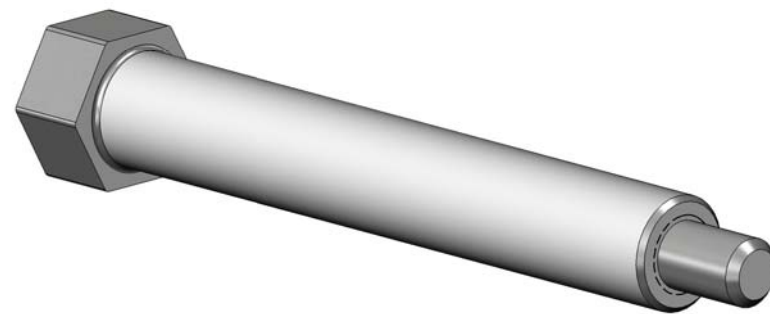
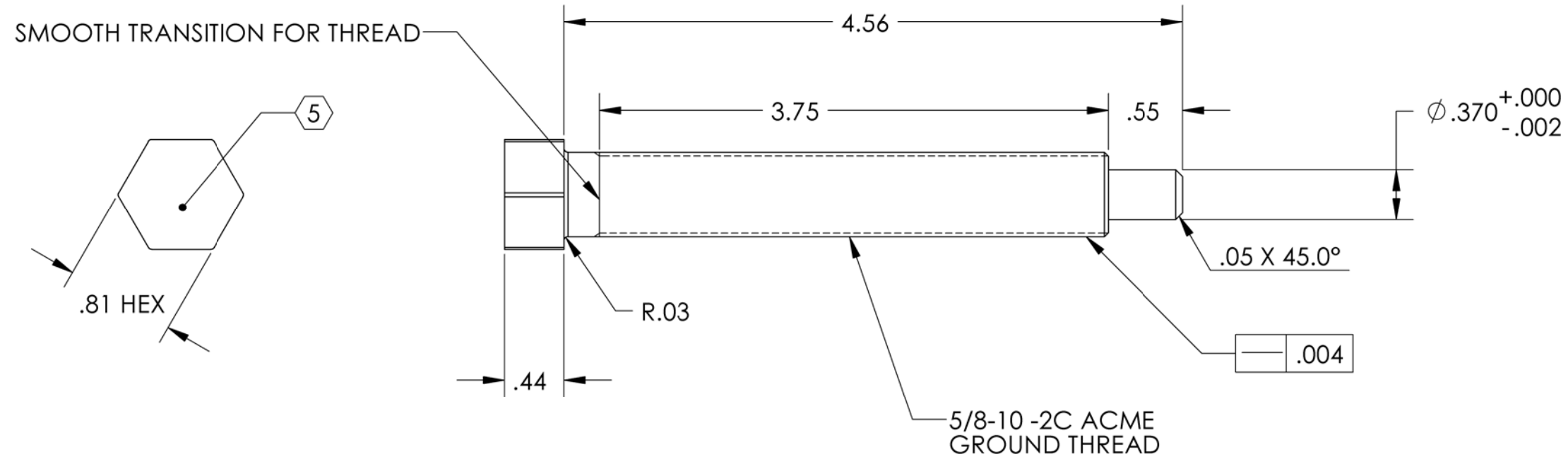


D0902599 Step 1 Bolt, Stage 0-1 Blade Pusher, aLIGO BSC-ISI, PART PDM REV: X-012, DRAWING PDM REV: X-011

| REV. | DATE | DCN # | DRAWING TREE # |
|------|--------------|----------|----------------|
| v1 | 14 Feb. 2010 | E1000028 | E1000025 |
| v2 | 20 May. 2010 | E1000174 | E1000025 |
| v3 | 23 June 2010 | E1000228 | E1000025 |
| v4 | 24 Aug. 2010 | E1000353 | 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 = 0.433 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 TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± .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. | | ADVANCED LIGO | | SEI | | STEP 1 BOLT, STAGE 0-1 BLADE PUSHER, aLIGO BSC-ISI | |
| MATERIAL 420 SSSL SEE NOTE 11 | | FINISH 32 μinch | | NEXT ASSY D0902464 | | DESIGNER S.BARNUM 09 Feb. 2010 | SIZE B | DWG. NO. D0902599 | REV. v4 | SCALE: 1:1 PROJECTION: SHEET 1 OF 1 | |