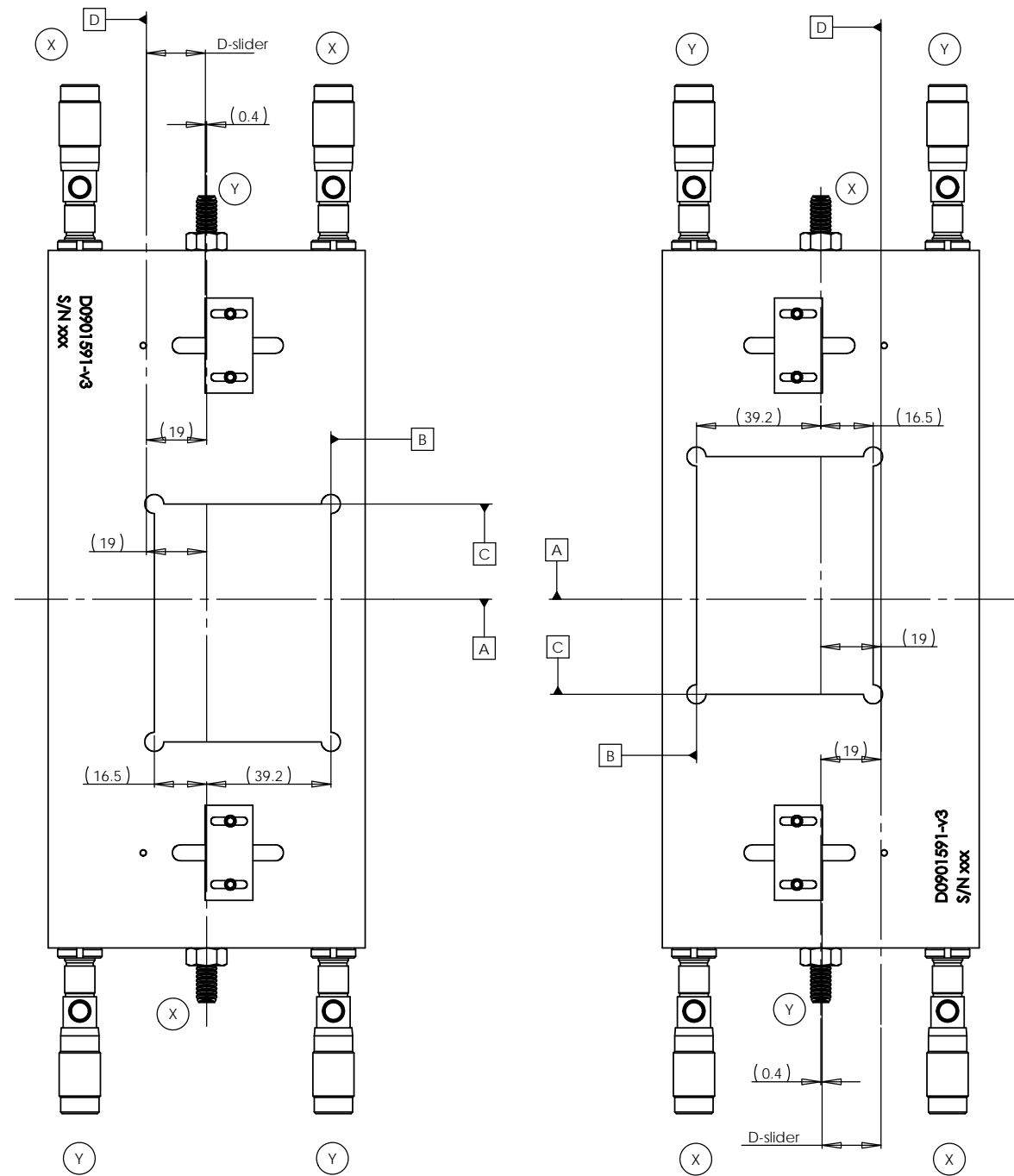


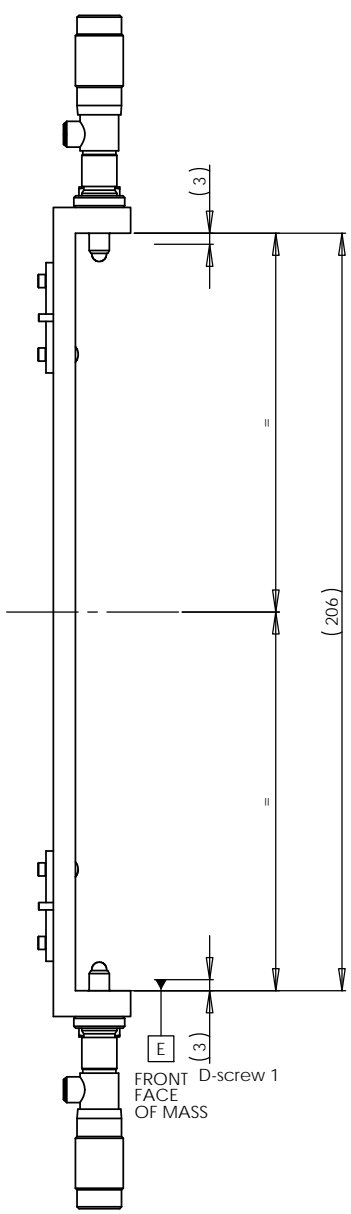
NOTES CONTINUED:

REV.	DATE	DCN #	DRAWING TREE #

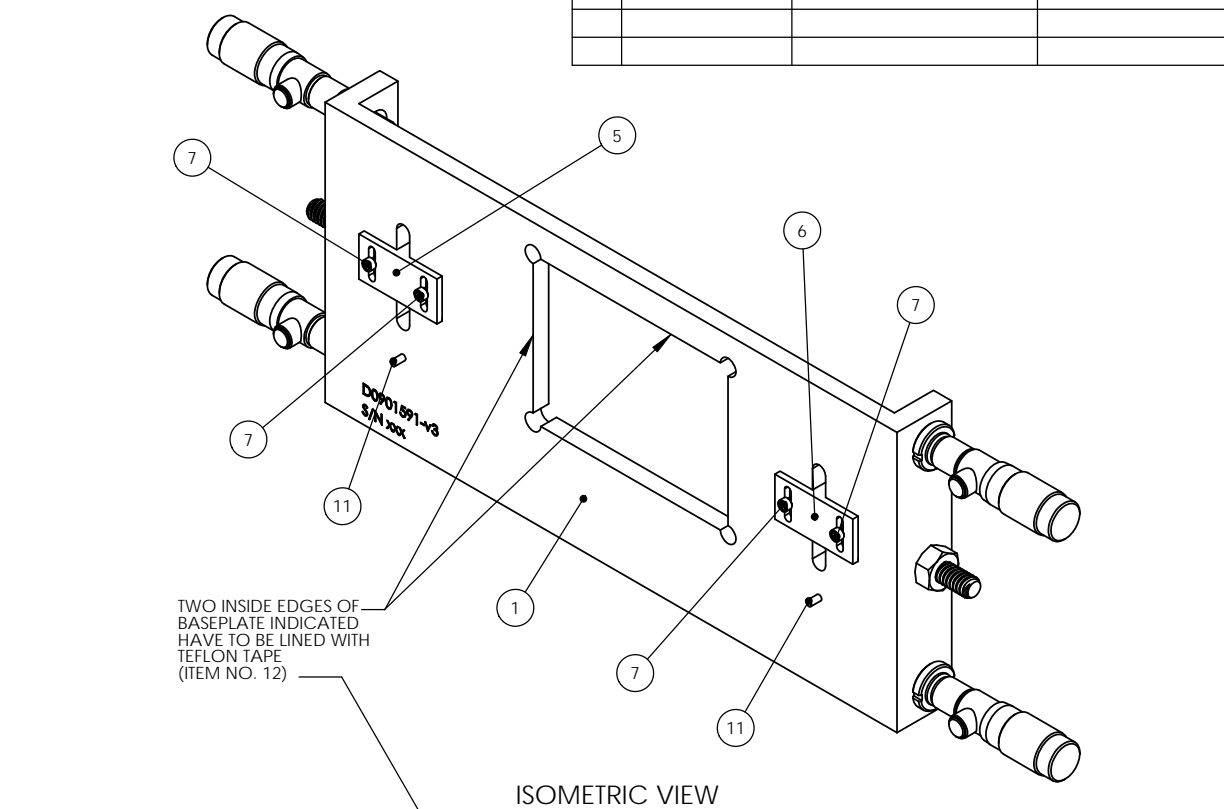


PLAN VIEW ON SIDE 2 OF EAR BONDING JIG ASSEMBLY AS IT WOULD BE VIEWED WHEN IN USE

PLAN VIEW ON SIDE 1 OF EAR BONDING JIG ASSEMBLY AS IT WOULD BE VIEWED WHEN IN USE

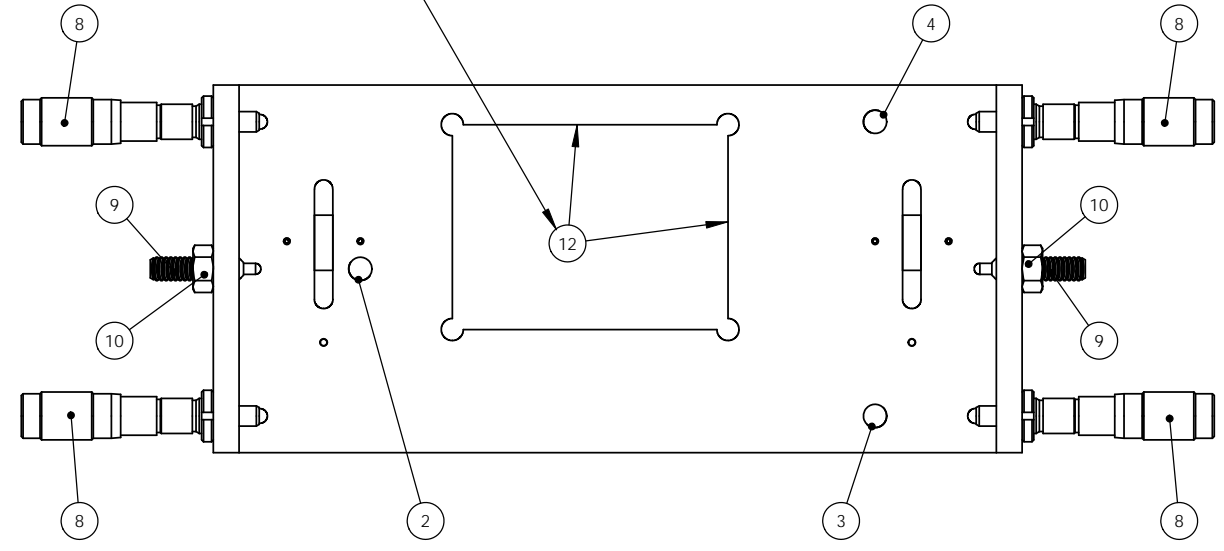


FRONT FACE OF MASS



TWO INSIDE EDGES OF BASEPLATE INDICATED HAVE TO BE LINED WITH TEFLON TAPE (ITEM NO. 12)

ISOMETRIC VIEW



VIEW LOOKING ON BACK

**EAR BONDING JIG ASSEMBLY SET UP PROCEDURE:-**

- MEASURE ACTUAL INTERNAL WIDTH OF BASEPLATE (206 NOMINAL) AND SUBTRACT ACTUAL WIDTH OF MASS (200 NOMINAL) IN ORDER TO CALCULATE D-screw 1 VALUE (3 NOMINAL), WHICH WILL BE USED TO LOCATE THE CENTRAL DATUM AXIS OF THE EAR BONDING JIG ASSEMBLY (DATUM A).
- LOCATE THE EAR BONDING JIG ASSEMBLY ONTO THE MASS AND ALWAYS MEASURING FROM THE FRONT FACE OF THE MASS (DATUM E) UTILISING MICROMETERS ALIGN AS COINCIDENT THE CENTRAL DATUM AXIS OF THE EAR BONDING JIG ASSEMBLY (DATUM A) WITH THE CENTRAL DATUM AXIS OF THE MASS.  
  
IMPORTANT NOTE:- AT ANY ONE TIME ONLY THE MICROMETERS ACTING ON THE FRONT FACE OF THE MASS AND THE OPPOSITE SPRING PIN END SCREW SHOULD BE IN CONTACT WITH THE MASS SURFACES, NO OTHER POINTS OF CONTACT ARE REQUIRED.  
  
I.E. WHEN SETTING UP ON SIDE 1 ONLY POSITIONS MARKED 'X' SHOULD BE UTILISED AND WHEN SETTING UP ON SIDE 2 ONLY POSITIONS MARKED 'Y' SHOULD BE UTILISED.
- LOCATE THE ALIGNMENT GUIDES RELATIVE TO THE VISIBLE REFERENCE GROOVES ON THE BASEPLATE AS SHOWN TO GIVE D-slider VALUE (THIS VALUE IS CHOSEN TO ACCOUNT FOR THE CORRECT FIBRE FLEXURE POSITION). ONCE ALIGNMENT GUIDES ARE IN POSITION ALIGN RELATIVE WITH THE CENTRAL REFERENCE GROOVE ON THE FLAT OF THE MASS, WHICH WILL ALIGN THE MEASUREMENT PIN DATUM SURFACE OF THE EAR BONDING JIG ASSEMBLY (DATUM D) RELATIVE TO THE CENTRAL GROOVE ON THE MASS AS SHOWN (19 NOMINAL).
- ADJUST ALIGNMENT UNTIL REFERENCE DATUM EDGES 'B' & 'C' ARE IN THE CORRECT POSITION FOR BONDING THE EAR.

DIMENSIONS ARE IN MILLIMETERS	
GENERAL TOLERANCES:	
0<-X<50mm:	± 0.1mm
50<-X<150mm:	± 0.2mm
150<-X<1000mm:	± 0.3mm
ANGULAR:	± 0.2°
GEOMETRIC TOLERANCES:	
ISO-2768-K	

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
1.	INTERPRET DRAWING PER BS8888.
2.	BREAK ALL SHARP EDGES 0.30 +/- 0.20 AND REMOVE ALL BURRS.
3.	DO NOT SCALE FROM DRAWING.
4.	ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.
MATERIAL	N/A
FINISH	N/A MICROMETERS

ITEM NO.	QTY.	DESCRIPTION	DWG. / PART NO.	MATERIAL
12	1	KAPTON TAPE 0.05mm THICK	N/A	KAPTON
11	2	DOWEL PIN, ∅ 2 mm x 10 LONG (McMASTER-CARR P/N)	91585A018	ST.ST.
10	2	HEX NUT 1/4-20	-	300 ST. ST.
9	2	SPRING PLUNGER, ROUND NOSE, 1/4-20 x 1 LONG (McMASTER CARR)	8688A151	316 ST. ST.
8	4	LOCKABLE MICROMETER (NEWPORT CORPORATION)	Newport-HR-13	VARIOUS
7	4	HEX SKT. HEAD CAP SCREW #2-56 x 0.3125 LONG	-	300 ST.ST.
6	1	ALIGNMENT GUIDE	LIGO-D1001633	NAT. PEEK
5	1	ALIGNMENT GUIDE	LIGO-D1001633	NAT. PEEK
4	1	1/4" STAINLESS STEEL BALL BEARING (McMASTER CARR P/N)	9529K15	440C ST. ST.
3	1	1/4" STAINLESS STEEL BALL BEARING (McMASTER CARR P/N)	9529K15	440C ST. ST.
2	1	1/4" STAINLESS STEEL BALL BEARING (McMASTER CARR P/N)	9529K15	440C ST. ST.
1	1	BASEPLATE	LIGO-D0901591	ALUMINIUM

		<b>EAR BONDING JIG ASSEMBLY</b>	
<b>ADVANCED LIGO</b>	<b>SUS</b>	DESIGNER: K.McINTYRE DRAFTER: K.McINTYRE CHECKER: M.v.VEGGEL APPROVAL: R.JONES	DWG. NO.: LIGO-D0901592 SCALE: 1:1 PROJECTION:
SHEET 1 OF 1		REV: v2	

Ear Bonding Jig Assembly, PART FROM REV.2, DRAWING FROM REV.