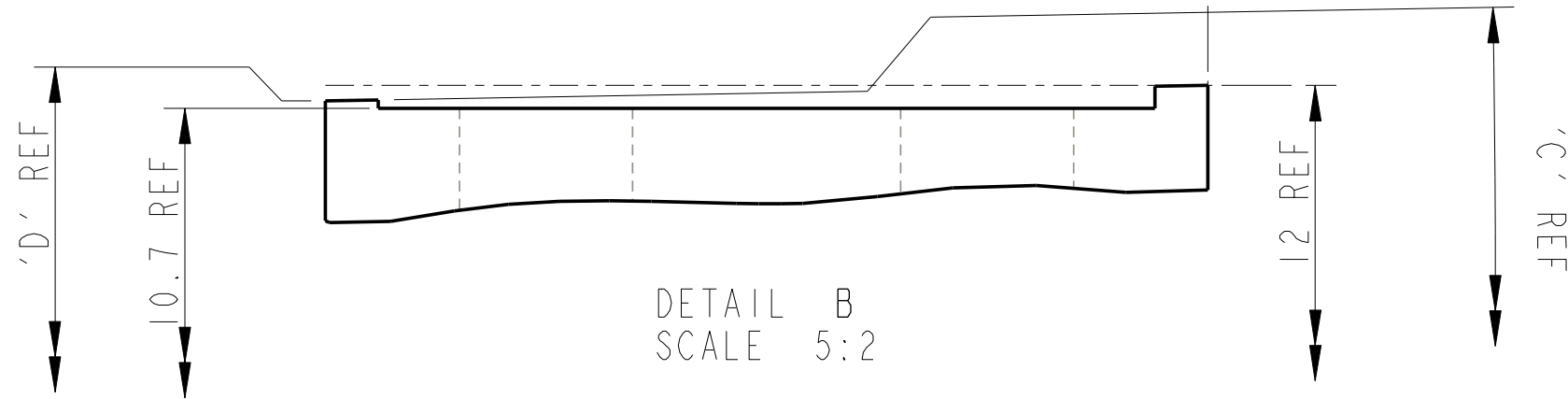


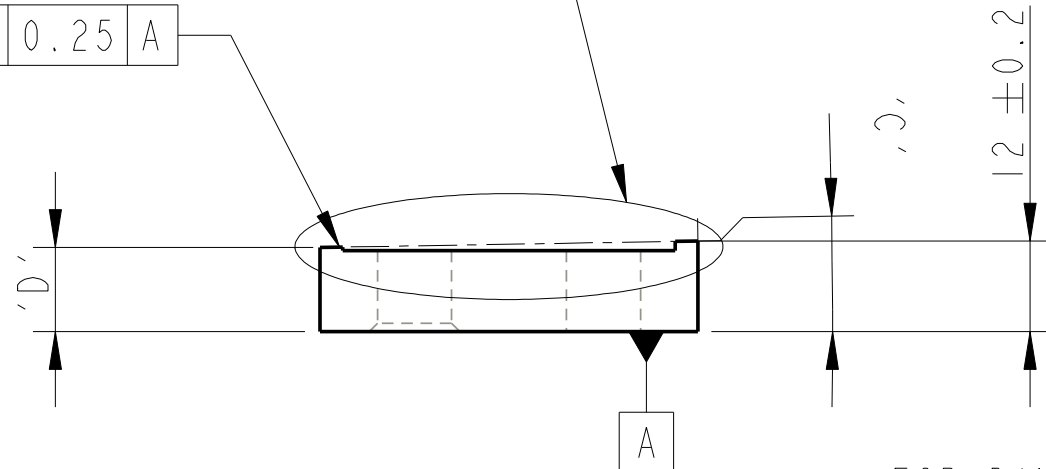
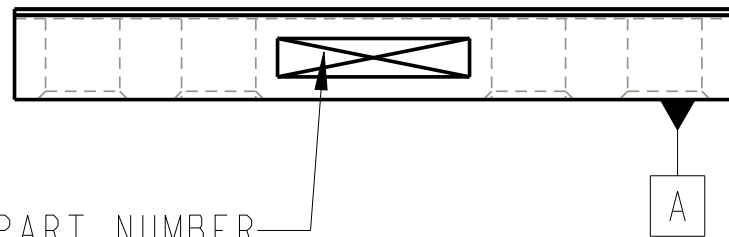
STAGE 2 MACHINING



DETAIL B
SCALE 5:2

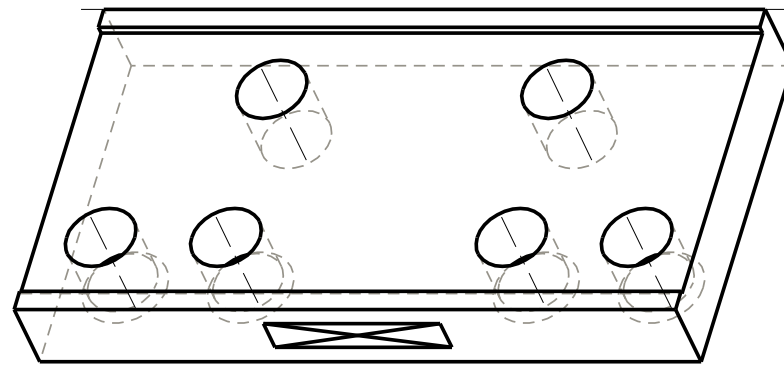
SEE DETAIL B

∠ 0.25 A



FOR DIMS C AND D SEE TABLE

VARIANT	ANGLE C	DIM D
0	0°	12 REF
1	0.109°	11.90 REF
2	0.218°	11.80 REF
3	0.327°	11.71 REF
4	0.437°	11.62 REF
5	0.546°	11.52 REF
6	0.655°	11.43 REF
7	0.764°	11.33 REF
8	0.837°	11.27 REF
9	0.982°	11.14 REF
10	1.091°	11.05 REF



3D VIEW

NOTES: (UNLESS OTHERWISE SPECIFIED)

- REMOVE ALL SHARP EDGES, R.02 MIN.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)
- SCRIBE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: D020188-001. A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN mm [INCHES]

X.XX ± 0.25 mm
ANGULAR ± 0.25 °

MATERIAL: ST STEEL 304/316

FINISH: CLEAN AND DEGREASED
√μm [μin] Ra = 1.6 [63]

	NAME	DATE
DRAWN	I WILMUT	05/Oct/06
CHECKED	AJB	5MAY08
APPROVED	AJB	157 JULY/08

SCALE 1:1 PROJECTION: SHEET 2 OF 2

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
1GR, GLASGOW UNIVERSITY GEO 600 GROUP
RUTHERFORD APPLETON LABORATORIES

SYSTEM **ADVANCED LIGO**

SUB-SYSTEM **SUS**

NEXT ASSY **QUAD N-P-TYPE TOP STAGE**

PART NAME **BLADE CLAMP (BTM HALF)**

DRG. NO. **D060327**

REV **E.**