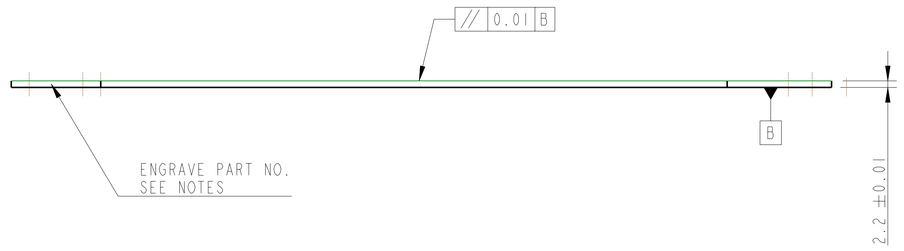
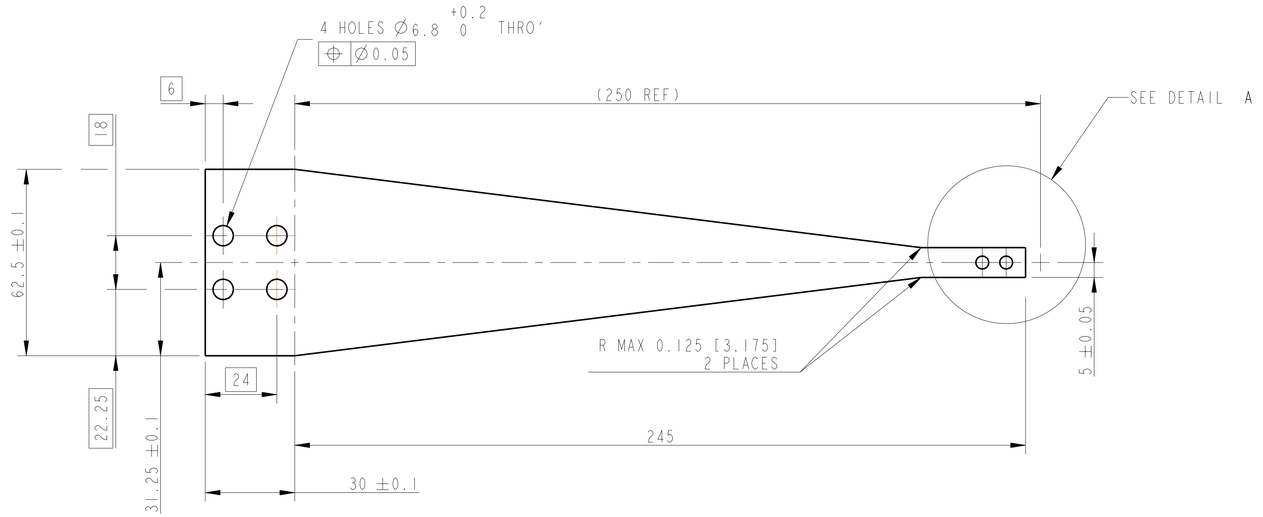
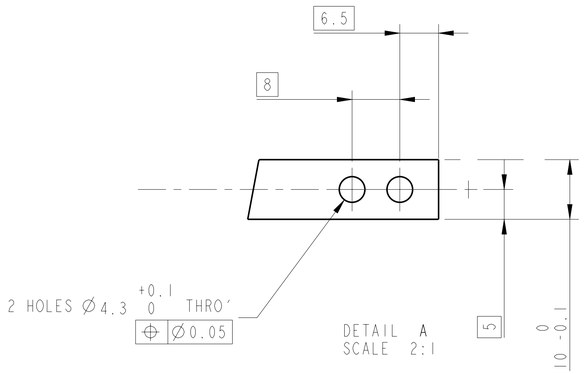
INTRALINK NAME: D080513-A

REV.	DATE	DCN #	DRAWING TREE #
A	.	.	.
B	.	.	.
C	.	.	.

FLAT PROFILE







DETAIL A
SCALE 2:1

NOTES: (UNLESS OTHERWISE SPECIFIED)

1. DO NOT SCALE FROM DRAWING.
2. INTERPRET DIMENSIONS PER: ANSI Y14.5 1982
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).
4. FABRICATE FROM SHEET MATERIAL; FORM RADIUS BY ROLLING.
5. REMOVE ALL SHARP EDGES, 0.02 MIN.
6. SCRIBE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: D020AR-001. A VIBRATORY TOOL MAY BE USED.
7. AFTER PARTS ARE ROLLED TO RADIUS, HARDEN FOR HEAT TREATMENT AT 435 DEG C FOR 10 HOURS AND AIR COOL. PARTS MUST BE SUPPORTED WITH TOOLING DURING HEAT TREATMENT TO AVOID RADIUS CHANGE DUE TO SELF WEIGHT. TOOLING FOR HEAT TREATMENT MAY BE A "DRAG RACK" TYPE OF TOOL THAT WILL ALLOW THE PARTS TO BE MOUNTED ON THEIR SIDES. PARTS MAY BE ROLLED AGAIN AFTER HEAT TREATMENT TO ADJUST RADIUS TO SPECIFICATION.

DIMENSIONS ARE IN mm
TOLERANCES:
X.XX ± 0.25 mm
X.XXX ±0.05
ANGULAR ±0.25 °

MATERIAL: MARAGING STEEL 250

FINISH: CLEAN AND DEGREASED
√(µm (µin)) Ra := 0.8

	NAME	DATE
DRAWN	I. WILMUT	5/NOV/07
CHECKED	R.JG	5/NOV/07
APPROVED	R.JG	--/--/--

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
IGR, GLASGOW UNIVERSITY GEO 600 GROUP
RUTHERFORD APPLETON LABORATORIES

SYSTEM ADVANCED LIGO

SUB-SYSTEM SUS

NEXT ASSY BS & FM SUS TOP STAGE

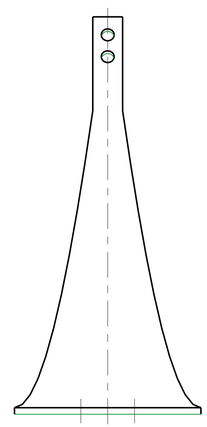
PART NAME TOP STAGE BLADE SPRING
-

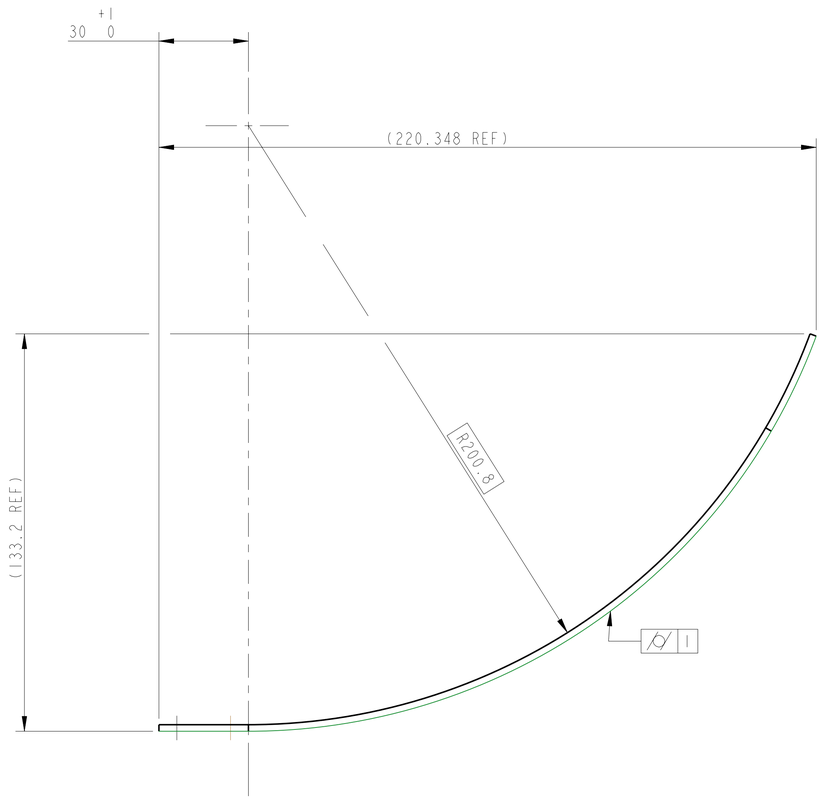
SIZE D | DRG. NO. D080513 | REV E

SCALE 1:1 | PROJECTION: | SHEET 1 OF 2

INTRALINK NAME: D080513-A

FORMED BLADE SPRING





NOTES: (UNLESS OTHERWISE SPECIFIED)

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4. FABRICATE FROM SHEET MATERIAL; FORM RADIUS BY ROLLING.
5. REMOVE ALL SHARP EDGES, R.02 MIN.
6. SCRIBE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: D020188-001. A VIBRATORY TOOL MAY BE USED.
7. AFTER PARTS ARE ROLLED TO RADIUS, HARDEN FOR HEAT TREATMENT AT 415 DEG C FOR 3 HOURS AND AIR COOL. PARTS MUST BE SUPPORTED WITH TOOLING DURING HEAT TREATMENT TO AVOID RADIUS CHANGE DUE TO SELF WEIGHT. TOOLING FOR HEAT TREATMENT MAY BE A "BIKE RACK" TYPE OF TOOL THAT WILL ALLOW THE PARTS TO BE MOUNTED ON THEIR SIDES. PARTS MAY BE ROLLED AGAIN AFTER HEAT TREATMENT TO ADJUST RADIUS TO SPECIFICATION.

DIMENSIONS ARE IN mm
TOLERANCES:
X.XX ± 0.25 mm
X.XXX ±0.05
ANGULAR ±0.25 °

MATERIAL: MARAGING STEEL 250

FINISH: CLEAN AND DEGREASED
ųm (µin) Ra = 0.8

	NAME	DATE
DRAWN	I WILMUT	5/NOV/07
CHECKED	RJG	5/NOV/07
APPROVED	RJG	--/---/--

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RUTHERFORD APPLETON LABORATORIES

SYSTEM ADVANCED LIGO

SUB-SYSTEM SUS

NEXT ASSY BS & FM SUS TOP STAGE

PART NAME TOP STAGE BLADE SPRING
-

SIZE D | DRG. NO. D080513 | REV E

SCALE 1:1 | PROJECTION: | SHEET 2 OF 2