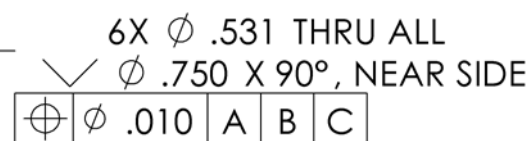
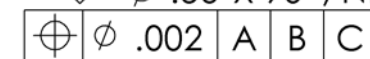
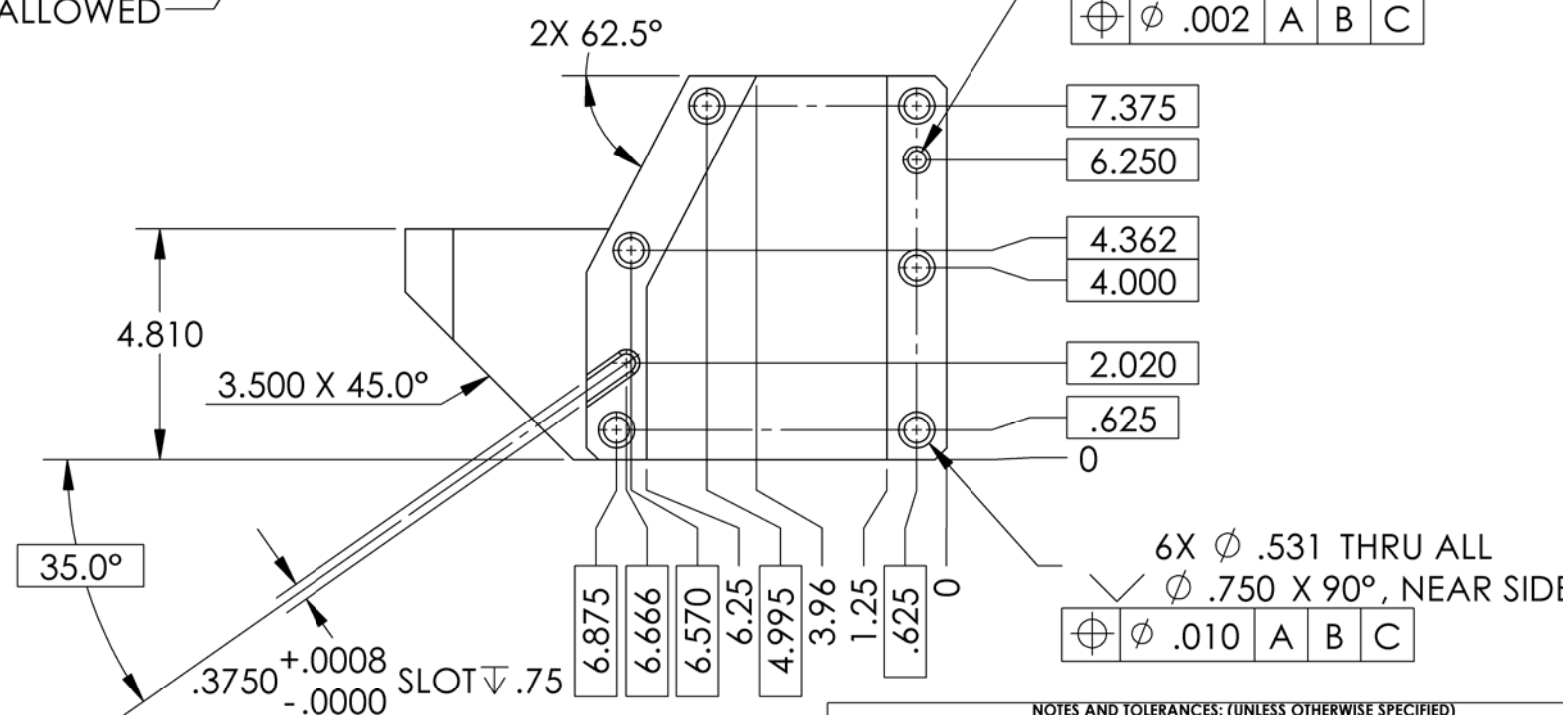
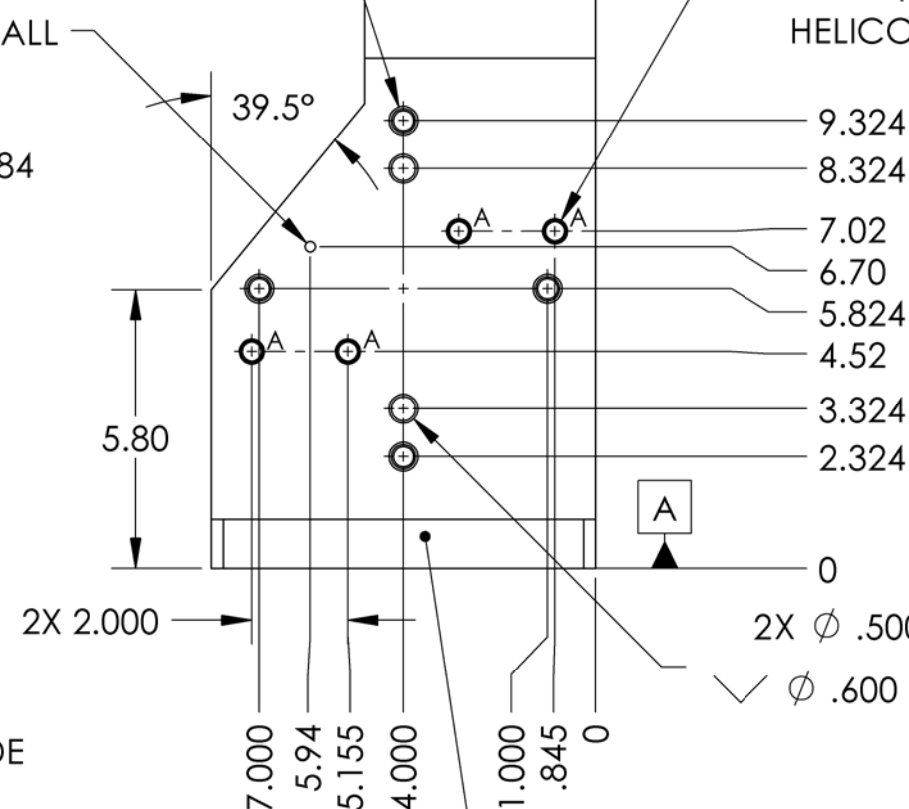
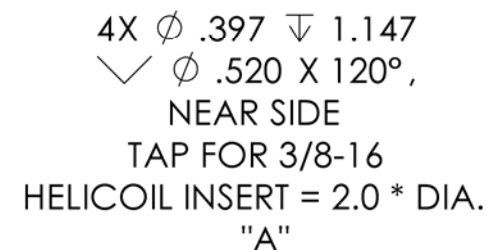
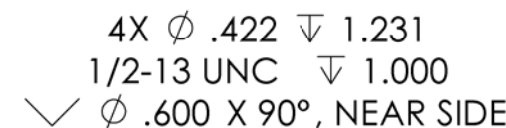


5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE") APPLICATION, AND NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12 HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
EXAMPLE DX00000X-VY, TYPE-XX, S/N XXX.
6. APPROXIMATE WEIGHT = 48.832 LB.
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 E9900364.
9. A TAPPED HOLE PITCH INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.
10. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES.
11. A TRUE POSITION TOLERANCE OF $\phi .010$ IS - THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.

$\perp$	.002	A	B
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BREAK EDGE .09 X 45°

	.002	A	B	C
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BOUNDARY

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		
DIMENSIONS ARE IN INCHES	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.	
TOLERANCES: .XX ± .015 .XXX ± .005	MATERIAL Material <not specified>	FINISH 32 μin/c

 CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME ACTUATOR POST STAGE 0-1, aLIGO BSC ISI				
SYSTEM ADVANCED LIGO		SUB-SYSTEM SEI		DESIGNER S.BARNUM 22 Feb. 2010	SIZE DWG. NO. D0901554	REV. v3
NEXT ASSY D0901182		DRAFTER M.HILLARD 22 Feb. 2010		CHECKER F.MATICHARD 22 Feb. 2010		APPROVAL K.MASON 22 Feb. 2010
		SCALE: 1:4		PROJECTION: 		SHEET 1 OF 2

D0901554 Actuator Post Stage0-1, PART PDM REV: X-023, DRAWING PDM REV: X-010

