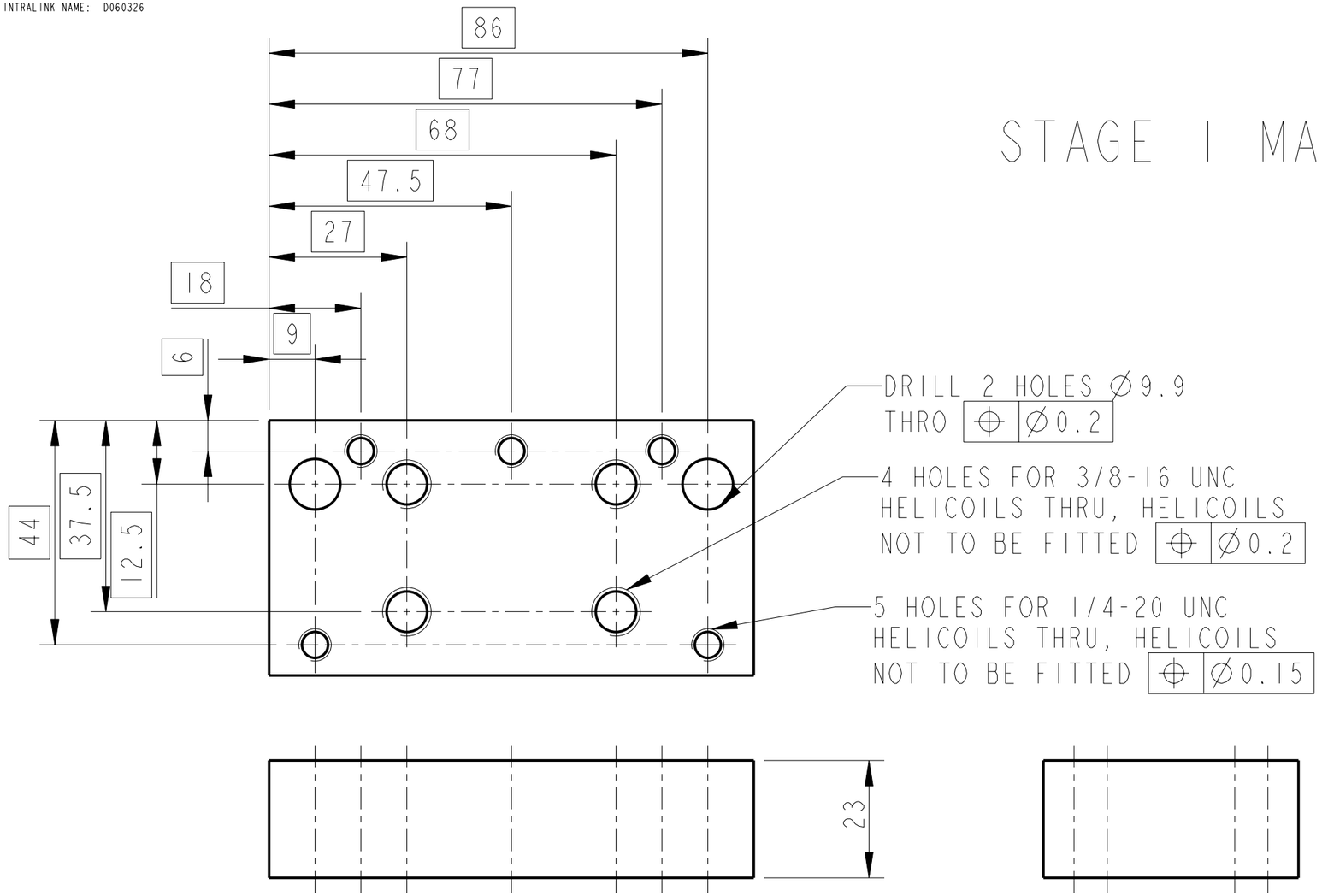
INTRALINK NAME: D060326

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

STAGE 1 MACHINING



NOTES: (UNLESS OTHERWISE SPECIFIED)

1. REMOVE ALL SHARP EDGES, R.02 MIN.
2. DO NOT SCALE FROM DRAWING.
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. 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 ±0.25 °

MATERIAL: ST. STEEL 304/316

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

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

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

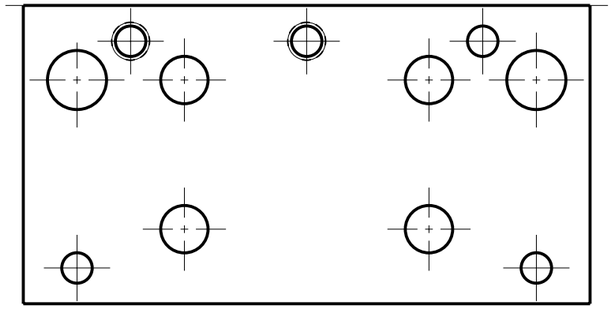
PART NAME BLADE CLAMP (TOP HALF)

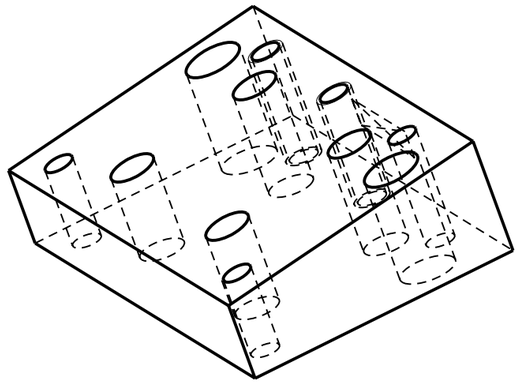
SIZE B | DRG. NO. D060326 | REV E.

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

INTRALINK NAME: D060326

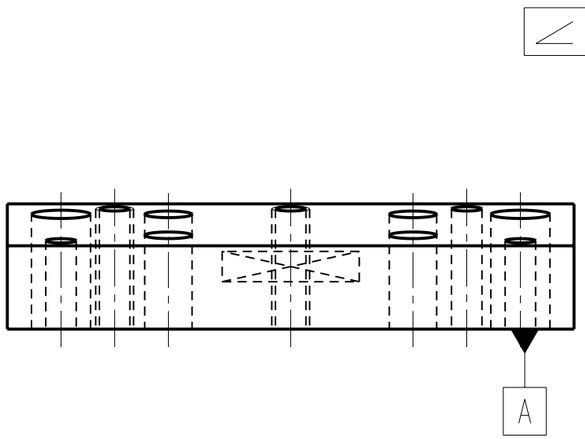
STAGE 2 MACHINING

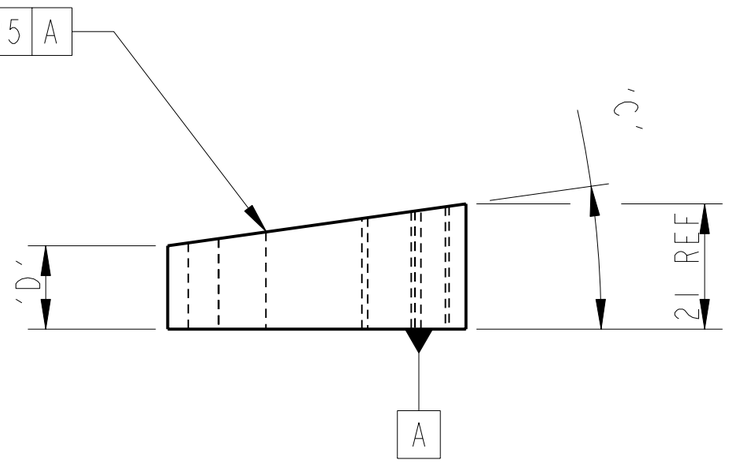




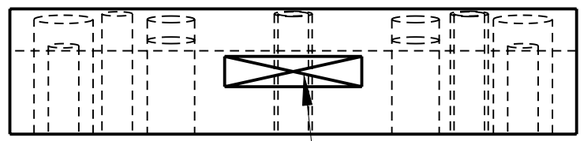
3D VIEW

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

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SYSTEM ADVANCED LIGO
SUB-SYSTEM SUS
NEXT ASSY QUAD N-PTYPE TOP STAGE
PART NAME BLADE CLAMP (TOP HALF)

SIZE B | DRG. NO. D060326 | REV E.

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