

D0902697 Spring Clamp Cap, Stage 0, aLIGO BSC ISI, PART PDM REV: X-006, DRAWING PDM REV: X-004

REV.	DATE	DCN #	DRAWING TREE #
v1	26 Feb. 2010	E1000022	E1000025

- 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 = 5.91 LB.
  7. A TRUE POSITION TOLERANCE OF  $\phi .010$  IS - THE SAME AS A CONVENTIONAL TOLERANCE OF  $\pm .005$ .
  8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
  9. PART TO BE ELECTROPOLISHED.
  10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
  11. DIMENSIONS AND TOLERANCES APPLY AFTER ELECTROPOLISHING.

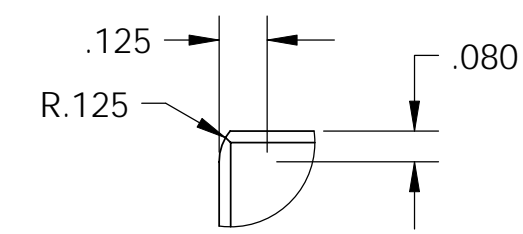
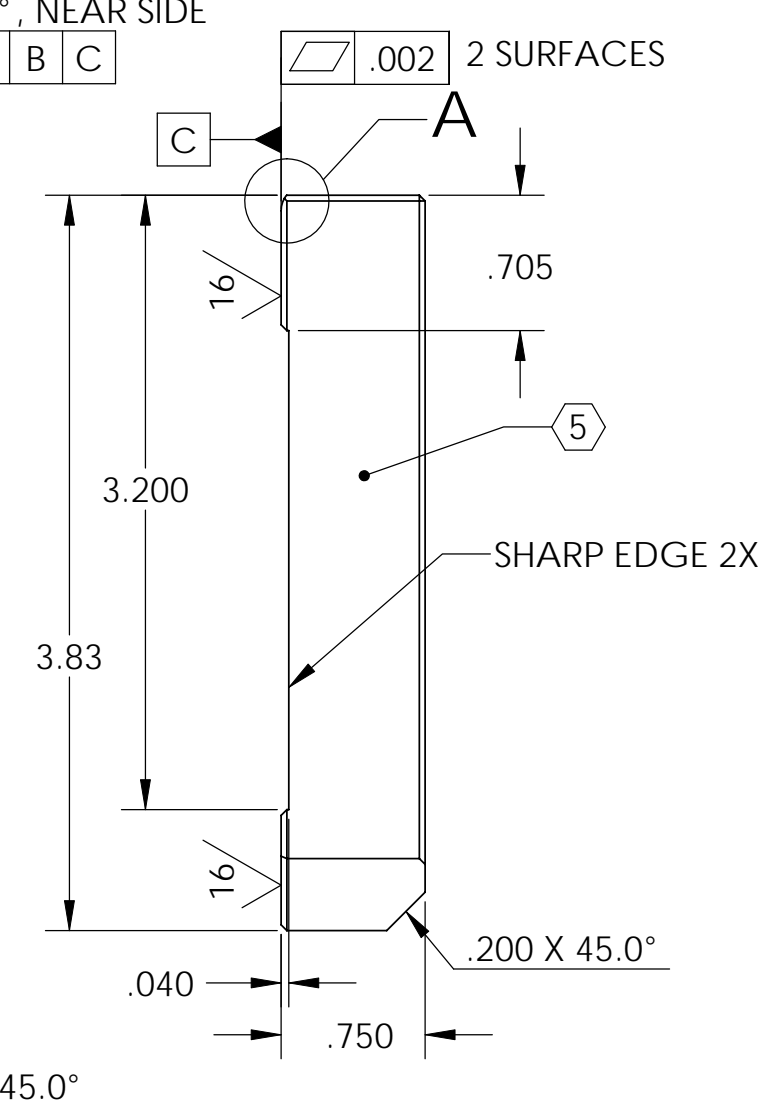
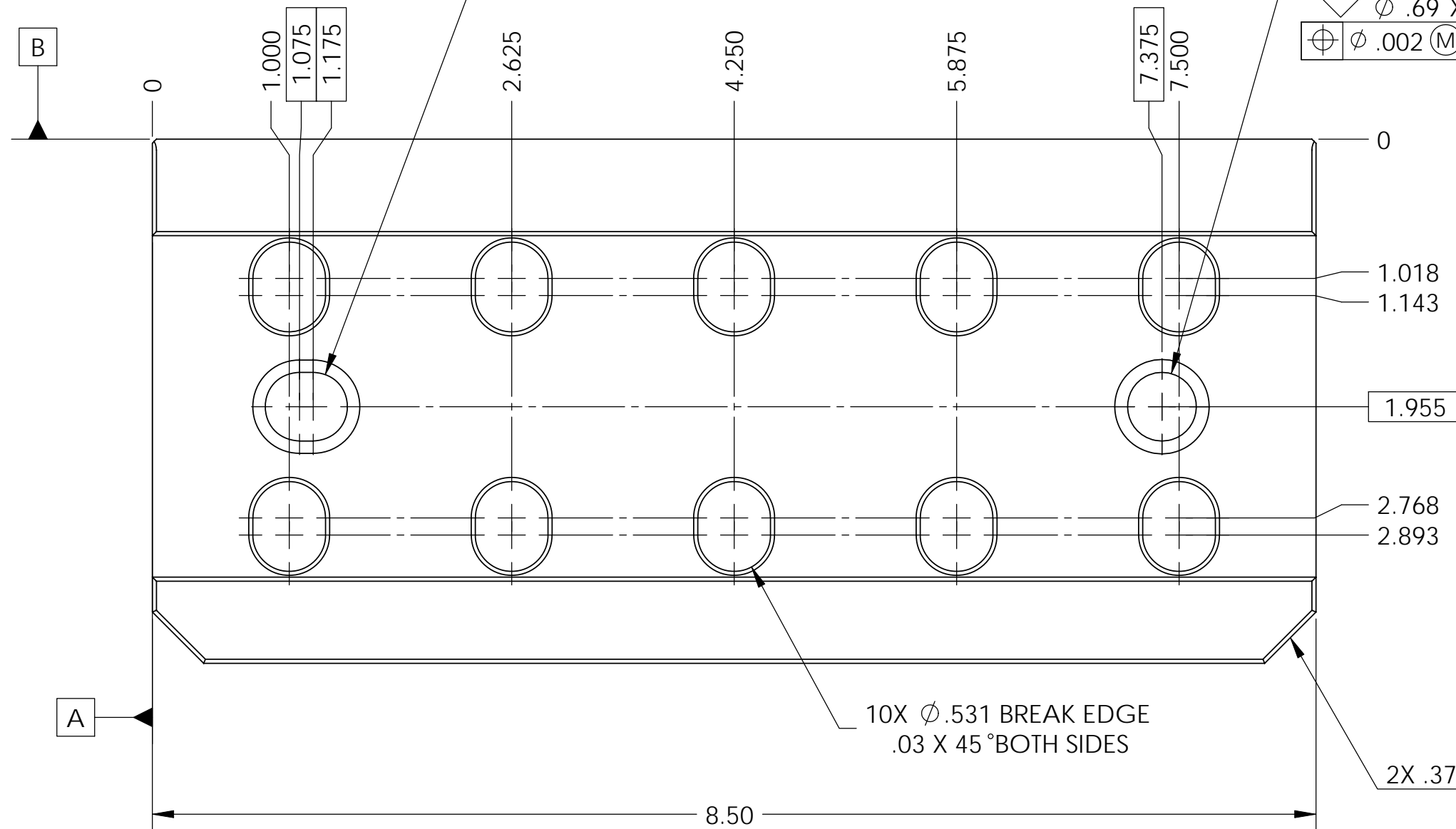
$\phi .502^{+.0005}_{-.0000}$  SLOT THRU  
 BREAK EDGE .09 X 45° NEAR SIDE  
 .03 X 45° FAR SIDE

$\phi .002$	(M)	A	B	C
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$\phi .502^{+.0005}_{-.0000}$  THRU  
 $\phi .56$  X 90°, FAR SIDE  
 $\phi .69$  X 90°, NEAR SIDE

$\phi .002$	(M)	A	B	C
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$\square .002$	2 SURFACES
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DETAIL A  
SCALE 2 : 1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		SPRING CLAMP CAP, STAGE 0, aLIGO BSC ISI					
TOLERANCES: .XX ± .015 .XXX ± .005				SEI		DESIGNER	A.STEIN	01 Feb. 2010	SIZE	DWG. NO.	REV.
ANGULAR ± .5°				MATERIAL		DRAFTER	M.HILLARD	01 Feb. 2010	B	D0902697	v1
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. BREAK ALL EDGES AND CORNERS .03 X 45°. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.				FINISH		CHECKER	F.MATICHARD	01 Feb. 2010	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1
17-4 PH SSSL, H 1150				63 $\mu$ inch		APPROVAL	K.MASON	01 Feb. 2010	NEXT ASSY D0901197		