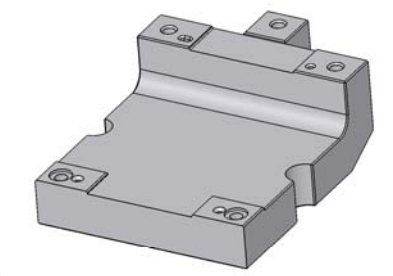
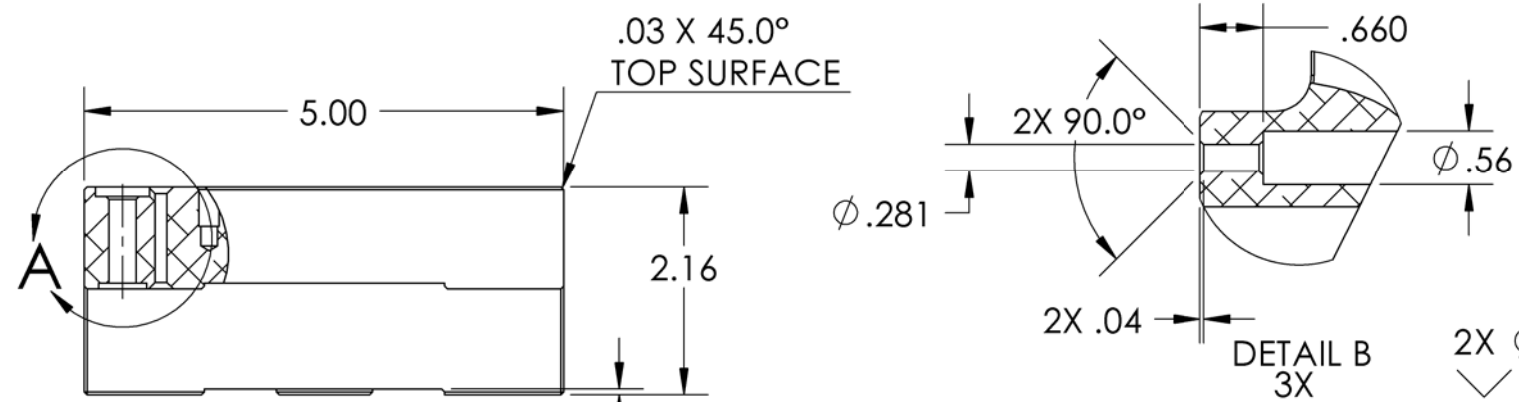


NOTES CONTINUED:

5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON 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: DXXXXXX-VY, TYPE-XX, S/N XXX
6. APPROXIMATE WEIGHT = 3.07 LB.
7. A TRUE POSITION TOLERANCE OF $\phi .010$ IS - THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.
8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
9. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONAL AFTER DELIVERY OF FINISHED PARTS.
10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 Feb. 2010	E1000049	E1000025
v2	28 July 2010	E1000339	E1000025

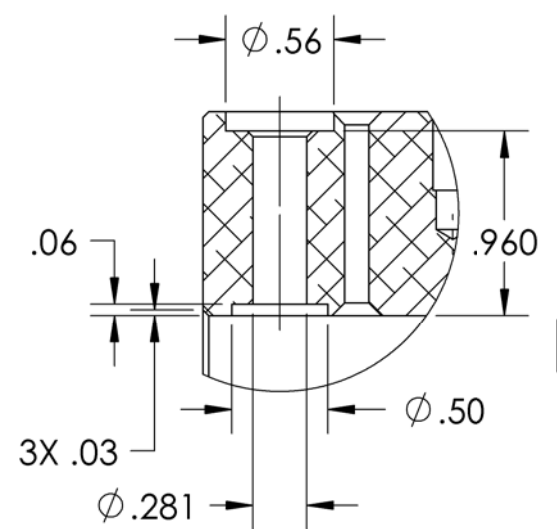


2X $\phi .17 \nabla .61$
 $\nabla \phi .26 \times 90^\circ$
 TAP FOR #8-32
 HELICOIL
 INSERT = 2.0 * DIA.

2X $\phi .1256^{+.0006}_{-.0000}$ THRU ALL
 $\nabla \phi .26 \times 90^\circ$, NEAR SIDE
 $\nabla \phi .26 \times 90^\circ$, FAR SIDE

$\phi .001$	A	B	C
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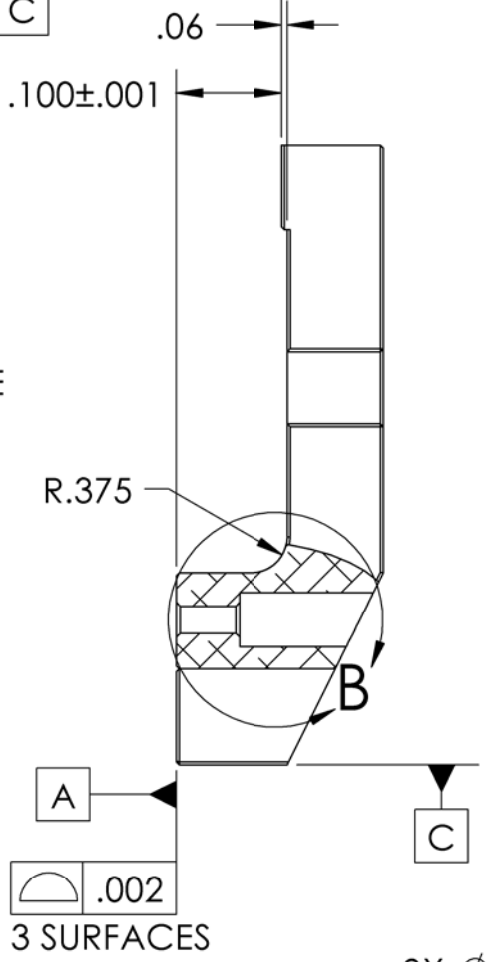
.001	A
2 SURFACES	



2X
 DETAIL A
 SCALE 1 : 1

$.1256^{+.0006}_{-.0000} \nabla .38$
 SLOT, BREAK EDGE
 $.04 \times 45^\circ$

$\phi .002$	A	B	C
BOUNDARY			



2X DETAIL A

2X R.375

2X 1.70

2X $\phi .25 \nabla 1.75$

3X SEE DETAIL B

$\phi .1256^{+.0006}_{-.0000} \nabla .375$
 $\nabla \phi .210 \times 90^\circ$, NEAR SIDE

$\phi .001$	A	B	C
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NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	1. INTERPRET DRAWING PER ASME Y14.5-1994, 2. BREAK ALL CORNERS AND EDGES .03 X 45°.
TOLERANCES: XX ± .015 XXX ± .005	3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.
ANGULAR ± 0.5°	
MATERIAL	6061-T6 Al
FINISH	63 μ inch

LIGO	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	SEI
NEXT ASSY	D1000290

PART NAME ACTUATOR TOOLING BAR, STAGE 0-1, aLIGO BSC ISI					
DESIGNER	S.BARNUM	22 Feb. 2010	SIZE	DWG. NO.	REV.
DRAFTER	M.HILLARD	22 Feb. 2010	B	D0902342	v2
CHECKER	F.MATICHARD	22 Feb. 2010	SCALE	1:2	PROJECTION
APPROVAL	K.MASON	22 Feb. 2010	SHEET 1 OF 1		

D0902342 Stage0-1 Actuator Tooling Bar, PART PDM REV: X-009, DRAWING PDM REV: X-005