

D1001759 - Left clamp for Stage 1 Vibration Absorber, PART PDM REV: X-008, DRAWING PDM REV: X-006

8 7 6 5 4 3 2 1

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 = 2.570 LBS.
- 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 E0900364.
- 9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364).
- 10. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF / WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICER'S REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.
- 11. THIS DRAWING IS MINIMALLY DIMENSIONED. REFER TO SOLID MODEL FOR NON DIMENSIONED FEATURES. A +/- 0.015" TOLERANCE APPLY TO NON DIMENSIONED FEATURES.

REV.	DATE	DCN #	DRAWING TREE #
V1	12 OCT 2010	E1100092	-
-	-	-	-
-	-	-	-

D

D

C

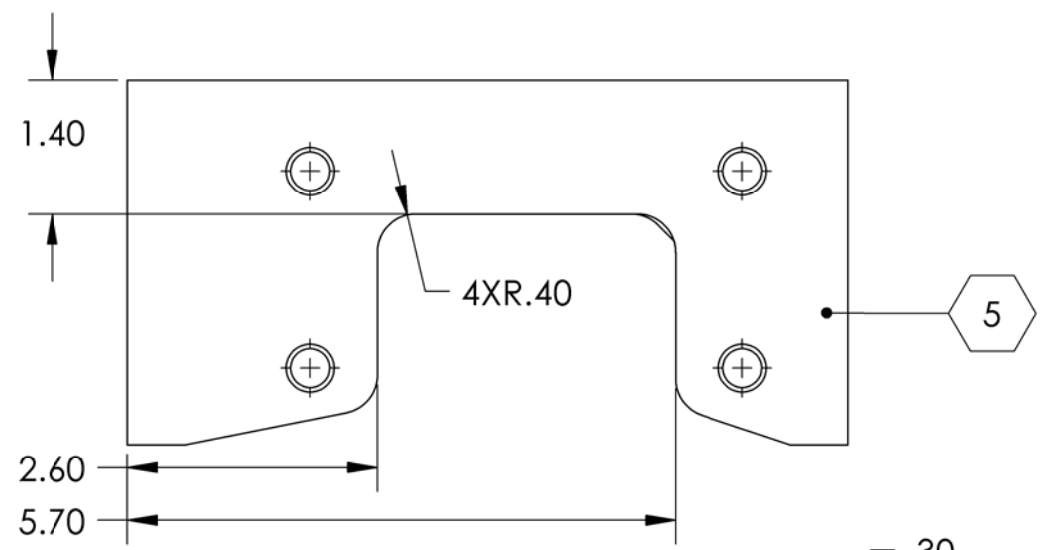
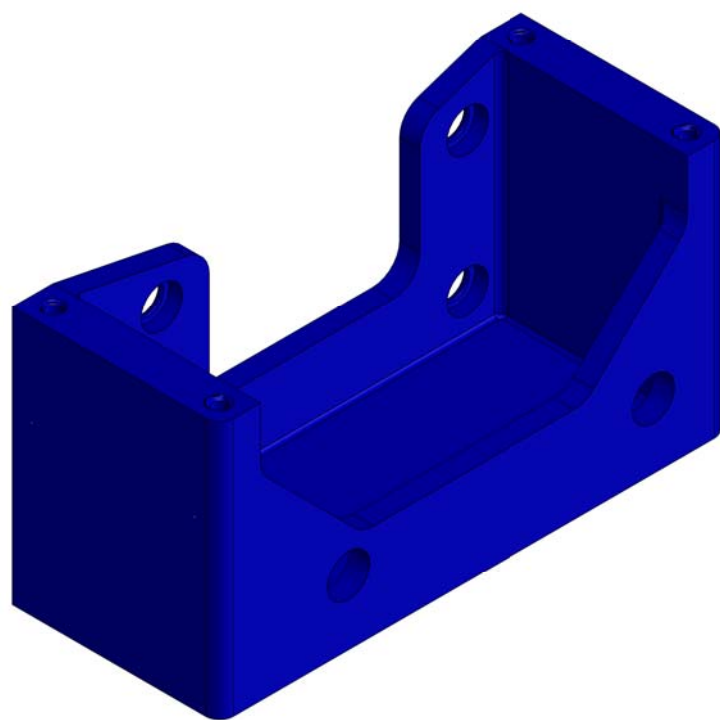
C

B

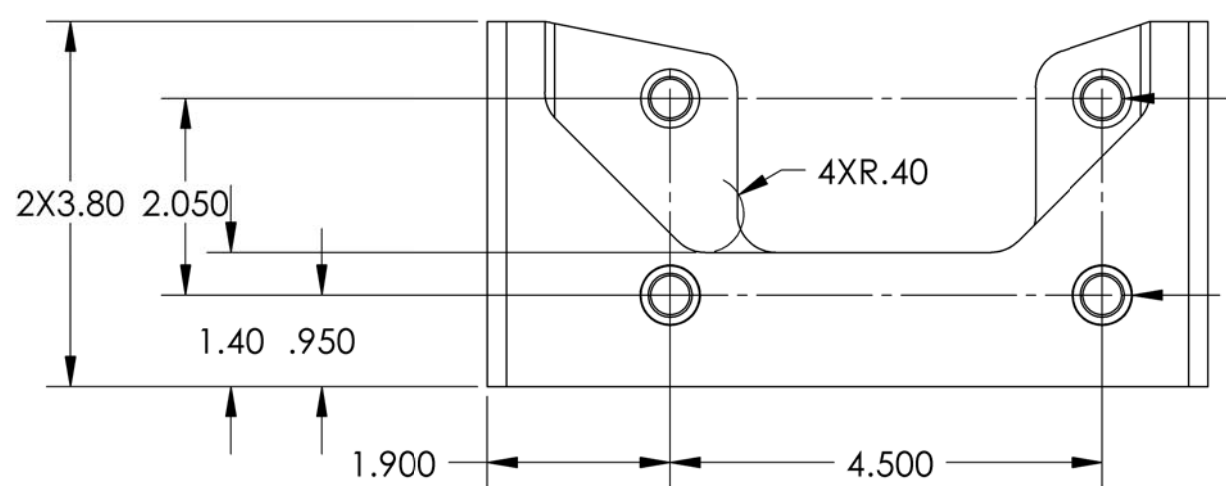
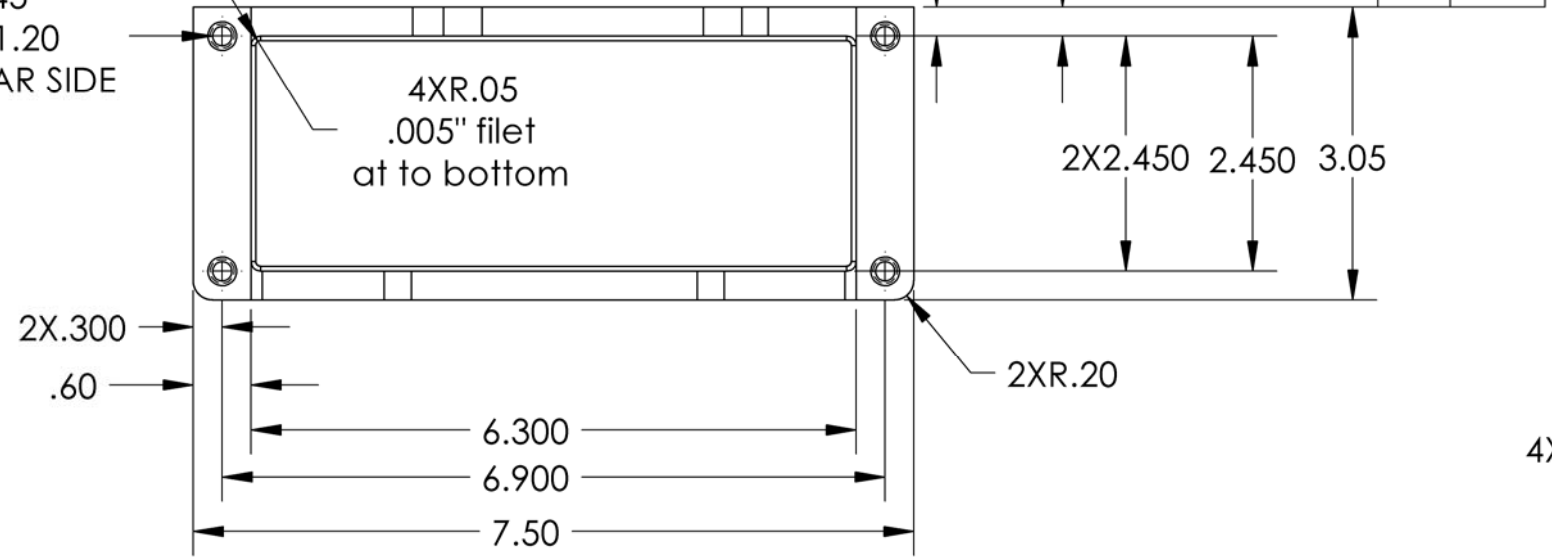
B

A

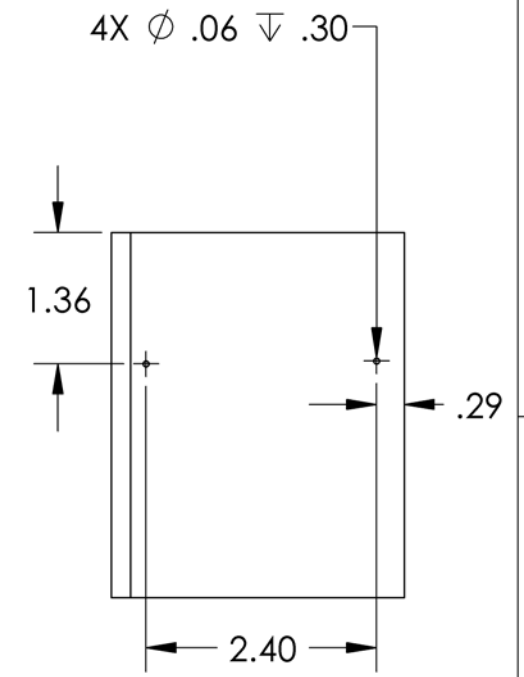
A



4X ϕ .20 ∇ 1.45
 1/4-20 UNC ∇ 1.20
 \surd ϕ .30 X 90°, NEAR SIDE



4X ϕ .41 THRU
 \surd ϕ .61 ∇ .20
 \surd ϕ .46 X 90°, MID SIDE
 \surd ϕ .50 X 90°, FAR SIDE



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		Left clamp for Stage 1 Vibration Absorber					
TOLERANCES: .XX ± 0.015 .XXX ± 0.005				SEI		DESIGNER	S.BISCANS	02 JULY 2010	SIZE	DWG. NO.	REV.
ANGULAR ± 0.1°				MATERIAL 6061-T6 Al		DRAFTER	S.BISCANS	12 OCT 2010	B	D1001759	v1
				FINISH 32 μ inch		CHECKER	F.MATICHARD	12 OCT 2010	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1
				NEXT ASSY D1001760		APPROVAL	K.MASON	12 OCT 2010			

8 7 6 5 4 3 2 1