

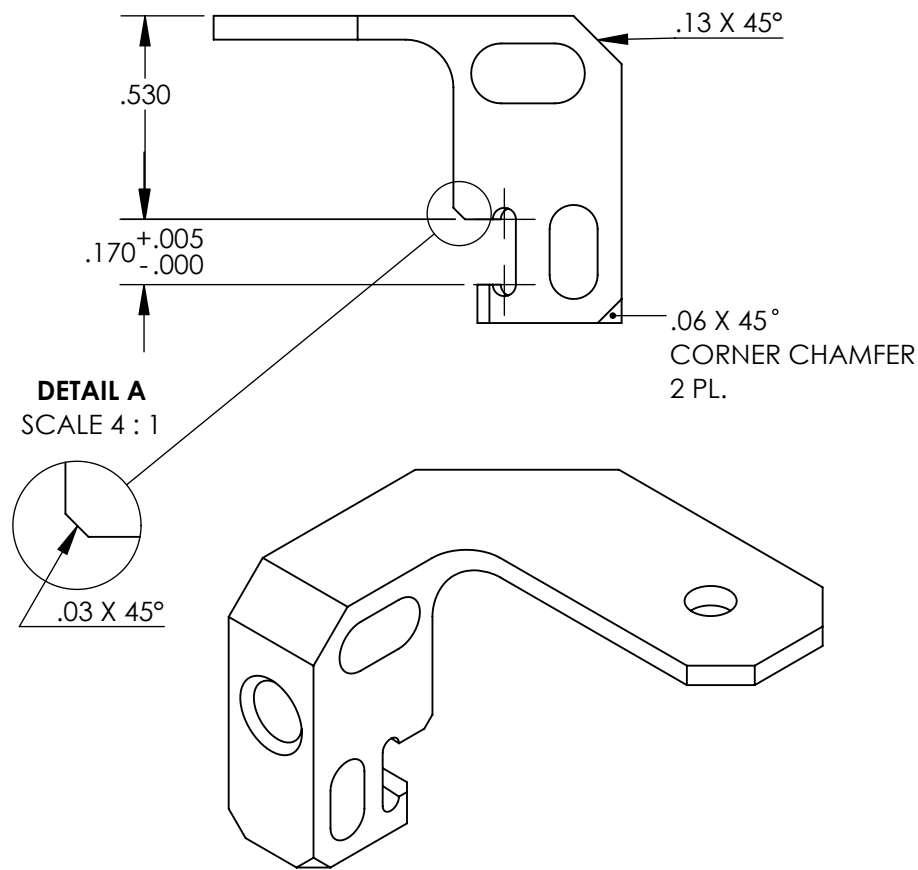
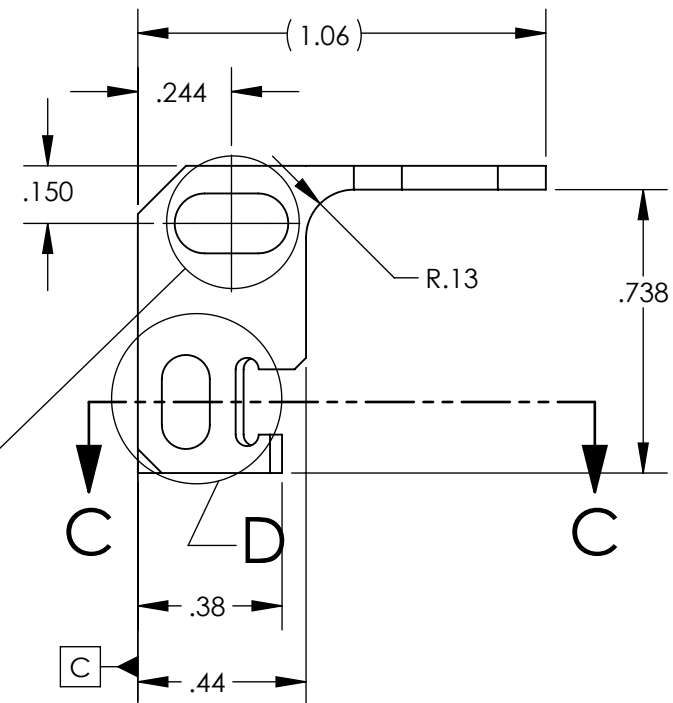
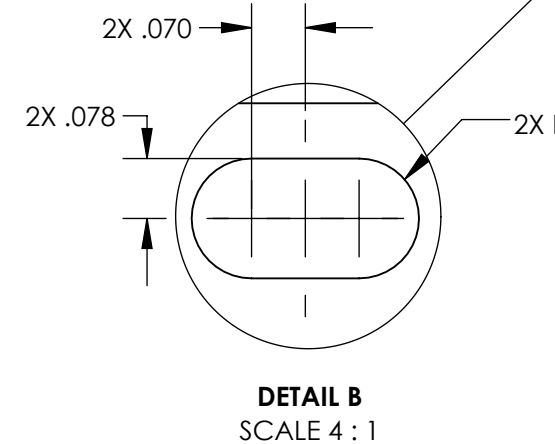
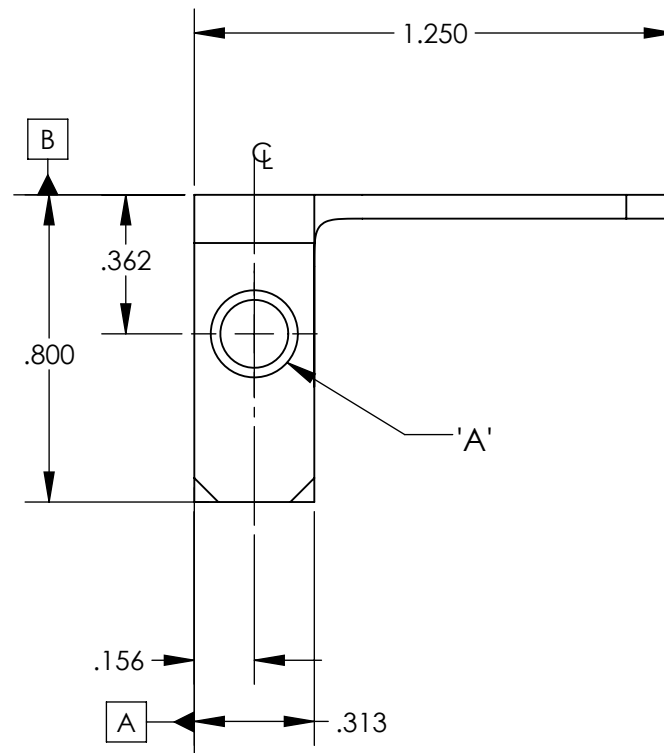
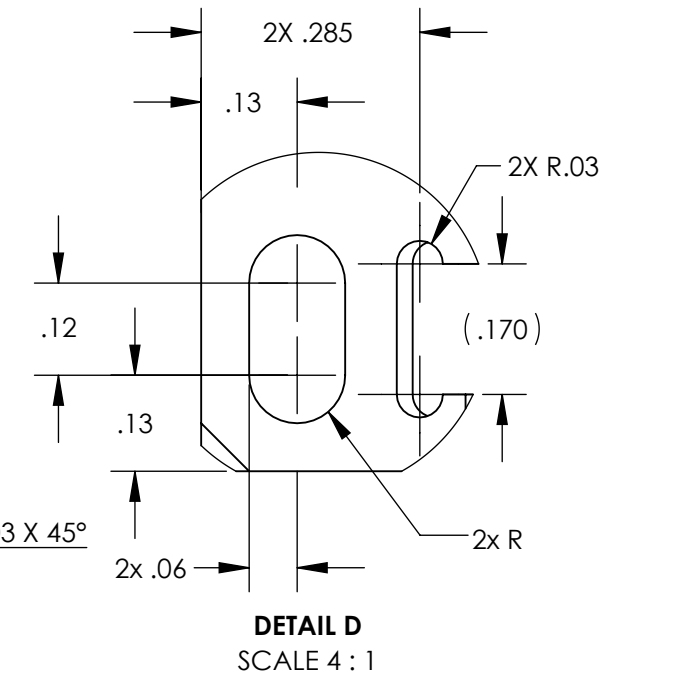
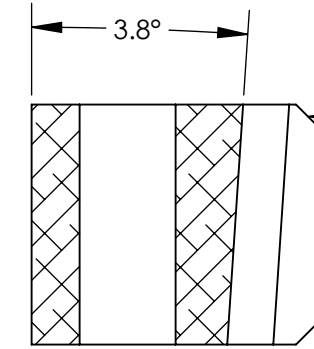
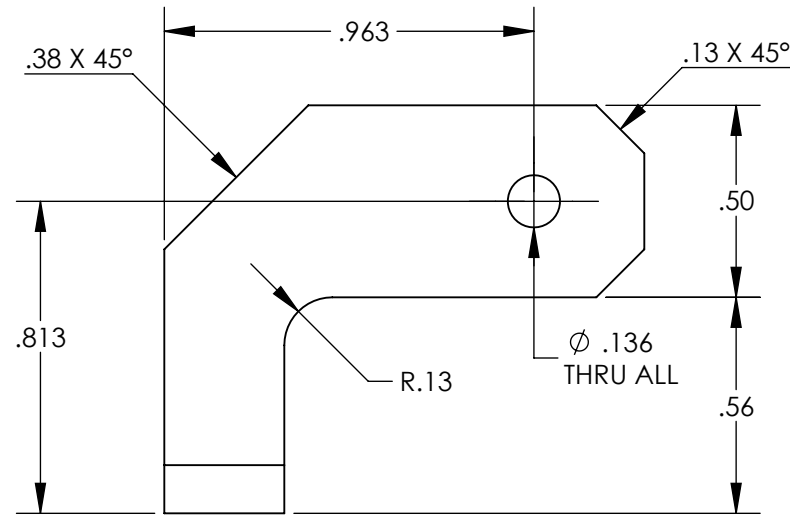
D1400297 aLIGO, SUS, NON-MAGNETIC BLADE DAMPER ASSY., 2 PIECE CLAW CLAMP, PART PDM REV: X-021, DRAWING PDM REV: X-013

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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
9. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.
10. 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	-
v4	02 NOV 2015	E1500429-x0	-
v5	08 FEB 2016	E1600045-x0	-

PART NUMBER	HOLE 'A'
D1400297-101	✓ $\phi .177$ THRU ALL ✓ $\phi .227 \times 90^\circ$, NEARSIDE ✓ $\phi .227 \times 90^\circ$, FAR SIDE
D1400297-103	✓ $\phi .173$ THRU ALL ✓ $\phi .223 \times 90^\circ$, NEARSIDE TAP FOR 8-32 HELICOIL THRU ALL ✓ $\phi .223 \times 90^\circ$, FAR SIDE



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 0.5°

MATERIAL: 6061-T6 Al

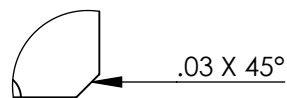
FINISH: 63 μinch

1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
 3. DO NOT SCALE FROM DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

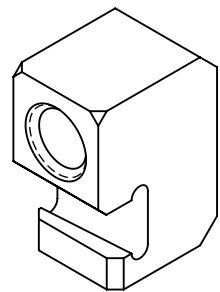
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME aLIGO, SUS, NON-MAGNETIC BLADE DAMPER ASSY., 2 PIECE CLAW CLAMP	
SYSTEM ADVANCED LIGO	SUB-SYSTEM SUS	DESIGNER E.SANCHEZ	DATE 19 AUG 2014
NEXT ASSY D1400298	CHECKER SEE DCC	DRAFTER E.SANCHEZ	DATE 27 AUG 2014
APPROVAL SEE DCC	APPROVAL SEE DCC	SIZE DWG. NO. B	DWG. NO. D1400297
SCALE: 2:1		PROJECTION:	
SHEET 1 OF 2		REV. v5	SHEET 1 OF 2

-101 & -103 DETAIL

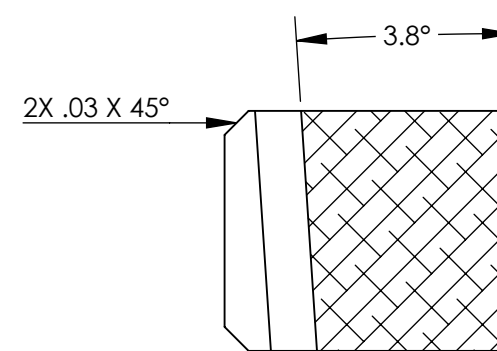
D1400297 dLIGO, SUS, NON-MAGNETIC BLADE DAMPER ASSY., 2 PIECE CLAW CLAMP, PART PDM REV: X-021, DRAWING PDM REV: X-013



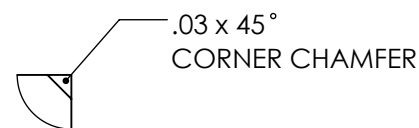
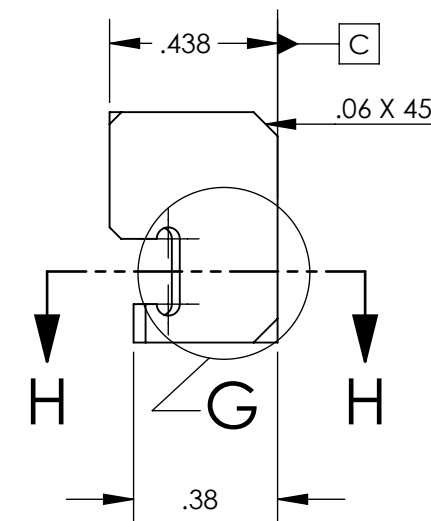
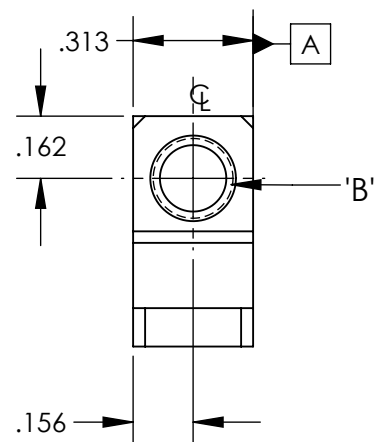
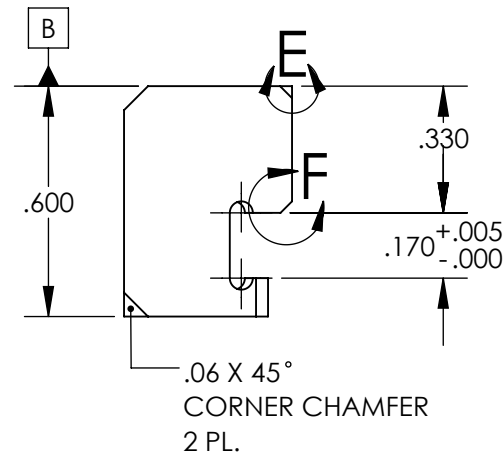
DETAIL F
SCALE 4 : 1



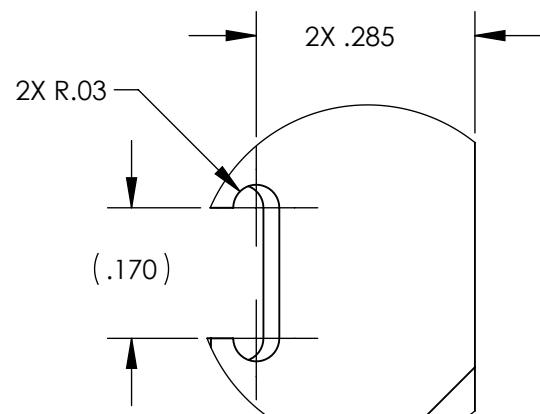
ISO VIEW



SECTION H-H
SCALE 4 : 1



DETAIL E
SCALE 4 : 1
2 PL.



DETAIL G
SCALE 4 : 1

PART NUMBER	HOLE 'B'
D1400297-102	ϕ .173 THRU ALL \checkmark ϕ .223 X 90°, NEARSIDE TAP FOR 8-32 HELICOIL THRU ALL \checkmark ϕ .223 X 90°, FAR SIDE
D1400297-104	ϕ .177 THRU ALL \checkmark ϕ .227 X 90°, NEARSIDE \checkmark ϕ .227 X 90°, FAR SIDE

-102 & -104 DETAIL

CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY
 SIZE DWG. NO. **D1400297** REV. **v5**
 SCALE: 2:1 PROJECTION: SHEET 2 OF 2