

8

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NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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. 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	-
V2	17 JUL 2012	E1200705	-
-	-	-	-

D

C

B

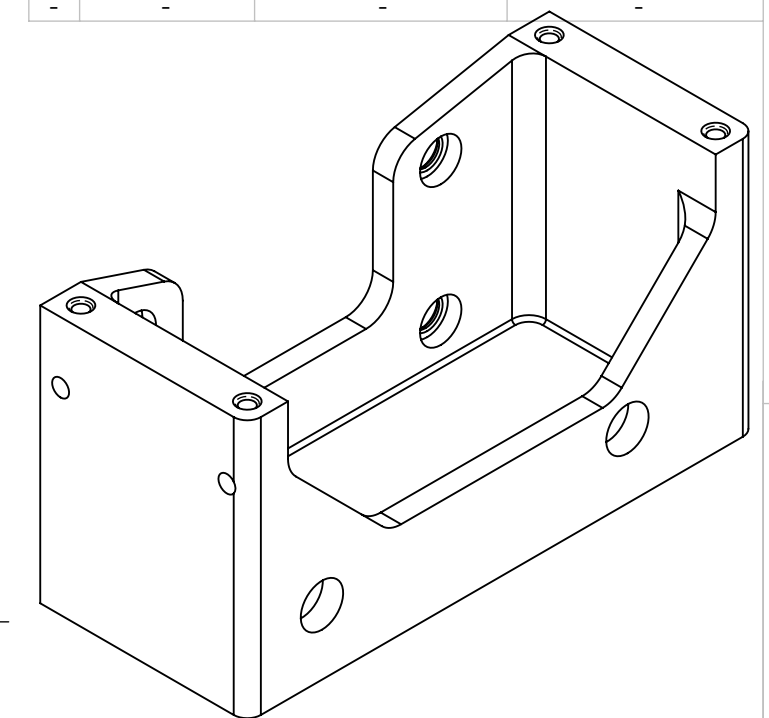
A

D

C

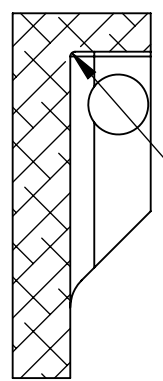
B

A

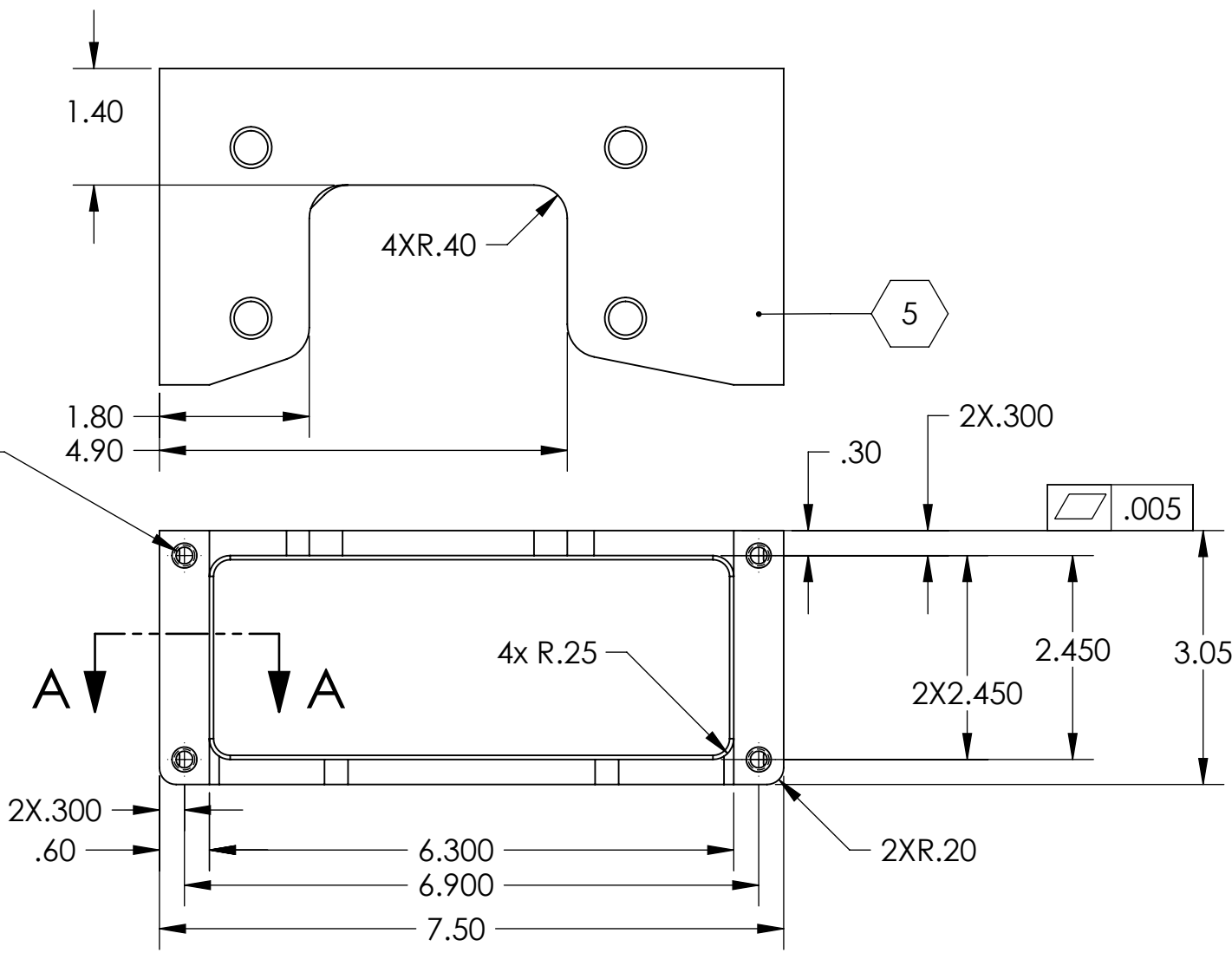


4X ϕ .20 ∇ 1.00
 1/4-20 UNC - 2B ∇ .75
 \surd ϕ .30 X 90°, NEAR SIDE

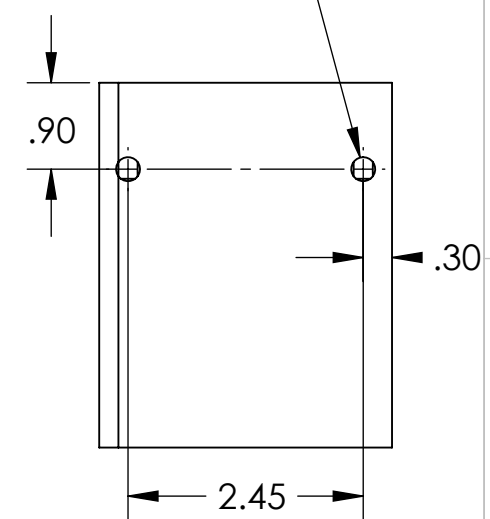
R.05 MAX
 ALL AROUND
 BOTTOM



SECTION A-A

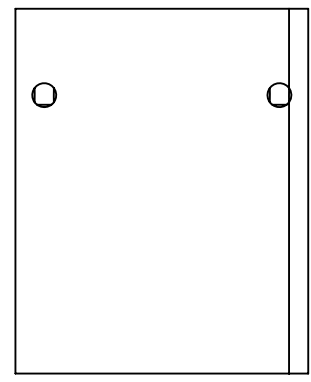
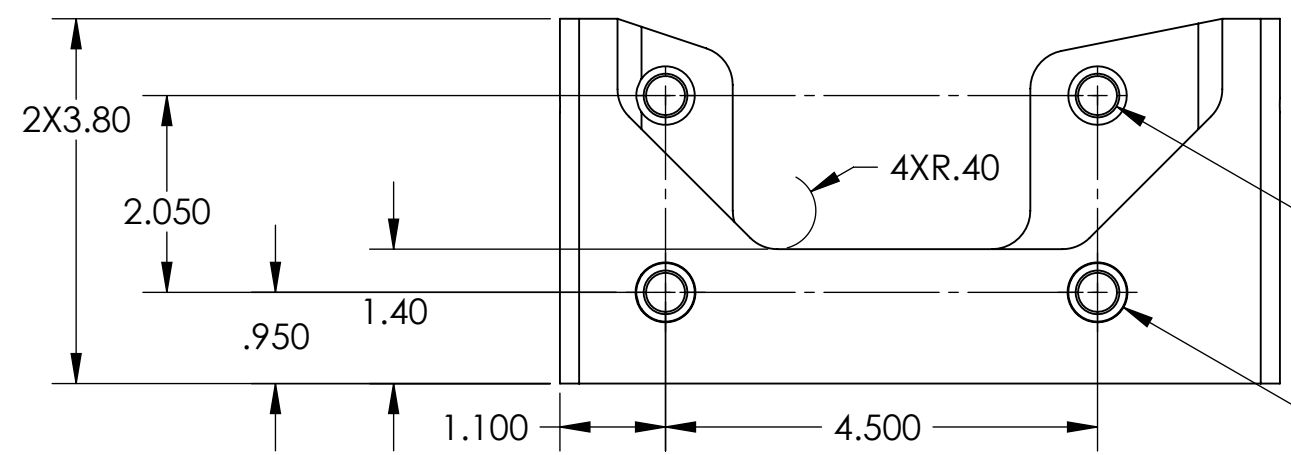


4X ϕ .25 MAX ∇ .30
 VENT HOLES



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

2X ϕ .63 THRU THIS SIDE
 ACCESS HOLES



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± 0.015 .XXX ± 0.005	
ANGULAR ± 0.1°	
MATERIAL	6061-T6 Al
FINISH	32 μ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **SEI**

NEXT ASSY: **D1001760**

PART NAME Right clamp for Stage 1 Vibration Absorber			
DESIGNER	S.BISCANS	02 JULY 2010	SIZE DWG. NO.
DRAFTER	S.BISCANS	12 OCT 2010	B
CHECKER	F.MATICHARD	12 OCT 2010	D1001764
APPROVAL	K.MASON	12 OCT 2010	REV. v2
SCALE: 1:2		PROJECTION:	SHEET 1 OF 1

D1001764 Right clamp for Stage 1 Vibration Absorber, PART PDM REV: X-007, DRAWING PDM REV: X-005

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