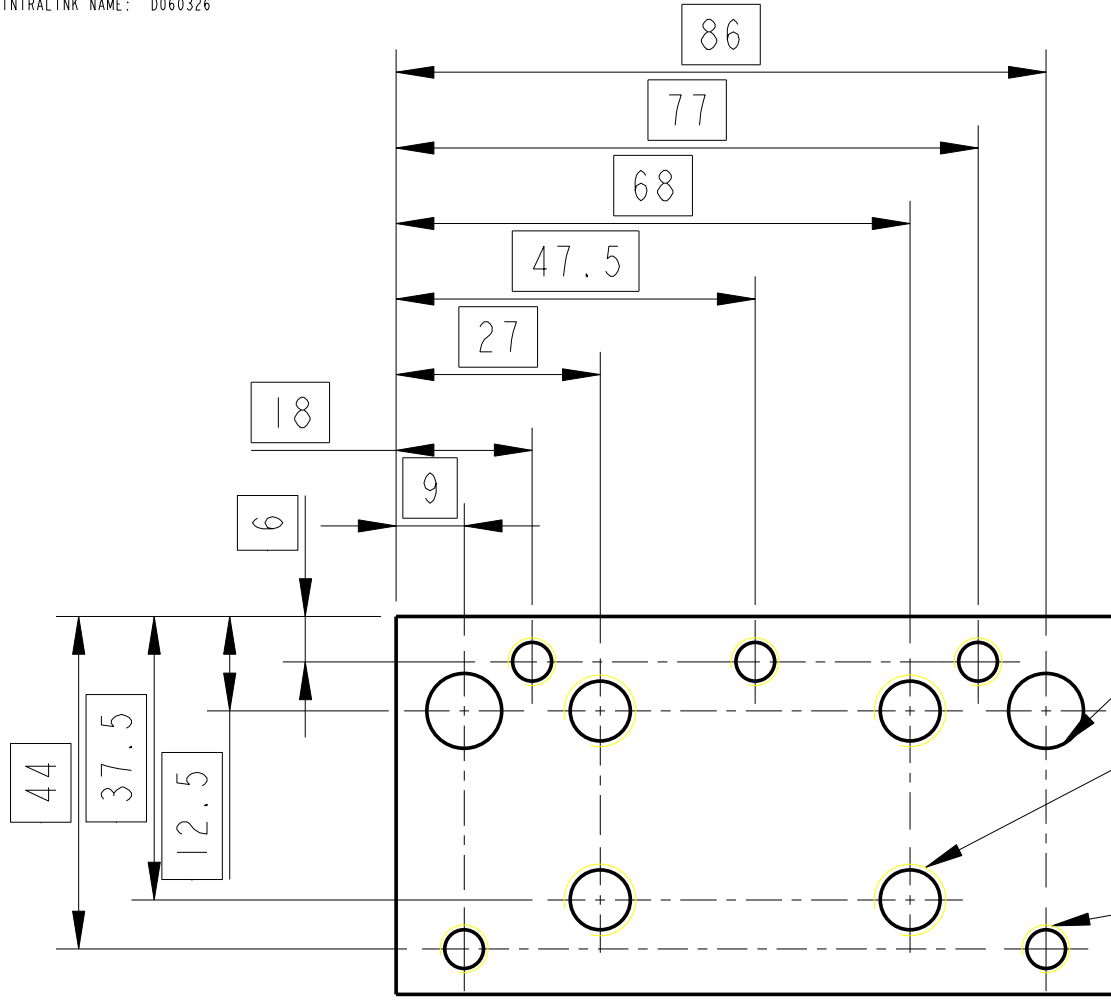
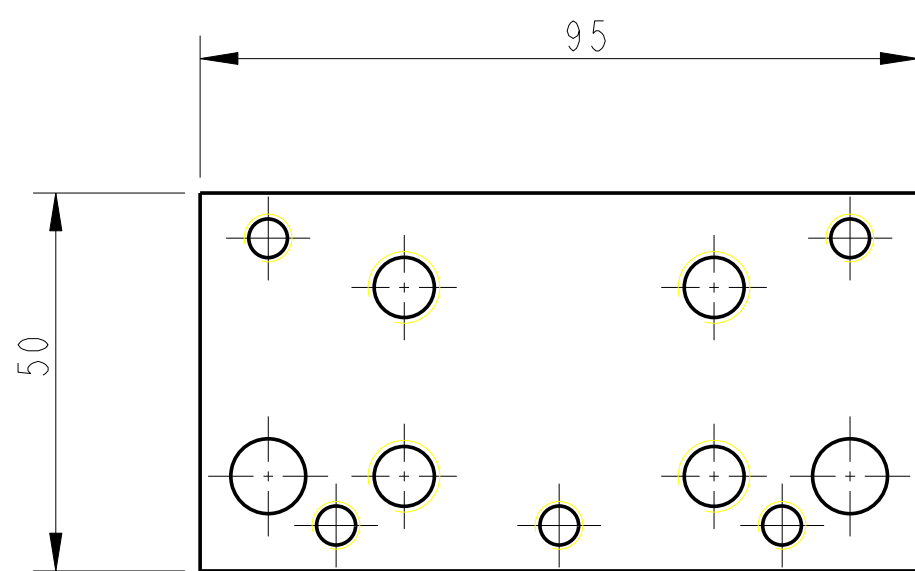
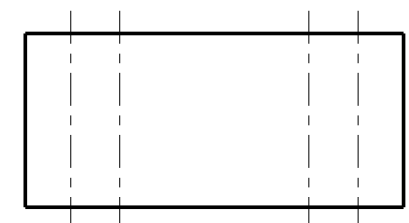
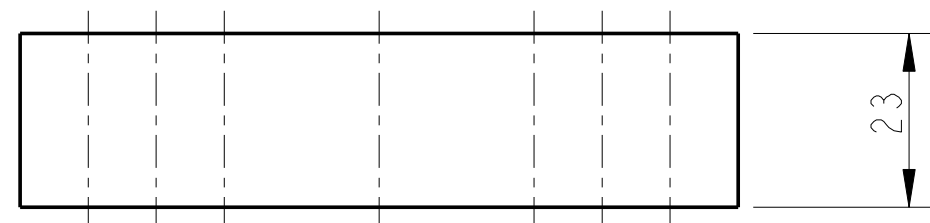


REV.	DATE	DCN #	DRAWING TREE #
A	13/OCT/06	E060238	
E	15/JULY/08	E080367	

STAGE I MACHINING



- DRILL 2 HOLES $\varnothing 9.9$ THRU $\varnothing 0.2$
- 4 HOLES FOR 3/8-16 UNC HELICOILS THRU, HELICOILS NOT TO BE FITTED $\varnothing 0.2$
- 5 HOLES FOR 1/4-20 UNC HELICOILS THRU, HELICOILS NOT TO BE FITTED $\varnothing 0.15$



NOTES: (UNLESS OTHERWISE SPECIFIED)

- REMOVE ALL SHARP EDGES, R.02 MIN.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)
- SCRIBE, ENGRAVE OR STAMP DRAWING PARTNUMBER 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.

DIMENSIONS ARE IN mm [INCHES]

TOLERANCES:
 X.XX ± 0.1 mm
 ANGULAR $\pm 0.25^\circ$

MATERIAL: ST. STEEL 304/316

FINISH: CLEAN, GREASE FREE
 $\sqrt{\mu m}$ [μin] Ra = 1.6 [63]

	NAME	DATE
DRAWN	I WILMUT	05/Oct/06
CHECKED	AJB	5/MAY/08
APPROVED	AJB	15/JULY/08

SCALE 1:1 PROJECTION: SHEET 1 OF 2

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

SYSTEM **ADVANCED LIGO**

SUB-SYSTEM **SUS**

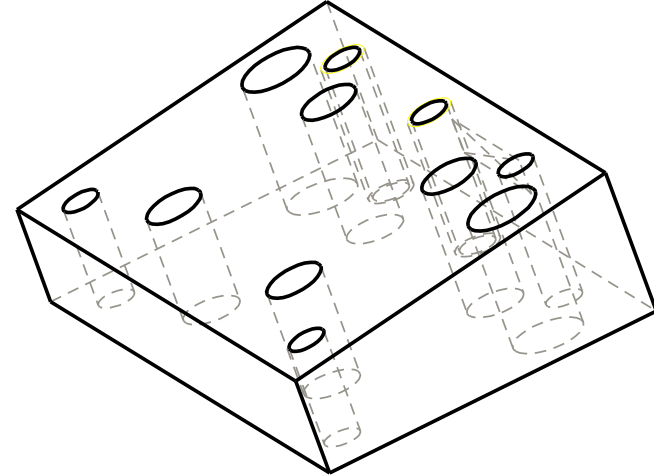
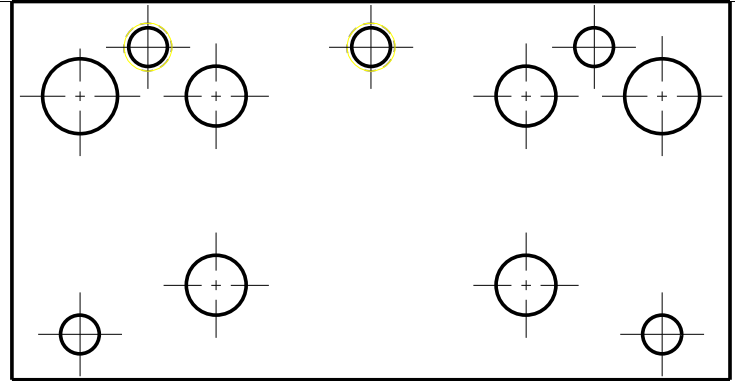
NEXT ASSY **QUAD N-PTYPE TOP STAGE**

PART NAME **BLADE CLAMP (TOP HALF)**

DRG. NO. **D060326**

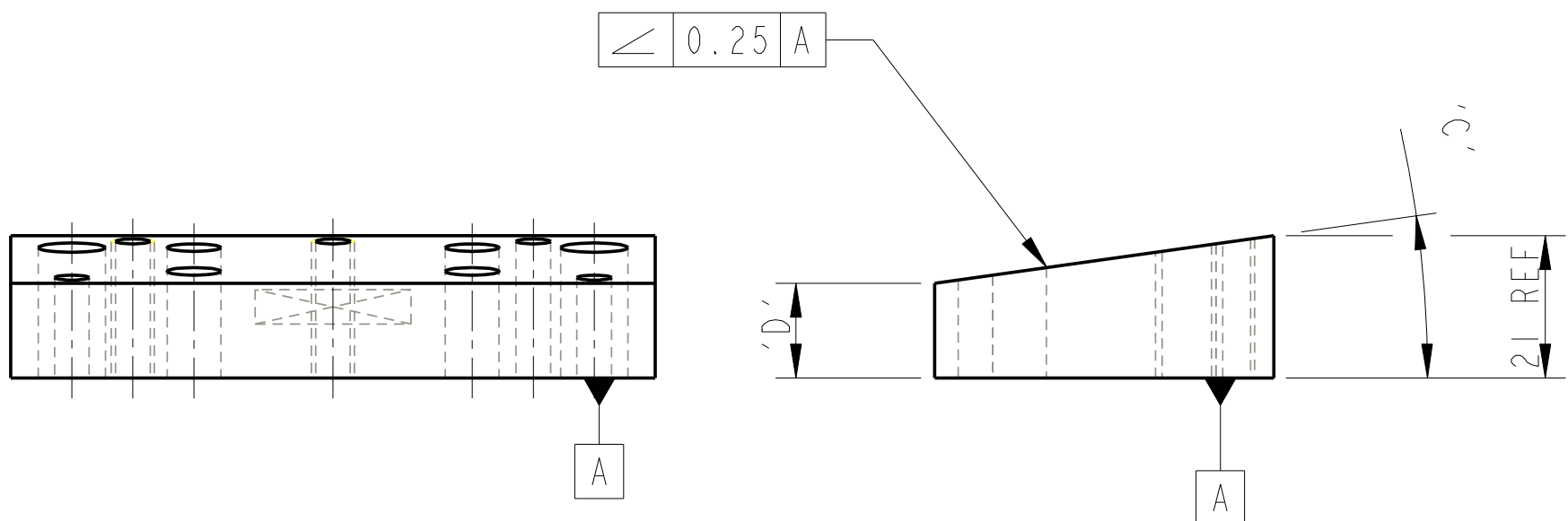
REV **E.**

STAGE 2 MACHINING

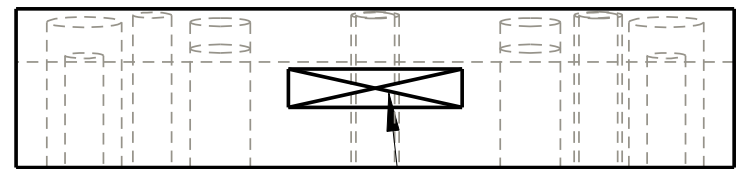


3D VIEW

VARIANT	ANGLE C	DIM D
0	0°	21 REF
1	0.109°	20.90 REF
2	0.218°	20.80 REF
3	0.327°	20.71 REF
4	0.437°	20.62 REF
5	0.546°	20.52 REF
6	0.655°	20.43 REF
7	0.764°	20.33 REF
8	0.837°	20.27 REF
9	0.982°	20.14 REF
10	1.091°	20.05 REF



FOR DIMS C AND D SEE TABLE



ENGRAVE PART NUMBER
SEE NOTE 4

NOTES: (UNLESS OTHERWISE SPECIFIED)

- REMOVE ALL SHARP EDGES, R.02 MIN.
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- 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.

DIMENSIONS ARE IN mm (INCHES)

X.XX ±0.1 mm
ANGULAR ±0.25 °

MATERIAL: ST. STEEL 304/316

FINISH: CLEAN, GREASE FREE
√μm [μin] Ra = 1.6 [63]

DRAWN	I WILMUT	05/Oct/06
CHECKED	AJB	5/MAY/08
APPROVED	AJB	15/JULY/08

SCALE 1:1 PROJECTION: SHEET 2 OF 2

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
RUTHERFORD APPLETON LABORATORIES

SYSTEM **ADVANCED LIGO**

SUB-SYSTEM **SUS**

NEXT ASSY **QUAD N-P-TYPE TOP STAGE**

PART NAME **BLADE CLAMP (TOP HALF)**

DRG. NO. **D060326**

REV **E.**