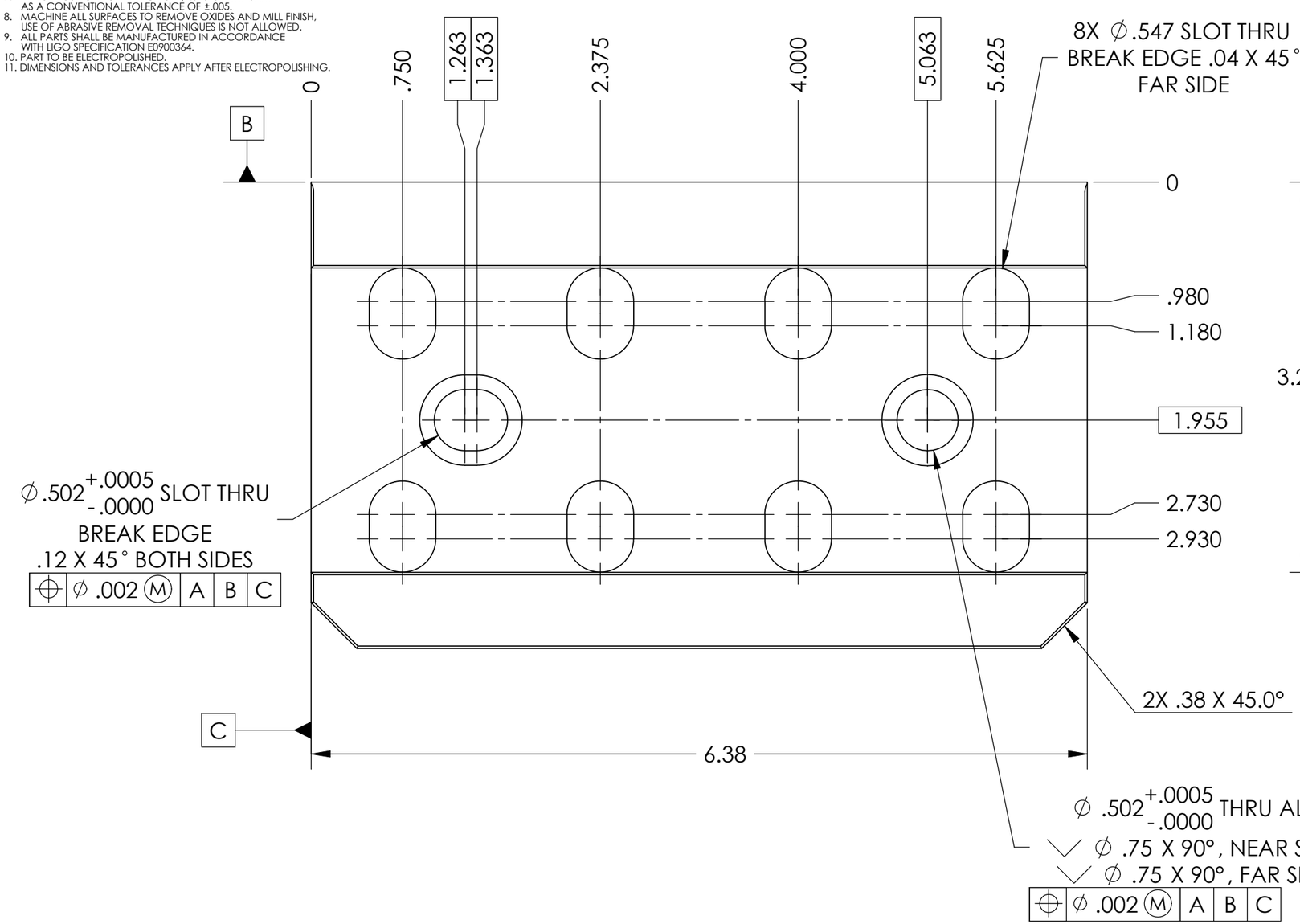
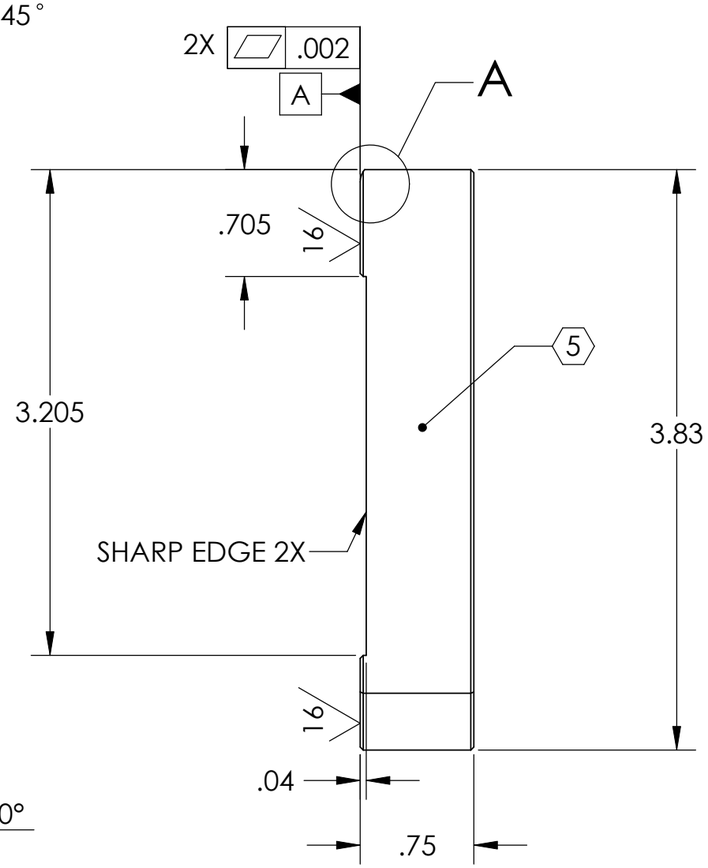
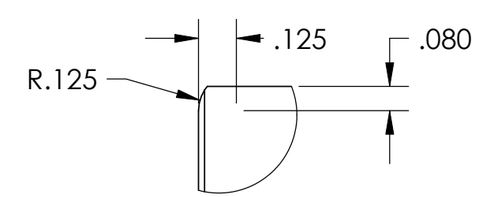
REV.	DATE	DCN #	DRAWING TREE #
v1	01 Mar. 2010	E1000026	E1000025

NOTES CONTINUED:

5. SCRIBE, ENGRAVE, 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. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX
6. APPROXIMATE WEIGHT = 4.31 LB.
7. A TRUE POSITION TOLERANCE OF ∅.010 IS ~ THE SAME AS A CONVENTIONAL TOLERANCE OF ±.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.
10. PART TO BE ELECTROPOLISHED.
11. DIMENSIONS AND TOLERANCES APPLY AFTER ELECTROPOLISHING.







DETAIL A
SCALE 2 : 1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .015
.XXX ± .005

ANGULAR ± .5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. BREAL ALL EDGES AND CORNERS .03 X 45°.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL: 17-4 PH SSTL, H 1150

FINISH: 32 µinch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO

SUB-SYSTEM: SEI

NEXT ASSY: D0902485

PART NAME: Spring Clamp Cap, Stage 1-2, aLIGO BSC ISI

DESIGNER	A.STEIN	01 Feb. 2010	
DRAFTER	M.HILLARD	01 Feb. 2010	
CHECKER	F.MATICHARD	01 Feb. 2010	
APPROVAL	K.MASON	01 Feb. 2010	

SIZE: B — DWG. NO.: D0902695 — REV.: v1

SCALE: 1:1 — PROJECTION: — SHEET 1 OF 1

D0902695 Spring Clamp Cap, Stage 1-2, aLIGO BSC ISI, PART PDM REV: X-008, DRAWING PDM REV: X-005