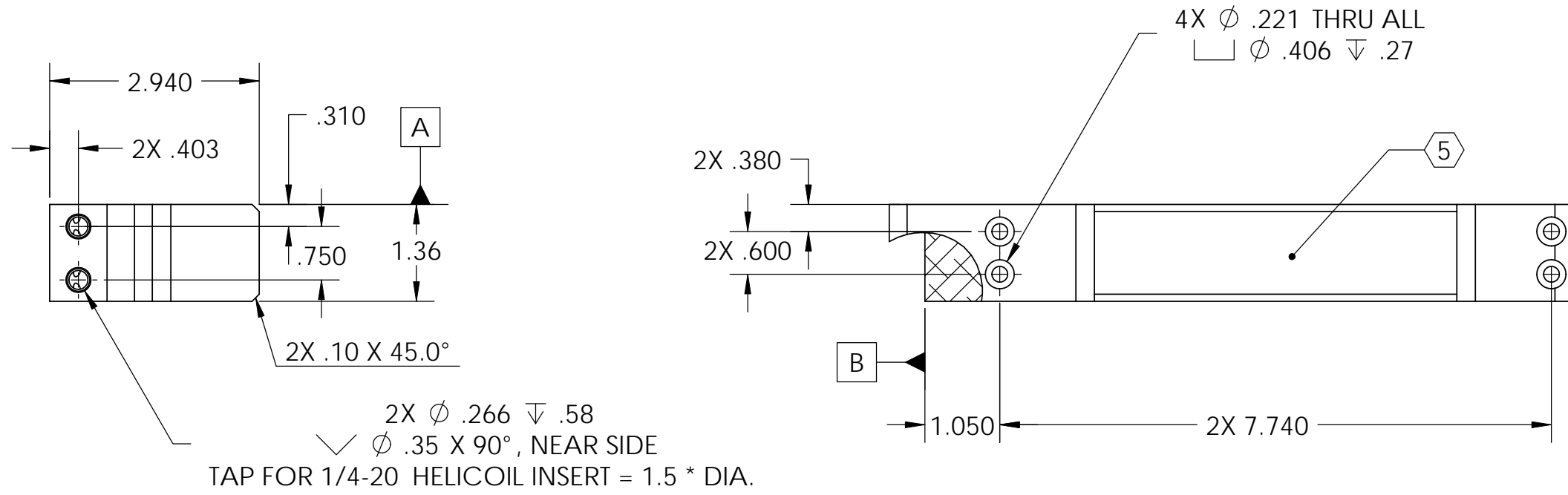
1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES, R.02 MIN.
 3. DO NOT SCALE FROM DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL	6061-T6 Al	FINISH	63 μ inch
----------	------------	--------	---------------

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME ACTUATOR COIL BRACKET HORIZONTAL, STAGE 0-1, aLIGO BSC ISI	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	SEI
DESIGNER	S.BARNUM	22 Feb. 2010	SIZE DWG. NO.
DRAFTER	M.HILLARD	22 Feb. 2010	B D0902427
CHECKER	F.MATICHERD	22 Feb. 2010	REV.
APPROVAL	K.MASON	22 Feb. 2010	v2
SCALE: 1:2		PROJECTION: 	
SHEET 1 OF 2			



D0902427 Stage0-1 Actuator Coil Bracket - Horizontal, PART PDM REV: X-010, DRAWING PDM REV: X-011



 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE B	DWG. NO. D0902427	REV. V2
SCALE: 1:2	PROJECTION:	SHEET 2 OF 2