

D1100570 Stage 0-1 Angled Blades Spacer, aLIGO BSC-ISI, PART PDM REV: X-001, DRAWING PDM REV: X-001

NOTES CONTINUED:

5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
6. APPROXIMATE WEIGHT = 6.14 LB.
7. A TRUE POSITION TOLERANCE OF $\phi .010$ IS - THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.
8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
9. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	31 Mar. 2011	E1100288	E1000025

$\phi .3757^{+.0008}_{-.0000}$ SLOT THRU
BREAK EDGE .09 X 45°
BOTH SIDES

$\oplus .002$	A	B	C
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$\phi .3757^{+.0008}_{-.0000}$ THRU
BREAK EDGE .09 X 45°
BOTH SIDES

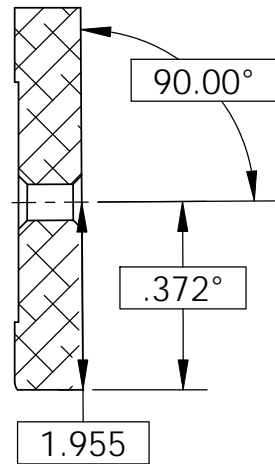
$\oplus .002$	A	B	C
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2X $\phi .5020^{+.0005}_{-.0000}$ THRU ALL
 $\sphericalangle \phi .69$ X 90°, NEAR SIDE
BREAK EDGE .09 X 45° FAR SIDE

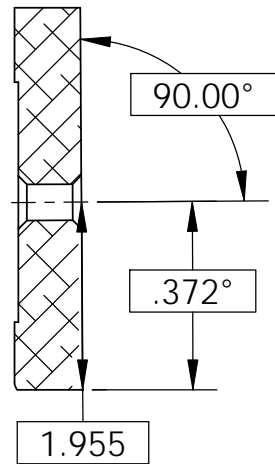
$\oplus .002$	D	B	C
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A B C D

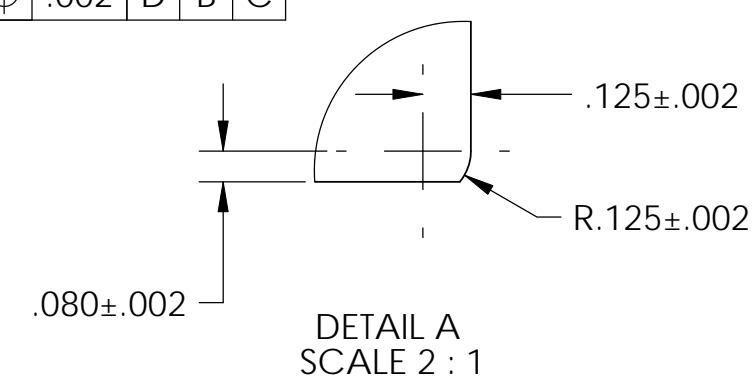
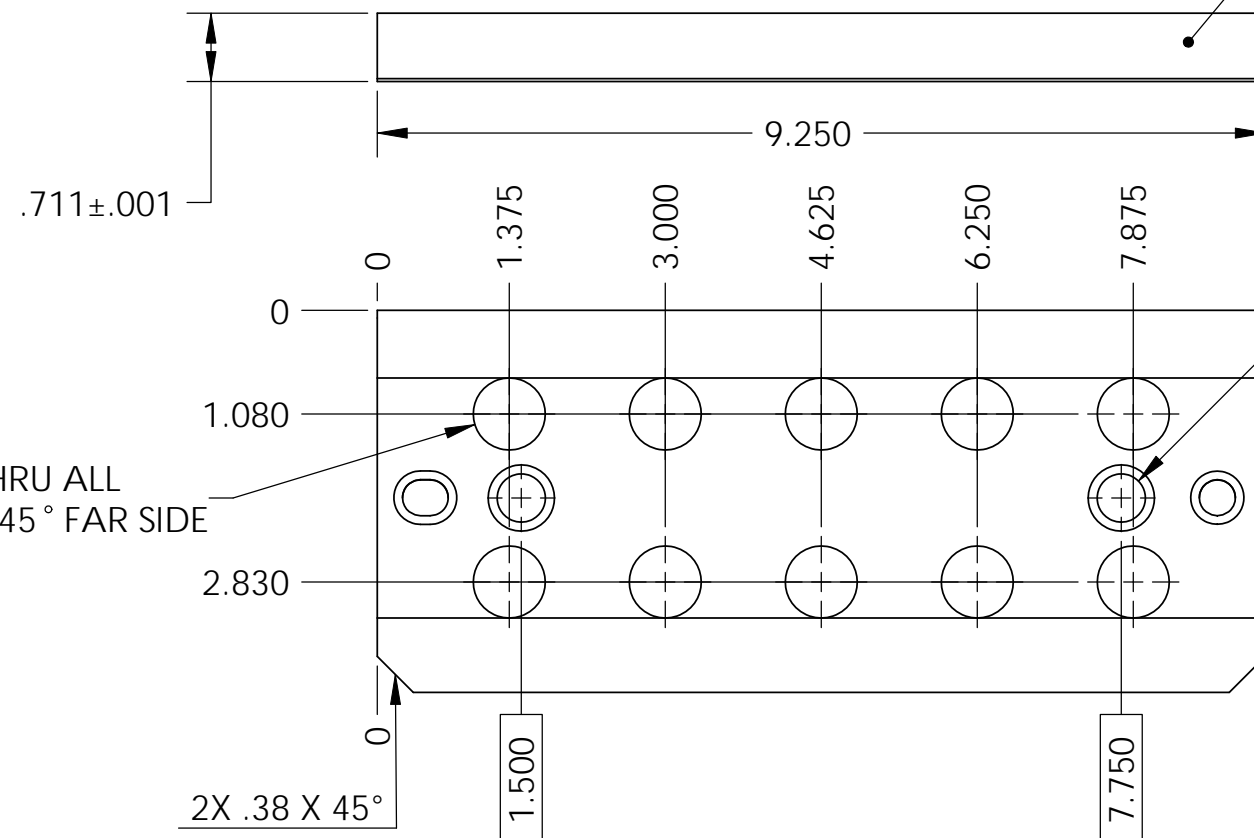
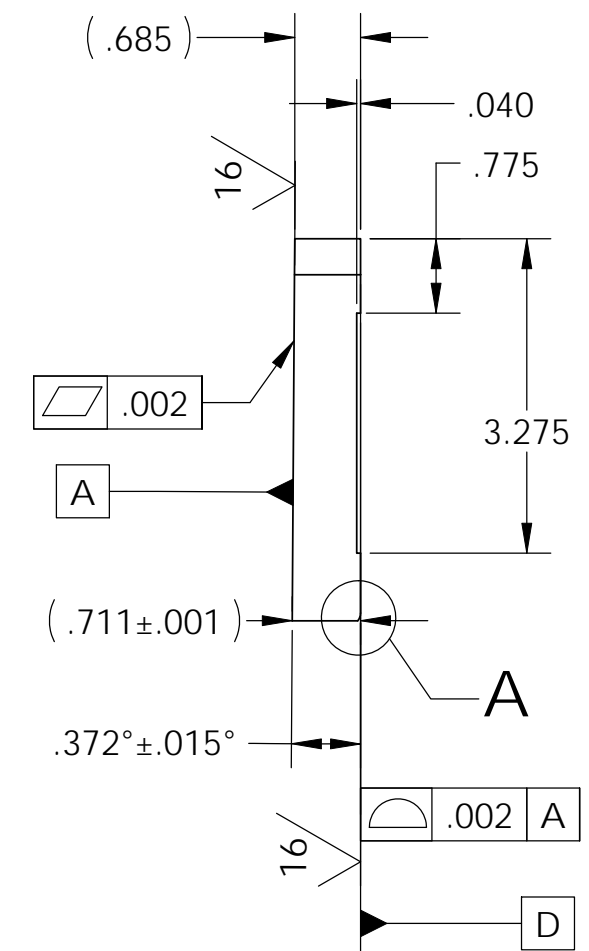
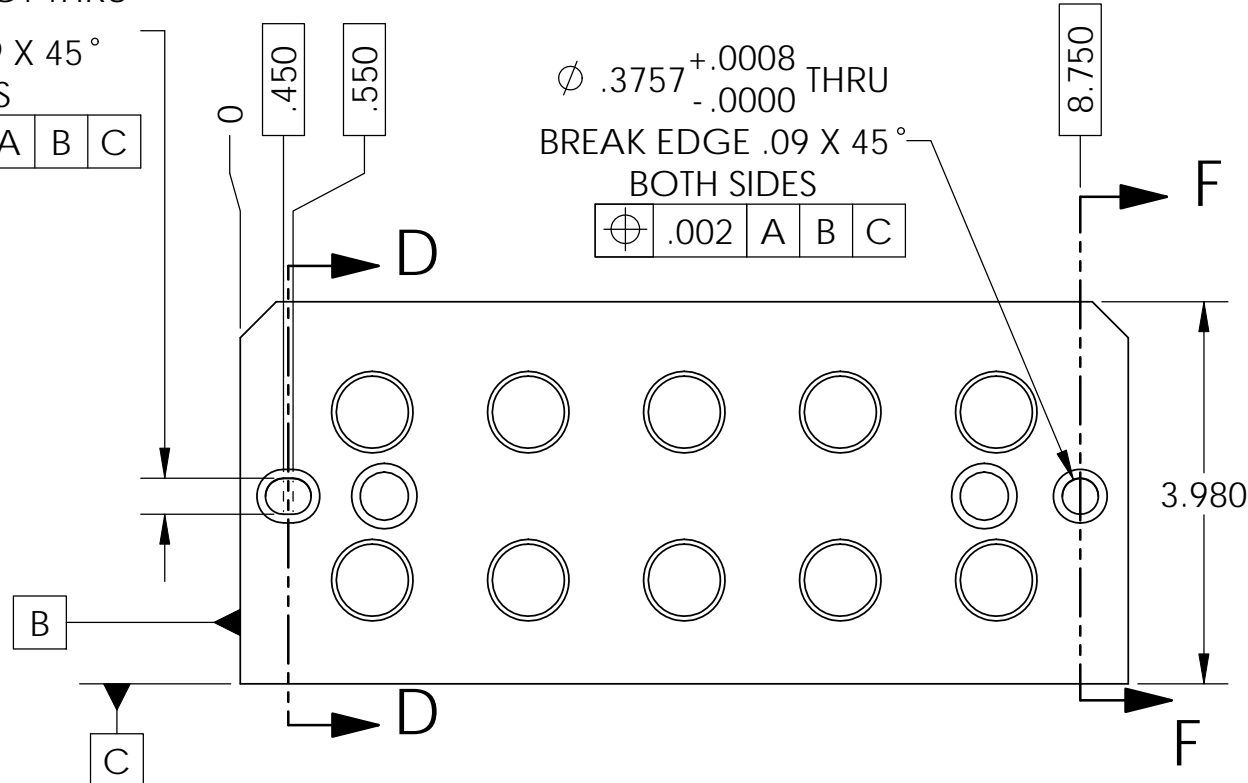
A B C D



SECTION D-D



SECTION F-F



DETAIL A
SCALE 2 : 1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	1. INTERPRET DRAWING PER ASME Y14.5-1994.
TOLERANCES (UNLESS OTHERWISE SPECIFIED):	2. BREAK ALL EDGES AND CORNERS .03 X 45°.
.XX ± .015	3. DO NOT SCALE FROM DRAWING.
.XXX ± .005	4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.
ANGULAR ± .5°	
MATERIAL	304 SSSL
FINISH	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM ADVANCED LIGO		SUB-SYSTEM SEI	
NEXT ASSY		D0901197	
DESIGNER	F.MATICHARD	31 Mar. 2011	SIZE DWG. NO.
DRAFTER	F.MATICHARD	31 Mar. 2010	B
CHECKER	K.MASON	31 Mar. 2010	D1100570
APPROVAL	K.MASON	31 Mar. 2010	REV.
			v1
SCALE: 1:2		PROJECTION:	
		SHEET 1 OF 1	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1