

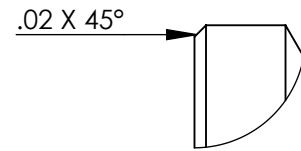
NOTES CONTINUED:

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. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.  
 EXAMPLE (PART): 001-v1  
 EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD

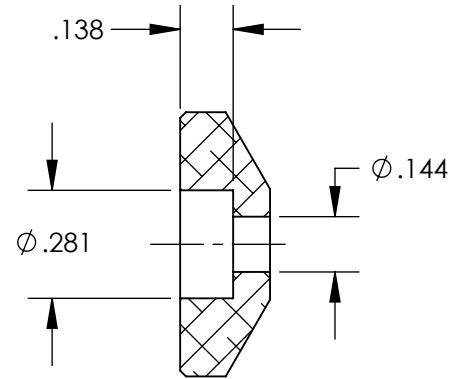
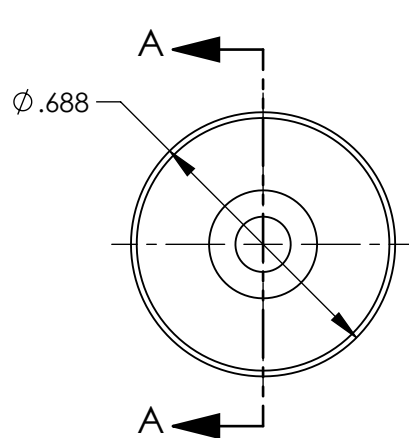
- 6. APPROXIMATE WEIGHT = 7.5g
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
- 10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
- 11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL), NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	27 AUG 2014	E1400354-x0	-
-	-	-	-
-	-	-	-

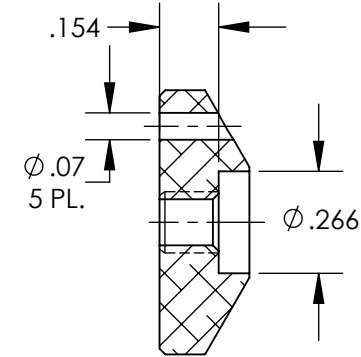
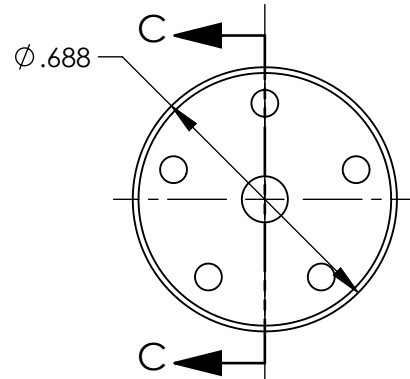
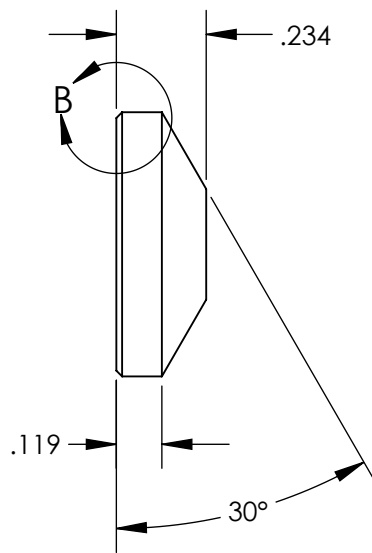
### -101 DETAIL



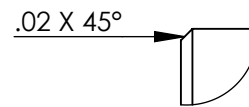
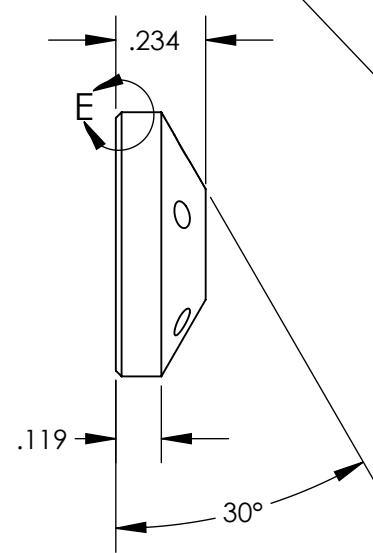
DETAIL B  
SCALE 4 : 1



SECTION A-A

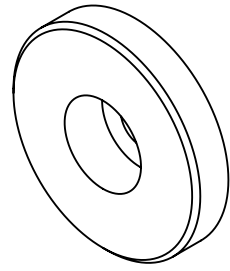


SECTION C-C

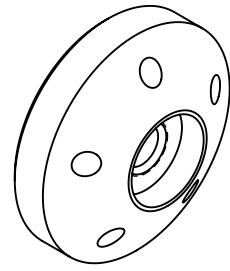


DETAIL E  
SCALE 4 : 1

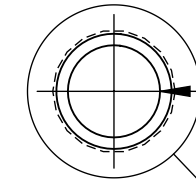
### -102 DETAIL



ISO VIEW

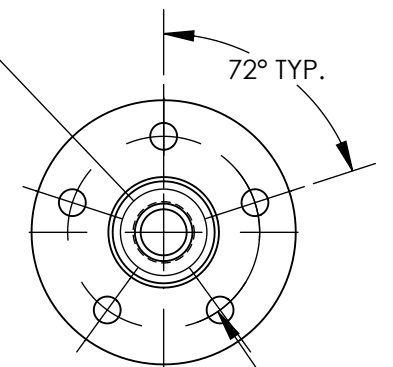


ISO VIEW



DETAIL D  
SCALE 4 : 1

Ø .12 THRU ALL  
 ✓ Ø .15 X 90°, NEAR SIDE  
 TAP FOR #4-40 HELICOIL INSERT = 1.0 \* DIA.



Ø .500 B.C.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES		1. INTERPRET DRAWING PER ASME Y14.5-1994.	
TOLERANCES:		2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS.	
.XX ± .01		3. DO NOT SCALE FROM DRAWING.	
.XXX ± .005		4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
ANGULAR ± 0.5°			
MATERIAL	304 SSSL	FINISH	63 μinch

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: SUS  
 NEXT ASSY: D1400298

PART NAME aLIGO, SUS, NON-MAGNETIC BLADE DAMPER ASSY., 7.5g MASS			
DESIGNER	E.SANCHEZ	19 AUG 2014	SIZE DWG. NO.
DRAFTER	E.SANCHEZ	27 AUG 2014	B
CHECKER	SEE DCC	SEE DCC	D1400296
APPROVAL	SEE DCC	SEE DCC	REV. v1
SCALE: 2:1		PROJECTION:  SHEET 1 OF 1	

D1400296 aLIGO, SUS, NON-MAGNETIC BLADE DAMPER ASSY., 7.5g MASS, PART PDM REV: , DRAWING PDM REV: