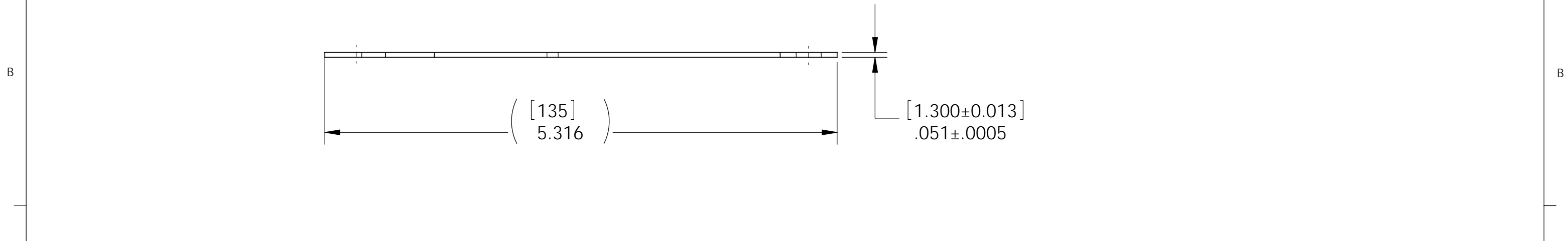




REV.	DATE	DCN #	DRAWING TREE #
04	04NOV03	BLADE TIP HOLES CONVERTED TO SLOTS FOR EASE OF ASSEMBLY.	
08	10JAN,08	UPDATED PER LATEST COMPUTATIONS	
A	FEB 1,08	RELEASED FOR RFQ	
B 17th Apr 08		E080169-00	
C 24TH Apr 08		E080179-00	



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	 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP	
1.3 SHEET 1 OF 2 SHOWS VIEWS PRIOR TO FORMING.	1.4 AFTER FORMING, HEAT TREAT AT 435°C FOR 100 HOURS.	2.3 PREDICTED FIRST INTERNAL FREQUENCY = 3.18 Hz	2.4 PREDICTED FIRST INTERNAL MODE = 340.0 Hz	SYSTEM ADVANCED LIGO SUB-SYSTEM RM SUS OVERALL ASSY NEXT ASSY UPPER MASS ASSY	
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.	PART NAME RM LOWER BLADE	
		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.	DRAWN: B.KIRSNER JAN 18, 2008 CHECKED: CIT JAN 18, 2008 APPROVED:	
				MATERIAL MARAGING STEEL C250 FINISH:	
				DUAL DIMENSIONS [mm] INCHES TOLERANCES FOR INCHES: .XX ± 0.01 .XXX ± 0.005 ANGULAR ± 0.5°	
				SIZE B DWG. NO. D020615 REV. C	
				SCALE: NTS PROJECTION:  SHEET 1 OF 2	

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1

REV.	DATE	DCN #	DRAWING TREE #

D

D

C

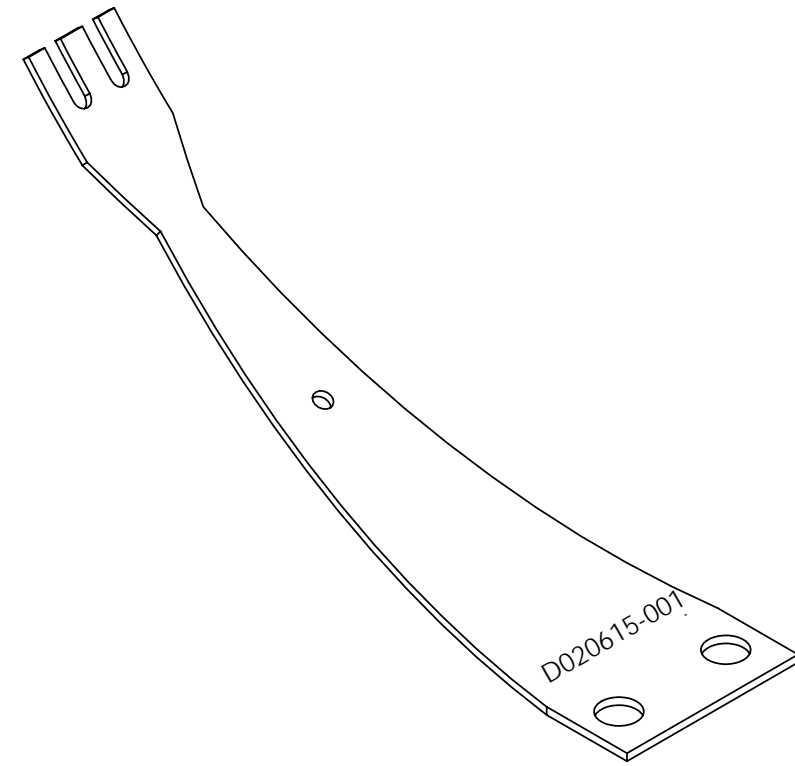
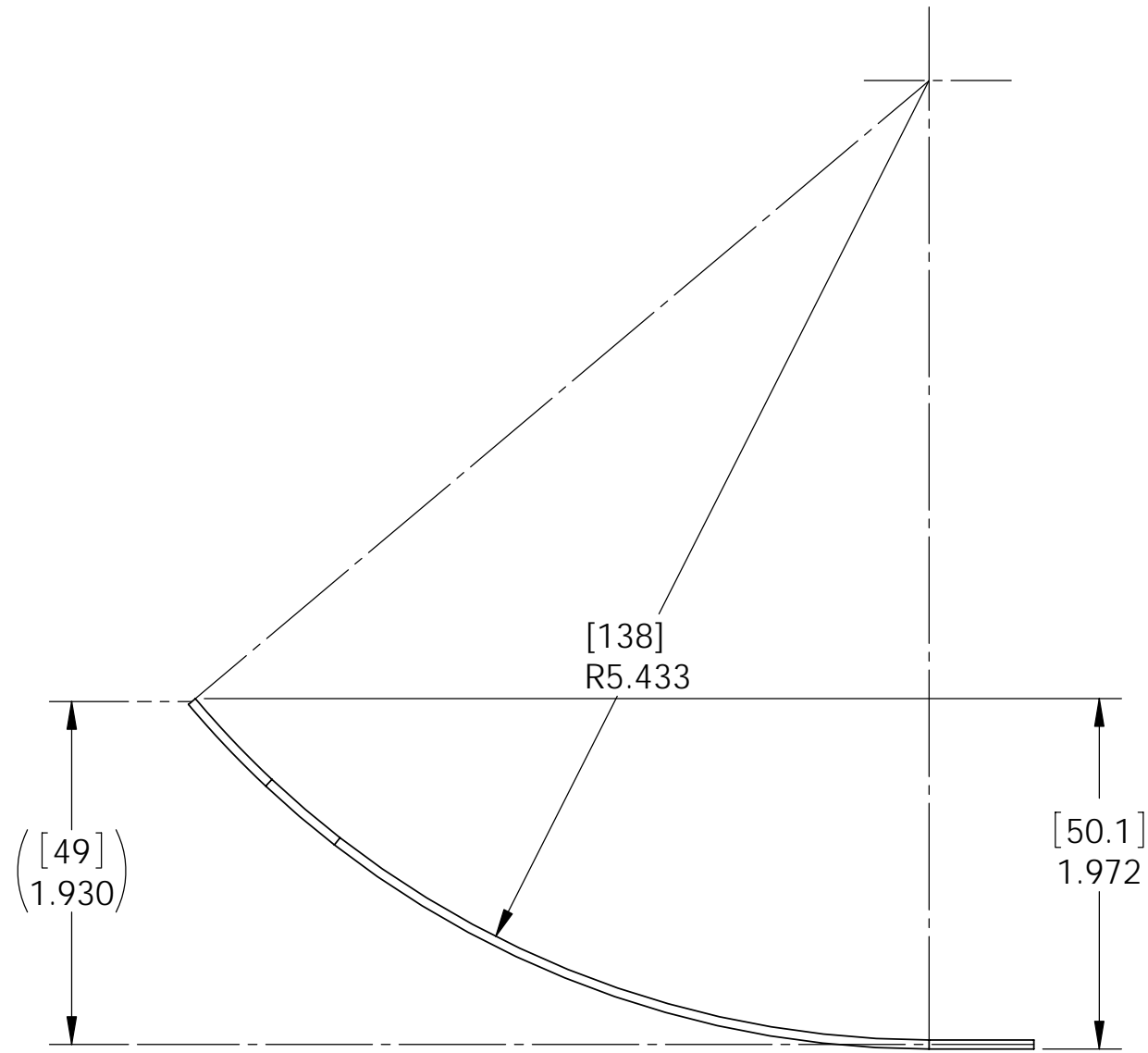
C



B

B

A

A



PARTS LIST															
DUAL DIMENSIONS [mm] INCHES TOLERANCES FOR INCHES: .XX ± 0.01 .XXX ± 0.005 ANGULAR ± 0.5°		 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP													
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MATERIAL	---	SUB-SYSTEM	RM SUS OVERALL ASSY												
FINISH	---	NEXT ASSY	UPPER MASS ASSY												
<table border="1"> <thead> <tr> <th> </th> <th>NAME</th> <th>DATE</th> </tr> </thead> <tbody> <tr> <td>DRAWN</td> <td>B.KIRSNER</td> <td>18 JAN, 2008</td> </tr> <tr> <td>CHECKED</td> <td>CJT</td> <td>18 JAN, 2008</td> </tr> <tr> <td>APPROVED</td> <td> </td> <td> </td> </tr> </tbody> </table>			NAME	DATE	DRAWN	B.KIRSNER	18 JAN, 2008	CHECKED	CJT	18 JAN, 2008	APPROVED			PART NAME	RM LOWER BLADE
	NAME	DATE													
DRAWN	B.KIRSNER	18 JAN, 2008													
CHECKED	CJT	18 JAN, 2008													
APPROVED															
SIZE	DWG. NO.	REV.													
B	D020615	C													
SCALE: NTS		PROJECTION:	 SHEET 2 OF 2												

7

6

5

4

3

2

1

FILE NAME/LOCATION: