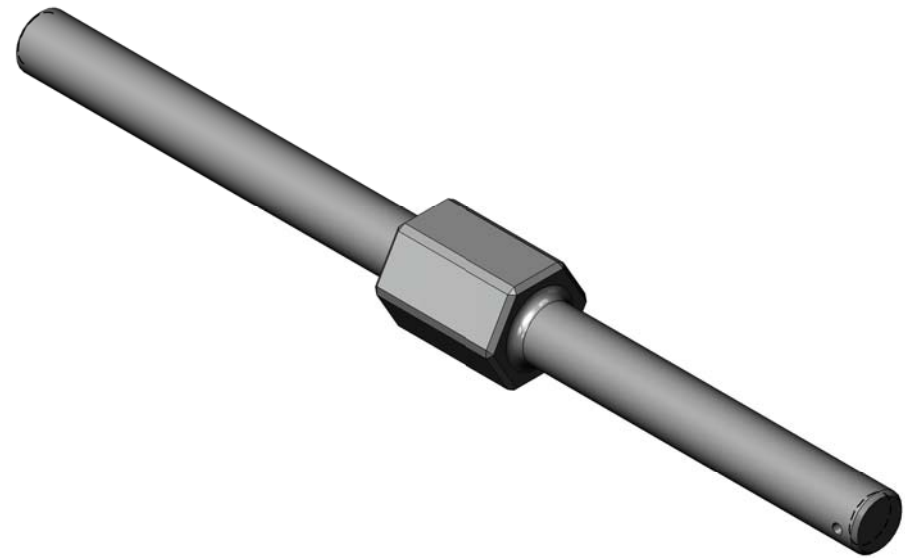
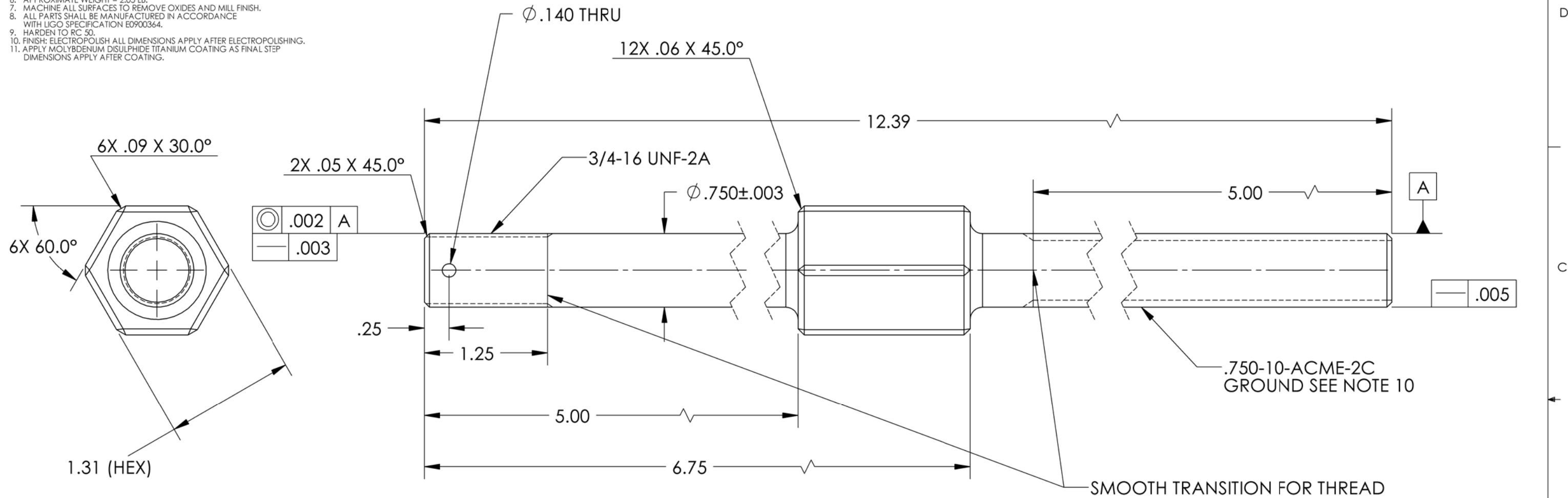


D0902193 Spring Preload Puller Bolt, Blade Puller Assy, Stage 1-2, aLIGO BSC ISI, PART PDM REV: X-011, DRAWING PDM REV: X-006

REV.	DATE	DCN #	DRAWING TREE #
v1	19 Feb. 2010	E0900391	E1000025
v2	22 June 2010	E1000224	E1000025

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 DXXXXXXX-VY, TYPE-XX, S/N XXX.
6. APPROXIMATE WEIGHT = 2.05 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. HARDEN TO RC 50.
10. FINISH: ELECTROPOLISH ALL DIMENSIONS APPLY AFTER ELECTROPOLISHING.
11. APPLY MOLYBDENUM DISULPHIDE TITANIUM COATING AS FINAL STEP DIMENSIONS APPLY AFTER COATING.



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .015 .XXX ± .005	
ANGULAR ± 0.5°	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
MATERIAL	420 SSSL SEE NOTE 11
FINISH	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		SPRING BLADE PULLER BOLT, BLADE PULLER ASSY, STAGE 1-2, aLIGO BSC ISI	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	SEI	DESIGNER	S.BARNUM 09 Feb. 2010
NEXT ASSY	D0902454	CHECKER	F.MATICHARD 19 Feb. 2010	APPROVAL	K.MASON 19 Feb. 2010
SIZE	B	DWG. NO.	D0902193		REV.
SCALE	1:1	PROJECTION			SHEET 1 OF 1