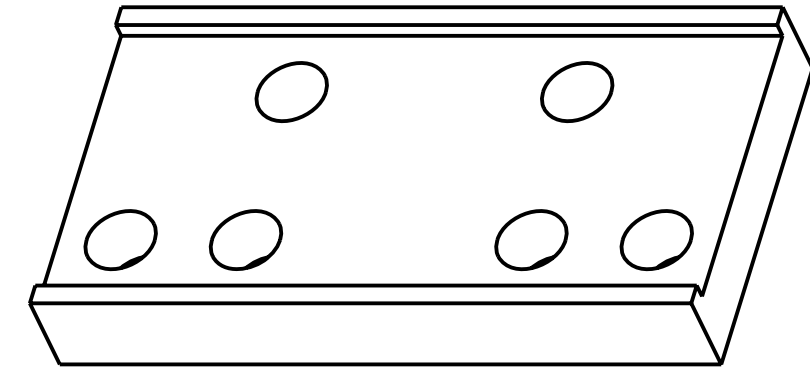
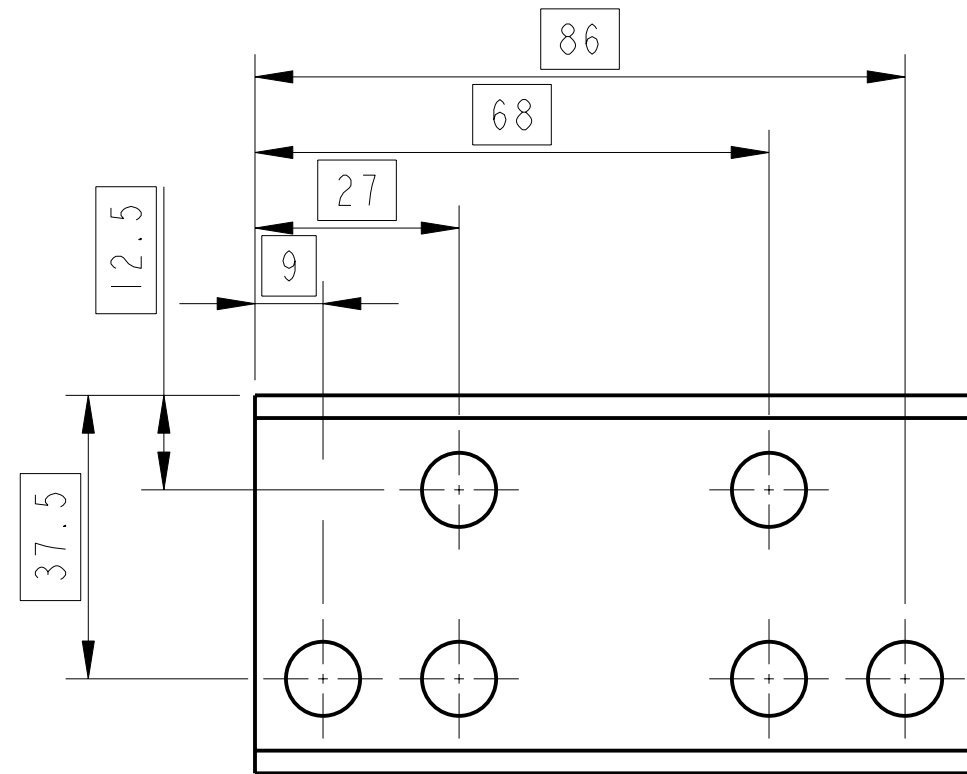
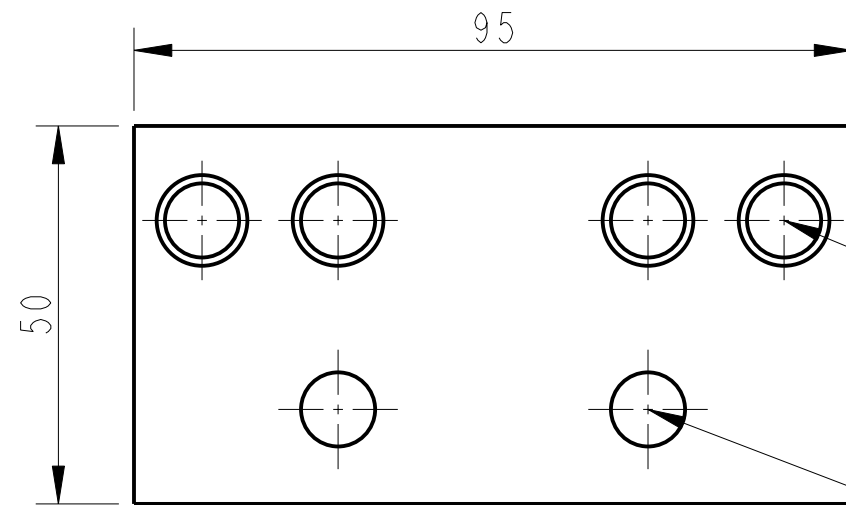
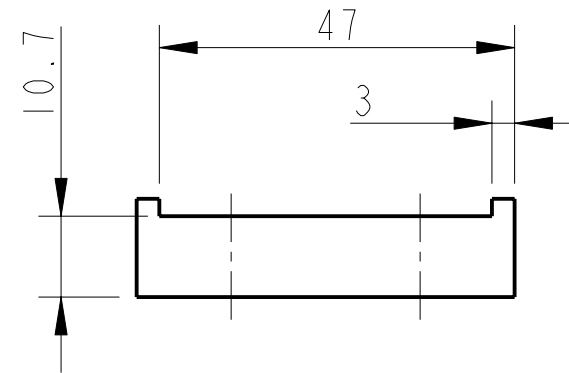


STAGE I MACHINING

REV.	DATE	DCN #	DRAWING TREE #
A	13/OCT/06	E060238	
E	15/JULY/08	E080367	



3D VIEW



DRILL 4 HOLES $\varnothing 9.8$ THRU
C'SINK $\varnothing 12$

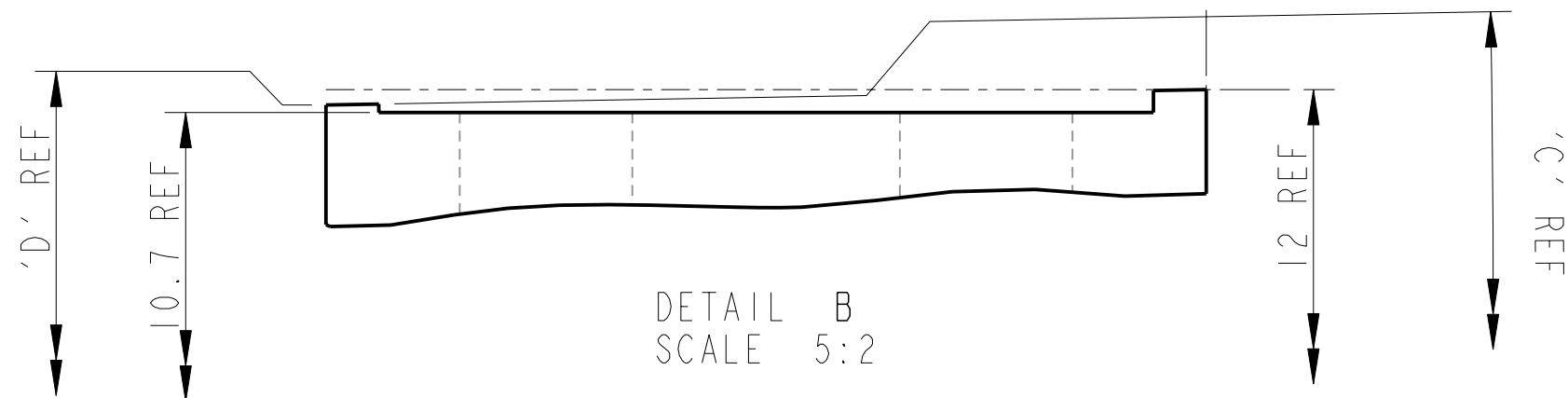
$\varnothing 0.2$

DRILL 2 HOLES $\varnothing 9.8$ THRU

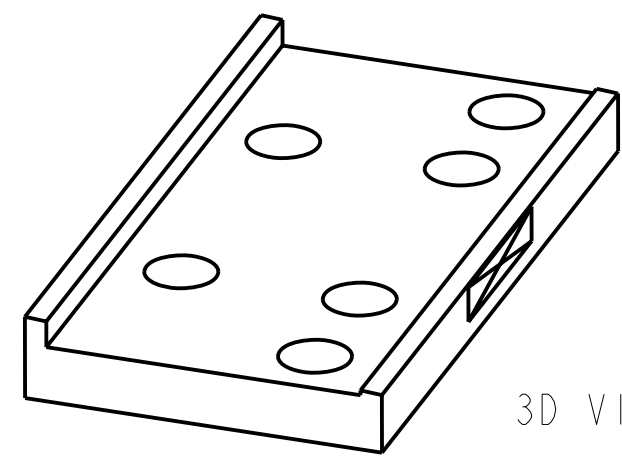
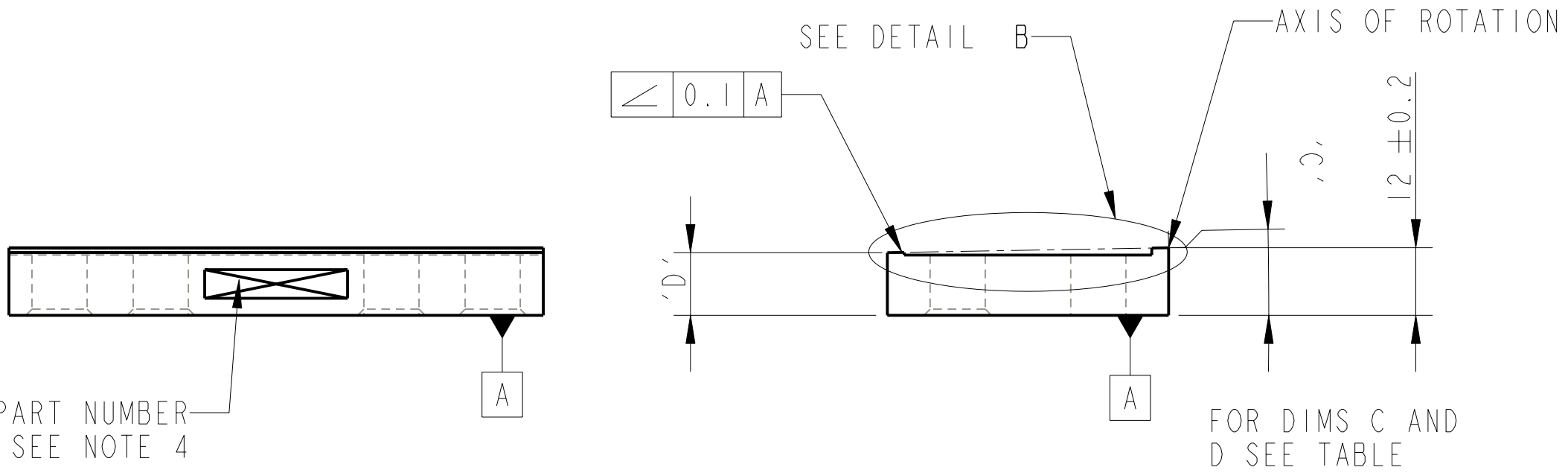
$\varnothing 0.2$

NOTES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES	
1. REMOVE ALL SHARP EDGES, R.02 MIN.	DIMENSIONS ARE IN mm [INCHES] TOLERANCES: X.XX ± 0.25 mm ANGULAR $\pm 0.25^\circ$	SYSTEM	aLIGO
2. DO NOT SCALE FROM DRAWING.		SUB-SYSTEM	SUS
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)	MATERIAL: ST STEEL 304/316	NEXT ASSY	QUAD TOP STAGE
4. 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.	FINISH: CLEAN AND DEGREASED $\sqrt{\mu m}$ [μin] Ra = 1.6 [63]	PART NAME	BLADE CLAMP (BTM HALF)
		SCALE	1:1
		PROJECTION	1st Angle
		SHEET	1 OF 2

STAGE 2 MACHINING



DETAIL B
SCALE 5:2



VARIANT	ANGLE C	DIM D
0	0°	12 REF
1	0.109°	11.90 REF
2	0.218°	11.80 REF
3	0.327°	11.71 REF
4	0.437°	11.62 REF
5	0.546°	11.52 REF
6	0.655°	11.43 REF
7	0.764°	11.33 REF
8	0.837°	11.27 REF
9	0.982°	11.14 REF
10	1.091°	11.05 REF

VARIANT	ANGLE C	DIM D
-10	-1.091°	12.95 REF
-9	-0.982°	12.86 REF
-8	-0.837°	12.73 REF
-7	-0.764°	12.67 REF
-6	-0.655°	12.57 REF
-5	-0.546°	12.48 REF
-4	-0.437°	12.38 REF
-3	-0.327°	12.29 REF
-2	-0.218°	12.2 REF
-1	-0.109°	12.1 REF

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 ±0.25 mm
ANGULAR ±0.25 °

MATERIAL: ST STEEL 304/316

FINISH: CLEAN AND DECREASED
√μm [μin] Ra = 1.6 [63]

NAME	DATE
DRAWN J O'DELL	03/NOV/09
CHECKED MB	15/MAR/10
APPROVED JOD	15/MAR/10

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
IGR, GLASGOW UNIVERSITY GEO 600 GROUP
RUTHERFORD APPLETON LABORATORIES

SYSTEM **aLIGO**

SUB-SYSTEM **SUS**

NEXT ASSY **QUAD TOP STAGE**

PART NAME **BLADE CLAMP (BTM HALF)**

SIZE **B** DRG. NO. **D060327** REV **F.**

SCALE 1:1 PROJECTION: SHEET 2 OF 2