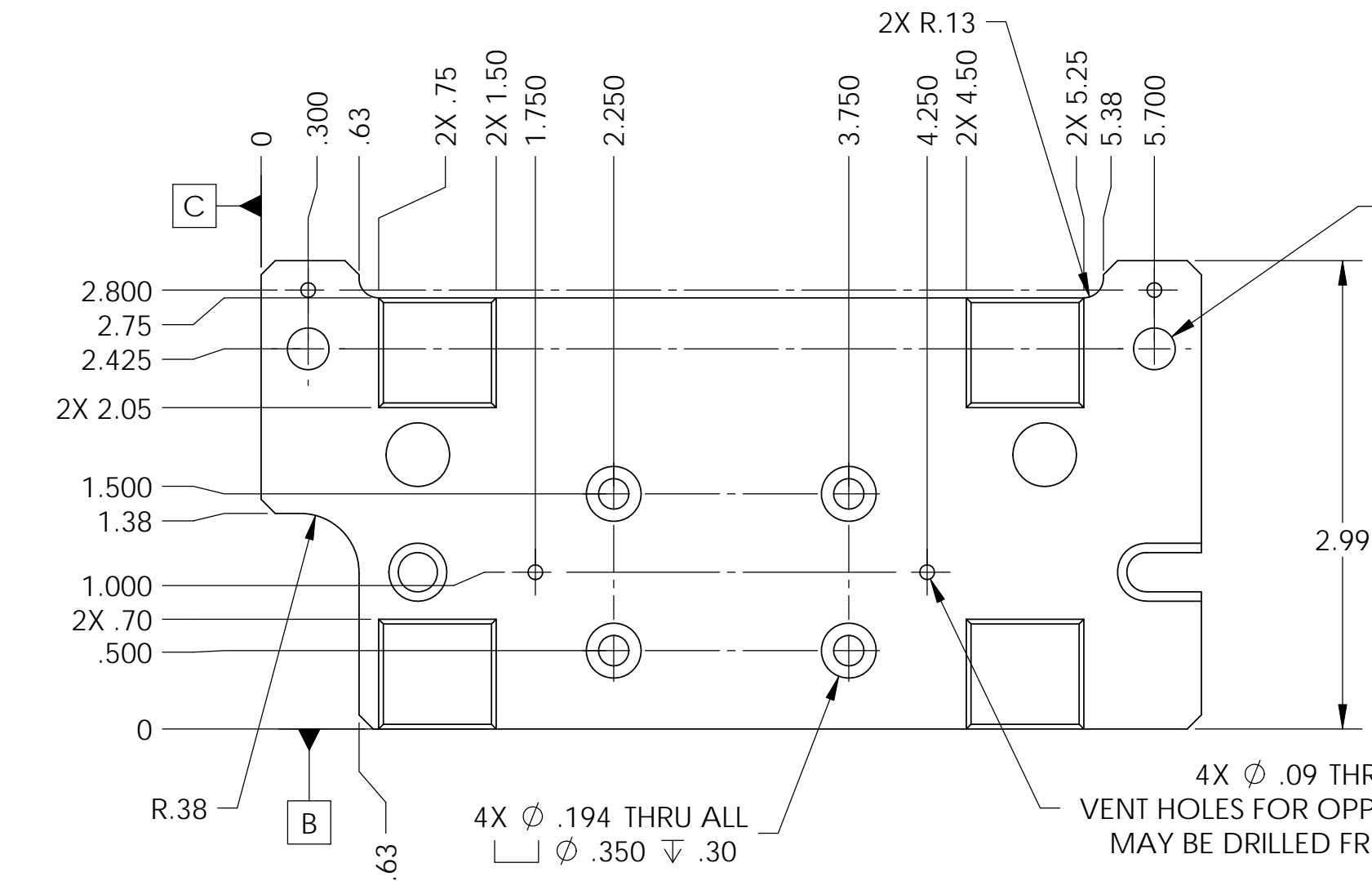


D0902134_Small Horizontal Actuator Magnet to Stage2 Interposer, PART PDM REV: X-019, DRAWING PDM REV: X-003

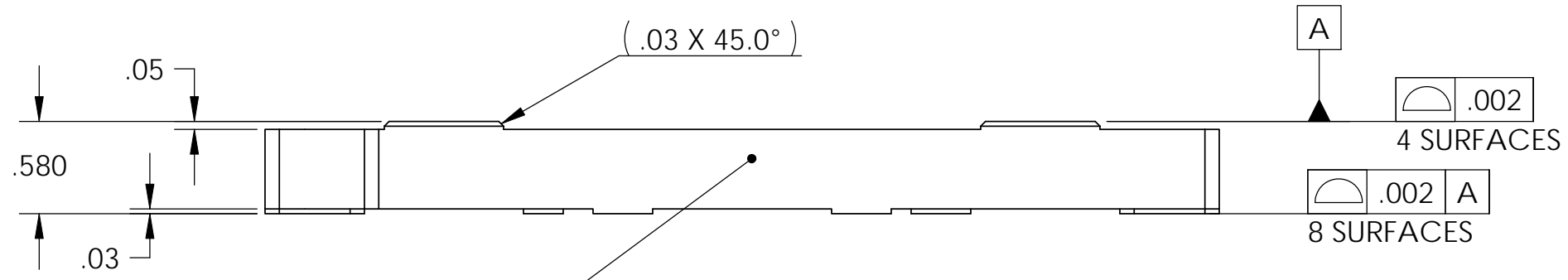
- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12 HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
EXAMPLE DXXXXXX-VY, TYPE-XX, S/N XXX.
 - 6. APPROXIMATE WEIGHT = 0.7 LB.
 - 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 - 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - 9. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
 - 10. A TRUE POSITION TOLERANCE OF ϕ .010 IS - THE SAME AS A CONVENTIONAL TOLERANCE OF \pm .005.

REV.	DATE	DCN #	DRAWING TREE #
v1	19 Mar. 2010	E1000049	E1000025



2X ϕ .27 THRU ALL
 \checkmark ϕ .36 X 120°, NEAR SIDE
 TAP FOR 1/4-20
 HELICOIL INSERT = 1.5 * DIA.
 FROM FAR SIDE

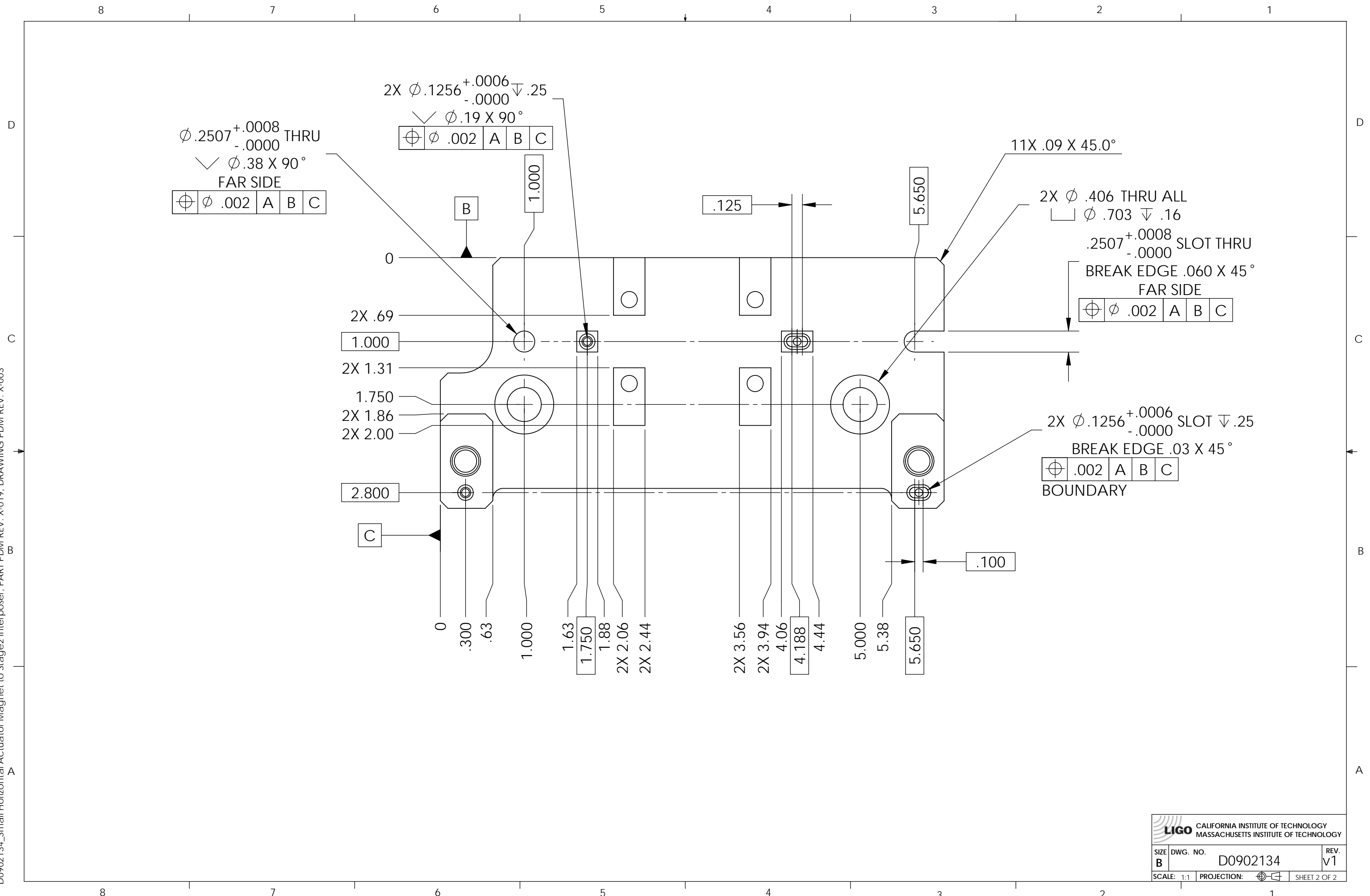
4X ϕ .09 THRU ALL
 VENT HOLES FOR OPP SIDE FEATURES
 MAY BE DRILLED FROM FAR SIDE



BOTTOM VIEW SEE SHEET 2

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES				1. INTERPRET DRAWING PER ASME Y14.5-1994.		MAGNET TO STAGE2 INTERPOSER, aLIGO BSC ISI					
TOLERANCES: .XX \pm .015 .XXX \pm .005				2. BREAK ALL EDGES AND CORNERS .03 X 45°.		SYSTEM		SUB-SYSTEM		DESIGNER	
ANGULAR \pm .5°				3. DO NOT SCALE FROM DRAWING.		ADVANCED LIGO		SEI		S.BARNUM	
MATERIAL				4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		NEXT ASSY		D0902530		19 Mar. 2010	
6061-T6 Al				FINISH		D0902134		DWG. NO.		SIZE	
63 μ inch				63 μ inch		B		D0902134		B	
										19 Mar. 2010	
										19 Mar. 2010	
										19 Mar. 2010	
										SCALE: 1:1	
										PROJECTION:	
										SHEET 1 OF 2	

D0902134_Small Horizontal Actuator Magnet to Stage2 Interposer, PART PDM REV: X-019, DRAWING PDM REV: X-003



$\phi .2507^{+.0008}_{-.0000}$ THRU
 $\sphericalangle \phi .38 \times 90^\circ$
 FAR SIDE
 $\oplus \phi .002$ A B C

$2X \phi .1256^{+.0006}_{-.0000} \sphericalangle .25$
 $\sphericalangle \phi .19 \times 90^\circ$
 $\oplus \phi .002$ A B C

11X .09 X 45.0°

2X $\phi .406$ THRU ALL
 $\phi .703 \sphericalangle .16$
 $.2507^{+.0008}_{-.0000}$ SLOT THRU
 BREAK EDGE .060 X 45°
 FAR SIDE
 $\oplus \phi .002$ A B C

2X $\phi .1256^{+.0006}_{-.0000}$ SLOT $\sphericalangle .25$
 BREAK EDGE .03 X 45°
 $\oplus .002$ A B C
 BOUNDARY

2X .69
 1.000
 2X 1.31
 1.750
 2X 1.86
 2X 2.00
 2.800

0
 .300
 .63
 1.000
 1.63
 1.750
 1.88
 2X 2.06
 2X 2.44

.125

5.650

.100

2X 3.56
 2X 3.94
 4.06
 4.188
 4.44
 5.000
 5.38
 5.650

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 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D0902134	V1
SCALE: 1:1	PROJECTION:	SHEET 2 OF 2