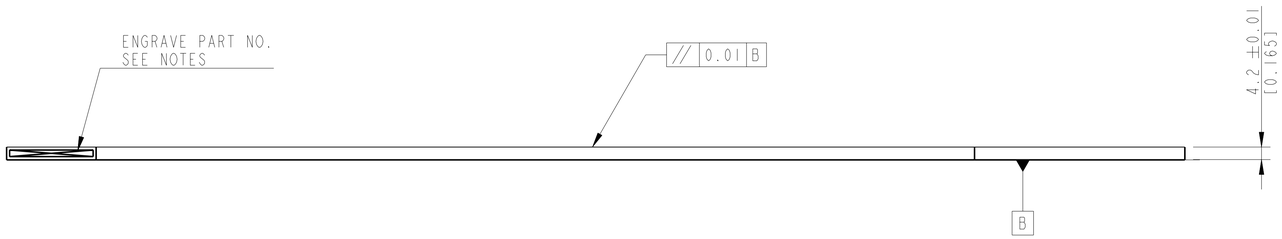
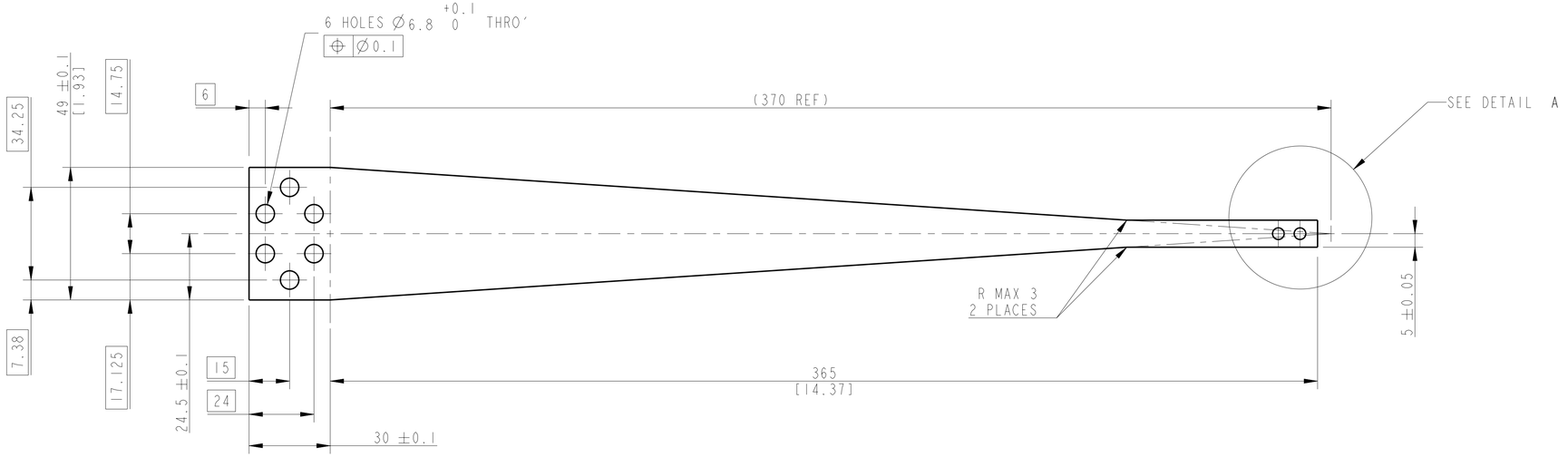
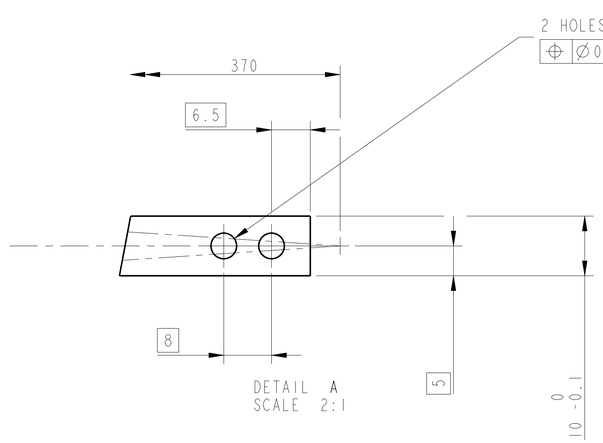
INTRALINK NAME: D060237-A

REV.	DATE	DCN #	DRAWING TREE #
A	26/JUL/06	E060211-00-K	

FLAT PROFILE







NOTES: (UNLESS OTHERWISE SPECIFIED)

1. DO NOT SCALE FROM DRAWING.
2. INTERPRET DIMENSIONS PER: ANSI Y14.5 1982
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)
4. FABRICATE FROM SHEET MATERIAL; FORM RADIUS BY ROLLING.
5. REMOVE ALL SHARP EDGES, R.02 MIN.
6. SCRIBE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: D020188-001. A VIBRATORY TOOL MAY BE USED.
7. AFTER PARTS ARE ROLLED TO RADIUS, HARDEN FOR HEAT TREATMENT AT 435 DEG C FOR 100 HOURS AND AIR COOL. PARTS MUST BE SUPPORTED WITH TOOLING DURING HEAT TREATMENT TO AVOID RADIUS CHANGE DUE TO SELF WEIGHT. TOOLING FOR HEAT TREATMENT MAY BE A "BIKE RACK" TYPE OF TOOL THAT WILL ALLOW THE PARTS TO BE MOUNTED ON THEIR SIDES. PARTS MAY BE ROLLED AGAIN AFTER HEAT TREATMENT TO ADJUST RADIUS TO SPECIFICATION.

DIMENSIONS ARE IN mm
TOLERANCES:
LINEAR ± 0.25 mm
ANGULAR ±0.25°

MATERIAL: MARAGING STEEL 250

FINISH: CLEAN AND DEGREASED
√(µm (µin)) Ra : 0.8

	NAME	DATE
DRAWN	I WILMUT	26/JUL/06
CHECKED	RJG	27/JUL/06
APPROVED	RJG	27/JUL/06

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
IGR, GLASGOW UNIVERSITY GEO 600 GROUP
RUTHERFORD APPLETON LABORATORIES

SYSTEM **ADVANCED LIGO**

SUB-SYSTEM **SUS**

NEXT ASSY **QUAD N-PTYPE UI MASS**

PART NAME **BOTTOM BLADE SPRINGS**
-

SIZE D | DRG. NO. D060237 | REV. C.

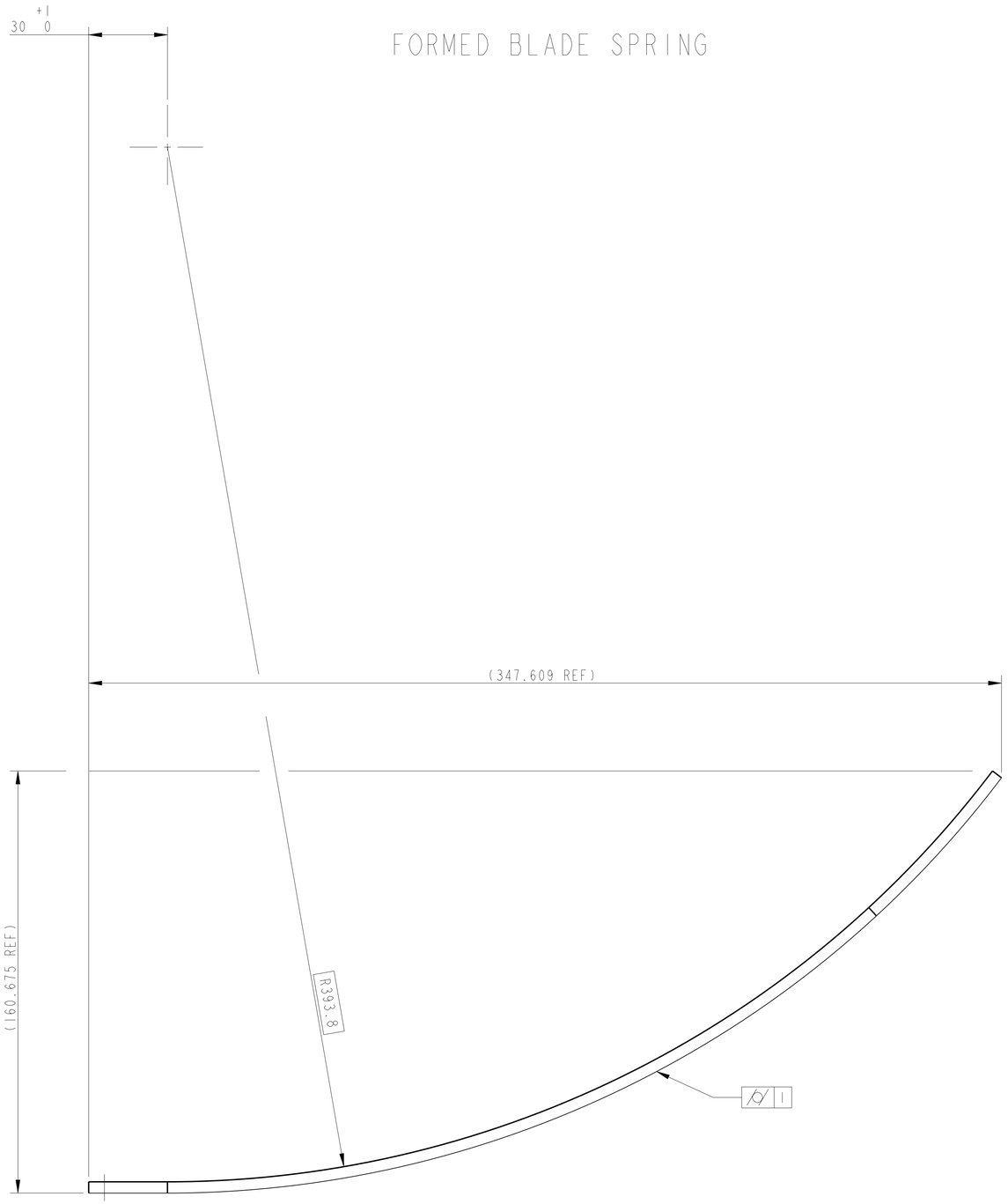
SCALE 1:1 | PROJECTION: | SHEET 1 OF 2

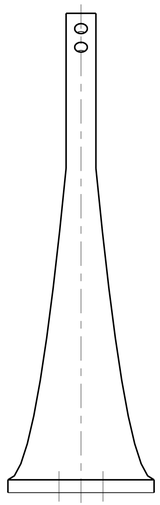
INTRALINK NAME: D060237-A

FOR INTERNAL USE ONLY:

E=186Gpa
TOTAL SUSP MASS = 39.5 KG
WIRE CLAMP OFFSET = 4.12 DOWN
BLADE BEND RAD CALCULATED BY FEA

FORMED BLADE SPRING





NOTES: (UNLESS OTHERWISE SPECIFIED)

1. DO NOT SCALE FROM DRAWING.
2. INTERPRET DIMENSIONS PER: ANSI Y14.5 1982
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).
4. FABRICATE FROM SHEET MATERIAL; FORM RADIUS BY ROLLING.
5. REMOVE ALL SHARP EDGES, R.02 MIN.
6. SCRIBE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: D020188-001. A VIBRATORY TOOL MAY BE USED.
7. AFTER PARTS ARE ROLLED TO RADIUS, HARDEN FOR HEAT TREATMENT AT 435 DEG C FOR 100 HOURS AND AIR COOL. PARTS MUST BE SUPPORTED WITH TOOLING DURING HEAT TREATMENT TO AVOID RADIUS CHANGE DUE TO SELF WEIGHT. TOOLING FOR HEAT TREATMENT MAY BE A "BIKE RACK" TYPE OF TOOL THAT WILL ALLOW THE PARTS TO BE MOUNTED ON THEIR SIDES. PARTS MAY BE ROLLED AGAIN AFTER HEAT TREATMENT TO ADJUST RADIUS TO SPECIFICATION.

DIMENSIONS ARE IN mm
TOLERANCES:
LINEAR ± 0.25 mm
ANGULAR ±0.25 °

MATERIAL: MARAGING STEEL 250

FINISH: CLEAN AND DEGREASED
ηfum (μin) Ra : 0.8

	NAME	DATE
DRAWN	J WILMUT	26/JUL/04
CHECKED	R.G	27/JUL/06
APPROVED	R.J.G	27/JUL/06

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSSETTS INSTITUTE OF TECHNOLOGY
IGR, GLASGOW UNIVERSITY GEO 600 GROUP
RUTHERFORD APPLETON LABORATORIES

SYSTEM ADVANCED LIGO
SUB-SYSTEM SUS
NEXT ASSY UPPER INTERMEDIATE MASS
PART NAME BOTTOM BLADE SPRINGS
-

SIZE D | DRG. NO. D060237 | REV C.

SCALE 1:1 | PROJECTION | SHEET 2 OF 2