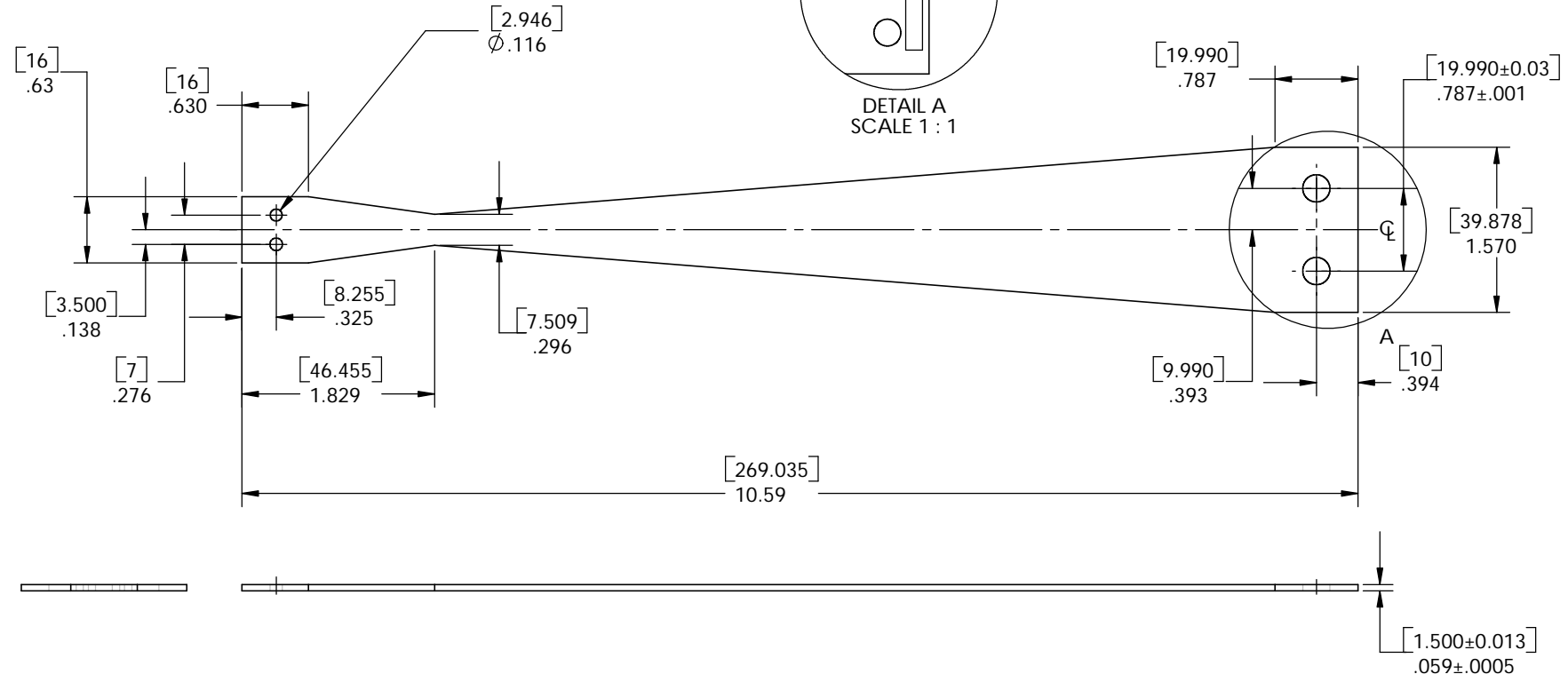
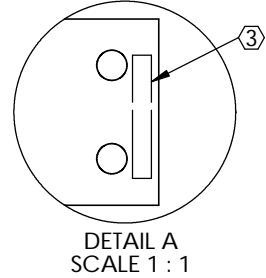


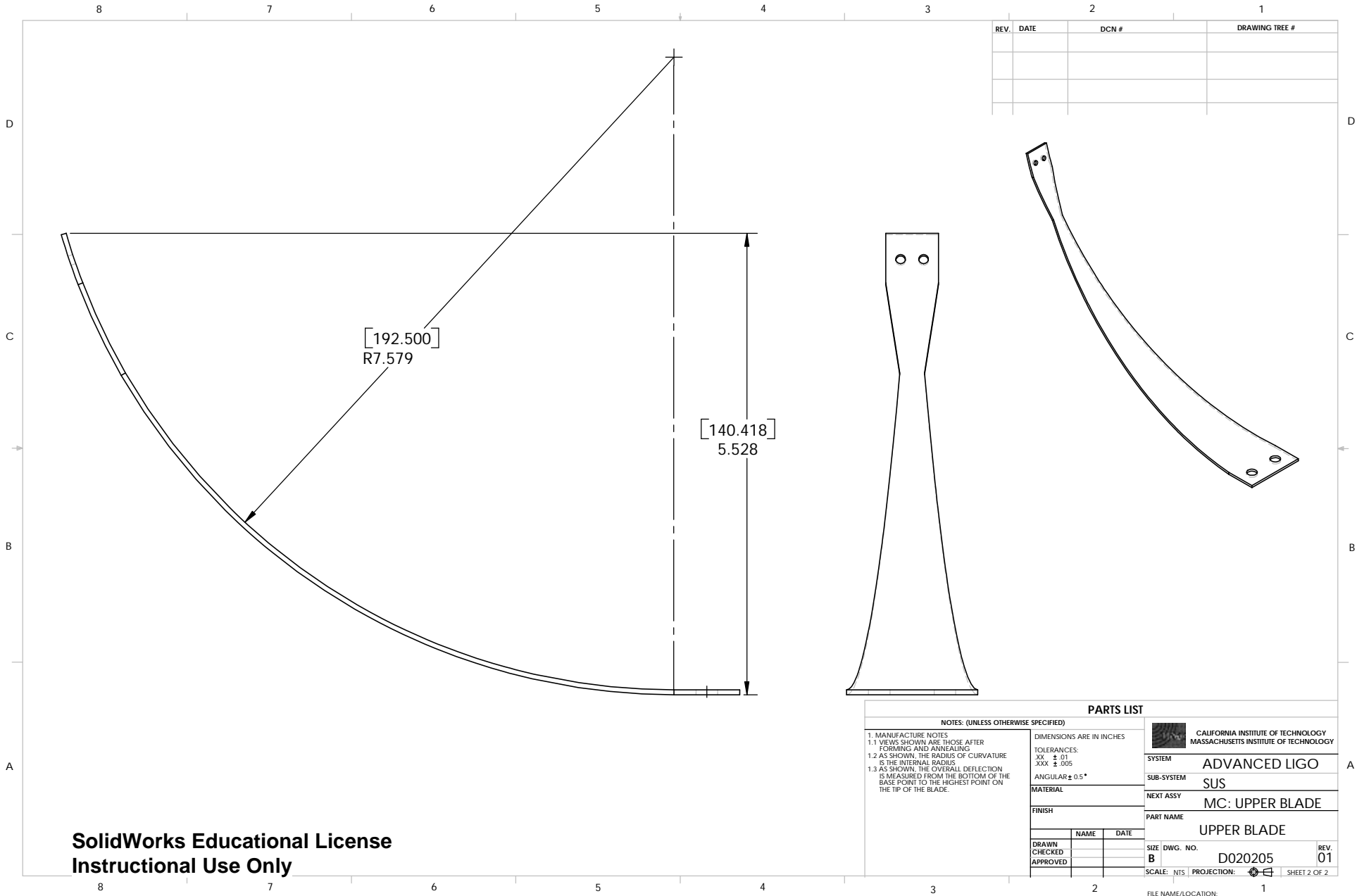
REV.	DATE	DCN #	DRAWING TREE #
01	01JUL02	RADIUS AND DEFLECTION UPDATED TOLERANCE REDUCED ON HOLES ADDED DIMENSION - NARROW WIDTH OF BLADE ADDED DIMENSION - FLAT WIDTH	
01	JUL02	USED FOR ORDER WITH LOBART AND SUPERIOR JIG	
01	MAY03	DUAL DIMENSIONS ADDED, NEW NOTE ADDED.(3) re: ENGRAVING/STAMPING	



PARTS LIST		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
NOTES: (UNLESS OTHERWISE SPECIFIED)			
1. REMOVE ALL SHARP EDGES. R102 MIN. 2. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL) 3. 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: D020198-001. A VIBRATORY TOOL MAY BE USED. 4. VIEWS PRIOR TO FORMING 5. AFTER FORMING THE BLADES ARE ANNEALED AT 490 °C FOR 4 HOURS AND AIR COOLED BACK TO ROOM TEMPERATURE.		DIMENSIONS ARE IN INCHES TOLERANCES: XX ± .01 XXX ± .005 ANGULAR ± 0.5°	
MATERIAL: MACHINING STEEL C250		SYSTEM: ADVANCED LIGO	
FINISH:		SUB-SYSTEM: SUS	
		NEXT ASSY: MC UPPER BLADES	
		PART NAME: UPPER BLADE	
DRAWN	CIT	DATE	MAY02
CHECKED			
APPROVED			
SIZE	DWG. NO.	B	D020205
SCALE:	NTS:	PROJECTION:	
			REV. 01
			SHEET 1 OF 2

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