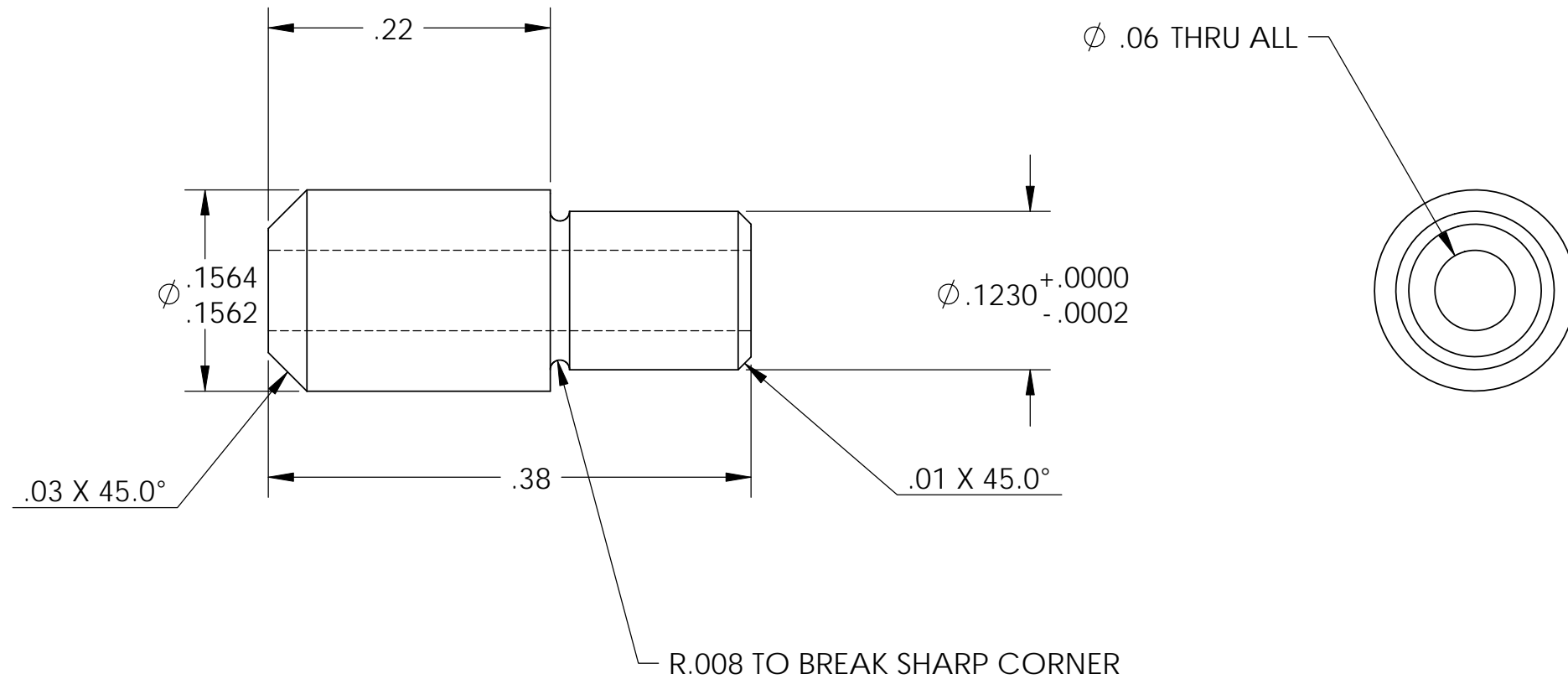


- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.  
EXAMPLE (PART): 001-V1  
EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY:TBD
  - 6. APPROXIMATE WEIGHT = 0.00 LB.
  - 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES (INCLUDING SANDING OR SCOURING FOR MATTE FINISH) 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. ALL HELICOIL TAPPED HOLES TO BE PREPARED ACCORDING TO EMHART HELICOIL PRODUCT CATALOG HC2000 CURRENT REV.
  - 10. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES.
  - 11. A TRUE POSITION TOLERANCE OF  $\phi .010$  IS - THE SAME AS A CONVENTIONAL TOLERANCE OF  $\pm .005$ .

REV.	DATE	DCN #	DRAWING TREE #
v1	24 Aug.2010	E1000353	E1000025



D1002282 STEP PIN, LARGE ACTUATOR, aLIGO BSC ISI, PART PDM REV: X-001, DRAWING PDM REV: X-001

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 <b>ADVANCED LIGO</b>		SUB-SYSTEM <b>SEI</b>		STEP PIN, LARGE ACTUATOR, aLIGO BSC ISI				
TOLERANCES: .XX $\pm .015$ .XXX $\pm .005$		MATERIAL 18-8 SS		FINISH 32 $\mu$ inch		NEXT ASSY D0901102, D0901103		DESIGNER S.BARNUM	DATE 24 Aug.2010	SIZE <b>B</b>	DWG. NO. <b>D1002282</b>	REV. v1
ANGULAR $\pm .5^\circ$		APPROVAL K.MASON		DATE 24 Aug.2010		SCALE: 8:1		PROJECTION:		SHEET 1 OF 1		