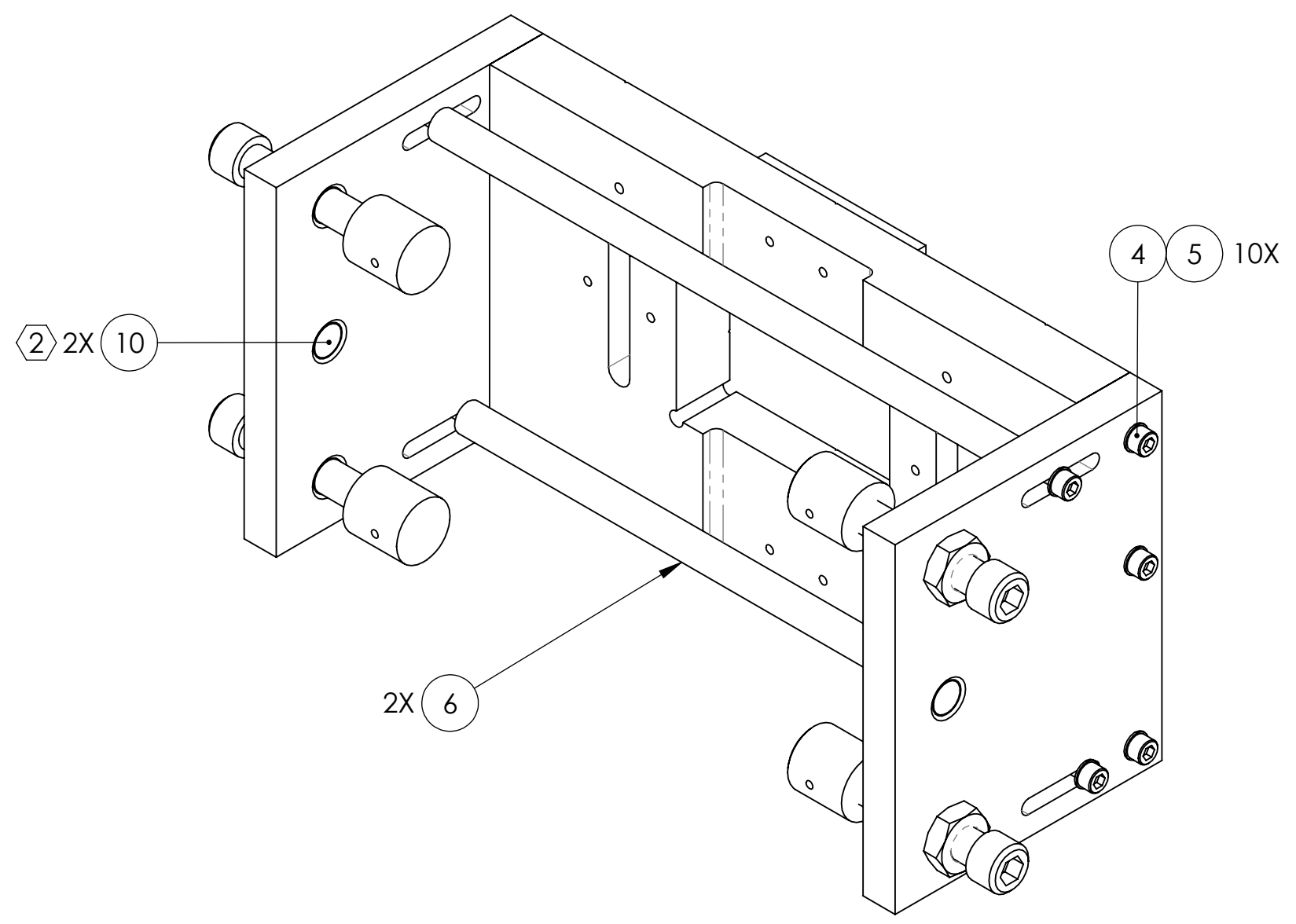
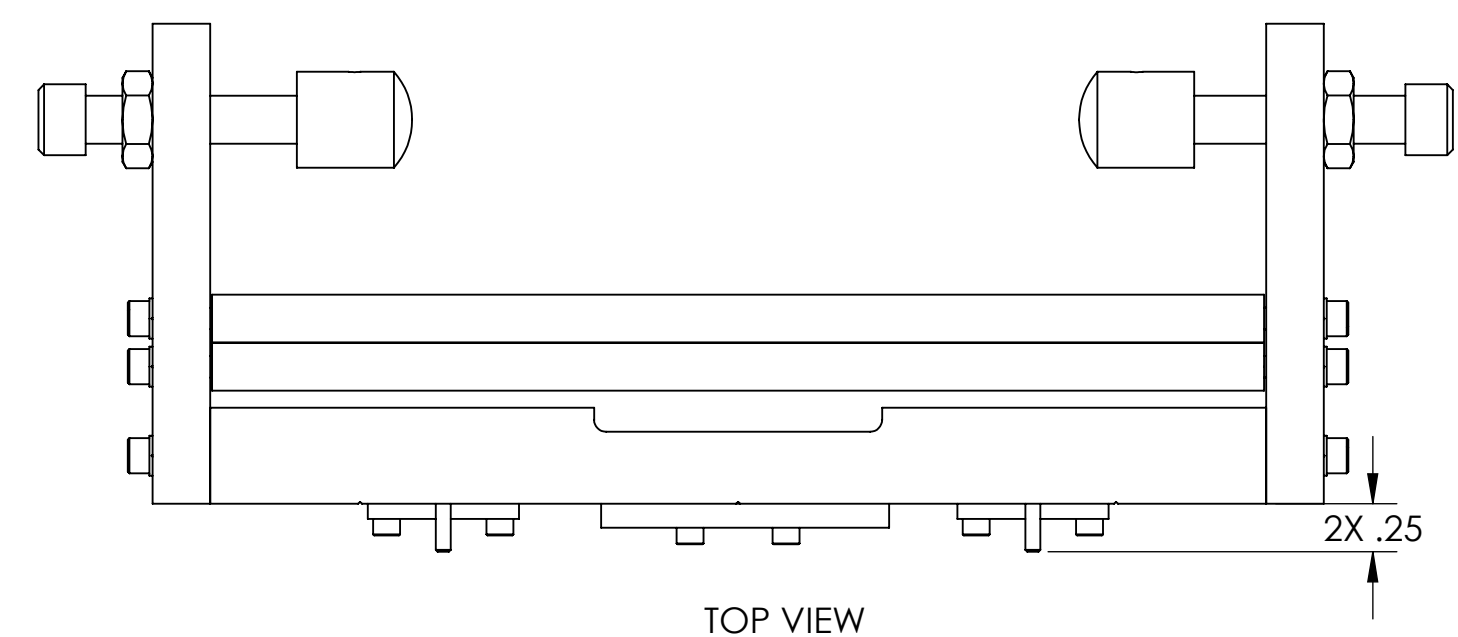
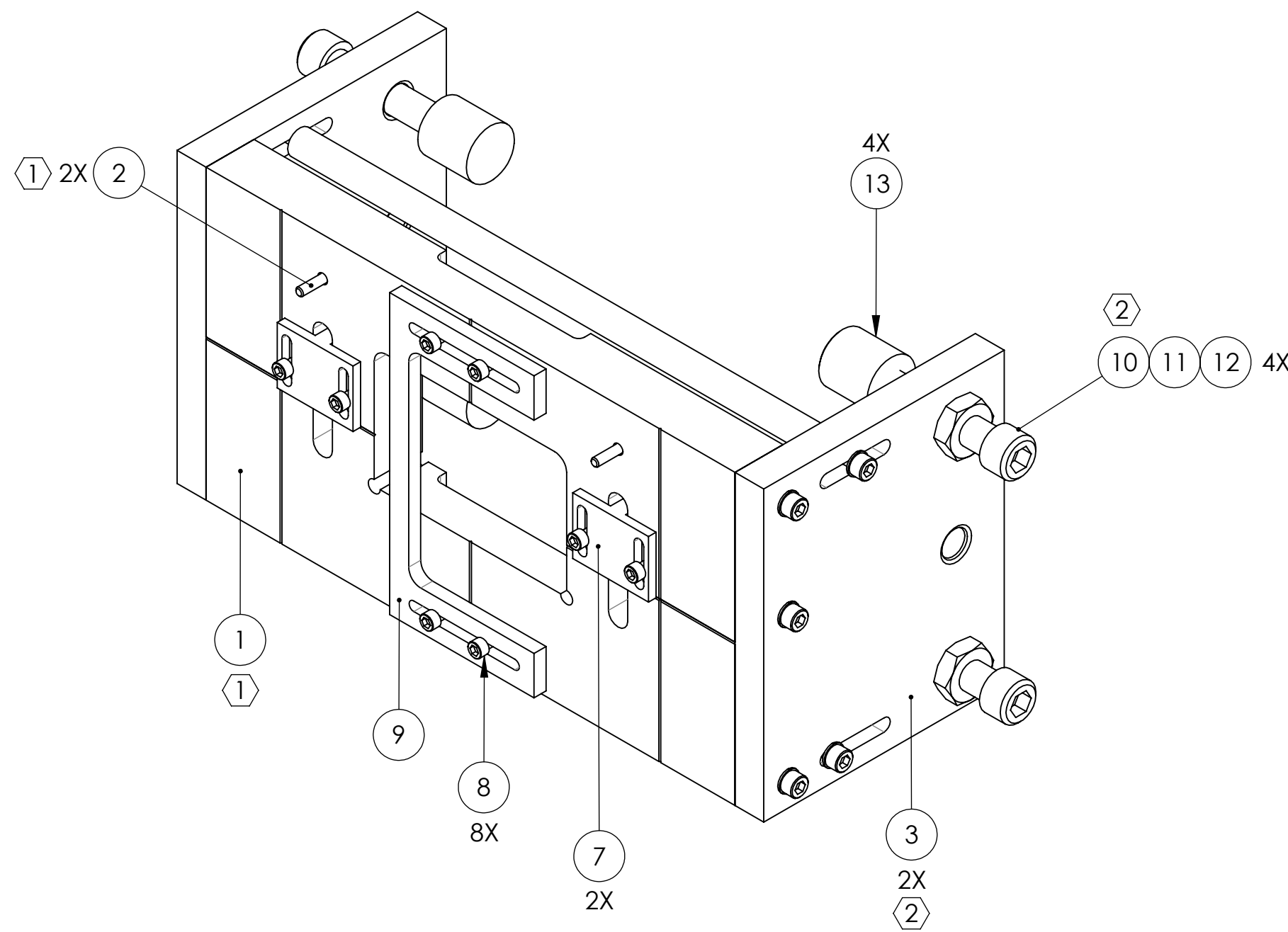


REV.	DATE	DCN #	DRAWING TREE #
v1	22 OCT 2009	E0900369	E080191
v2	02 SEP 2011	E1100826	E080191
v3	14 DEC 2011	E1101195	E080191



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
13	D1102161	CAP BODY, SEMI-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

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

SYSTEM
ADVANCED LIGO

SUB-SYSTEM
SUS

NEXT ASSY
SAPPHIRE PRISM BONDING JIG, HLTS

PART NAME
SAPPHIRE PRISM BONDING FIXTURE

DESIGNER D. BRIDGES 02 SEP 2011

DRAFTER D. BRIDGES 17 DEC 2011

CHECKER B. MOORE 19 DEC 2011

APPROVAL

SIZE c

DWG. NO. D0902662

SCALE: 1:1

PROJECTION:

REV. v3

SHEET 1 OF 1

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX \pm .01
.XXX \pm .005