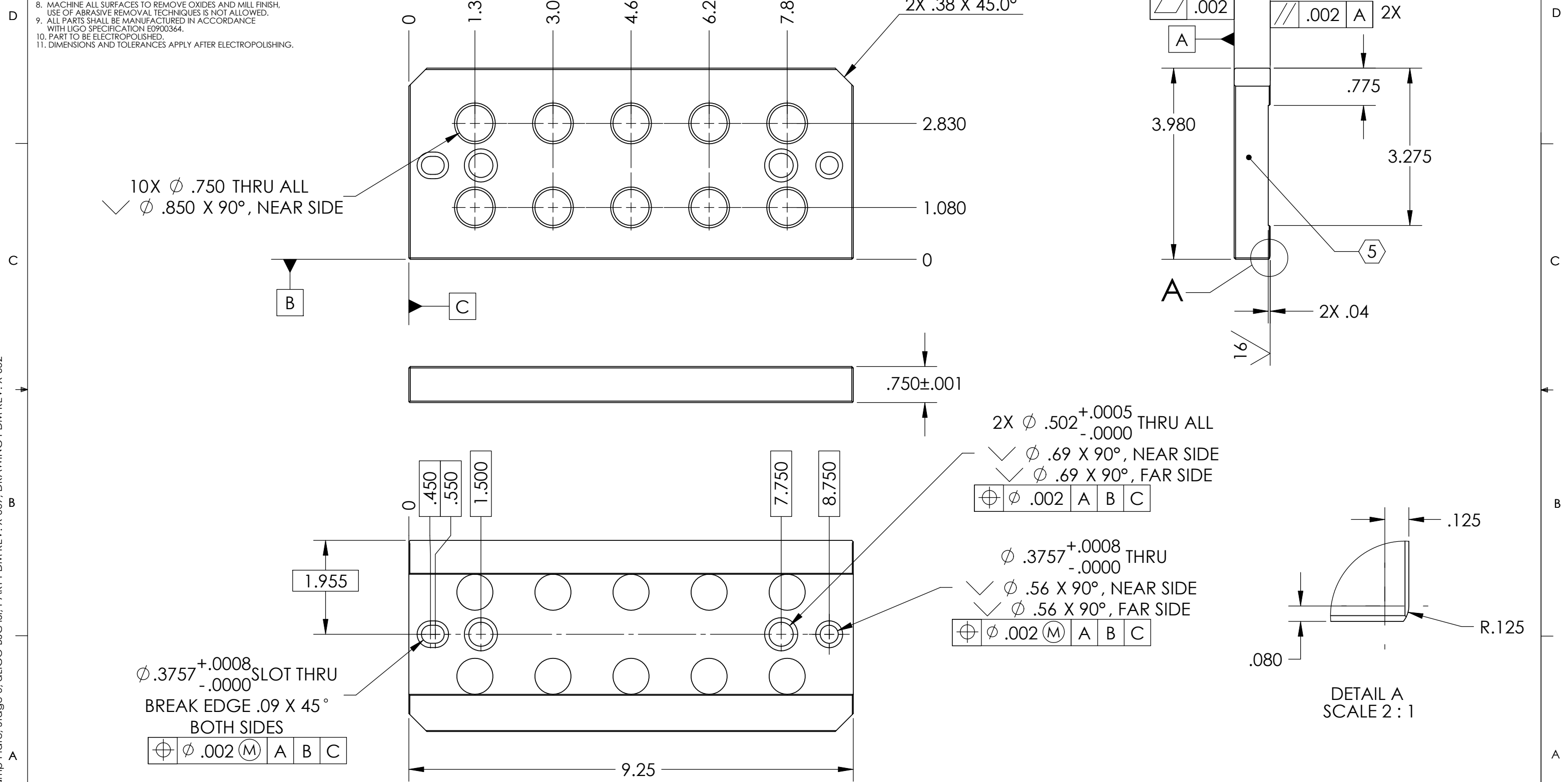


NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001.
 A VIBRATORY TOOL MAY BE USED.
 6. APPROXIMATE WEIGHT = 6.47 LB.
 7. A TRUE POSITION TOLERANCE OF ϕ .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 PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 10. PART TO BE ELECTROPOLISHED.
 11. DIMENSIONS AND TOLERANCES APPLY AFTER ELECTROPOLISHING.

REV.	DATE	DCN #	DRAWING TREE #
v1	26 Feb. 2010	E1000022	E1000025

D0902696 Spring Clamp Plate, Stage 0, aLIGO BSC ISI, PART PDM REV: X-009, DRAWING PDM REV: X-002



10X ϕ .750 THRU ALL
 \checkmark ϕ .850 X 90°, NEAR SIDE

2X .38 X 45.0°

2X ϕ .502^{+.0005}/_{-.0000} THRU ALL
 \checkmark ϕ .69 X 90°, NEAR SIDE
 \checkmark ϕ .69 X 90°, FAR SIDE

ϕ .3757^{+.0008}/_{-.0000} THRU
 \checkmark ϕ .56 X 90°, NEAR SIDE
 \checkmark ϕ .56 X 90°, FAR SIDE

ϕ .3757^{+.0008}/_{-.0000} SLOT THRU
 BREAK EDGE .09 X 45°
 BOTH SIDES

DETAIL A
 SCALE 2 : 1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME							
DIMENSIONS ARE IN INCHES TOLERANCES: .XX \pm .015 .XXX \pm .005 ANGULAR \pm .5°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. BREAK ALL EDGES AND CORNERS .03 X 45°. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SPRING CLAMP PLATE, STAGE 0, aLIGO BSC ISI							
						MATERIAL 17-4 PH SSSL, H 1150		FINISH 63 μ inch		NEXT ASSY D0901197		DESIGNER A.STEIN 01 Feb. 2010	
						SYSTEM ADVANCED LIGO		SUB-SYSTEM SEI		DRAFTER M.HILLARD 01 Feb. 2010		SIZE DWG. NO. B D0902696	
APPROVAL K.MASON 01 Feb. 2010		SCALE: 1:2		PROJECTION:		SHEET 1 OF 1		REV. v1					