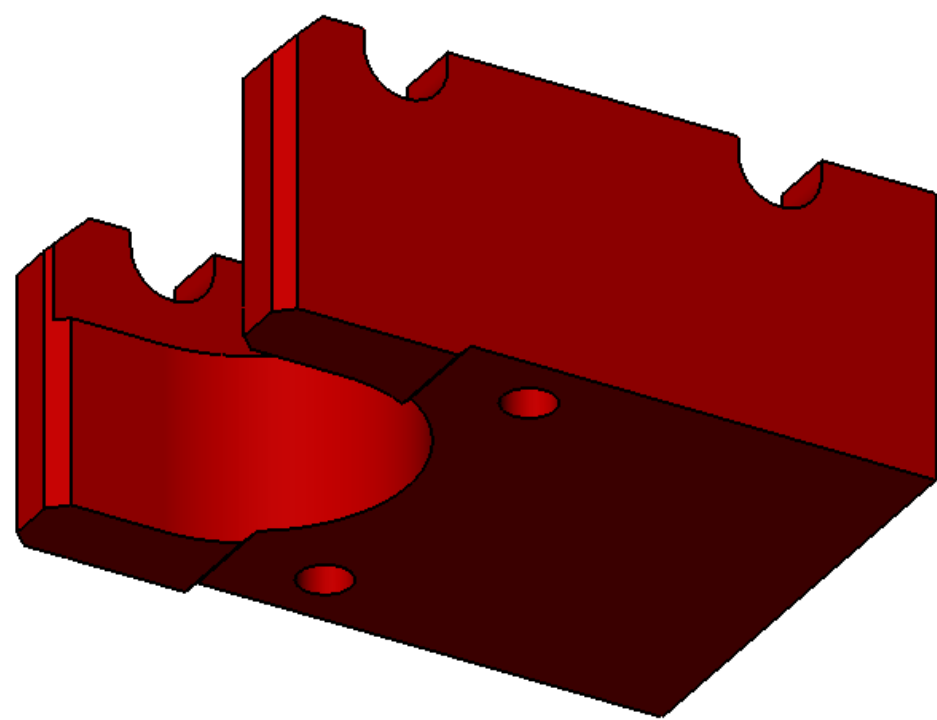
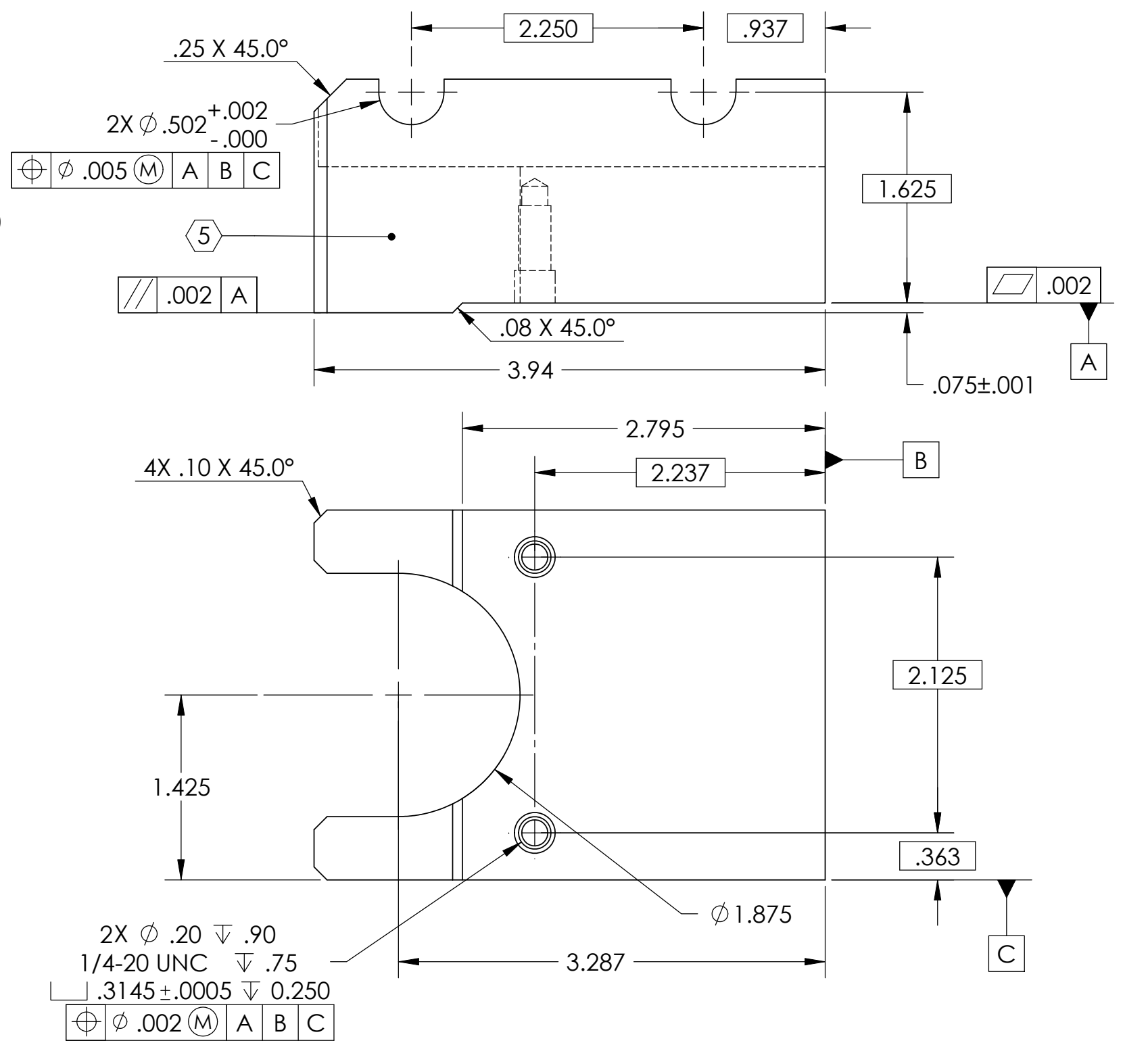
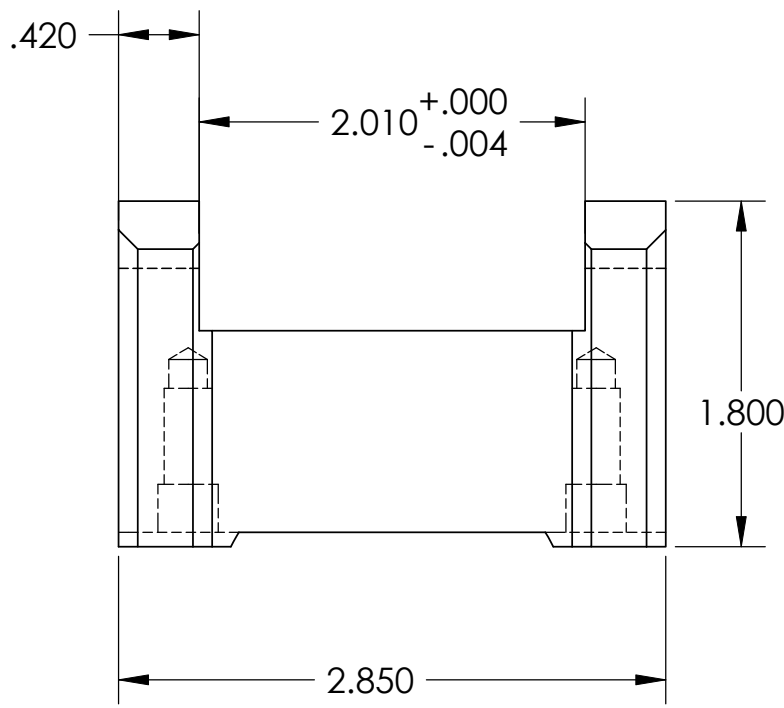


D0902483 Saddle on Large Blades, Stage 0-1 Blade Pusher, aLIGO BSC-ISI, PART PDM REV: X-012, DRAWING PDM REV: X-007

REV.	DATE	DCN #	DRAWING TREE #
v1	14 FEB 2010	E1000028	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. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.  
 7. APPROXIMATE WEIGHT: 3.2LB.  
 8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH.  
 9. ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME SADDLE ON LARGE BLADES, STAGE 0-1 BLADE PUSHER, aLIGO BSC ISI								
DIMENSIONS ARE IN INCHES				1. INTERPRET DRAWING PER ASME Y14.5-1994.		SYSTEM ADVANCED LIGO		SUB-SYSTEM SEI		DESIGNER C.RAMET	9 Feb. 2010	SIZE DWG. NO. B	D0902483	REV. v1
TOLERANCES: .XX ± .015 .XXX ± .005				2. REMOVE ALL SHARP EDGES, R.02 MIN.		NEXT ASSY D0902464		DRAFTER M.HILLARD		14 FEB 2010		SCALE: 1:1		
ANGULAR ± 0.5°				3. DO NOT SCALE FROM DRAWING.		MATERIAL 304 SSSL		CHECKER F.MATICHARD		14 FEB 2010		PROJECTION:		
				4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		FINISH 32 μinch		APPROVAL K.MASON		14 FEB 2010		SHEET 1 OF 1		