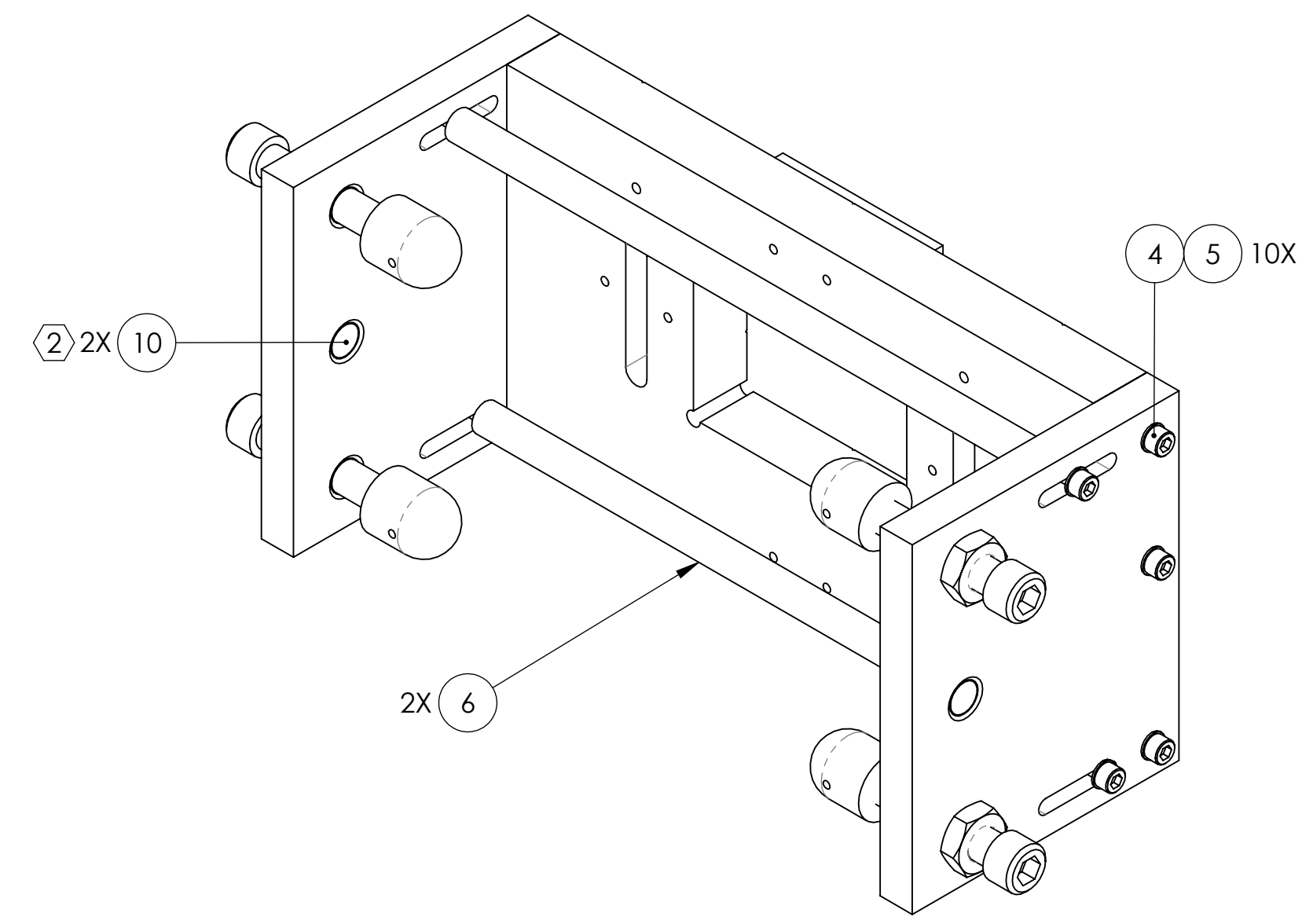
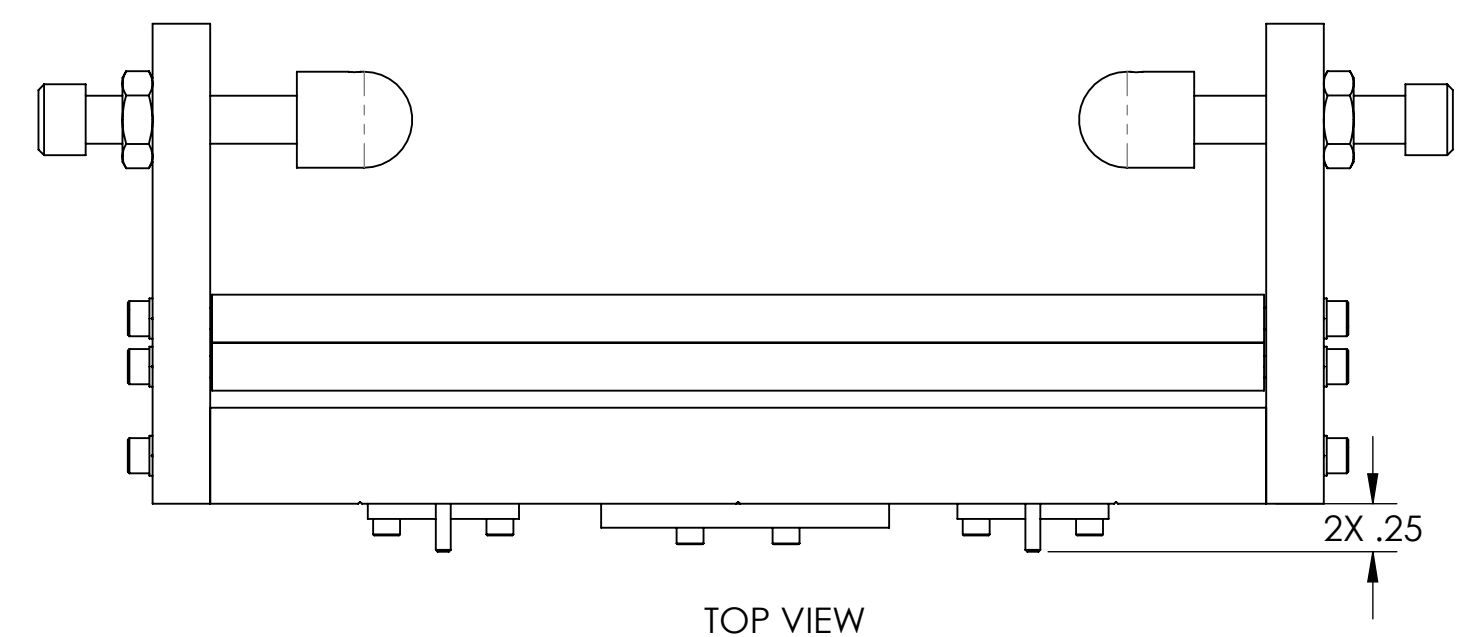
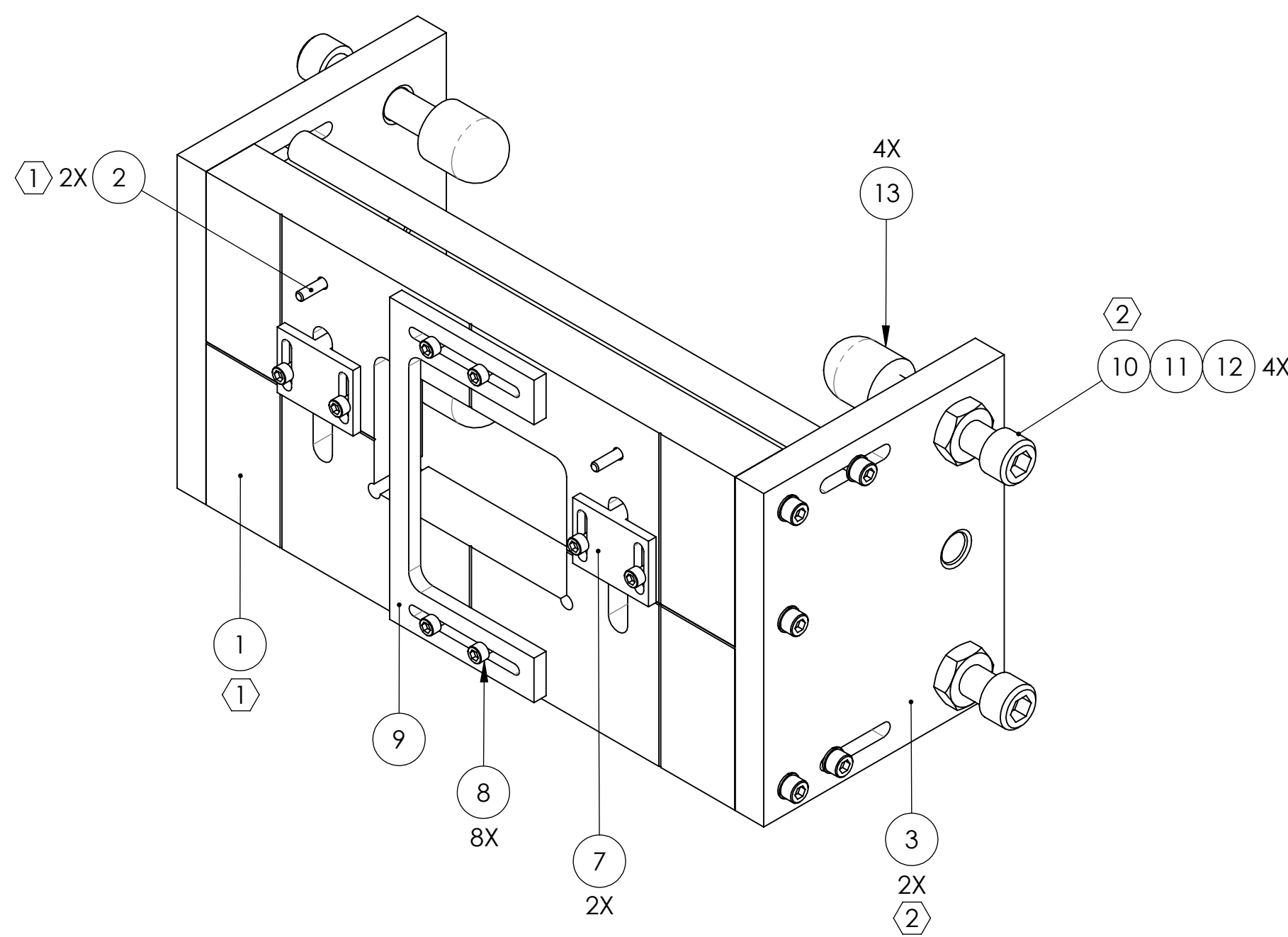


REV.	DATE	DCN #	DRAWING TREE #
v1	22 OCT 2009	E0900369	E080191
v2	02 SEP 2011	E1100826	E080191
-	-	-	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
13	D1101648	CAP BODY, ROUNDED END, EARTHQUAKE STOP	PFA440 HP (Preshrunk)	4	1	5
12	-	JAM NUT, 1/4-20	300 SSTL	4	1	5
11	-	SCREW, SOCKET HEAD CAP, 1/4-20 UNC-2A X 1.5 LONG, FULLY THREADED	300 SSTL	4	1	5
10	1185-4EN250	HELICOIL, 1/4-20 X 0.25 LONG (2)	NITRONIC 60	6	3	9
9	D0902721	SAPPHIRE PRISM HOLDER GUIDE	6061-T6 Al	1	0	1
8	-	SCREW, SOCKET HEAD CAP, #2-56 UNC-2A X 0.375 LONG	300 SSTL	8	2	10
7	D080409	ALIGNMENT GUIDE	6061-T6 Al	2	0	2
6	D0902669	SUPPORT CYLINDER	PFA440 HP (Preshrunk)	2	1	3
5	-	WASHER, FLAT, VENTED, #4 (U-C COMPONENTS P/N WFV-04 OR EQUIVALENT)	300 SSTL	10	2	12
4	-	SCREW, SOCKET HEAD CAP, #4-40 UNC-2A X 0.5 LONG	300 SSTL	10	2	12
3	D0902666	BONDING TEMPLATE SIDE (2)	6061-T6 Al	2	0	2
2	91585A018	DOWEL PIN, ϕ 2 mm X 10 mm LONG (MCMMASTER CARR P/N) (1)	300 SSTL	2	1	3
1	D0902665	BONDING TEMPLATE FRONT (1)	6061-T6 Al	1	0	1
PARTS LIST						

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

(1) PRESS FIT DOWEL PINS INTO HOLES AS SHOWN AFTER ALL PARTS ARE CLEANED AND BAKED.

(2) HELICOILS TO BE INSTALLED INTO ITEM NO. 3 BY LIGO PERSONNEL PRIOR TO ASSEMBLY AND AFTER ALL PARTS ARE CLEANED AND BAKED.

MATERIAL N/A

FINISH N/A μ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME SAPPHIRE PRISM BONDING FIXTURE

SYSTEM ADVANCED LIGO **SUB-SYSTEM** SUS

DESIGNER D. BRIDGES 02 SEP 2011 **SIZE** DWG. NO. **REV.** v2

DRAFTER D. BRIDGES 02 SEP 2011 **c** **D0902662**

CHECKER B. MOORE 06 SEP 2011

APPROVAL _____

SCALE: 1:1 **PROJECTION:** SHEET 1 OF 1