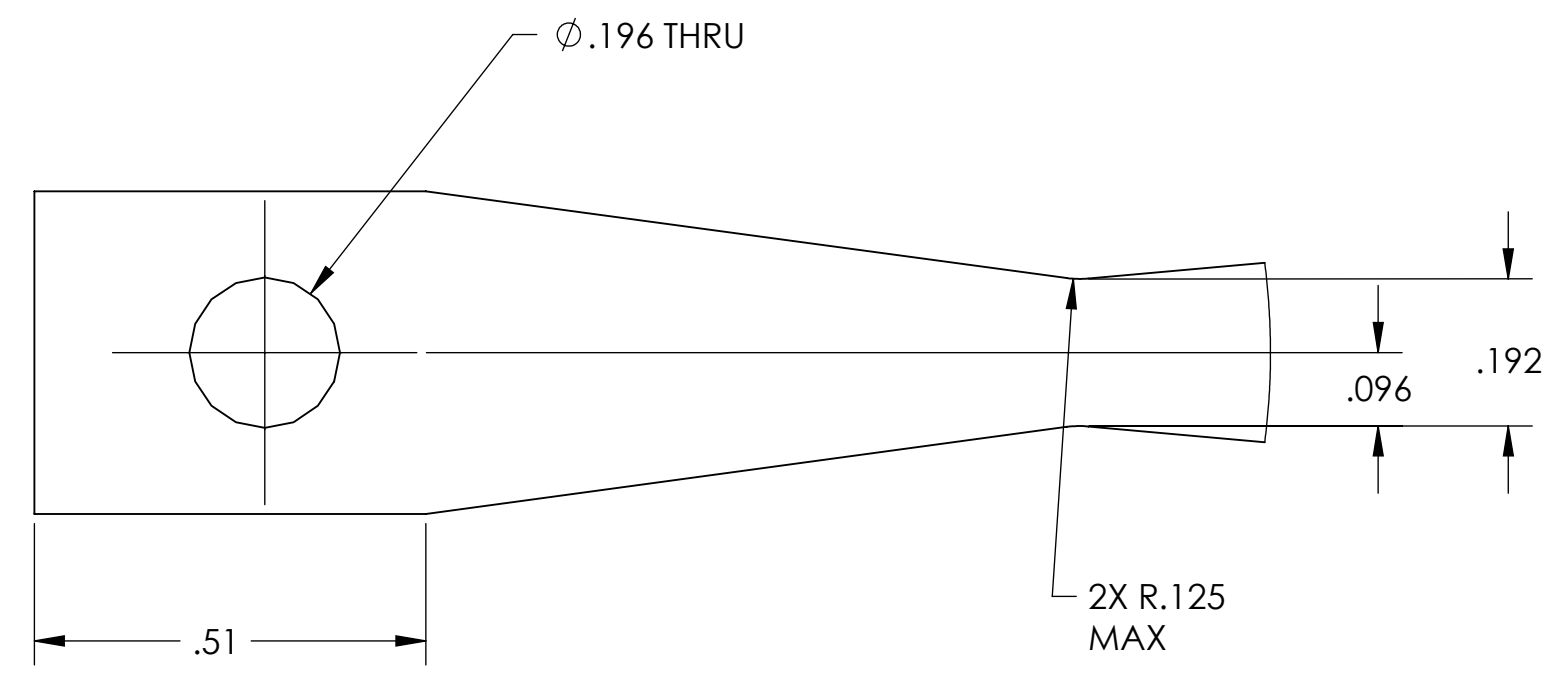
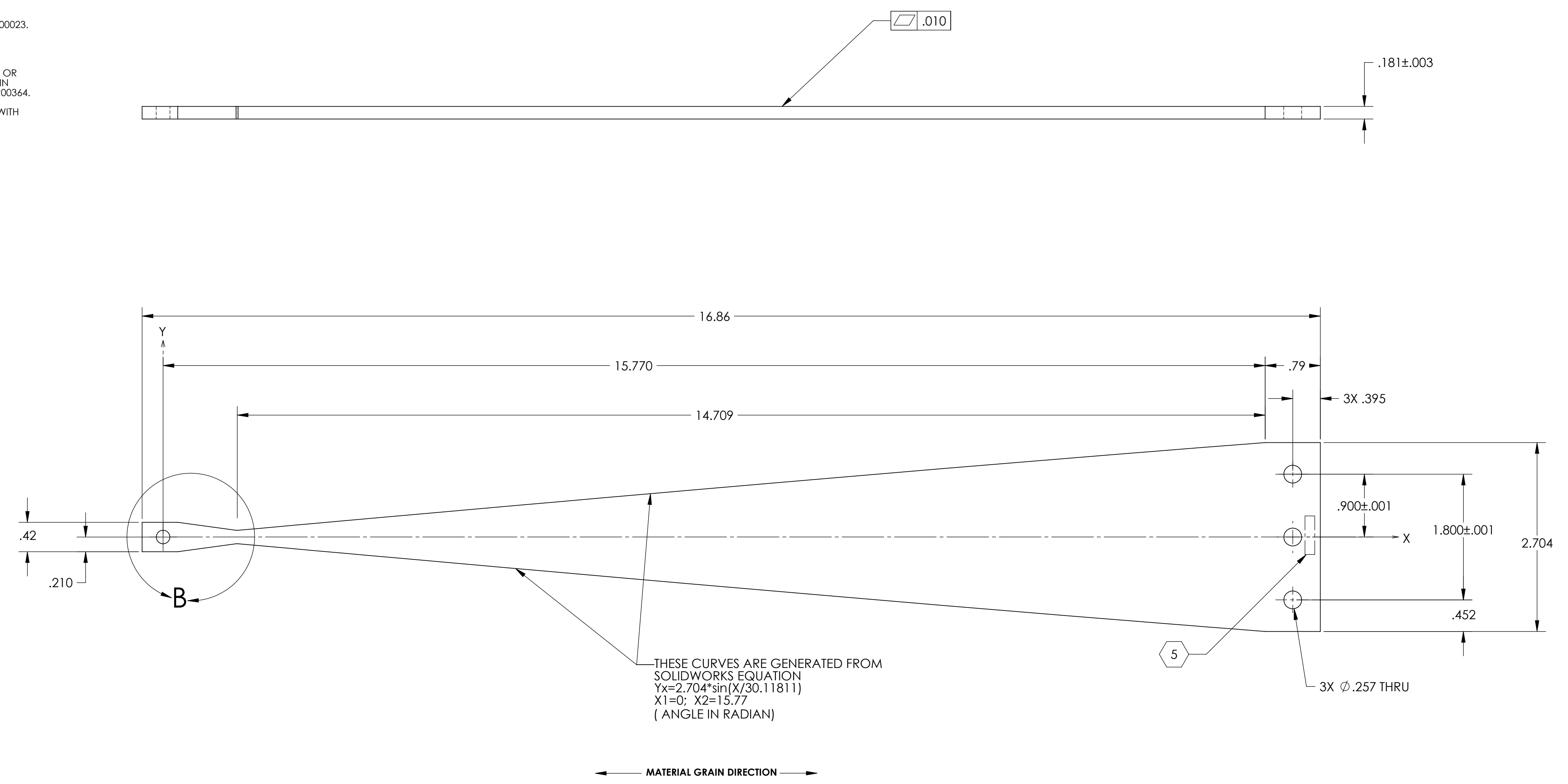


- NOTES: UNLESS OTHERWISE SPECIFIED**
1. INTERPRET DRAWING PER ASME Y14.5-1994.
  2. REMOVE ALL SHARP EDGES 0.005" TO 0.015".
  3. DO NOT SCALE FROM DRAWING.
  4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. REFER TO LIGO E0900237 FOR LIST OF APPROVED COOLANTS.
  5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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.  
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
  6. APPROXIMATE WEIGHT = 1.27 LB.
  7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900023.
  8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900023.
  9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
  10. PART TO BE MANUFACTURED, TREATED AND PLATED IN ACCORDANCE WITH LIGO SPECIFICATION E0900023.

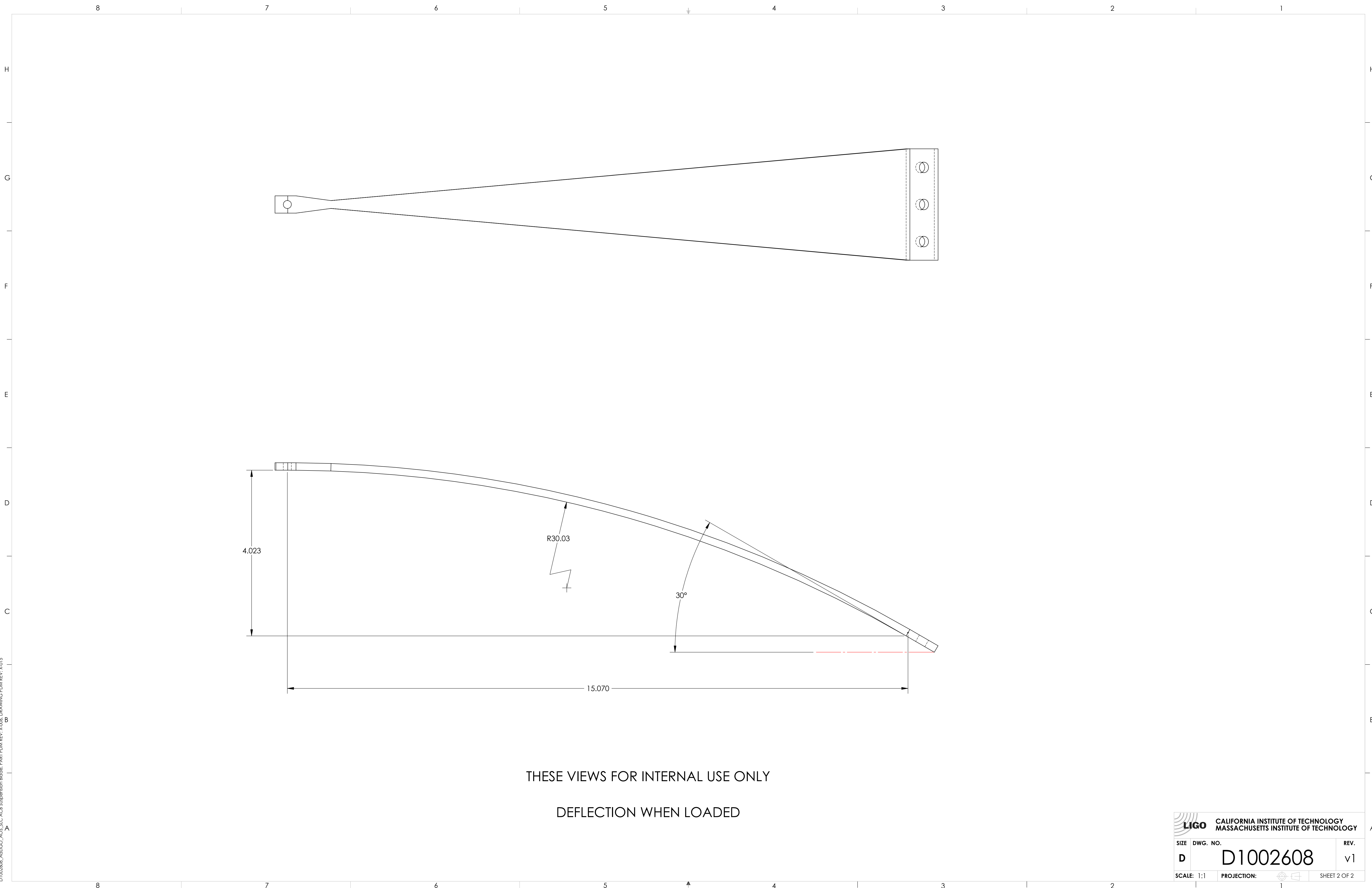
REV.	DATE	DCN #	DRAWING TREE #
v1	22 JUL 2010	E1000285	



**DETAIL B**  
**SCALE 4 : 1**

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME				
DIMENSIONS ARE IN INCHES				<b>SYSTEM</b> ADVANCED LIGO <b>SUB-SYSTEM</b> AOS <b>NEXT ASSY</b> D1001005		<b>SLC ACB SUSPENSION BLADE</b>				
TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1.0°						<b>DESIGNER</b>	N.Nguyen	01 Jun 2010	<b>SIZE</b>	<b>DWG. NO.</b>
<b>MATERIAL</b> MARAGING STEEL C250				<b>FINISH</b> 63 μinch	<b>CHECKER</b>	TG. NGUYEN	22 JUL 2010	<b>D</b>	<b>D1002608</b>	v1
					<b>APPROVAL</b>	D. COYNE	20 NOV 2010	<b>SCALE:</b> 1:1	<b>PROJECTION:</b>	SHEET 1 OF 2

D1002608\_AutLIGO\_ACS\_SLC ACB Suspension Blade: PART PDM REV: X-004: DRAWING PDM REV: X-015



THESE VIEWS FOR INTERNAL USE ONLY

DEFLECTION WHEN LOADED

 <b>CALIFORNIA INSTITUTE OF TECHNOLOGY</b> <b>MASSACHUSETTS INSTITUTE OF TECHNOLOGY</b>		
SIZE	DWG. NO.	REV.
D	D1002608	v1
SCALE: 1:1	PROJECTION:	SHEET 2 OF 2

D:\002608\_Adu\GO\_ACS\_Suspension\Blade\_P\PART PDM REV.X-004\_DRAWING PDM REV.X-015