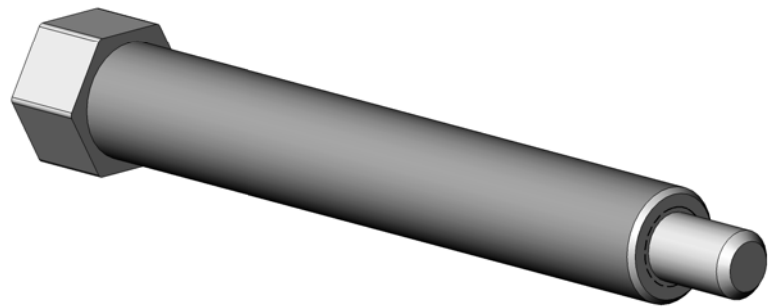
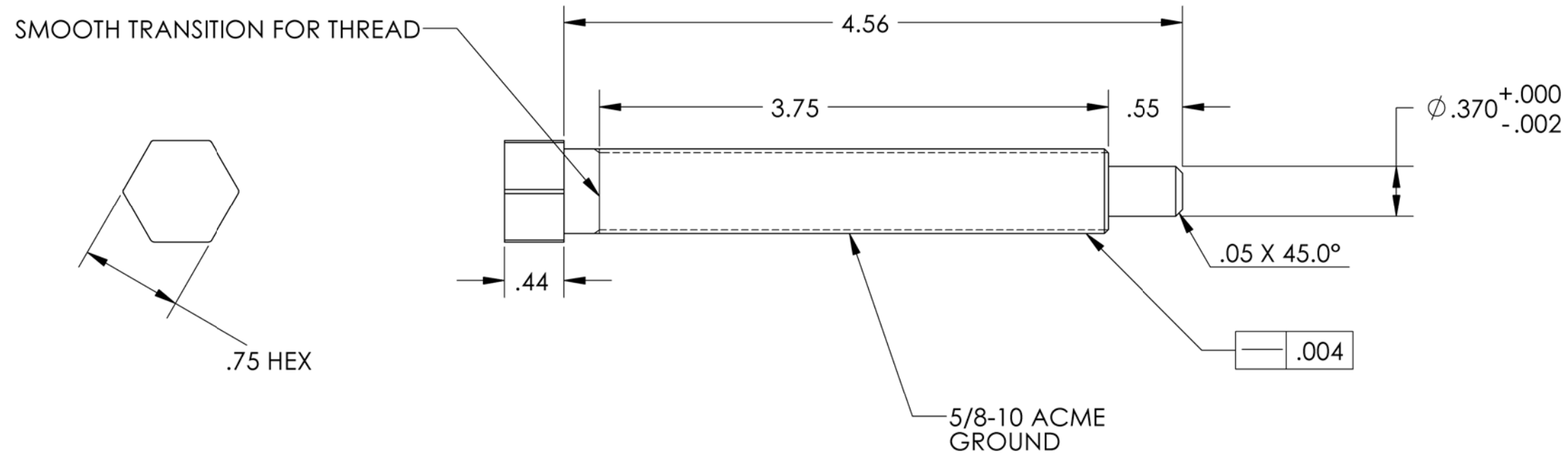


D0902599 Step 1 Bolt, Stage 0-1 Blade Pusher, aLIGO BSC-ISI, PART PDM REV: X-008, DRAWING PDM REV: X-008

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 DXXXXXX-VY, TYPE-XX, S/N XXX.
 6. APPROXIMATE WEIGHT = 0.423 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.
 11. APPLY MOLYBDENUM DISULPHIDE TITANIUM COATING AS FINAL STEP DIMENSIONS APPLY AFTER COATING.



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. 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.		SYSTEM ADVANCED LIGO		SUB-SYSTEM SEI		STEP 1 BOLT, STAGE 0-1 BLADE PUSHER, aLIGO BSC-ISI				
TOLERANCES: .XX ± .015 .XXX ± .005		MATERIAL 420 SSSL SEE NOTE 11		FINISH 32 μinch		NEXT ASSY D0902464		DESIGNER S.BARNUM	DATE 09 Feb. 2010	SIZE B	DWG. NO. D0902599	REV. v2
ANGULAR ± .5°						CHECKER F.MATICHARD		DATE 14 FEB 2010	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1	
						APPROVAL K.MASON		DATE 14 FEB 2010				