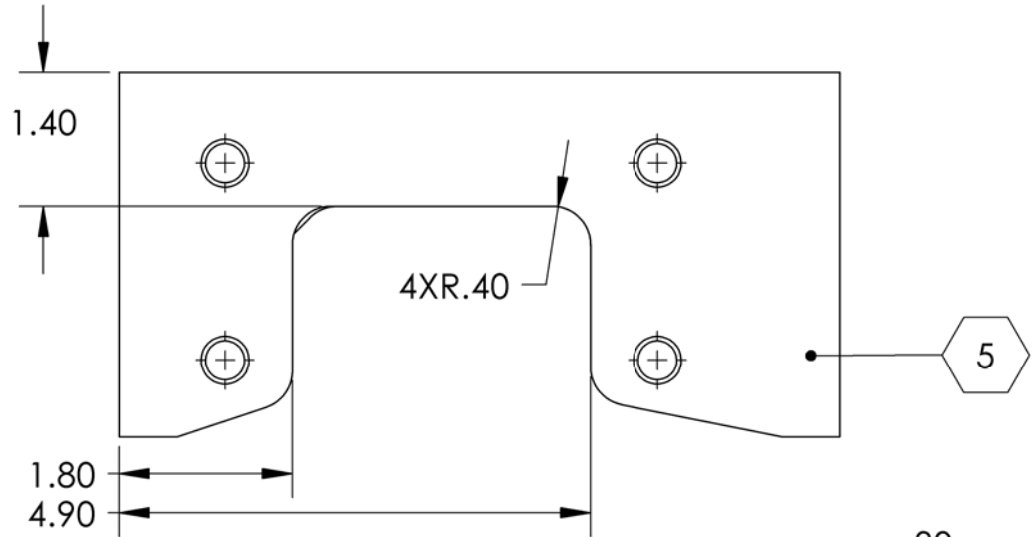


8 7 6 5 4 3 2 1

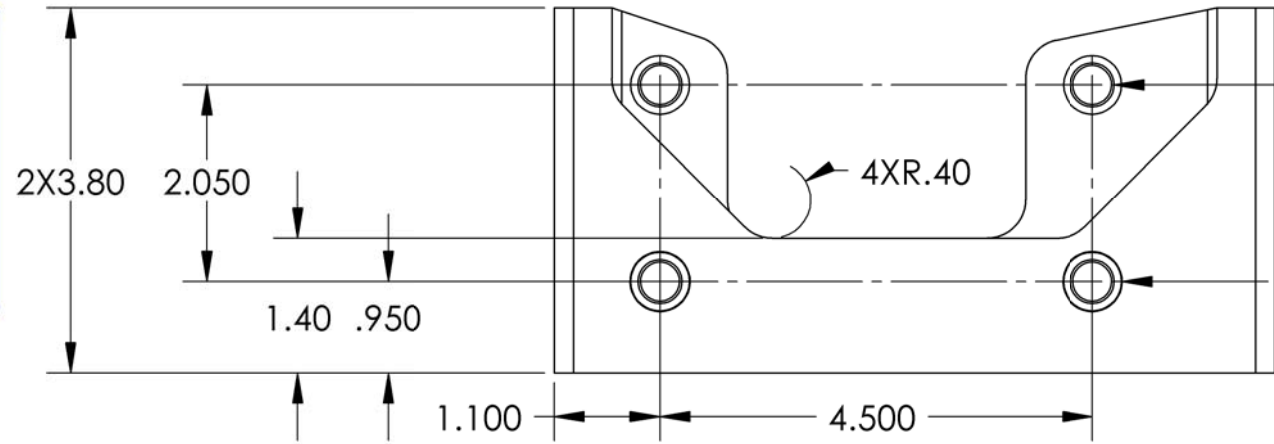
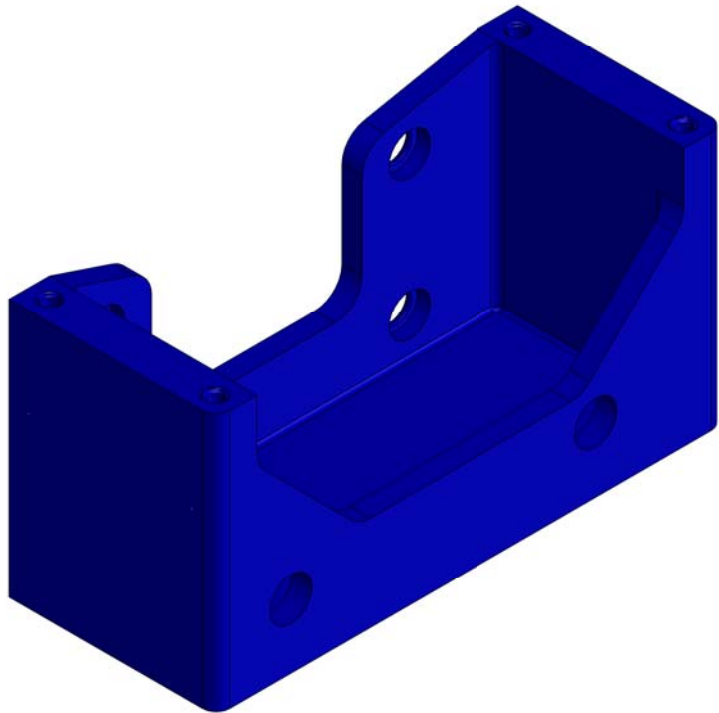
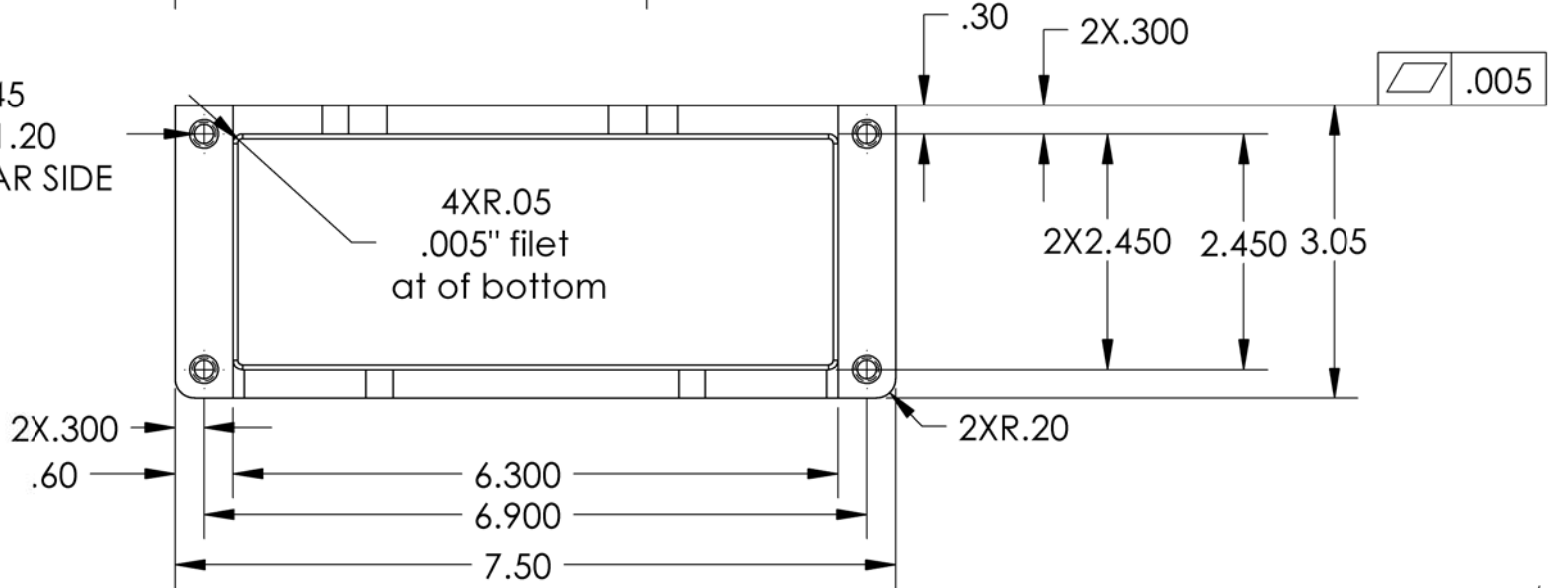
REV.	DATE	DCN #	DRAWING TREE #
V1	12 OCT 2010	E1100092	-
-	-	-	-
-	-	-	-

NOTES CONTINUED:

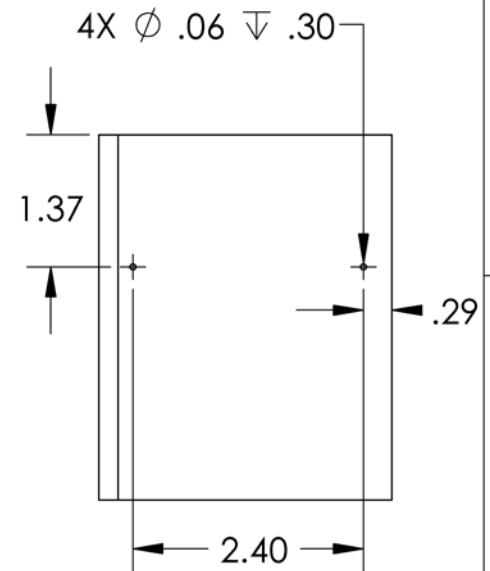
- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS. UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. APPROXIMATE WEIGHT = 2.570 LBS.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO. REFER TO LIGO-E0900364.
- 10. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS. REFER TO LIGO-E0900364.
- 11. THIS DRAWING IS MINIMALLY DIMENSIONED. REFER TO SOLID MODEL FOR NON DIMENSIONED FEATURES. A +/- 0.015" TOLERANCE APPLY TO NON DIMENSIONED FEATURES.



4X ϕ .20 ∇ 1.45
1/4-20 UNC ∇ 1.20
 \surd ϕ .30 X 90°, NEAR SIDE



4X ϕ .41 THRU
 \square ϕ .61 ∇ .20
 \surd ϕ .46 X 90°, MID SIDE
 \surd ϕ .50 X 90°, FAR SIDE



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± 0.015 .XXX ± 0.005	
ANGULAR ± 0.1°	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 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	6061-T6 Al
FINISH	32 μ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	SEI
NEXT ASSY	D1001760

PART NAME			
Right clamp for Stage 1 Vibration Absorber			
DESIGNER	S.BISCANS	02 JULY 2010	SIZE
DRAFTER	S.BISCANS	12 OCT 2010	DWG. NO.
CHECKER	F.MATICHARD	12 OCT 2010	B
APPROVAL	K.MASON	12 OCT 2010	D1001764
SCALE: 1:2		PROJECTION:	SHEET 1 OF 1

D1001764 Right clamp for Stage 1 Vibration Absorber, PART PDM REV: X-006, DRAWING PDM REV: X-003

8 7 6 5 4 3 2 1