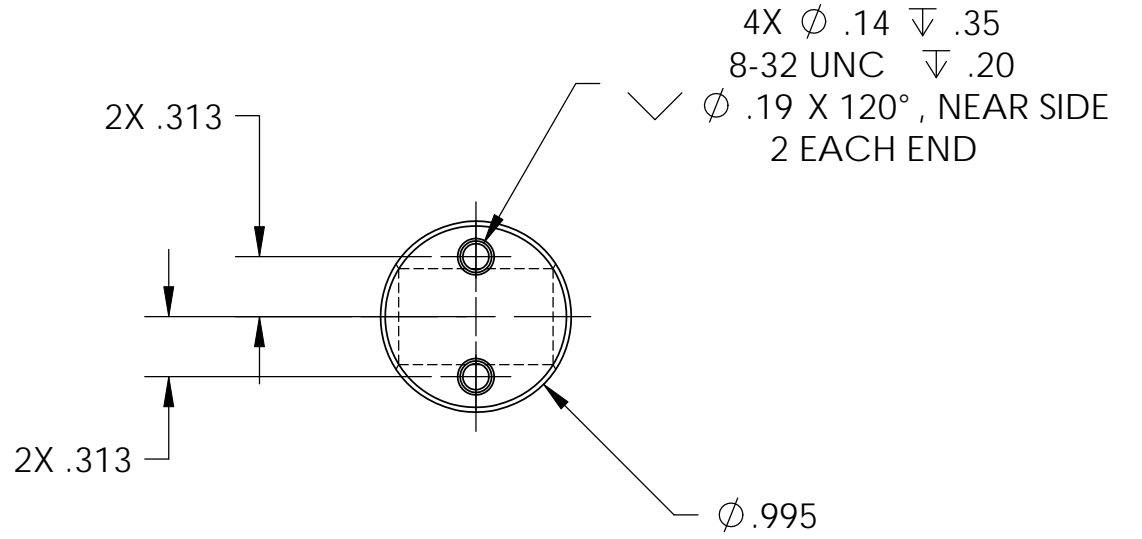
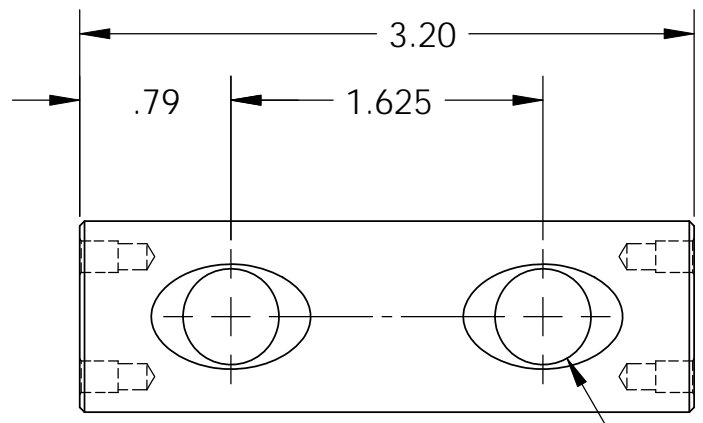


D1002380 Barrel Nut Bar, Stage 1-2, aLIGO BSC ISI, PART PDM REV: X-001, DRAWING PDM REV: X-002

REV.	DATE	DCN #	DRAWING TREE #
v1	09 Sept 2010	E1000401	E1000025

**NOTES CONTINUED:**

5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12 HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXX-VY, TYPE-XX, S/N XXX.
6. APPROXIMATE WEIGHT = 0.6 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES (INCLUDING SANDING OR SCOURING FOR MATTE FINISH) IS NOT ALLOWED.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. PART TO BE ELECTROPOLISHED.
10. DIMENSIONS AND TOLERANCES APPLY AFTER ELECTROPOLISHING



2X  $\phi$  .42 THRU ALL  
 1/2-13 UNC -H11 THRU ALL  
 $\checkmark$   $\phi$  .83 X 120°, NEAR SIDE  
 $\checkmark$   $\phi$  .83 X 120°, FAR SIDE

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		ADVANCED LIGO		SUB-SYSTEM		SEI		Barrel Nut Bar, Stage 1-2, aLIGO BSC ISI	
TOLERANCES: .XX ± .015 .XXX ± .005		MATERIAL		FINISH		NEXT ASSY		DESIGNER		M.HILLARD 09 Sept 2010	
ANGULAR ± .5°		NITRONIC 60		63 $\mu$ inch		D0902485		DRAFTER		M.HILLARD 09 Sept 2010	
								CHECKER		F.MATICHARD 09 Sept 2010	
								APPROVAL		K.MASON 09 Sept 2010	
								SCALE: 1:1		PROJECTION:	
								SIZE DWG. NO.		REV.	
								B D1002380		v1	
								SHEET 1 OF 1			