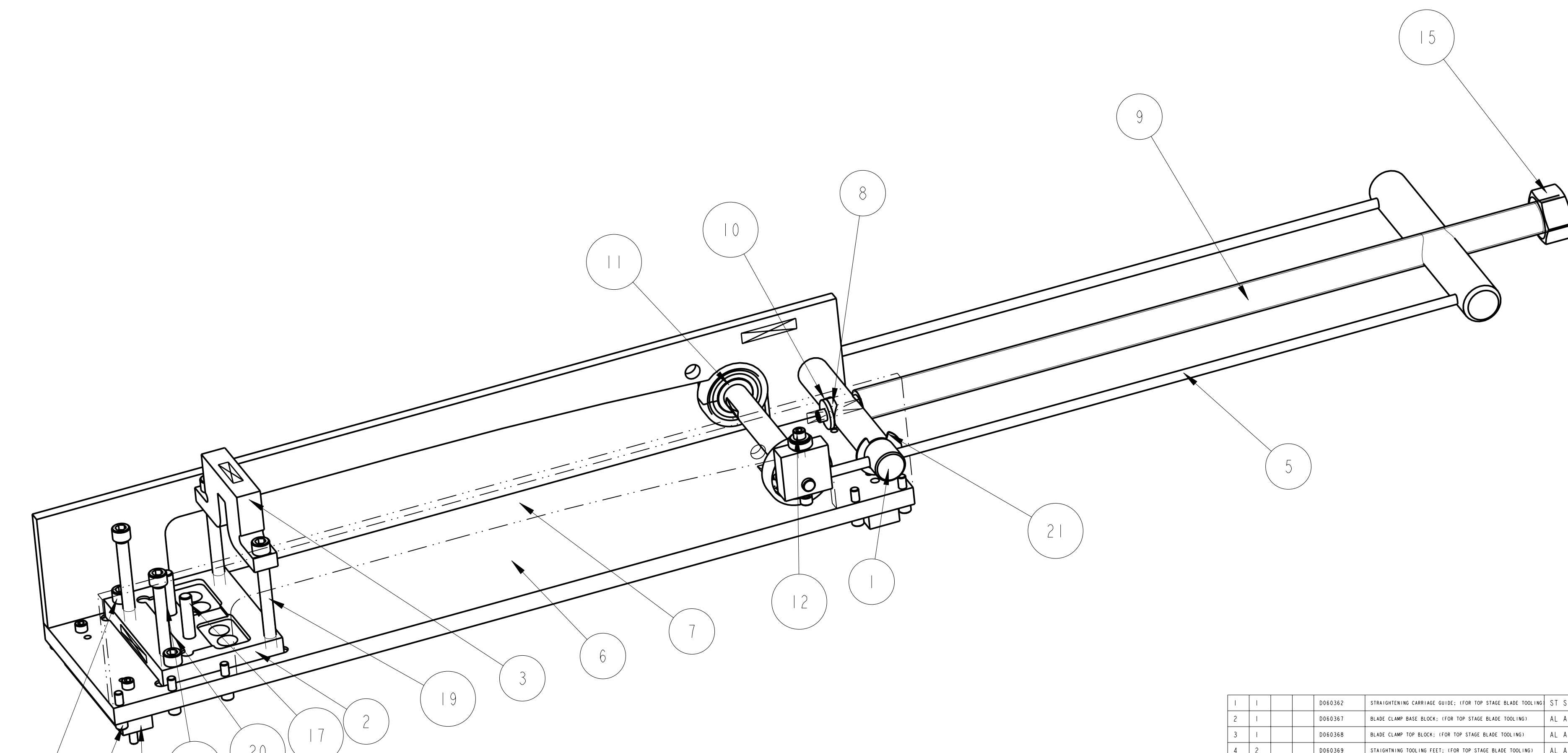


REV.	DATE	DCN #	DRAWING TREE #
A	17/OCT/06	E060242	



ISOMETRIC VIEW WITH ONE SIDE SHOWN
 AS HIDDEN DETAIL FOR CLARITY
 NOTE: WITHOUT THE TOP STAGE IN PLACE THIS ASSEMBLY
 CONFIGURATION IS IMPOSSIBLE

ITEM	QTY	SPARE	TOTAL	PART NUMBER	DESCRIPTION	MATERIALS
1	1			D060362	STRAIGHTENING CARRIAGE GUIDE; (FOR TOP STAGE BLADE TOOLING)	ST STEEL: 303/304
2	1			D060367	BLADE CLAMP BASE BLOCK; (FOR TOP STAGE BLADE TOOLING)	AL ALLOY: 6061 T6
3	1			D060368	BLADE CLAMP TOP BLOCK; (FOR TOP STAGE BLADE TOOLING)	AL ALLOY: 6061 T6
4	2			D060369	STRAIGHTENING TOOLING FEET; (FOR TOP STAGE BLADE TOOLING)	AL ALLOY: 6061 T6
5	1			D060371	BLADE STREIGHTENING CARRIAGE; (FOR TOP STAGE BLADE TOOLING)	AS DRWS: -----
6	1			D060372	BACKBONE PART 1; (FOR TOP STAGE BLADE TOOLING)	AL ALLOY: 6061 T6
7	2			D060373	BACKBONE PART 2; (FOR TOP STAGE BLADE TOOLING)	AL ALLOY: 6061 T6
8	1			D080748	BUSH; TOP STAGE TOOLING	PTFE: -----
9	1			D080749	SCREWED ROD; TOP STAGE TOOLING	ST STEEL: 316/304
10	1			D0902581	.. .	-----: -----
11	1				1/4" 20 UNC X 0.5" CAP HEAD: .	
12	4				1/4" 20 UNC X 0.75" CAP HEAD: .	ST STEEL 300 SERIES
13	10				1/4" 20 UNC X 1" CAP HEAD: .	ST STEEL 300 SERIES
14	2				1/4" 20 UNC X 2" CAP HEAD: .	
15	1				1-8 UNC NUT: .	
16	2				3/8-16 UNC X 1.25" CAP HEAD: .	ST STEEL 300 SERIES
17	2				3/8-16 UNC X 2.00" CAP HEAD: .	ST STEEL 300 SERIES
18	2				3/8-16 UNC X 3.0" CAP HEAD: .	ST STEEL 300 SERIES
19	2				3/8-16 UNC X 3.5" CAP HEAD: .	ST STEEL 300 SERIES
20	2				3/8 FLAT WASHER: .	ST STEEL 300 SERIES
21	2				CIRCLIP; SERIAL No. 0087	ST STEEL 300 SERIES

NOTES: (UNLESS OTHERWISE SPECIFIED)

- REMOVE ALL SHARP EDGES. R.02 MIN.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).
- SCRIBE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: D020188-001. A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES)
 TOLERANCES:
 X.XX ± [] °
 ANGULAR ± °

MATERIAL: -----
 FINISH: -----
 Ra = -----
 Rz = -----

NAME	DATE
DRAWN I WILMUT	25/SEP/06
CHECKED J'OD	17/OCT/06
APPROVED RJG	17/OCT/06

CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY
 RUTHERFORD APPLETON LABORATORIES

SYSTEM **ADVANCED LIGO**
 SUB-SYSTEM **SUS**
 NEXT ASSY **QUAD N-PTYPE TOP STAGE**
 PART NAME **STREIGHTENING TOOLING ASSY**
 (TOP STAGE BLADE TOOLING)

DRG. NO. **D060370**
 SCALE 2:5 PROJECTION 1 OF 1