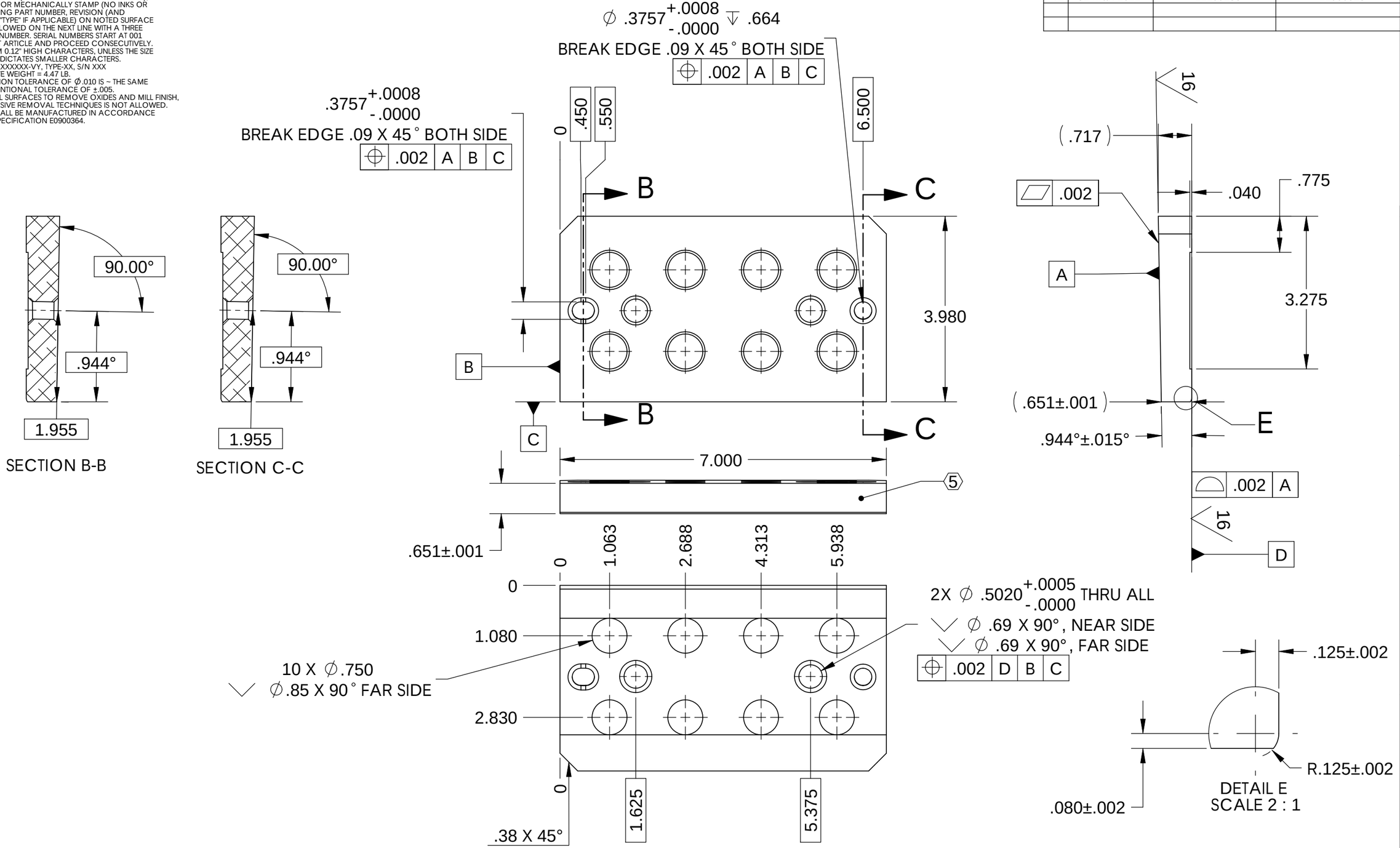
REV.	DATE	DCN #	DRAWING TREE #
v1	31 Mar. 2011	E1100288	E1000025

NOTES CONTINUED:

5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX
6. APPROXIMATE WEIGHT = 4.47 LB.
7. A TRUE POSITION TOLERANCE OF ∅.010 IS ~ THE SAME AS A CONVENTIONAL TOLERANCE OF ±.005.
8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
9. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .015
.XXX ± .005

ANGULAR ± .5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. BREAK ALL CORNERS AND EDGES .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.

MATERIAL: 304 SSTL

FINISH: 32 µinch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO

SUB-SYSTEM: SEI

NEXT ASSY: D0902485

PART NAME: Stage 1-2 Angled Blade Spacer, aLIGO BSC ISI

DESIGNER	F.MATICHARD	30 Mar 2011
DRAFTER	F.MATICHARD	30 Mar 2011
CHECKER	K.MASON	30 Mar 2011
APPROVAL	K.MASON	30 Mar 2011

SIZE: B — DWG. NO.: D1100564 — REV.: v1

SCALE: 1:2 — PROJECTION: — SHEET 1 OF 1

D1100564 Stage 1-2 Angled Blades Spacer, aLIGO BSC-ISI, PART PDM REV: X-002, DRAWING PDM REV: X-002