

8

7

6

5

4

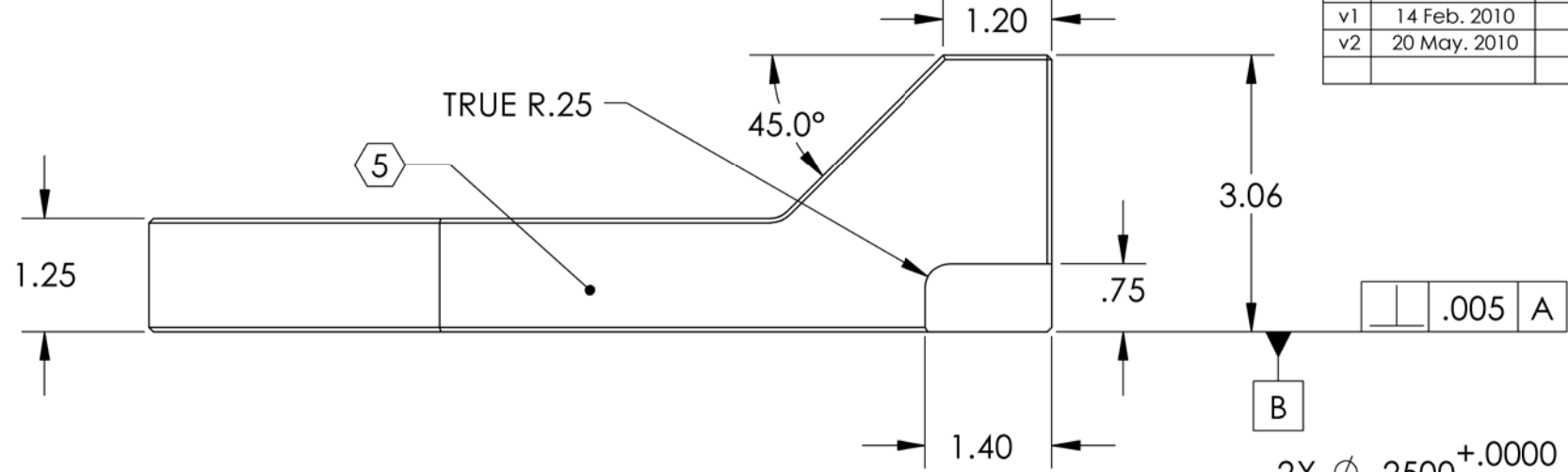
3

2

1

REV.	DATE	DCN #	DRAWING TREE #
v1	14 Feb. 2010	E1000028	E1000025
v2	20 May. 2010	E1000174	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: DXXXXXXXX-VY, TYPE-XX, S/N XXX
 6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 7. APPROXIMATE WEIGHT: 15.5LB.
 8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH.
 9. ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.

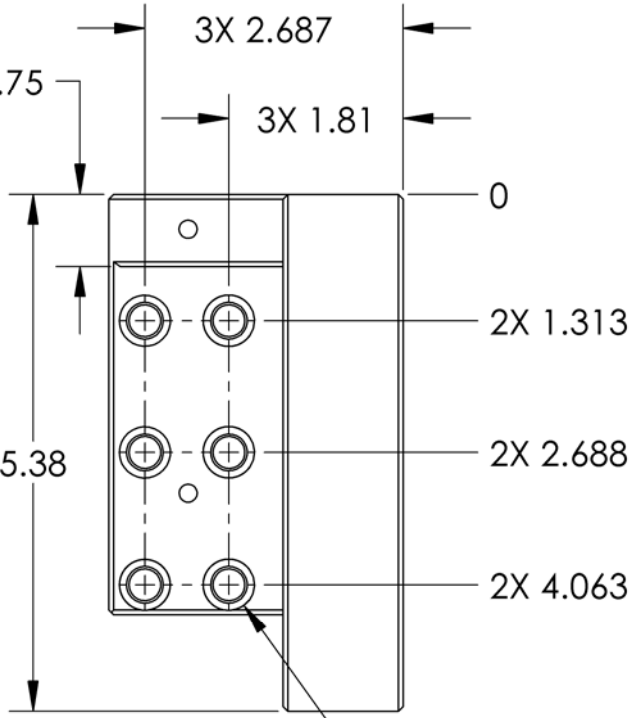


2X $\phi .2500^{+0.0000}_{-0.0004}$ $\nabla .38$

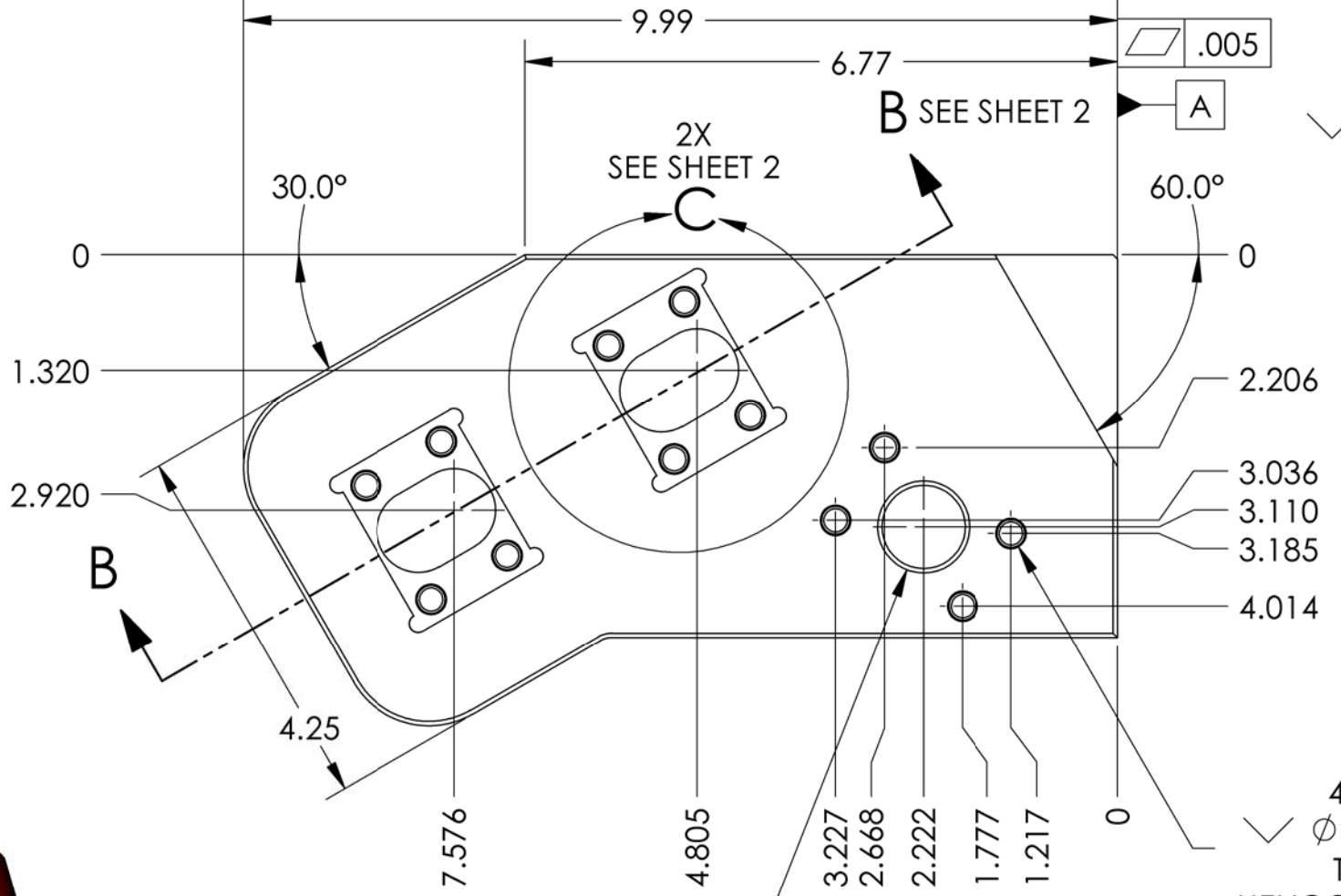
$\nabla \phi .251^{+0.001}_{-0.000}$ $\nabla .10$

$\nabla \phi .28 \times 90^\circ$, NEAR SIDE
 $\phi .19$ THRU

$\oplus .002$ (M) A B C

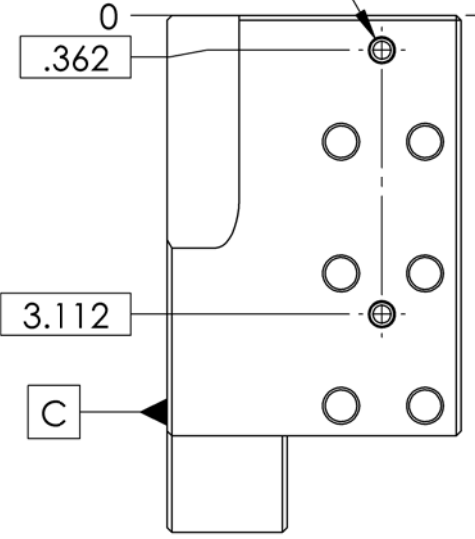


6X $\phi .33$ THRU ALL
 $\nabla \phi .53 \nabla .31$
 $\nabla \phi .38 \times 90^\circ$, MID SIDE
 $\nabla \phi .38 \times 90^\circ$, FAR SIDE



$\phi .95$ THRU
 $\nabla \phi 1.05 \times 90^\circ$
 NEAR SIDE AND FAR SIDE

4X $\phi .27 \nabla 1.00$
 $\nabla \phi .35 \times 90^\circ$, NEAR SIDE
 TAP FOR 1/4-20
 HELICOIL INSERT = 2.0 * DIA.



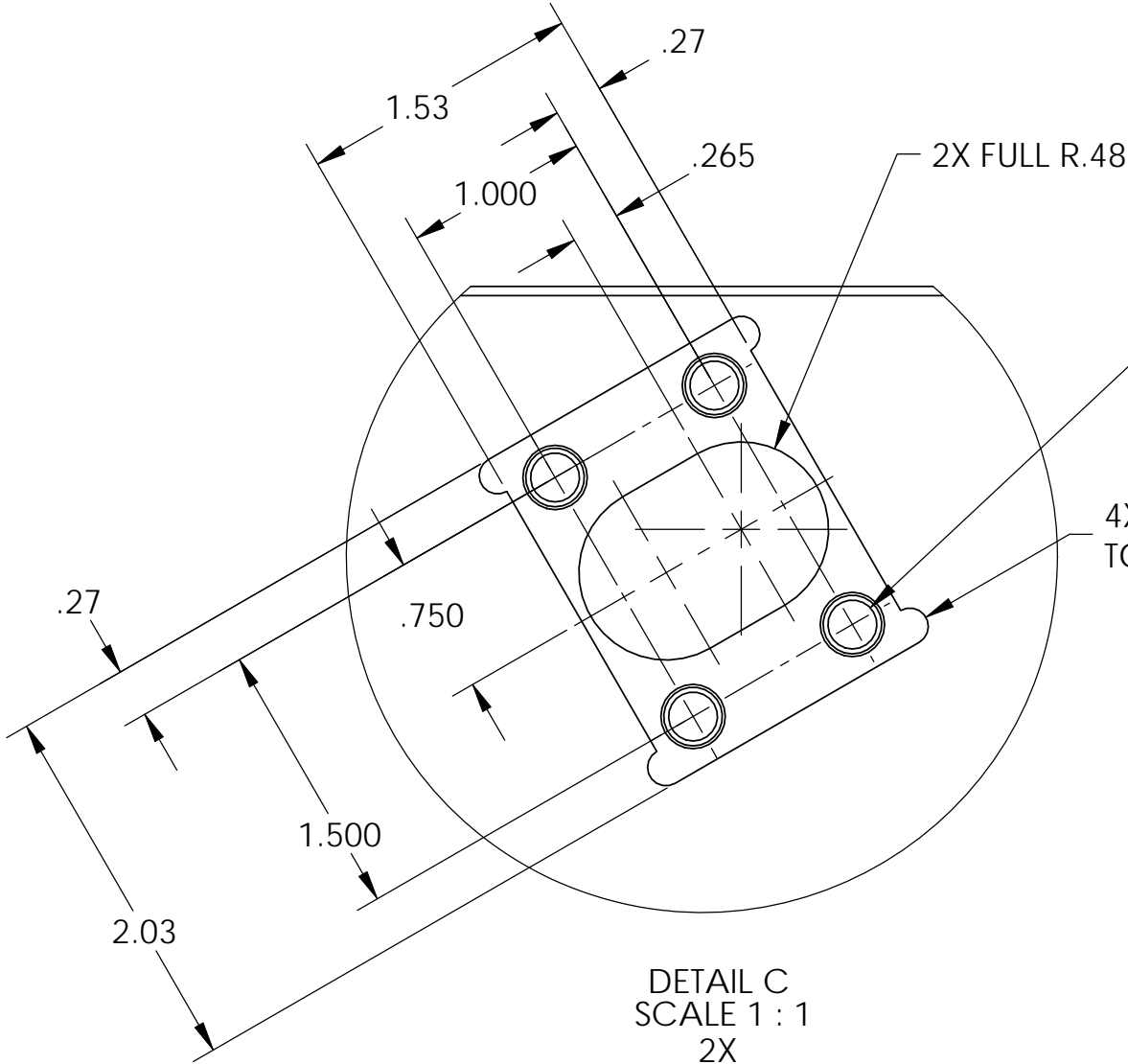
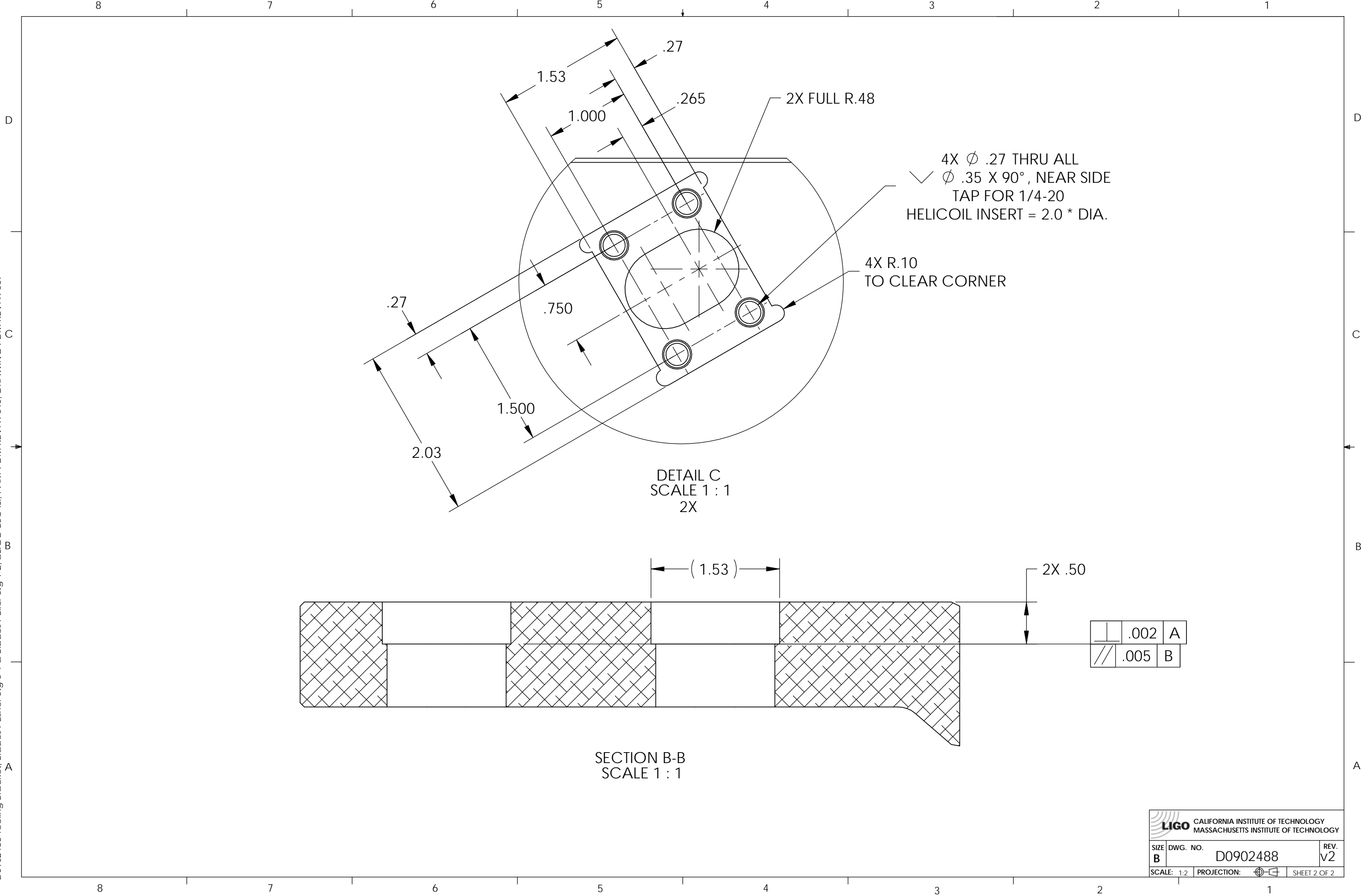
D0902488 Tooling Bracket, Blades Pusher Stg 0-1 & Blades Puller Stg 1-2, aLIGO BSC-ISI, PART PDM REV: X-015, DRAWING PDM REV: X-007

DIMENSIONS ARE IN INCHES		TOLERANCES: .XX $\pm .015$.XXX $\pm .005$		ANGULAR $\pm .5^\circ$	
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)					
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	304 SSSL	FINISH	32 μ inch	SYSTEM	ADVANCED LIGO
NEXT ASSY	D0902464	SUB-SYSTEM	SEI	DESIGNER	S.BARNUM 09 Feb. 2010
				DRAFTER	M.HILLARD 14 FEB 2010
				CHECKER	F.MATICHARD 14 FEB 2010
				APPROVAL	K.MASON 14 FEB 2010

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY				PART NAME			
TOOLING BRACKET, BLADES PUSHER STG 0-1 & BLADES PULLER STG 1-2, aLIGO BSC ISI							
DESIGNER	S.BARNUM	09 Feb. 2010	SIZE	DWG. NO.			
DRAFTER	M.HILLARD	14 FEB 2010	B	D0902488		REV.	
CHECKER	F.MATICHARD	14 FEB 2010				v2	
APPROVAL	K.MASON	14 FEB 2010	SCALE: 1:2	PROJECTION:			SHEET 1 OF 2

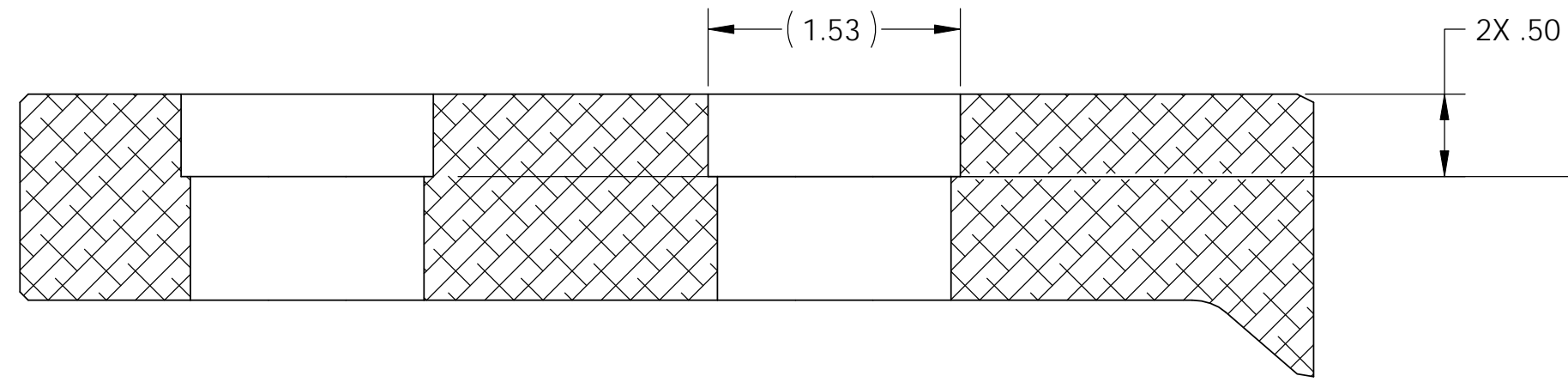
8 7 6 5 4 3 2 1

D0902488 Tooling Bracket, Blades Pusher Stg 0-1 & Blades Puller Stg 1-2, allIGO BSC-ISI, PART PDM REV: X-015, DRAWING PDM REV: X-007



4X ϕ .27 THRU ALL
 ϕ .35 X 90°, NEAR SIDE
TAP FOR 1/4-20
HELICOIL INSERT = 2.0 * DIA.

DETAIL C
SCALE 1 : 1
2X



SECTION B-B
SCALE 1 : 1

	.002	A
	.005	B

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D0902488	v2
SCALE: 1:2	PROJECTION:	SHEET 2 OF 2