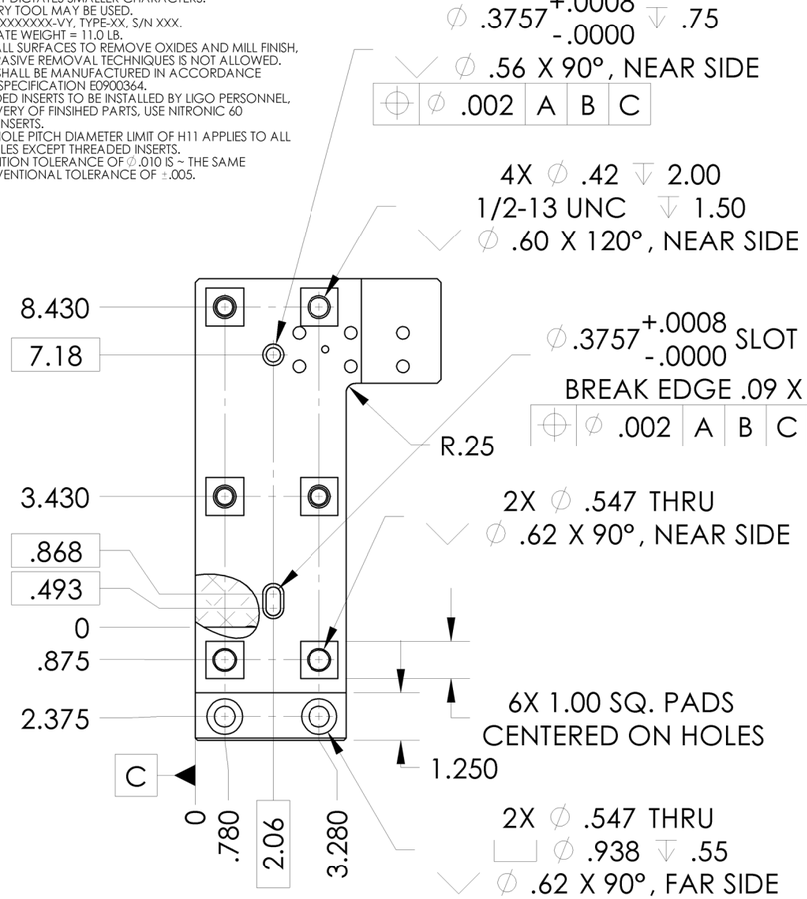
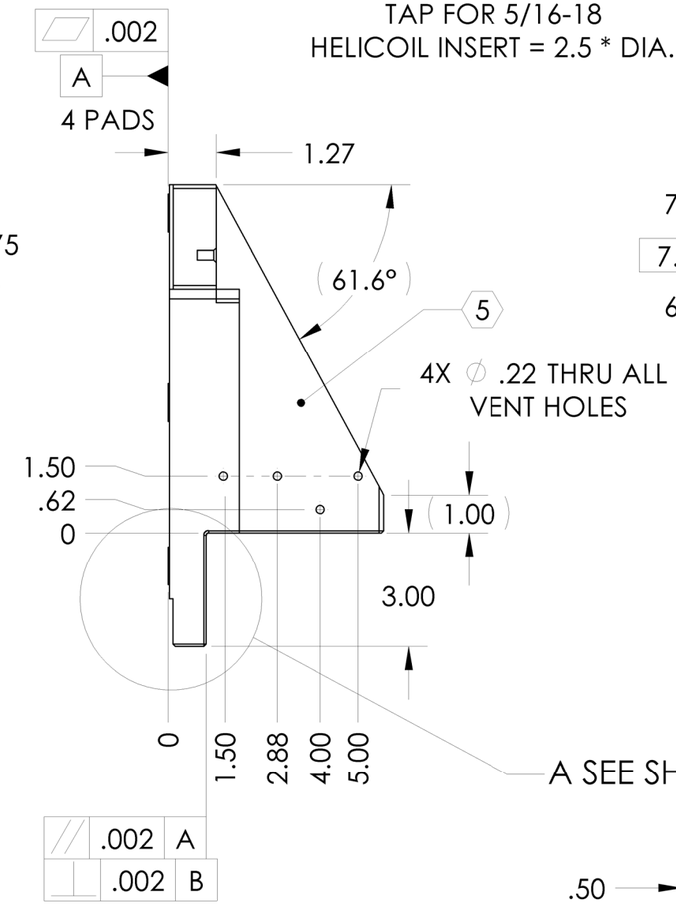
REV.	DATE	DCN #	DRAWING TREE #
v1	12 Mar. 2010	E0900495	E1000025

NOTES CONTINUED:

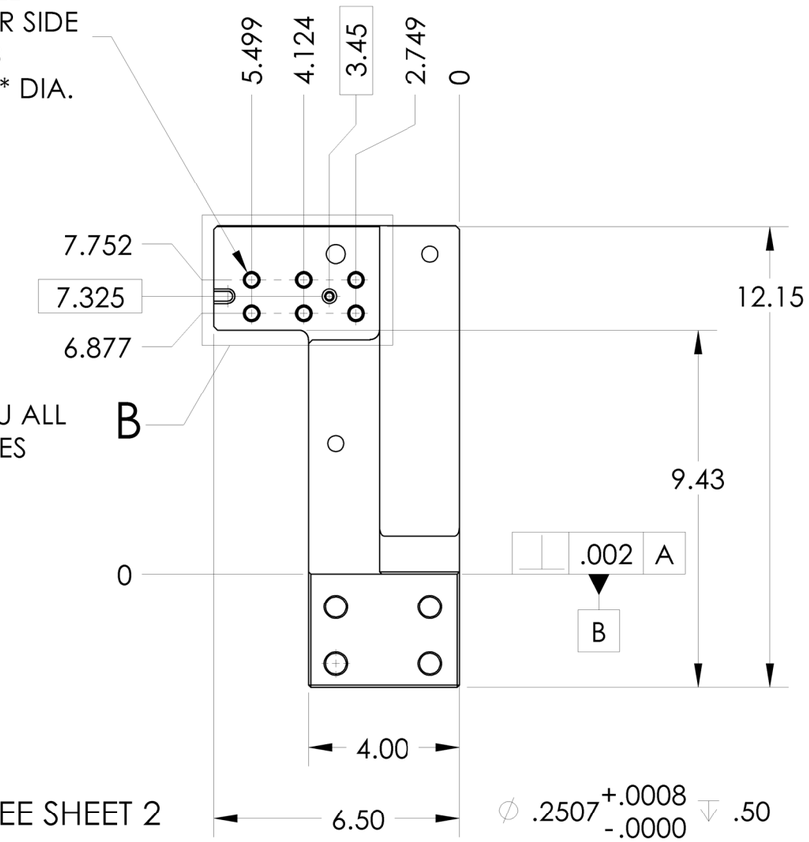
(5) SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIENT OR "TYPE" IF APPLICABLE ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 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.

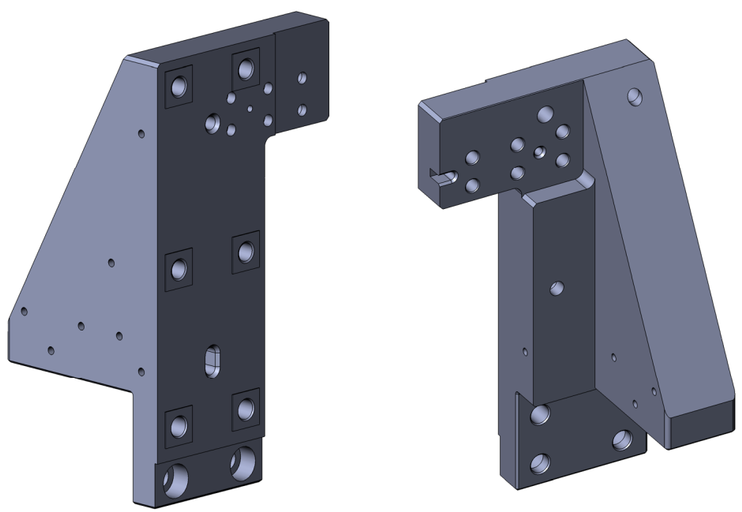
6. APPROXIMATE WEIGHT = 11.0 LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
9. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINSIHED PARTS, USE NITRONIC 60 THREADED INSERTS.
10. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES TO ALL TAPPED HOLES EXCEPT THREADED INSERTS.
11. A TRUE POSITION TOLERANCE OF ∅.010 IS ~ THE SAME AS A CONVENTIONAL TOLERANCE OF ±.005.

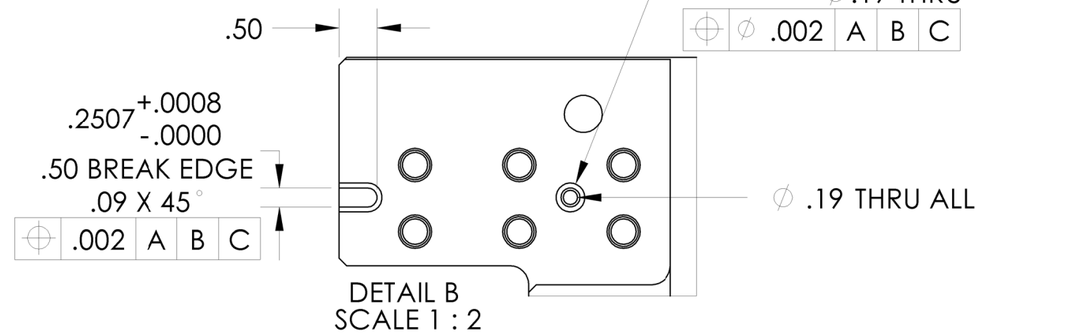




BOTTOM VIEW SEE SHEET 2
SCALE 1:2







DETAIL B
SCALE 1 : 2

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .015
.XXX ± .005

ANGULAR ± .5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. BREAK ALL EDGES AND CORNERS .03 X 45°.
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: 6061-T6 Al
FINISH: 63 µinch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

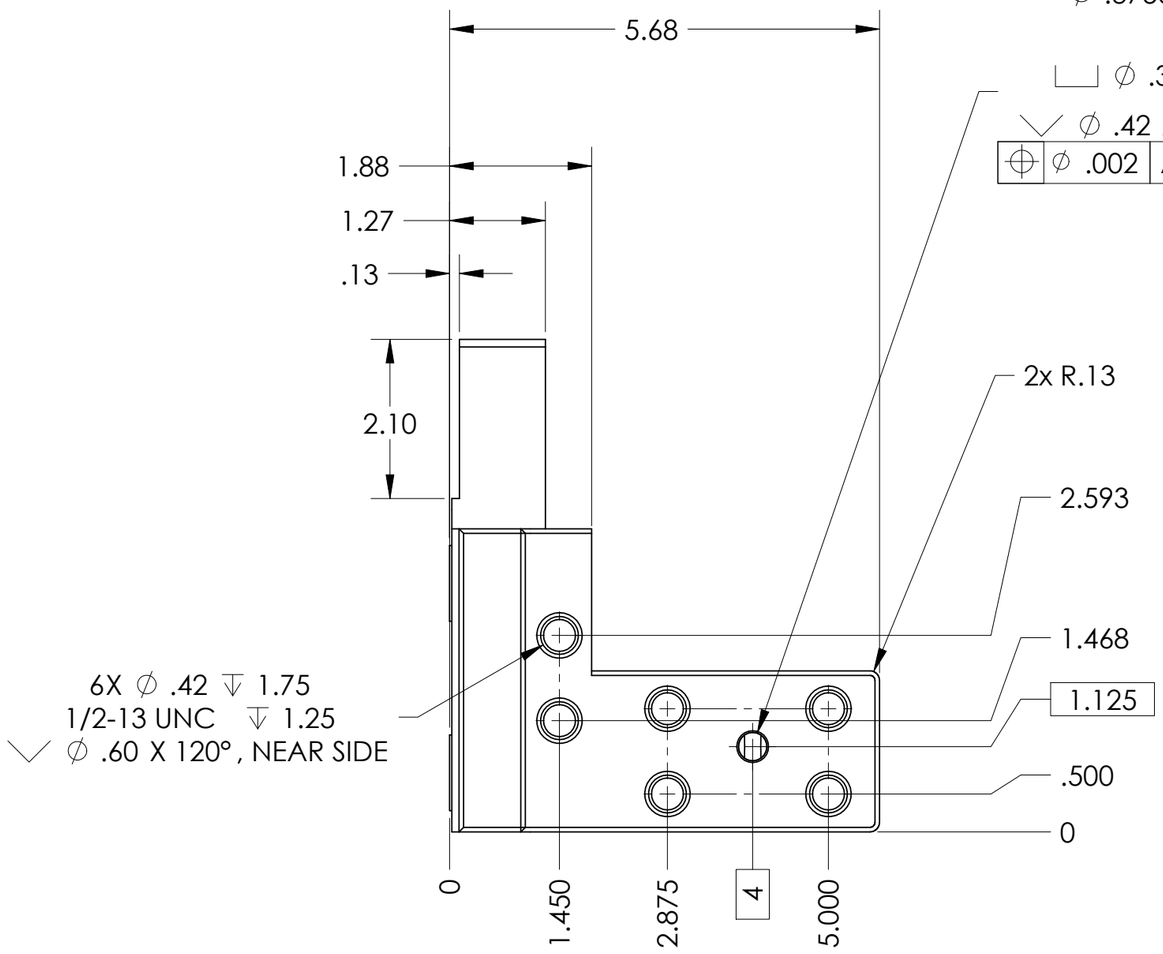
SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SEI
NEXT ASSY: D0901180

PART NAME: FLEXURE ROD GUSSET, STAGE 1, aLIGO BSC ISI

DESIGNER	F.MATICHARD	15 Jan. 2010	
DRAFTER	M.HILLARD	15 Jan. 2010	
CHECKER	A.STEIN	15 Jan. 2010	
APPROVAL	K.MASON	15 Jan. 2010	

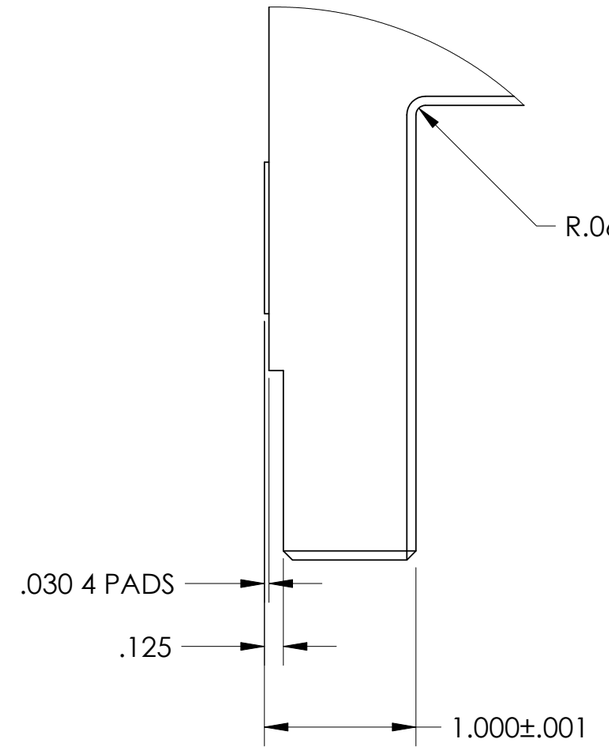
SIZE: B — DWG. NO.: D0902277 — REV.: v1
SCALE: 1:4 — PROJECTION: — SHEET 1 OF 2

D0902277 Flexure Rod Gusset, Stage 1, BSC-ISI, PART PDM REV: X-021, DRAWING PDM REV: X-006



BOTTOM VIEW

DETAIL A SEE SHEET 2
SCALE 1 : 1



D0902277 Flexure Rod Gusset, Stage 1, BSC-ISI, PART PDM REV: X-021, DRAWING PDM REV: X-006

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY			
SIZE B	DWG. NO. D0902277		REV. v1
SCALE: 1:2	PROJECTION:	SHEET 2 OF 2	