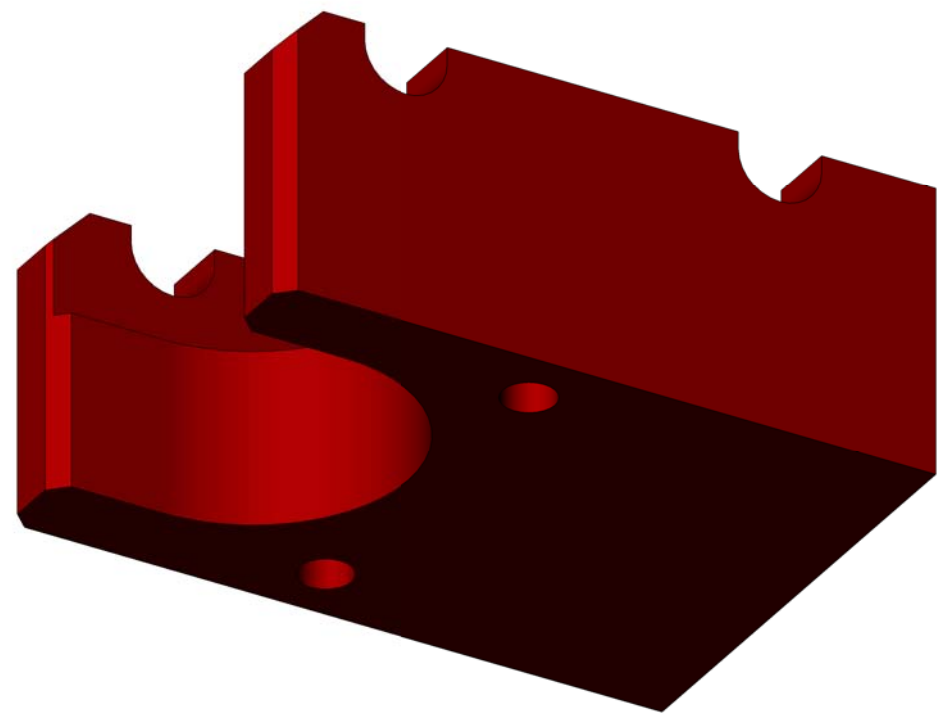
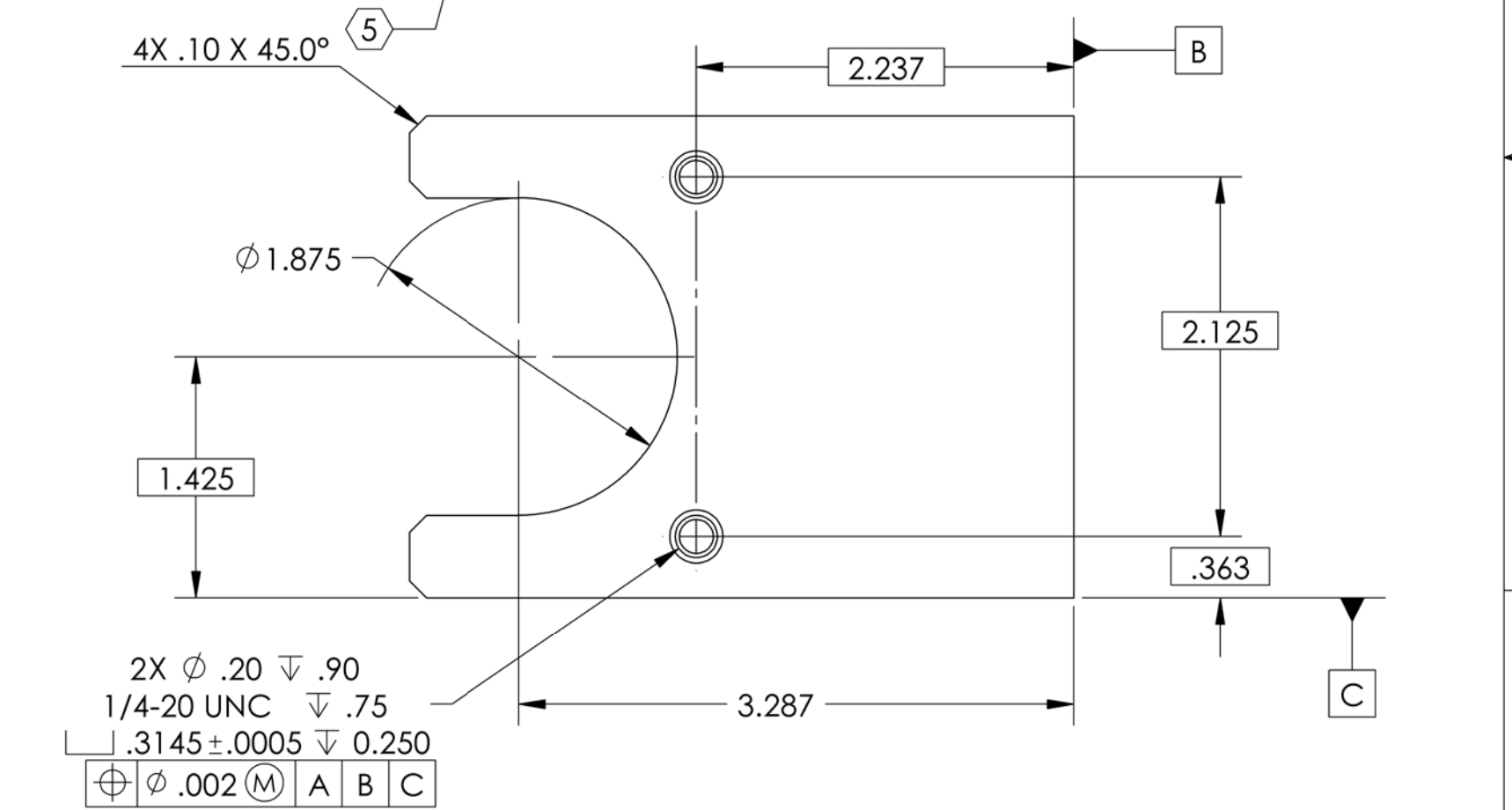
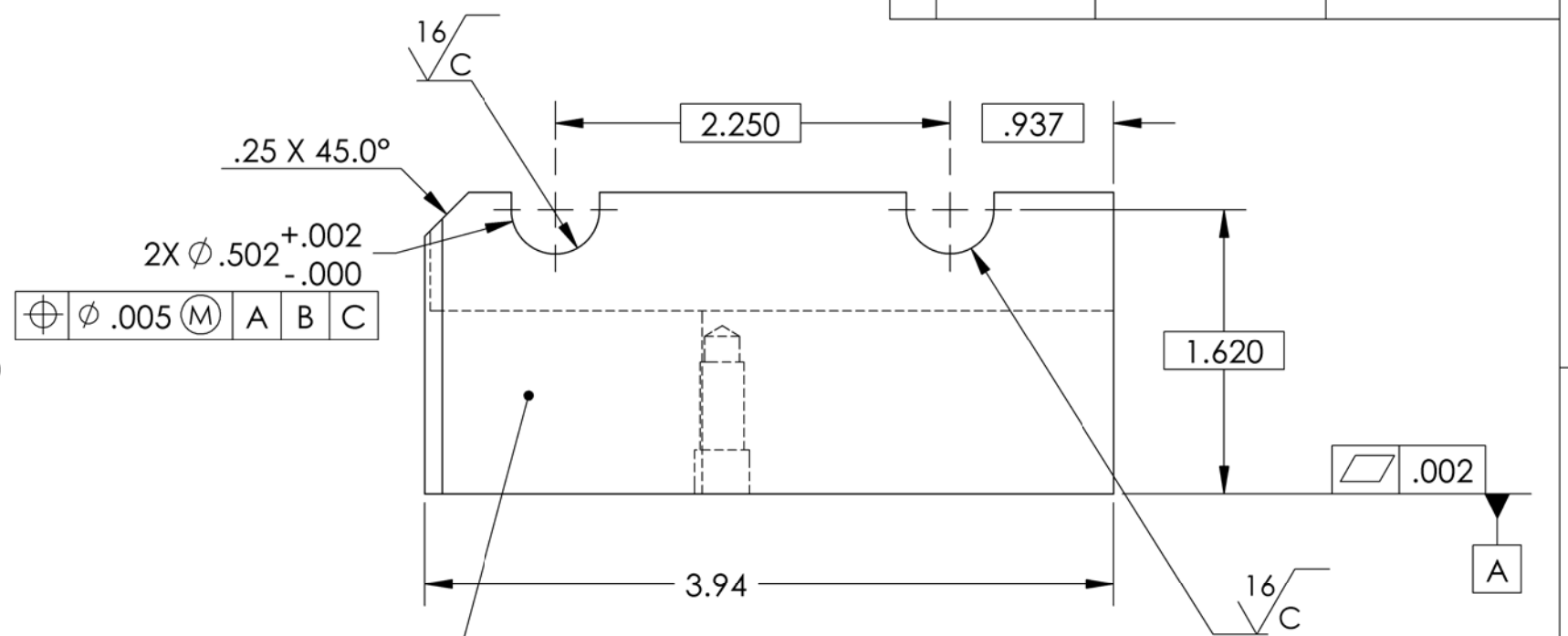
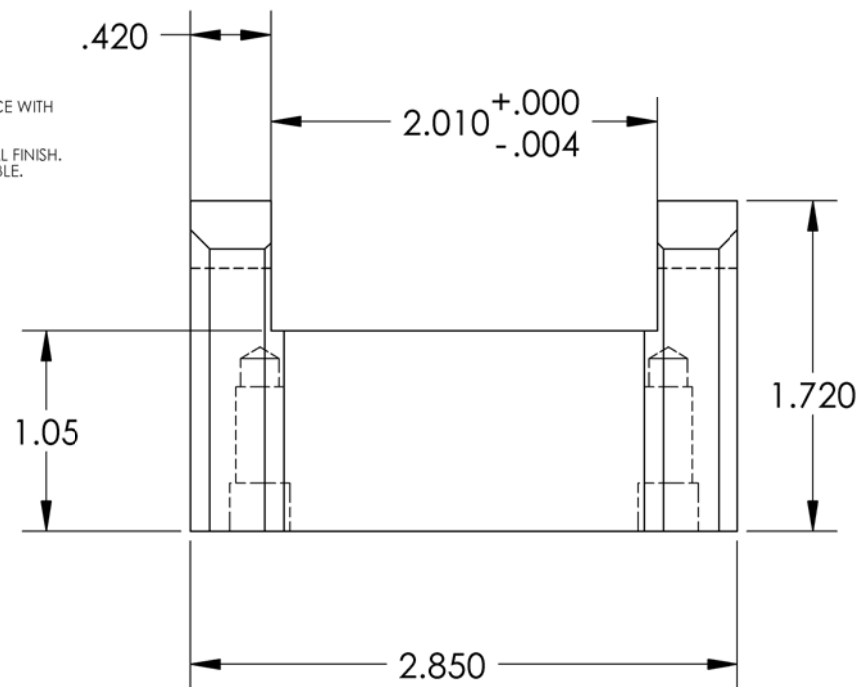


D0902483 Saddle on Large Blades, Stage 0-1 Blade Pusher, aLIGO BSC-ISI, PART PDM REV: X-013, DRAWING PDM REV: X-008

REV.	DATE	DCN #	DRAWING TREE #
v1	14 Feb. 2010	E1000028	E1000025
v2	20 May, 2010	E1000174	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: DXXXXXXX-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.		DESIGNER C.RAMET		9 Feb. 2010		SIZE DWG. NO.	
TOLERANCES: .XX ±.015 .XXX ±.005				2. REMOVE ALL SHARP EDGES, R.02 MIN.		DRAFTER M.HILLARD		14 FEB 2010		B D0902483	
ANGULAR ± 0.5°				3. DO NOT SCALE FROM DRAWING.		CHECKER F.MATICHARD		14 FEB 2010		REV. v2	
				4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		APPROVAL K.MASON		14 FEB 2010		SCALE: 1:1 PROJECTION: SHEET 1 OF 1	
MATERIAL 304 SSTL				FINISH 32 μinch		NEXT ASSY D0902464					