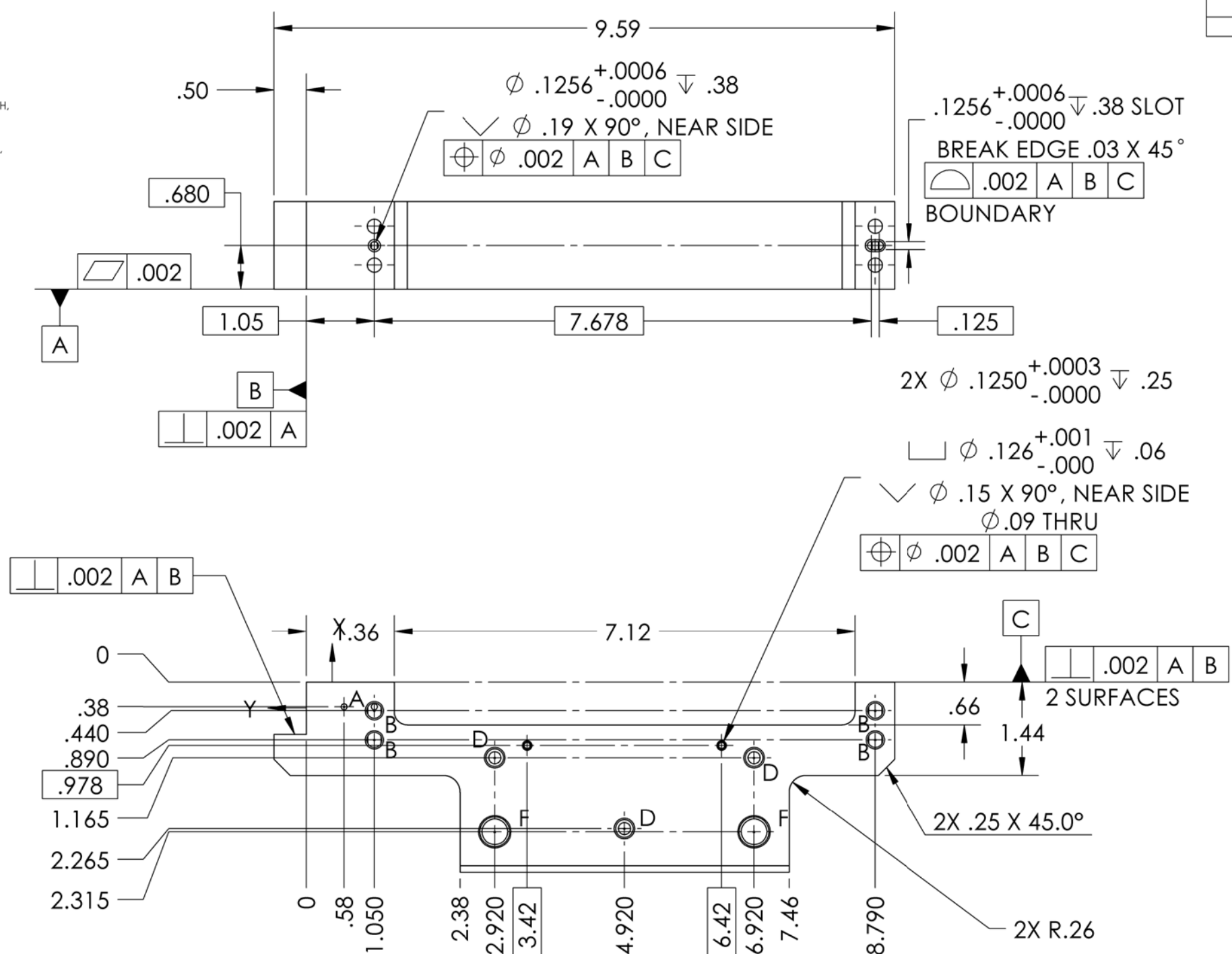


D0902427 Stage0-1 Actuator Coil Bracket - Horizontal, PART PDM REV: X-008, DRAWING PDM REV: X-009

- 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 = 2.047 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 $\phi .010$ IS THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.

| REV. | DATE | DCN # | DRAWING TREE # |
|------|--------------|----------|----------------|
| v1 | 22 Feb. 2010 | E1000049 | E1000025 |
| | | | |



| TAG | SIZE | QUANTITY |
|-----|---|----------|
| A | $\phi .09$ THRU ALL | 1 |
| B | $\phi .201 \downarrow .42$ $\phi .28 \times 90^\circ$, NEAR SIDE TAP FOR #10-32 HELICOIL INSERT = 1.5 * DIA. | 4 |
| D | $\phi .272 \downarrow .94$ TAP FOR 1/4-20 HELICOIL INSERT = 2.0 * DIA. | 3 |
| F | $\phi .40 \downarrow 1.36$ $\phi .50 \times 90^\circ$, NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA. | 2 |

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX $\pm .015$
 .XXX $\pm .005$
 ANGULAR $\pm 0.5^\circ$

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.

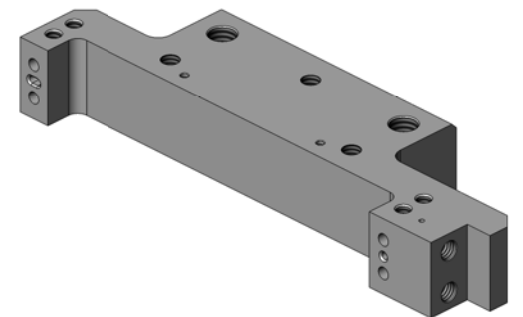
MATERIAL: 6061-T6 Al
 FINISH: 63 μ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

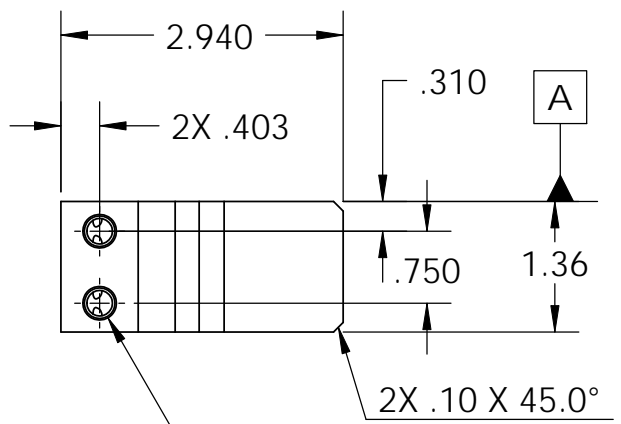
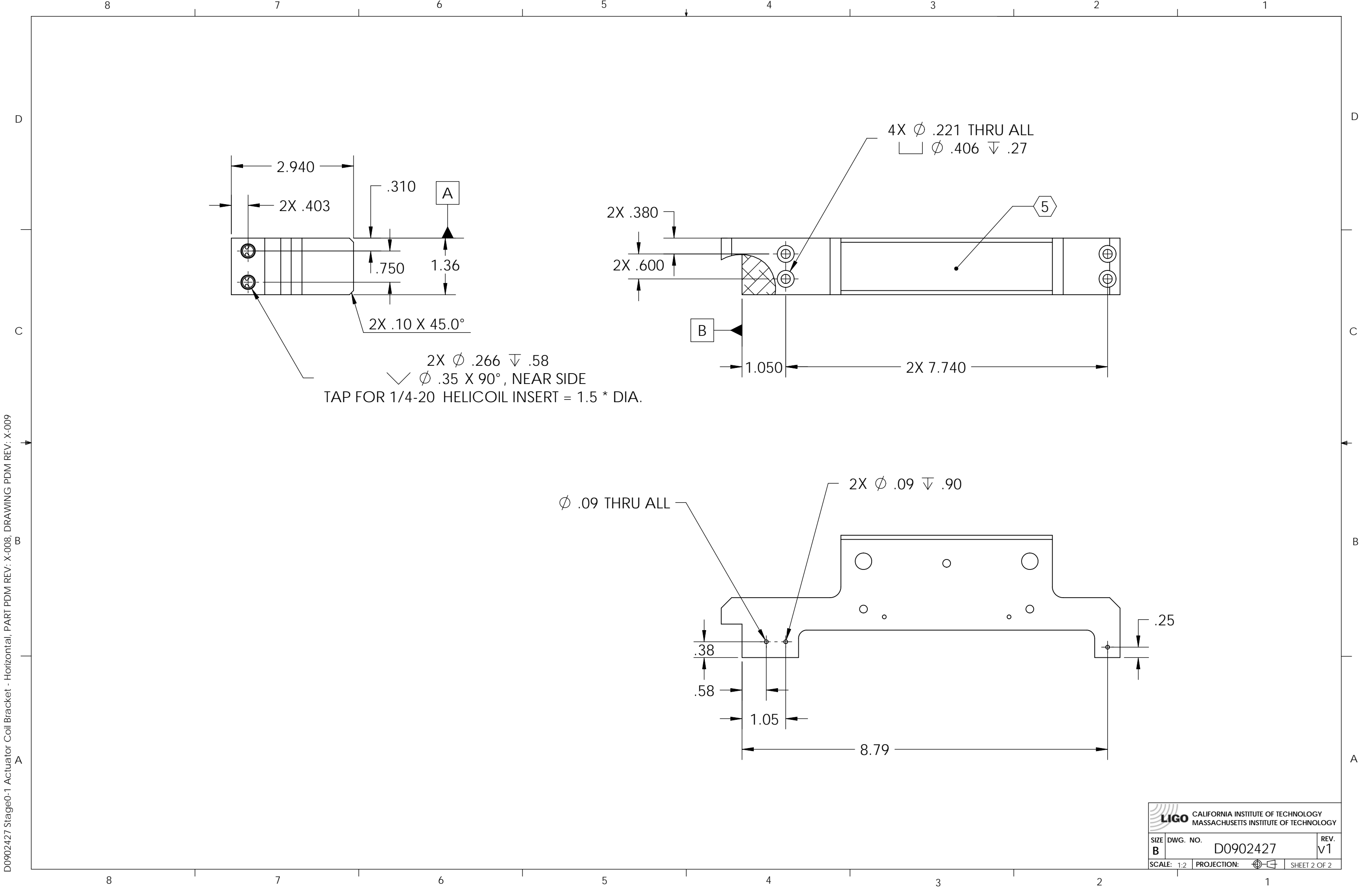
PART NAME: ACTUATOR COIL BRACKET HORIZONTAL, STAGE 0-1, aLIGO BSC ISI

| | | | | | |
|----------|-------------|--------------|--------|----------|-------------|
| DESIGNER | S.BARNUM | 22 Feb. 2010 | SIZE | DWG. NO. | REV. |
| DRAFTER | M.HILLARD | 22 Feb. 2010 | B | D0902427 | v1 |
| CHECKER | F.MATICHARD | 22 Feb. 2010 | SCALE: | 1:2 | PROJECTION: |
| APPROVAL | K.MASON | 22 Feb. 2010 | SHEET | 1 OF 2 | |

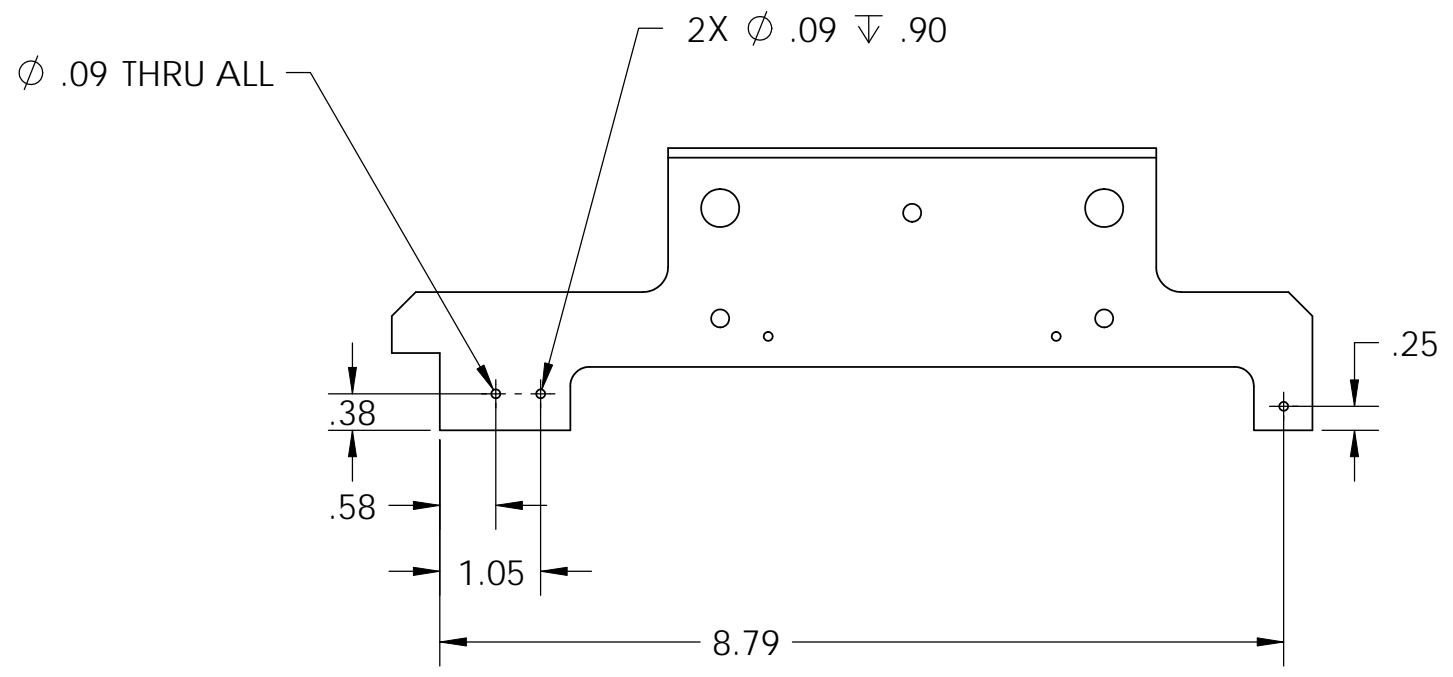
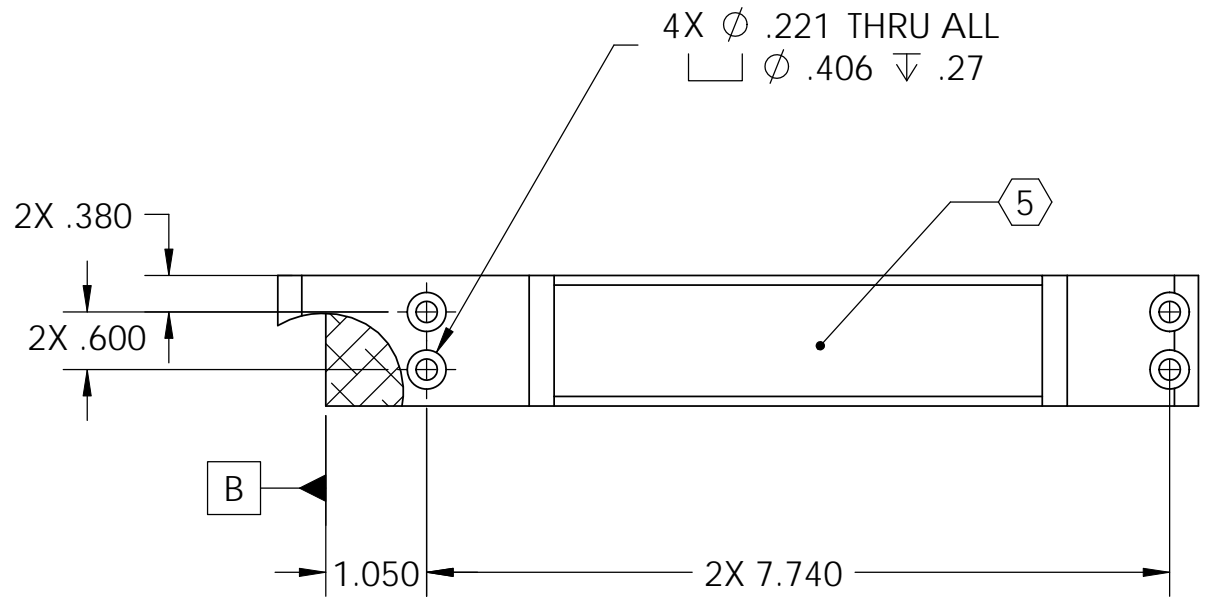
SYSTEM: ADVANCED LIGO
 SUB-SYSTEM: SEI
 NEXT ASSY: D0901102





D0902427 Stage0-1 Actuator Coil Bracket - Horizontal, PART PDM REV: X-008, DRAWING PDM REV: X-009



2X ϕ .266 ∇ .58
 ∇ ϕ .35 X 90°, NEAR SIDE
TAP FOR 1/4-20 HELICOIL INSERT = 1.5 * DIA.



| | | |
|---|---|--------------|
|  CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY | | |
| SIZE B | DWG. NO. D0902427 | REV. V1 |
| SCALE: 1:2 | PROJECTION:  | SHEET 2 OF 2 |