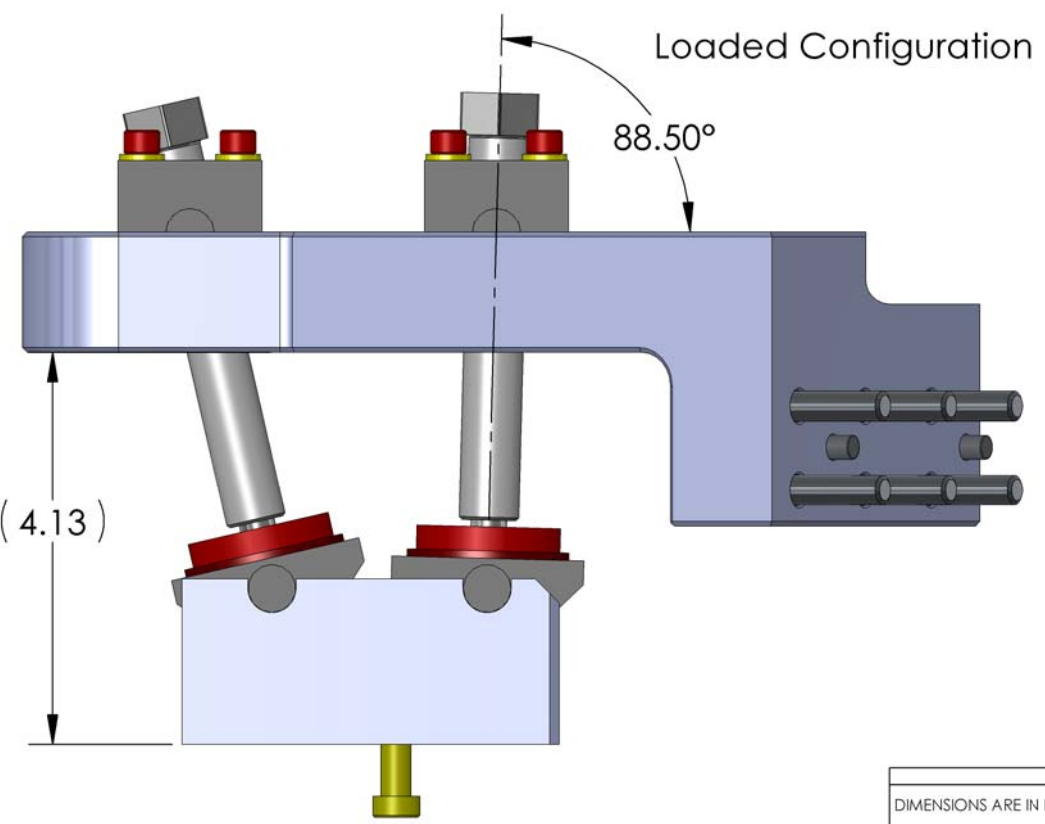
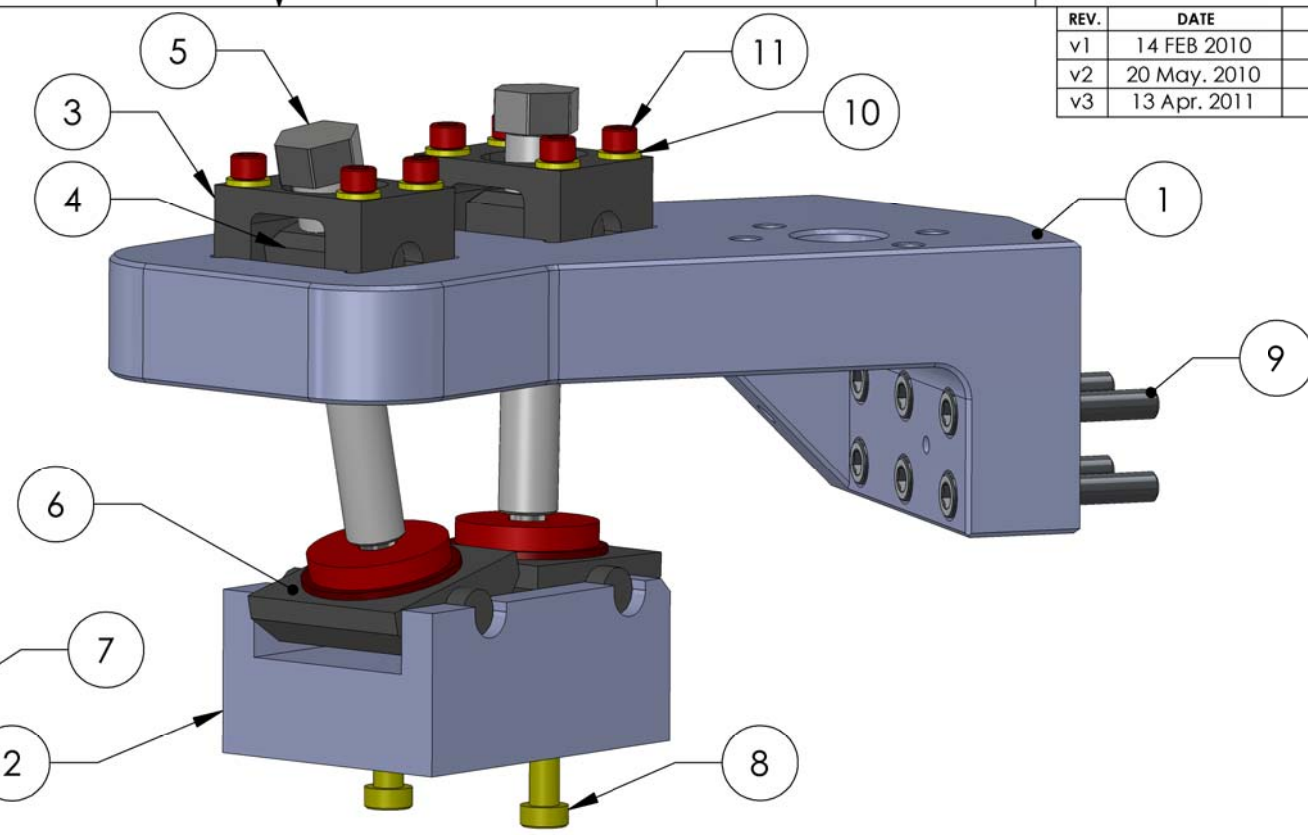
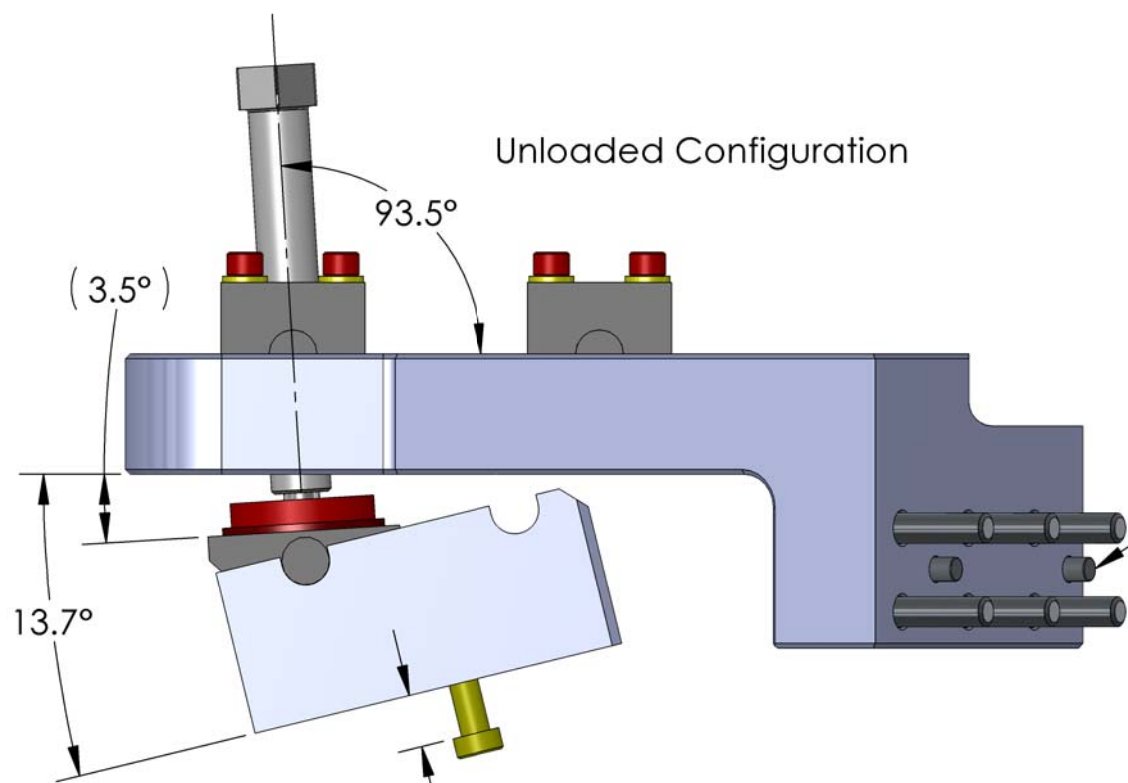


D0902464 Blade Pusher, Blades Loading Tooling, Stage 0-1, aLIGO BSC ISI, PART PDM REV: X-048, DRAWING PDM REV: X-010

NOTES CONTINUED:
 5. VENDOR REFERENCES ARE PROVIDED AS EXAMPLES OF PARTS ALL REQUIRED SPECIFICATIONS. EQUIVALENTS ARE ALWAYS ACCEPTABLE UNLESS OTHERWISE SPECIFIED.
 6. REFER TO LIGO DOC E0900357 FOR THE ASSEMBLY AND LOADING PROCEDURE.

REV.	DATE	DCN #	DRAWING TREE #
v1	14 FEB 2010	E1000028	E1000025
v2	20 May, 2010	E1000174	E1000025
v3	13 Apr. 2011	E1000662	E1000025



11	Holokrome_78068	SCREW, SHCS 1/4-20 x 1.75 lg.	304, 316 OR 302 SSTL	8
10	McMASTER_90945A761	WASHER .26 ID X .47 OD X .06-.07 THK (NAS 620-C416)	300 SSTL	8
9	Holokrome_78088	SHCS 5/16-18 x 2 lg	18-8 SS	6
8	McMaster_94035A306	Shoulder Screw, 1/4"-20, 5/16" x 3/4"L, 18-8 SS	18-8 SSTL	2
7	McMaster_90145A539	Dowel Pin 1/4" (.2501) x 5/8" L 18.8 SST	18-8 Stainless	2
6	D0902593	Pusher Pivot Assembly, Stage 0-1 Blade Pusher, aLIGO BSC-ISI	N/A	2
5	D0902599	STEP 1 BOLT, STAGE 0-1 BLADE PUSHER, aLIGO BSC-ISI	420 SSTL	2
4	D0902594	THREADED PIVOT, STAGE 0-1 BLADE PUSHER, aLIGO BSC-ISI	NITRONIC 60	2
3	D0902200	Top Saddle on Bracket, Stage 0-1 Blade Pusher, aLIGO BSC-ISI	NITRONIC 60	2
2	D0902483	SADDLE ON LARGE BLADES, STAGE 0-1 BLADE PUSHER, aLIGO BSC ISI	304 SSTL	1
1	D0902488	TOOLING BRACKET, BLADES PUSHER STG 0-1 & BLADES PULLER STG 1-2, aLIGO BSC ISI	304 SSTL	1
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	Default/REQ

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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.

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± n/a
 .XXX ± n/a
 ANGULAR ± n/a°

MATERIAL: N/A

FINISH: N/A μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: Stage0-1 Blade Pusher, aLIGO BSC-ISI Blades Loading Tooling	
SYSTEM: ADVANCED LIGO SUB-SYSTEM: SEI	DESIGNER: C.RAMET DRAFTER: F.MATICHARD CHECKER: F.MATICHARD APPROVAL: K.MASON	DATE: 14 FEB 2010 DATE: 14 FEB 2010 DATE: 14 FEB 2010 DATE: 14 FEB 2010	SIZE: B DWG. NO.: D0902464 SCALE: 1:3 PROJECTION:
NEXT ASSY: D0901182	REV: v3	SHEET 1 OF 1	