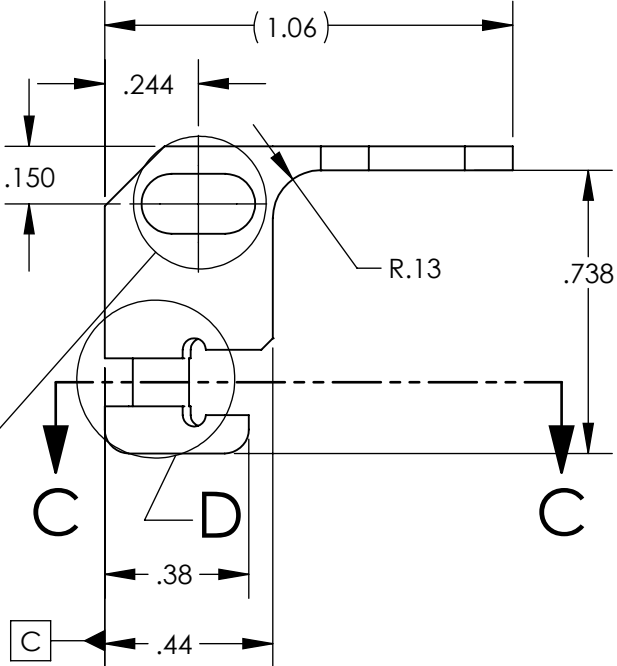
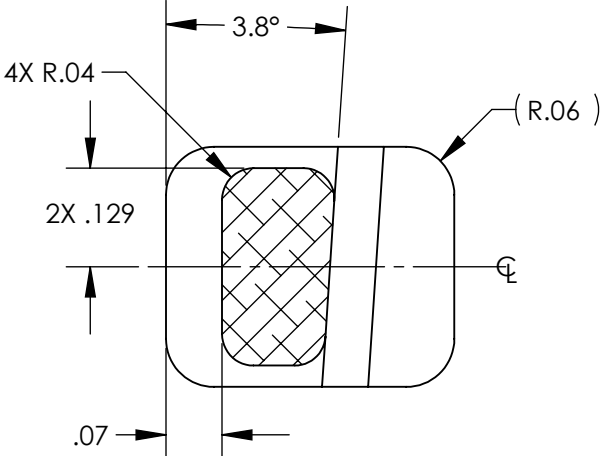
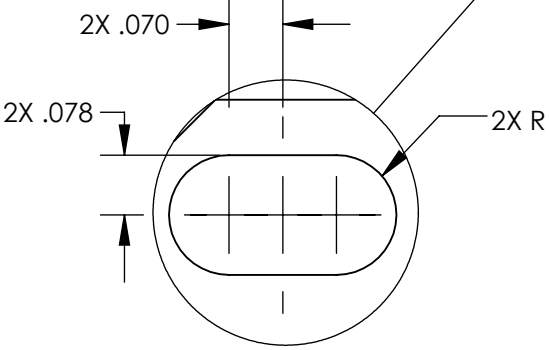
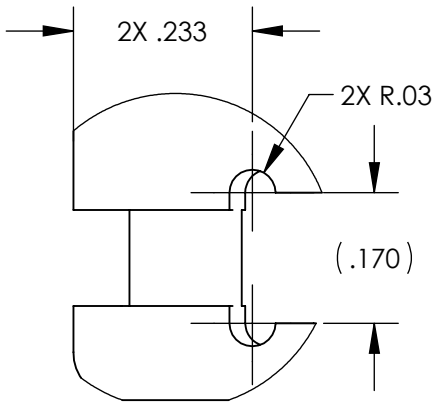
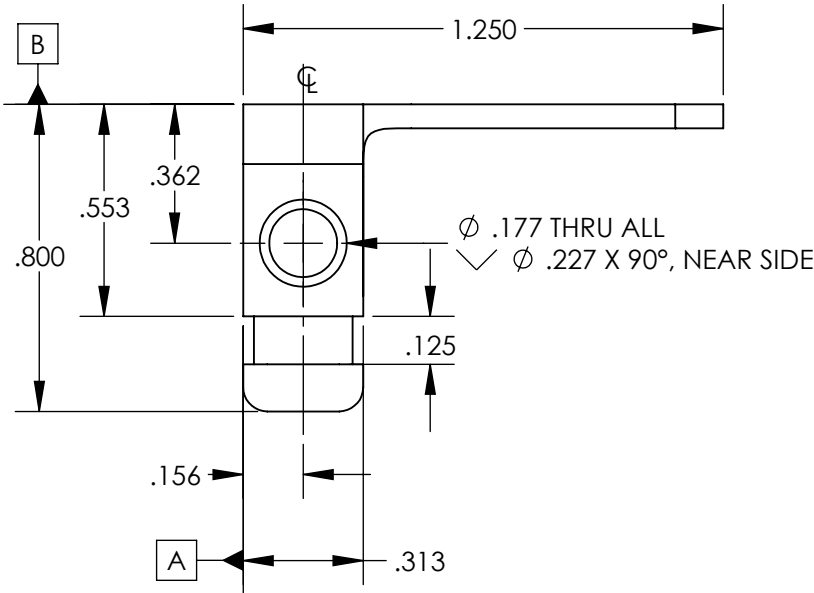
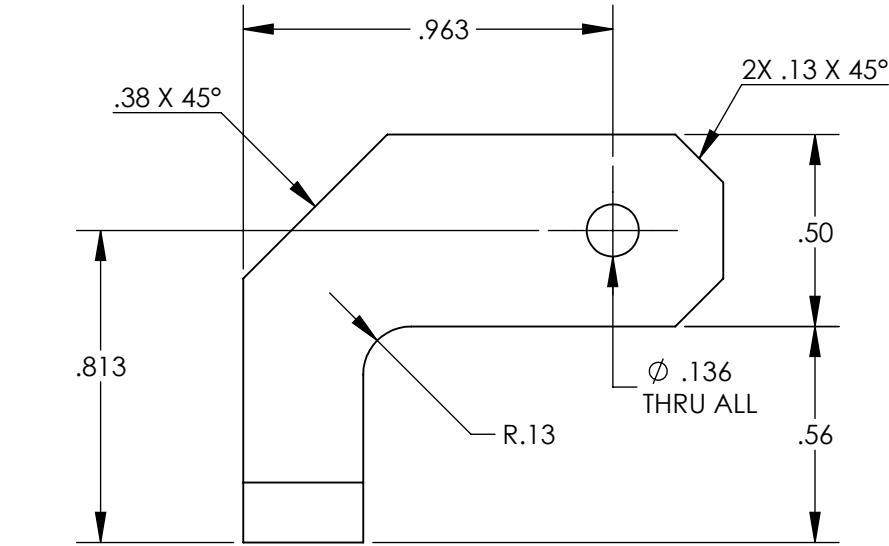
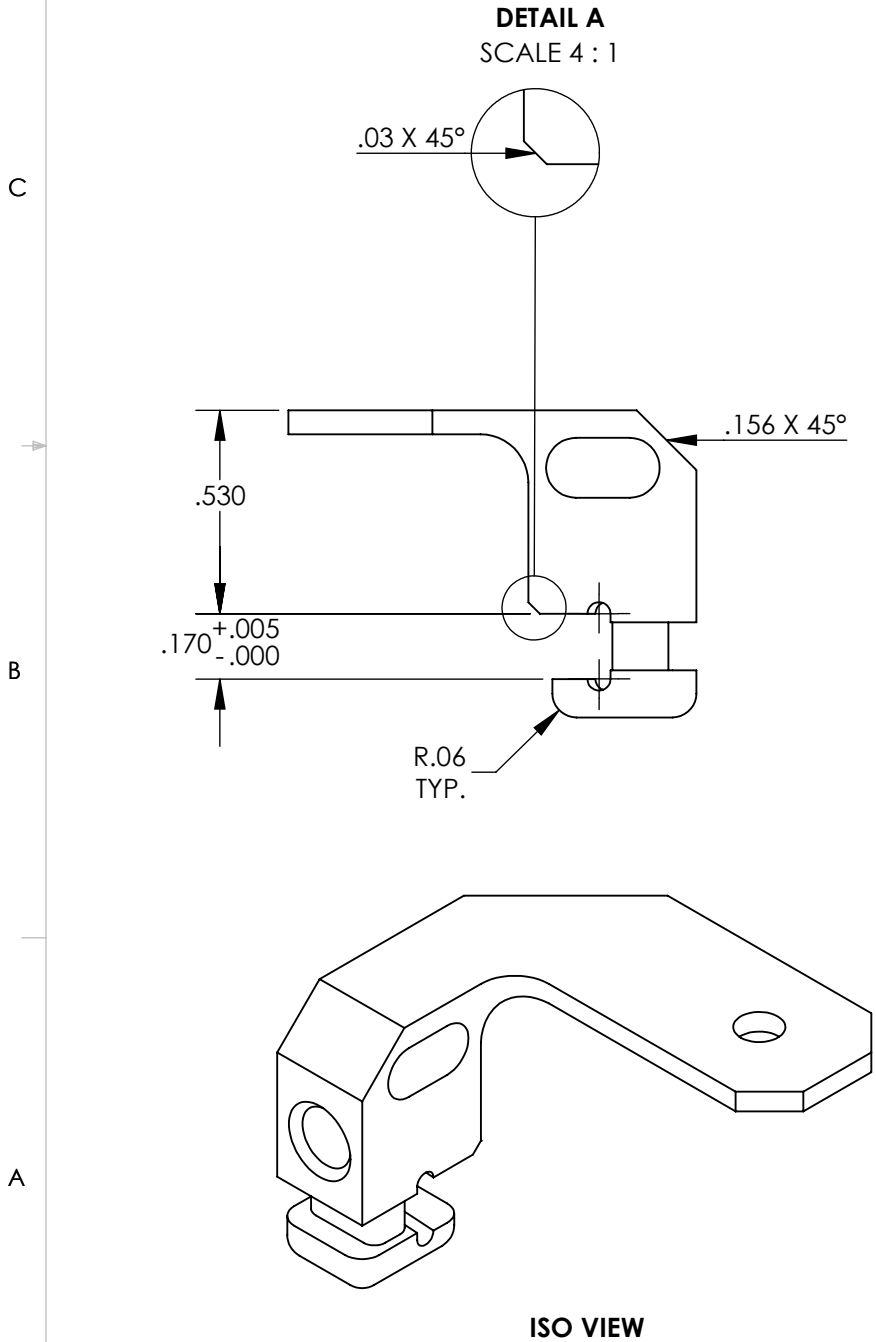


D1400297 aLIGO, SUS, NON-MAGNETIC BLADE DAMPER ASSY., 2 PIECE CLAW CLAMP, PART PDM REV: X-004, DRAWING PDM REV: X-003

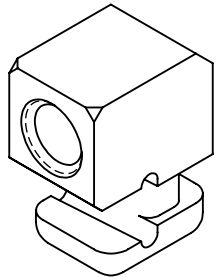
- NOTES CONTINUED:
5. SCRIBE, ENGRAVE, LASER MARK OR MECHANICALLY STAMP (NO DYES OR INKS) A UNIQUE THREE DIGIT SERIAL NUMBER & REVISION NUMBER ON EACH PART. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. BAG AND TAG PARTS WITH THEIR DRAWING PART NUMBER, REVISION, VARIANT 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	-
v2	27 APR 2015	E1500225-x0	-
-	-	-	-

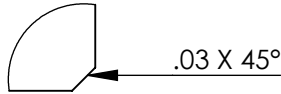


-101 DETAIL

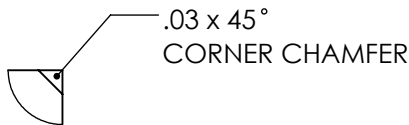
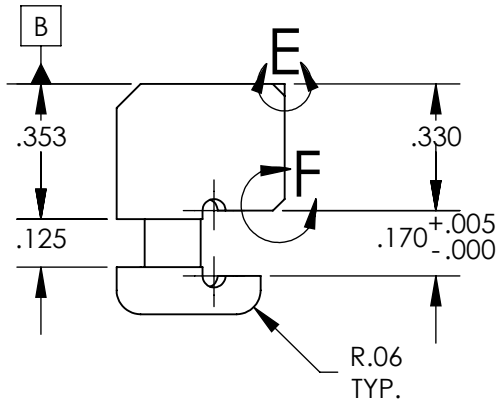
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				PART NAME			
DIMENSIONS ARE IN INCHES				aLIGO, SUS, NON-MAGNETIC BLADE DAMPER ASSY., 2 PIECE CLAW CLAMP			
TOLERANCES: .XX ± .01 .XXX ± .005				DESIGNER	E.SANCHEZ	19 AUG 2014	SIZE DWG. NO.
ANGULAR ± 0.5°				DRAFTER	E.SANCHEZ	27 AUG 2014	B D1400297
MATERIAL 6061-T6 Al				CHECKER	SEE DCC	SEE DCC	REV. v2
FINISH 63 μinch				APPROVAL	SEE DCC	SEE DCC	SCALE: 2:1
NEXT ASSY D1400298				PROJECTION:			
				SHEET 1 OF 2			



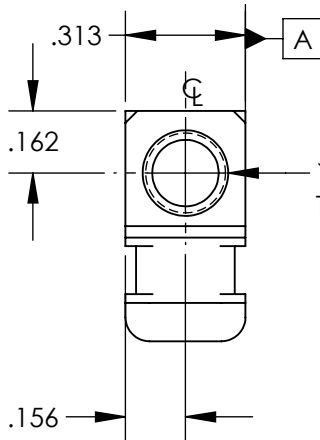
ISO VIEW



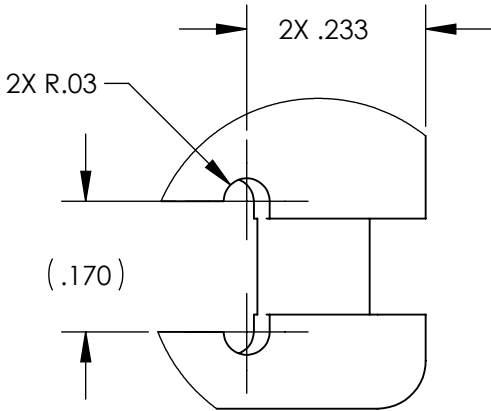
DETAIL F
SCALE 4 : 1



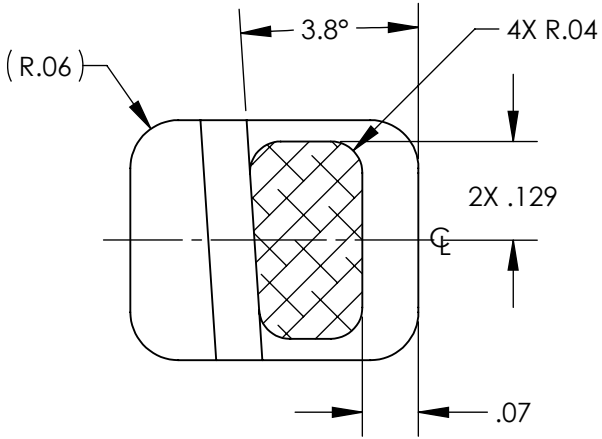
DETAIL E
SCALE 4 : 1
2 PL.



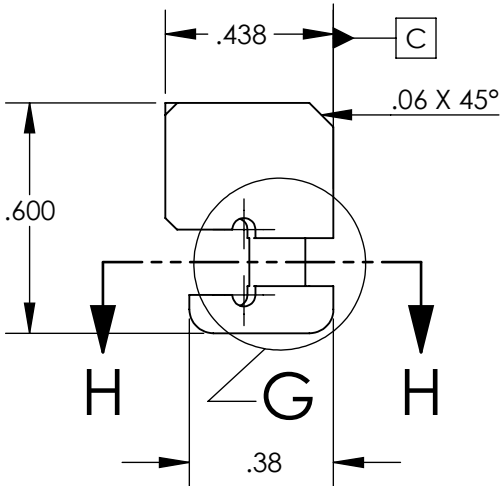
Ø .173 THRU ALL
✓ Ø .223 X 90°, NEAR SIDE
TAP FOR #8-32 HELICOIL INSERT = 1.5 * DIA.




DETAIL G
SCALE 4 : 1



SECTION H-H
SCALE 4 : 1



-102 DETAIL

		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE B	DWG. NO.	D1400297	REV. v2
SCALE: 2:1		PROJECTION:	SHEET 2 OF 2