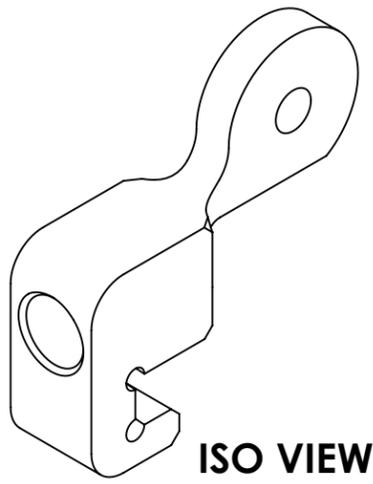
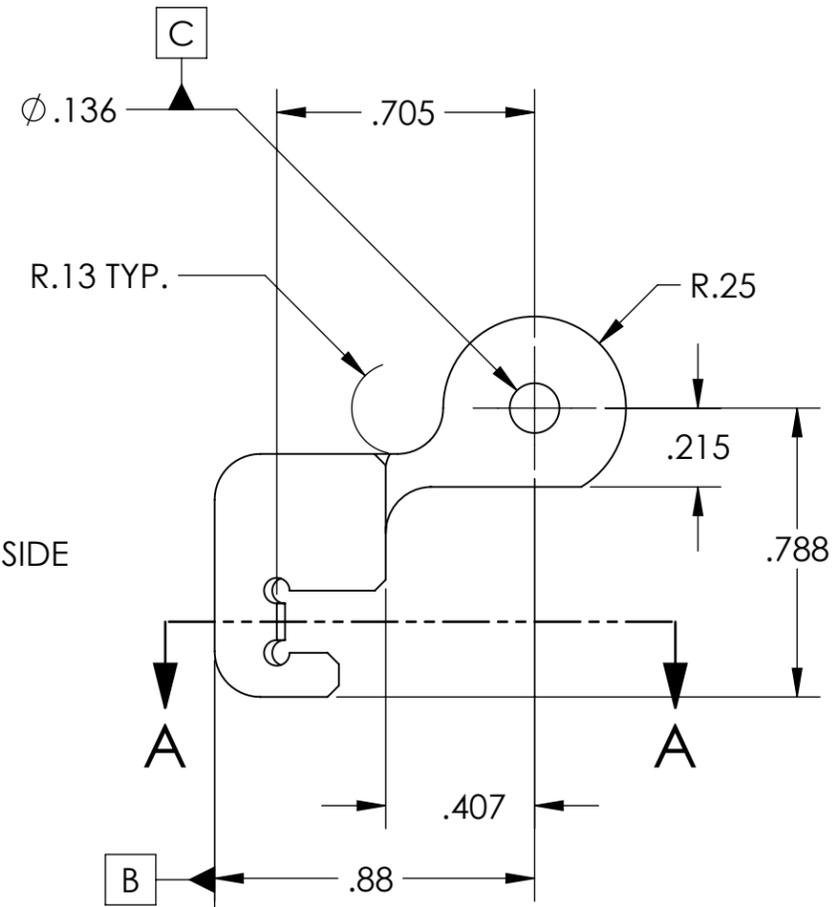
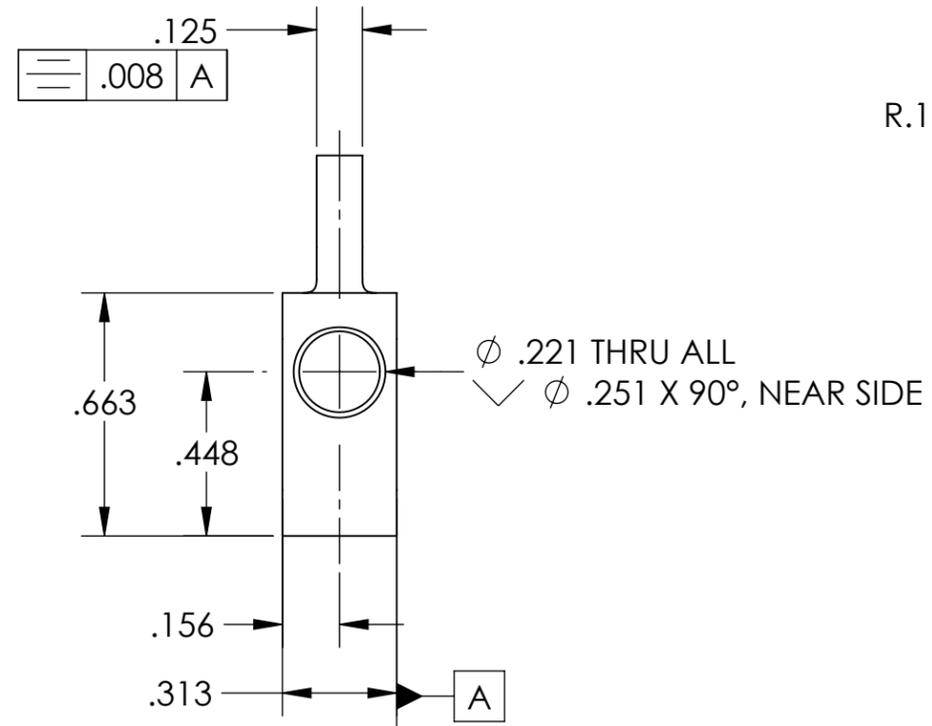
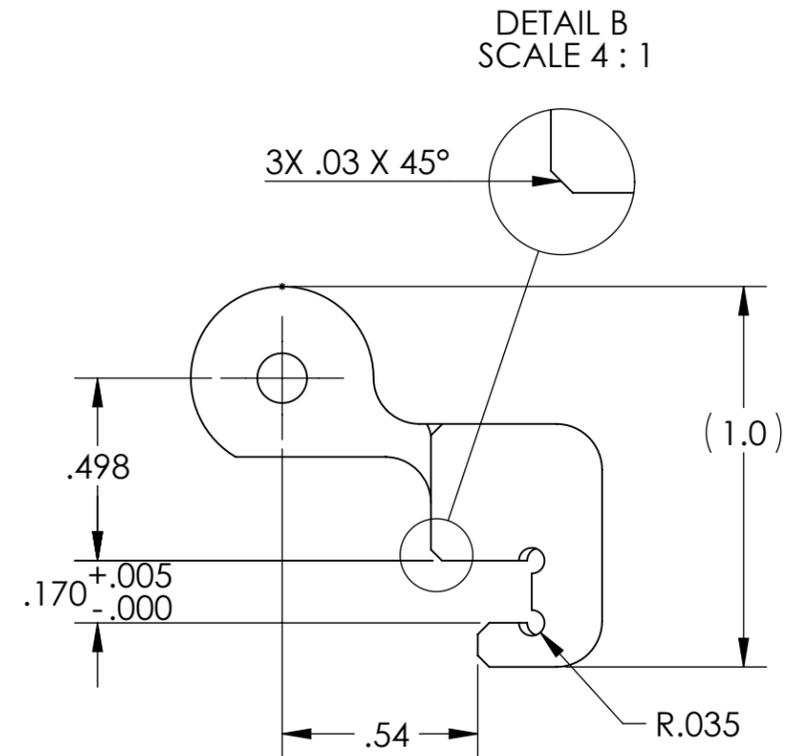
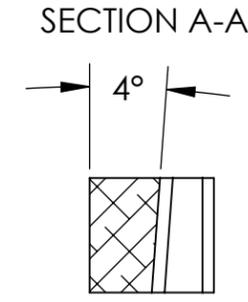
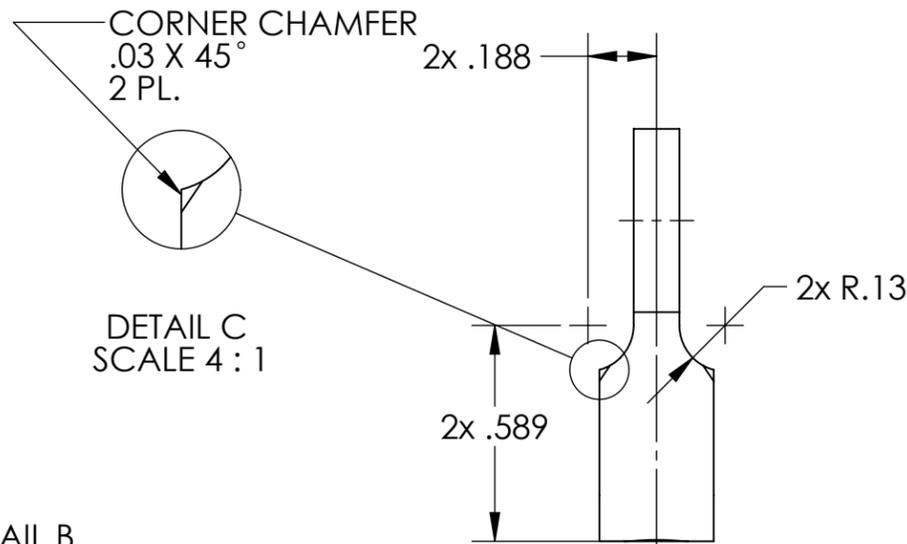


NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT OR "TYPE" (IF APPLICABLE), AND QUANTITY. IF PARTS ARE TOO SMALL TO SCRIBE, BAGGING AND TAGGING ALONE IS SUFFICIENT.
EXAMPLE (PART): 001-v1
EXAMPLE (TAG): DXXXXXX-VY, TYPE-XX, QTY: TBD
- 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 8. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
- 9. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
- 10. 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

REV.	DATE	DCN #	DRAWING TREE #
v1	27 AUG 2014	E1400354-x0	-
-	-	-	-
-	-	-	-



-101 DETAIL

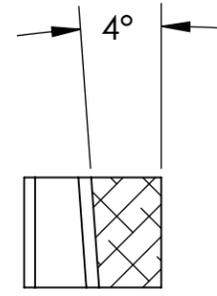
ISO VIEW

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		aLIGO, SUS, NON-MAGNETIC BLADE DAMPER ASSY., 2 PIECE CLAW CLAMP	
TOLERANCES: .XX ± .01 .XXX ± .005				SUB-SYSTEM SUS		DESIGNER E.SANCHEZ 19 AUG 2014	
ANGULAR ± 0.5°				MATERIAL 6061-T6 Al		DRAFTER E.SANCHEZ 27 AUG 2014	
FINISH 63 μinch				NEXT ASSY D1400298		CHECKER SEE DCC	
						APPROVAL SEE DCC	
						SIZE DWG. NO. B D1400297	
						REVISION v1	
						SCALE: 2:1 PROJECTION: SHEET 1 OF 2	

D1400297 aLIGO, SUS, NON-MAGNETIC BLADE DAMPER ASSY., 2 PIECE CLAW CLAMP, PART PDM REV: , DRAWING PDM REV:

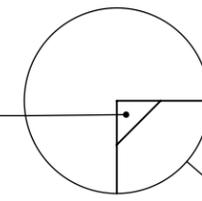


ISO VIEW



SECTION E-E

.03 X 45°
CORNER CHAMFER
2 PL.

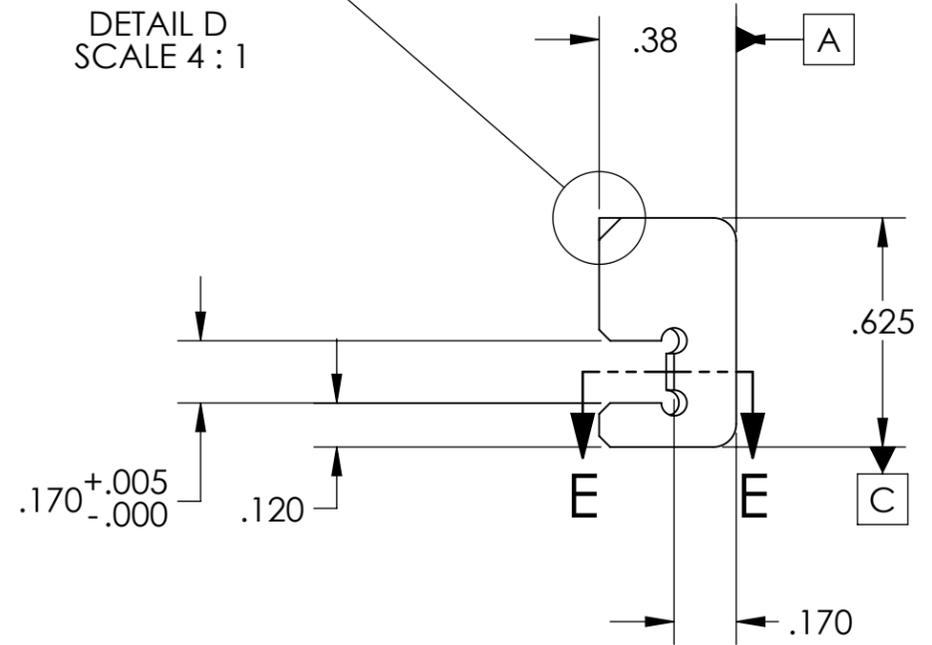
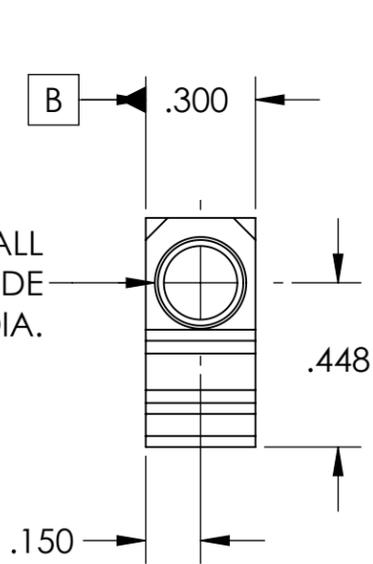


DETAIL D
SCALE 4:1

2X R.06
2X R.035

2X .03 X 45°

∅ .20 THRU ALL
∠ ∅ .25 X 90°, NEAR SIDE
TAP FOR #10-32 HELICOIL INSERT = 1.5 * DIA.



-102 DETAIL

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE DWG. NO. B D1400297	REV. v1
SCALE: 2:1 PROJECTION:	SHEET 2 OF 2

D1400297 dLIGO, SUS, NON-MAGNETIC BLADE DAMPER ASSY., 2 PIECE CLAW CLAMP, PART PDM REV: , DRAWING PDM REV: