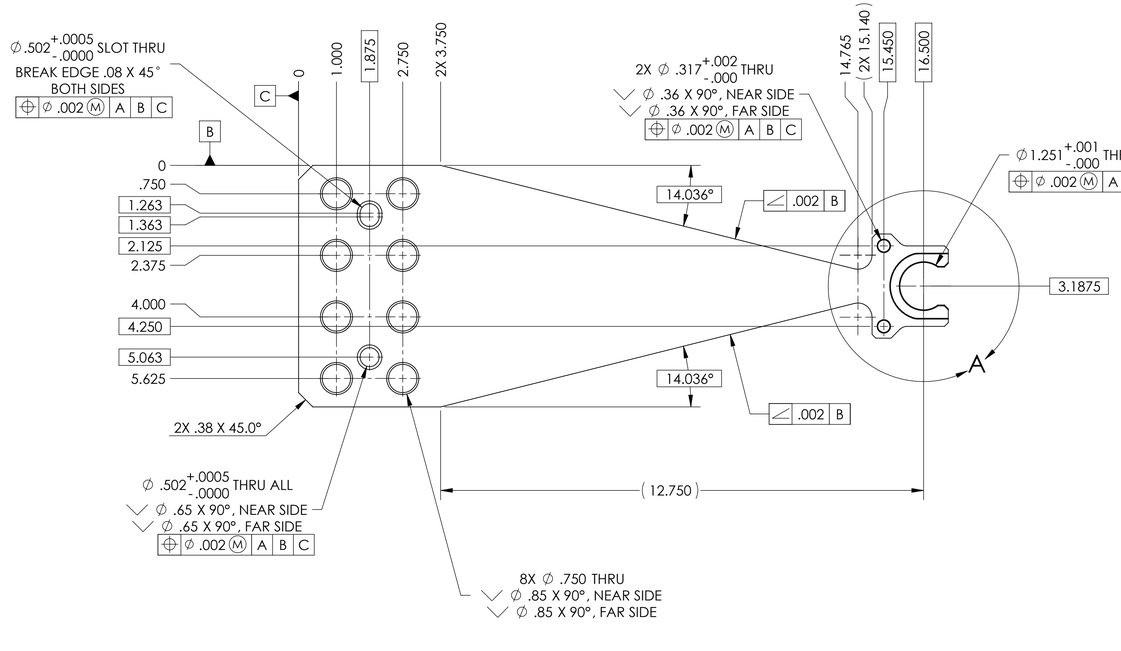
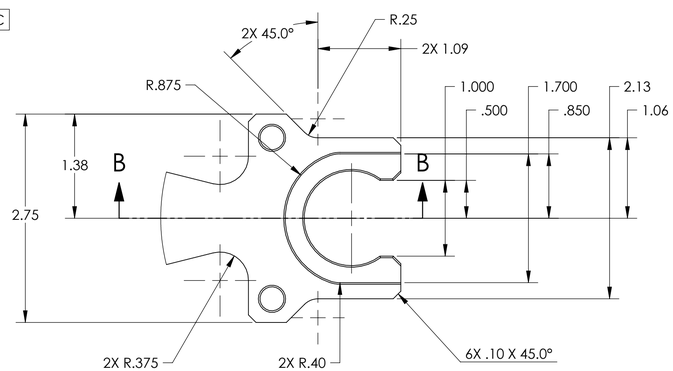
NOTES CONTINUED:

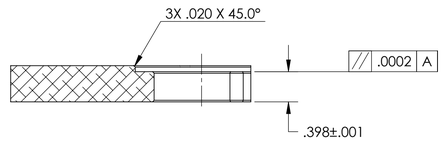
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICAL AND PROCEED CONSECUTIVELY. USE .07 HIGH CHARACTERS. EXAMPLE DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.
6. APPROXIMATE WEIGHT = 8.722 LB.
7. A TRUE POSITION TOLERANCE OF ∅.010 IS ~ THE SAME AS A CONVENTIONAL TOLERANCE OF ±.005.
8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
9. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
10. PROCESS MARAGING C300 STEEL IN ACCORDANCE WITH WITH LIGO SPECIFICATION E0900023.
11. DIMENSIONS AND TOLERANCES APPLY AFTER FINAL OPERATIONS OF HEAT TREATMENT AND MACHINING.

REV.	DATE	DCN #	DRAWING TREE #
v1	01 Mar. 2010	E1000026	E1000025

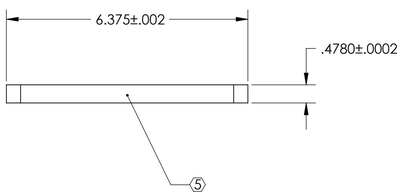


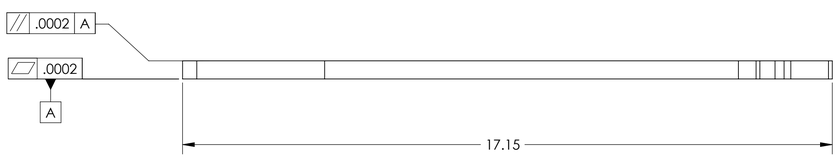


DETAIL A
SCALE 1 : 1



SECTION B-B
SCALE 1 : 1





NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)											
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± .5°	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.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: Blade Spring, Stage 1-2, aLIGO BSC ISI						
	MATERIAL: MARAGING STEEL C300	FINISH: 32 µinch	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: SEI	NEXT ASSY: D0902485	DESIGNER	A.STEIN	01 Feb. 2010	SIZE: D	DWG. NO.: D0902502	REV.: v1
						DRAFTER	M.HILLARD	01 Feb. 2010			
						CHECKER	F.MATICHARD	01 Feb. 2010			
						APPROVAL	K.MASON	01 Feb. 2010	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1

D0902502-v1 Blade Spring, Stage 1-2, aLIGO BSC ISI, PART PDM REV= X-000, DRAWING PDM REV= X-010