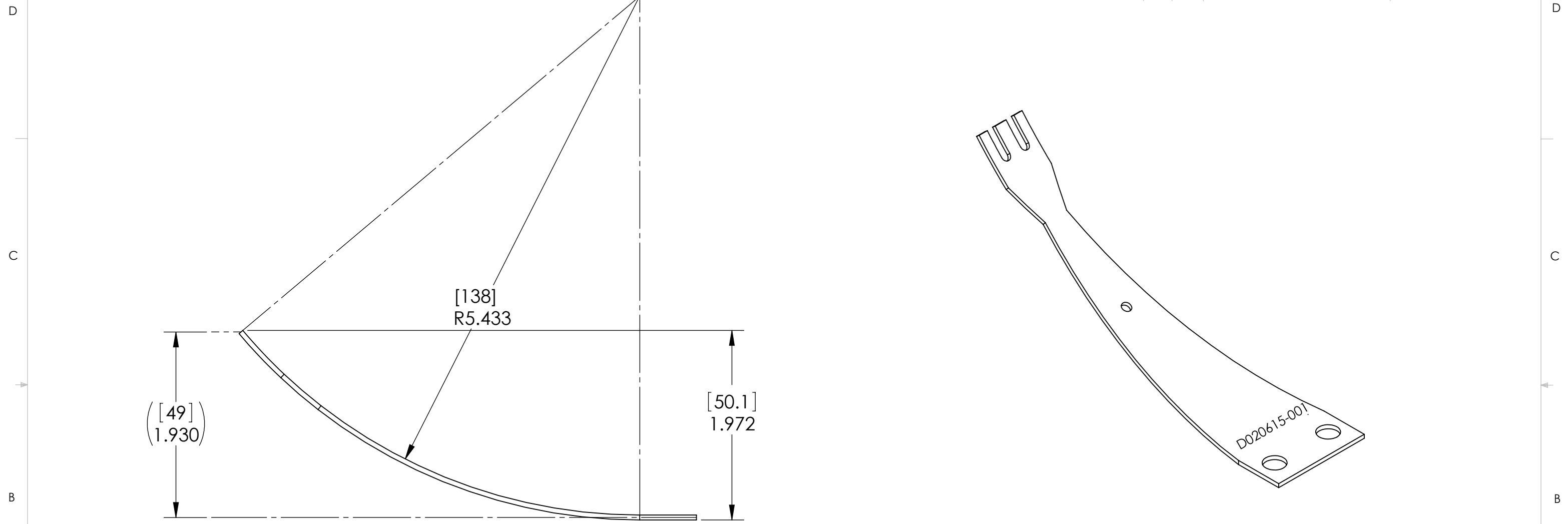


REV.	DATE	DCN #	DRAWING TREE #
04	04NOV03	BLADE TIP HOLES CONVERTED TO SLOTS FOR EASE OF ASSEMBLY.	
08	10JAN,08	UPDATED PER LATEST COMPUTATIONS	
A	FEB 1,08	RELEASED FOR RFQ PER DCN #E080066	

MANUFACTURING NOTES: (UNLESS OTHERWISE SPECIFIED)		OTHER NOTES (FOR INTERNAL USE)		PARTS LIST	
1.1 REMOVE ALL SHARP EDGES, R.02 MIN.	1.2 ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).	2.1 SHAPE FACTOR FOR LOWER BLADE = 1.55	2.2 LOAD ON LOWER BLADE (FLAT) = 6.09 KG	DUAL DIMENSIONS [mm] INCHES	
1.3 SHEET 1 OF 2 SHOWS VIEWS PRIOR TO FORMING.	1.4 AFTER FORMING, THE BLADES ARE ANNEALED AT 490°C FOR 4 HOURS AND AIR COOLED BACK TO ROOM TEMPERATURE.	2.3 PREDICTED FIRST INTERNAL FREQUENCY = 3.18 Hz	2.4 PREDICTED FIRST INTERNAL MODE = 340.0 Hz	TOLERANCES FOR INCHES: .XX ± 0.01 .XXX ± 0.005 ANGULAR ± 0.5°	
1.5 ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND THREE DIGITS SERIAL NUMBER. SERIAL NUMBER STARTS AT 001 FOR THE FIRST PART AND PROCEEDS CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: D020615-001. A VIBRATORY TOOL MAY BE USED.		2.5 MAXIMUM STRESS = 795 MPa	2.6 SOLIDWORKS RADIUS VALUE OVERRITTEN WITH VALUE CALCULATED BY NAR.	MATERIAL MARAGING STEEL C250	
		2.7 IN SOLIDWORKS PART, BLADE MUST BE DRAWN WITH SHEET METAL AND EXTRUDED VERTICALLY DOWNWARDS.	2.8 IN SOLIDWORKS PART, RADIUS SHOULD BE ADJUSTED TO ATTAIN DESIRED LENGTH ON DRAWING SHEET.	FINISH	
				CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP	
				SYSTEM ADVANCED LIGO	
				SUB-SYSTEM RM SUS OVERALL ASSY	
				NEXT ASSY UPPER MASS ASSY	
				PART NAME RM LOWER BLADE	
				DRAWN: B.KIRSNER JAN 18, 2008	
				CHECKED: CIT JAN 18, 2008	
				APPROVED:	
				SIZE DWG. NO. B D020615	REV. A
				SCALE: NTS PROJECTION: SHEET 1 OF 2	

8 7 6 5 4 3 2 1

REV.	DATE	DCN #	DRAWING TREE #



PARTS LIST		
DUAL DIMENSIONS [mm] INCHES TOLERANCES FOR INCHES: .XX ± 0.01 .XXX ± 0.005 ANGULAR ± 0.5°		
MATERIAL _____		
FINISH _____		
DRAWN B.KIRSNER 18 JAN, 2008 CHECKED CIT 18 JAN, 2008 APPROVED		
SYSTEM <b>ADVANCED LIGO</b> SUB-SYSTEM <b>RM SUS OVERALL ASSY</b> NEXT ASSY <b>UPPER MASS ASSY</b> PART NAME <b>RM LOWER BLADE</b>		
SIZE	DWG. NO.	REV.
<b>B</b>	<b>D020615</b>	<b>A</b>
SCALE: NTS PROJECTION:  SHEET 2 OF 2		

8 7 6 5 4 3 2 1

FILE NAME/LOCATION: 1