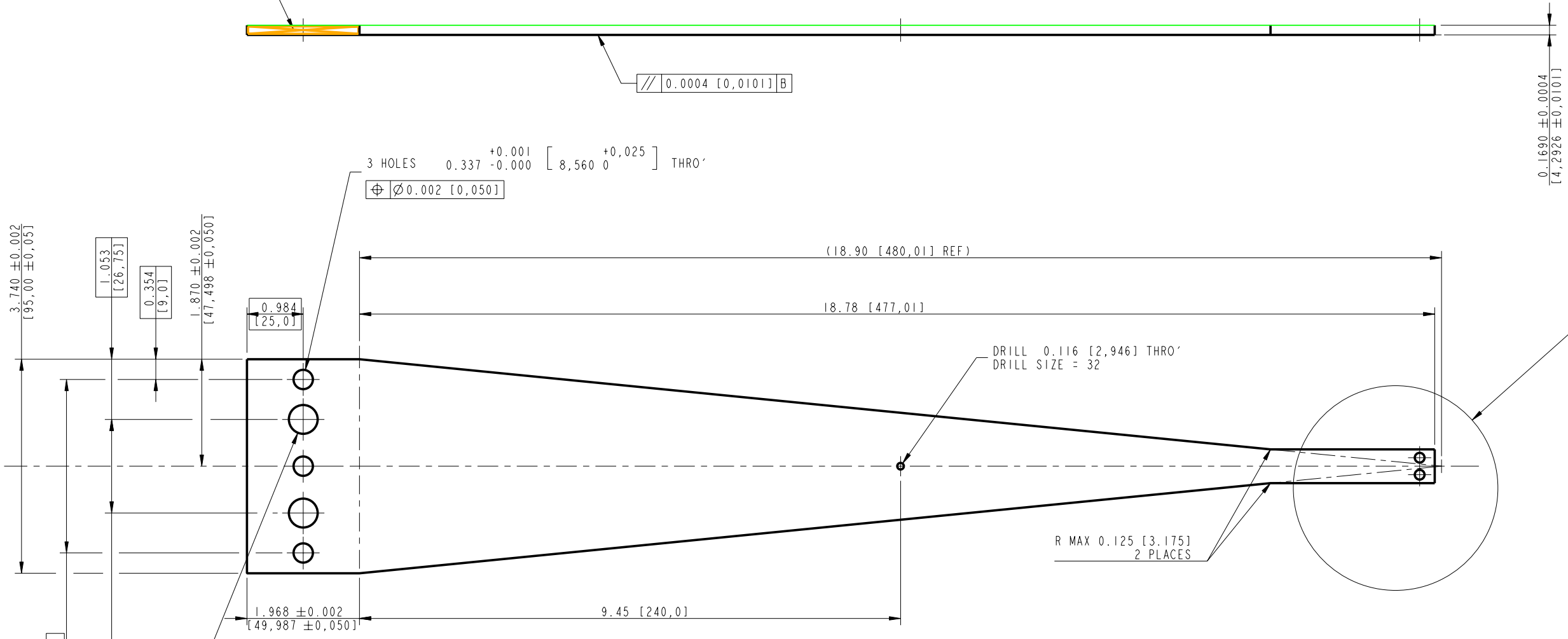
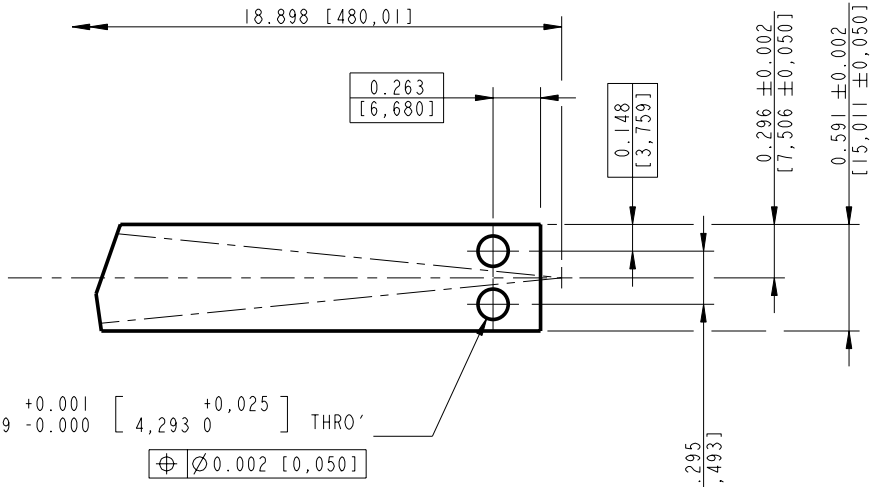


# FLAT BLADE PROFILE

ENGRAVE PART NO.  
SEE NOTES



SEE DETAIL A



DETAIL A  
SCALE 2:1

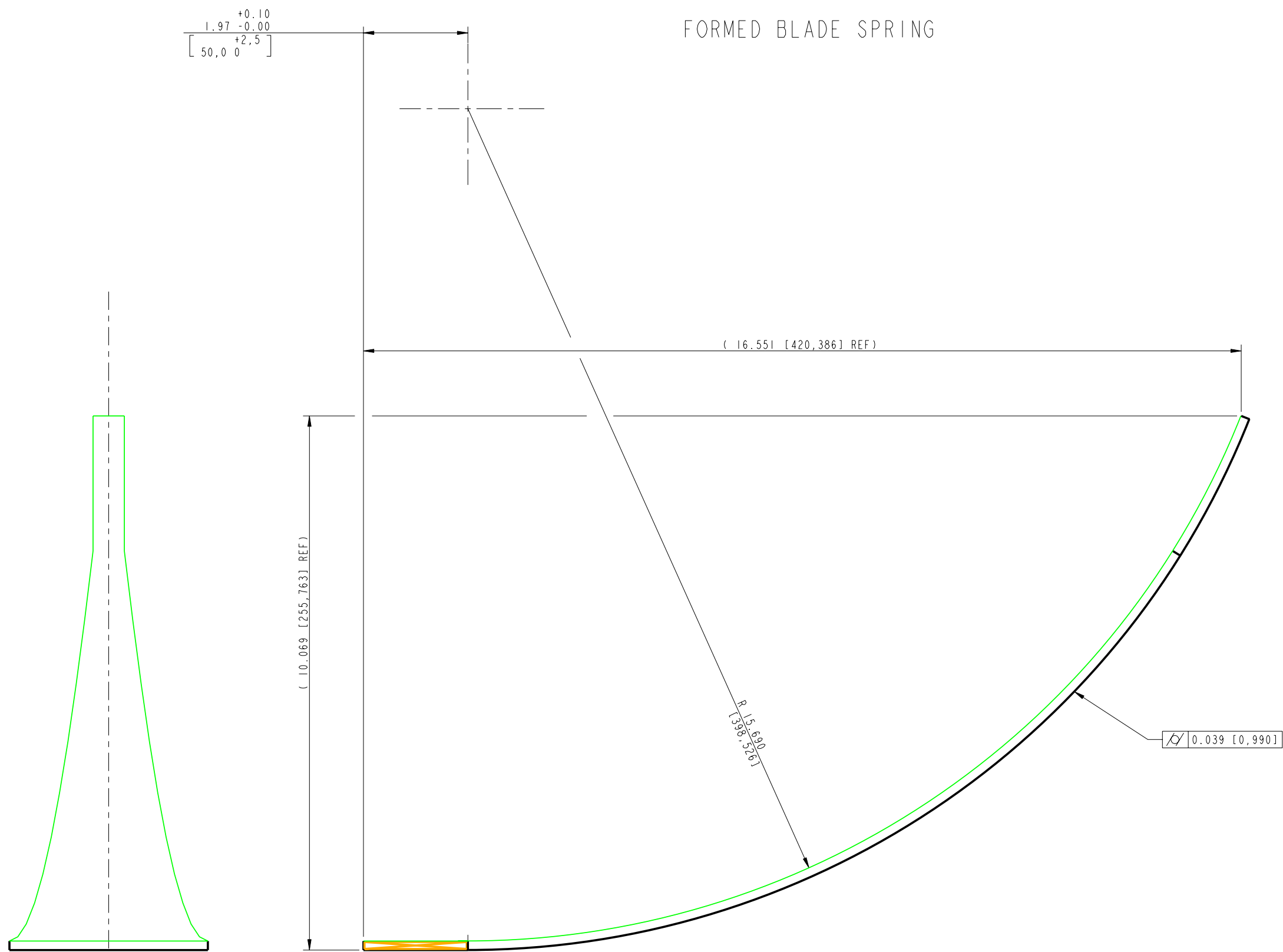
3.032 [77,013] = 2 X 1.516 [38,506]

1.634 [41,504]

NOTES: (UNLESS OTHERWISE SPECIFIED)		DIMENSIONS ARE IN INCHES (mm)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY UCR, GLAZIER UNIVERSITY IED GROUP RUTHERFORD APPLIED LABORATORIES	
1. REMOVE ALL SHARP EDGES. R.02 MIN.	2. DO NOT SCALE FROM DRAWING.	TOLERANCES:		SYSTEM <b>ADVANCED LIGO</b>	
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CYNTECH 410 (STAINLESS STEEL).	4. SCRIBE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .01" HIGH CHARACTERS. EXAMPLE: D020188-001. A VIBRATORY TOOL MAY BE USED.	F. INCHES: ±0.0015 G. MILLIMETERS: ±0.0254		SUB-SYSTEM <b>SUS</b>	
5. INTERPRET DIMENSIONS PER: ANSI Y14.5 1982	6. PRIOR TO DELIVERY HARDEN BY HEAT TREATMENT AT 435°C FOR 100 HOURS AND AIR COOL.	FINISH: CLEAN AND DEGREASE (60µm Ra) Ra = 32 (0.8)		NEXT ASSY <b>TOP STAGE</b>	
7. DURING HEAT TREATMENT THE PART MUST BE SUPPORTED SO THAT IT DOES NOT CHANGE RADII DUE TO SELF WEIGHT.		MATERIAL: WORKING STEEL 250		PART NAME <b>TOP STAGE BLADES</b>	
		APPROVED: _____		CONTROLS PROTOTYPE	
		SCALE 1:1 PROJECTION:		Dwg. NO. <b>D040298</b>	
				SHEET 1 OF 2	

INTRALINK NAME: TD-1039-201-1  
 FOR INTERNAL USE ONLY:  
 E=186Gpa  
 ALPHA=1.35  
 TOTAL SUSP MASS = 61 KG  
 P MASS = 11 KG  
 PREDICTED:  
 F = 2.33Hz  
 1st INTERNAL MODE = 70.26Hz  
 σ MAX = 981Mpa  
 REF: COMMUNICATION WITH BLADE COMMITTEE

# FORMED BLADE SPRING



NOTES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY UPR, GLASGOW UNIVERSITY IED GROUP RUTHERFORD APPLETON LABORATORIES	
1. REMOVE ALL SHARP EDGES. R. 02 MIN.	2. DO NOT SCALE FROM DRAWING.	DIMENSIONS ARE IN INCHES (mm)	SYSTEM <b>ADVANCED LIGO</b>
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CINTEC 410 (STAINLESS STEEL).	4. SCRIBE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE 01* HIGH CHARACTERS. EXAMPLE: D020188-001. A VIBRATORY TOOL MAY BE USED.	TOLERANCES: 1.XX ±0.01 (0.254 mm) 2.XX ±0.005 ANNULAR ±0.250°	SUB-SYSTEM <b>SUS</b>
5. INTERPRET DIMENSIONS PER: ANSI Y14.5 1982	6. PRIOR TO DELIVERY HARDEN BY HEAT TREATMENT AT 435°C FOR 100 HOURS AND AIR COOL	FINISH: CLEAN AND DEGREASE WASH (mm) Ra = 32 (12.9)	NEXT ASST <b>TOP STAGE</b>
7. DURING HEAT TREATMENT THE PART MUST BE SUPPORTED SO THAT IT DOES NOT CHANGE RADIUS DUE TO SELF WEIGHT			PART NAME <b>TOP STAGE BLADES</b> <b>CONTROLS PROTOTYPE</b>
		DRWN: I WILLIOT 01/07/04 CHKD: ... APPROVED: ...	DATE: ... BY: ... Dwg. NO. <b>D040298</b> SCALE: 1:1 PROJECTION:  SHEET 2 OF 2