

D1100570 Stage 0-1 Angled Blades Spacer, aLIGO BSC-ISI, PART PDM REV: X-003, DRAWING PDM REV: X-005

NOTES CONTINUED:

5. SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY.

TEXT HEIGHT BETWEEN .25"MIN--.5"MAX

BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY.

EXAMPLE (PART): DXXXXXX-v2 S/N 001

EXAMPLE (TAG): DXXXXXX-v2, QTY: TBD

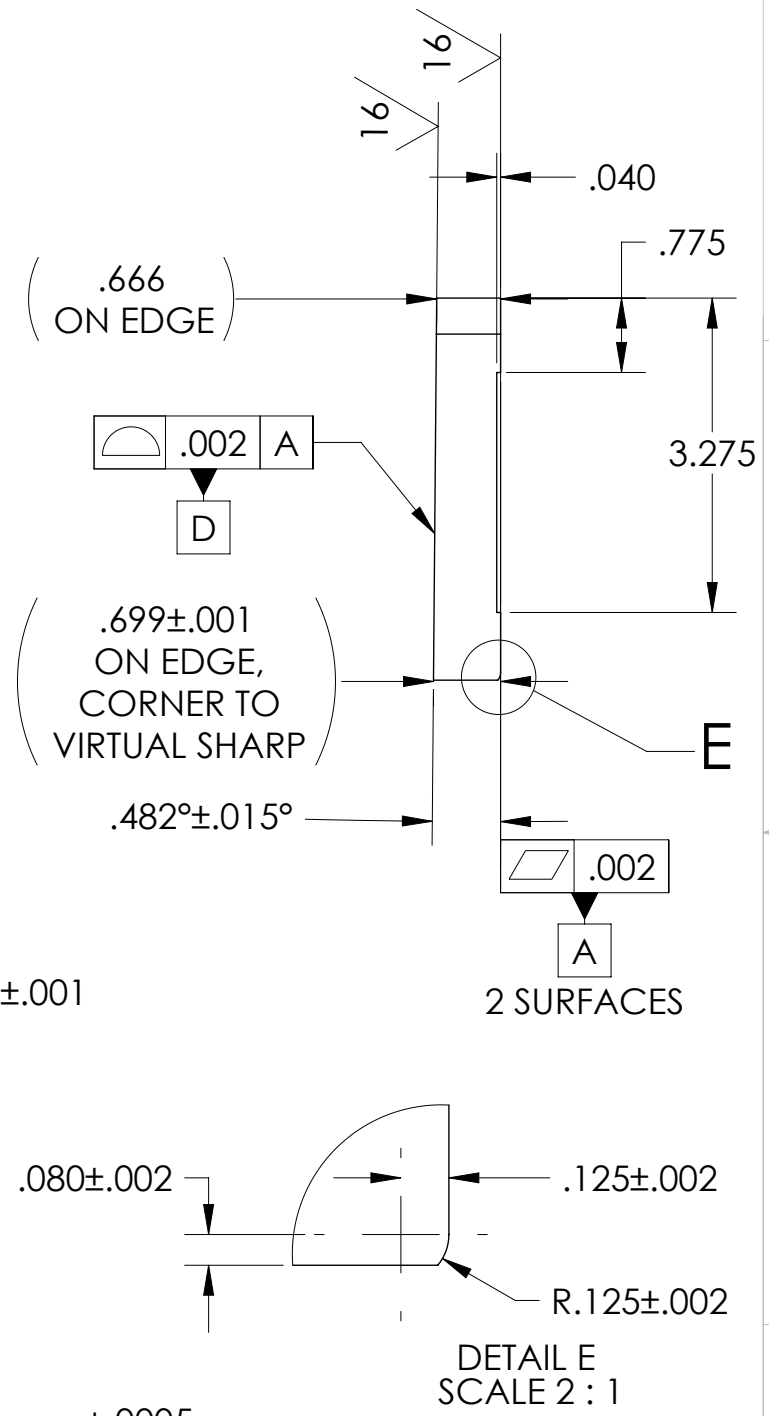
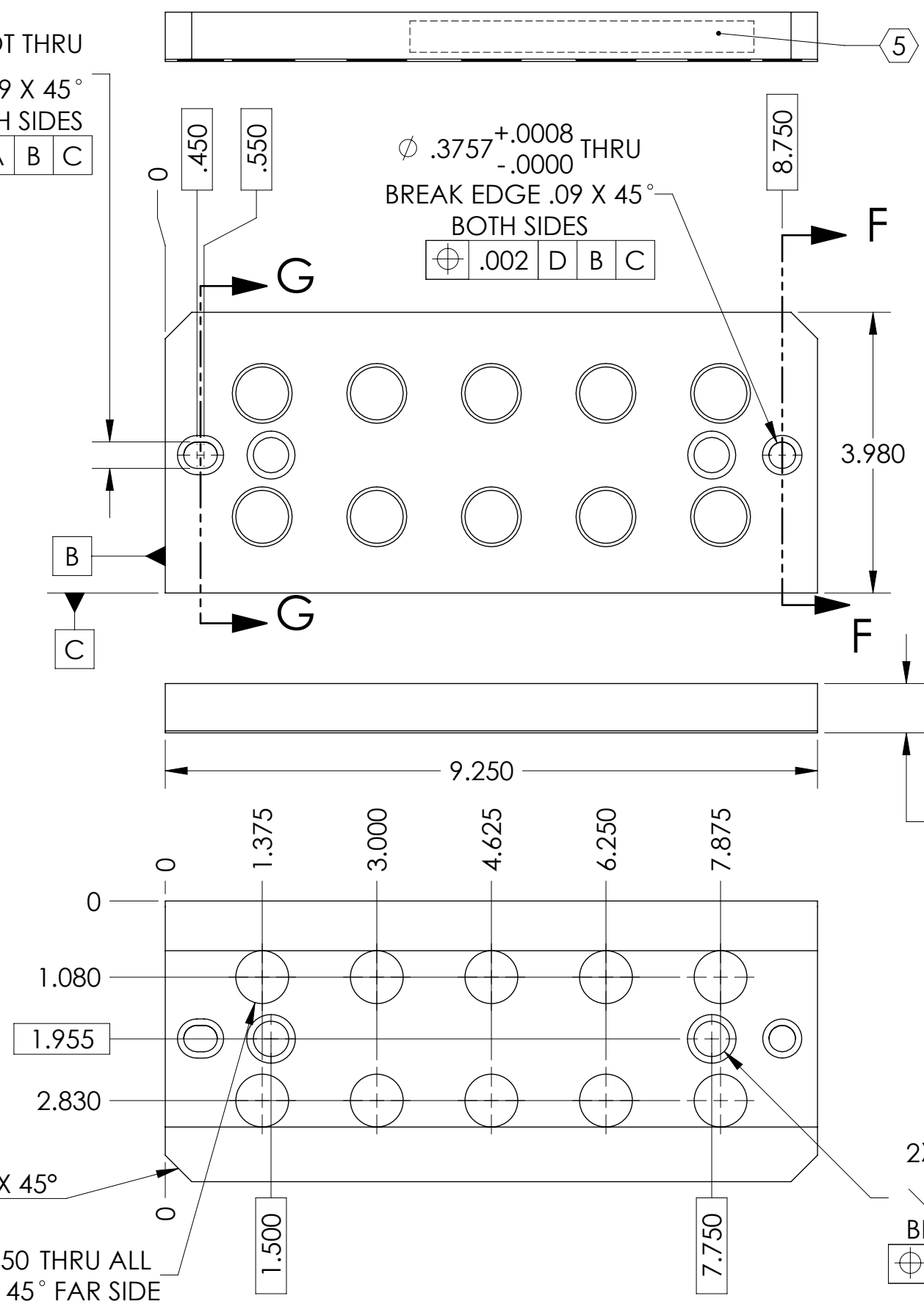
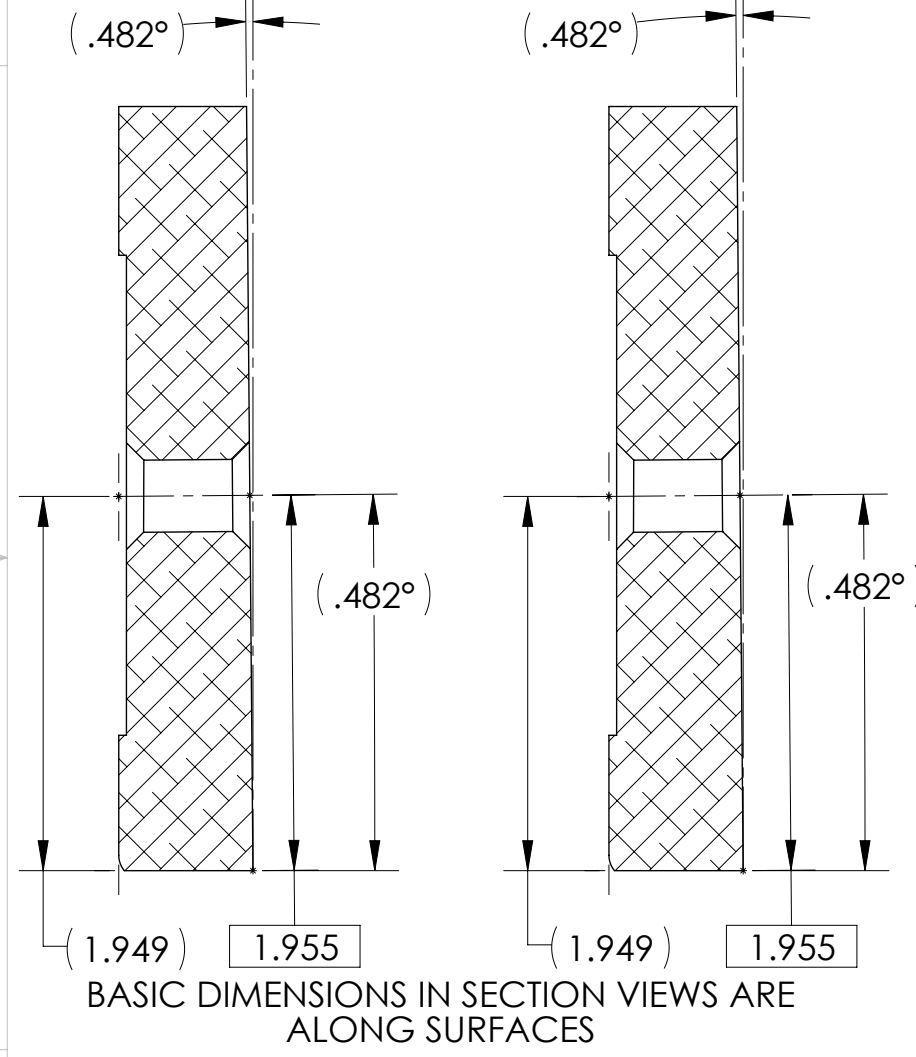
6. APPROXIMATE WEIGHT = 6.00 LB.

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. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	31 Mar. 2011	E1100288	E1000025
v2	19 APR 2012	E1200400	



SECTION G-G
SCALE 1:1

SECTION F-F
SCALE 1:1

DETAIL E
SCALE 2:1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- INTERPRET DRAWING PER ASME Y14.5-1994.
- BREAK ALL EDGES AND CORNERS .03 X 45°.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN INCHES

TOLERANCES (UNLESS OTHERWISE SPECIFIED):
 .XX ± .015
 .XXX ± .005

ANGULAR ± .15°

MATERIAL	304 S316L	FINISH	63 μinch
NEXT ASSY	D0901197		

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME Stage 0-1 Blades Angled Spacer, aLIGO BSC-ISI	
DESIGNER F.MATICHARD	31 Mar. 2011	SIZE B	DWG. NO. D1100570
DRAFTER SBARNUM	19 APR 2012	REVISION v2	SHEET 1 OF 1
CHECKER FMATICHARD	25 APR 2012	SCALE 1:2	PROJECTION
APPROVAL K.MASON	30 APR 2012	SYSTEM ADVANCED LIGO	SUB-SYSTEM SEI