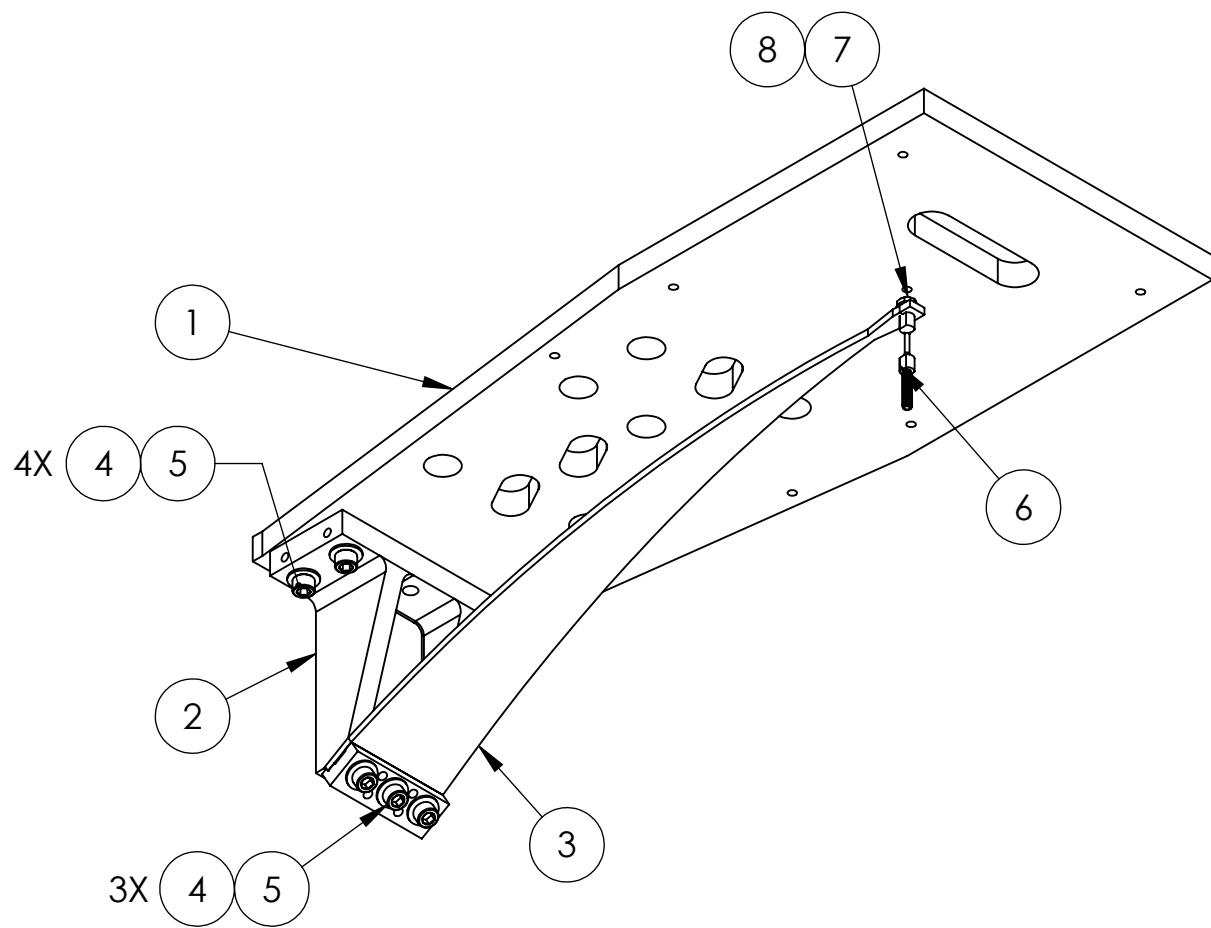
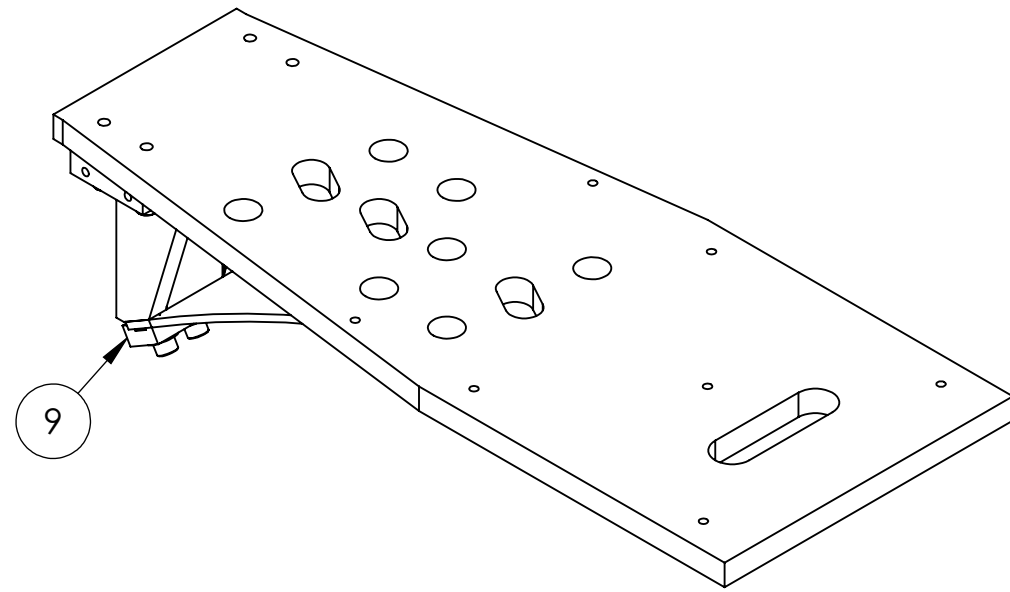


D1101886_aLIGO AOS ITM ELLIPTICAL BAFFLE BLADE ASSY, BSC4 H2, PART PDM REV: X-025, DRAWING PDM REV: X-019

NOTES CONTINUED:
 5. APPROXIMATE WEIGHT = 38.743 LB.

REV.	DATE	DCN #	BOM #
v1	03 OCT 2011	E1101007	E1101045
-	-	-	-
-	-	-	-



ISO BOTTOM
FOR CLARITY

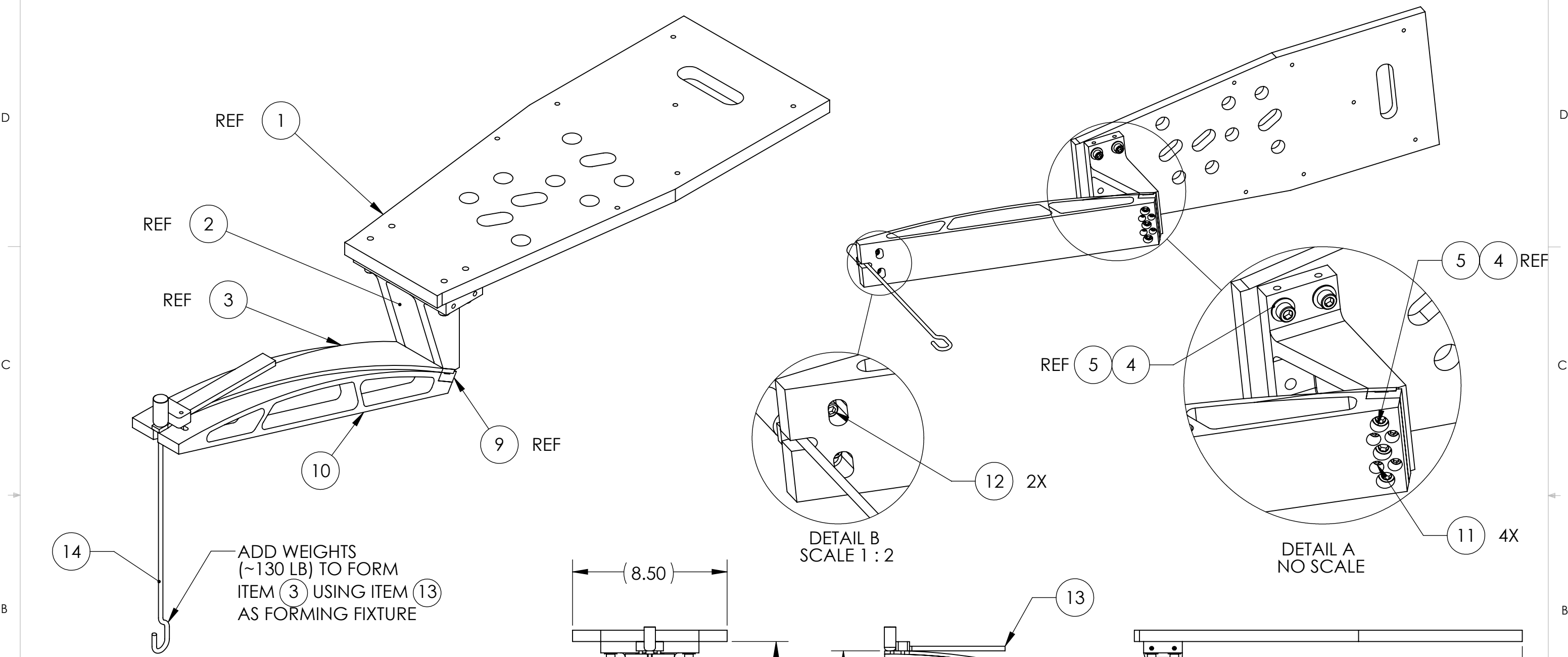
9	D1002844	SLC ACB BLADE CLAMP	304 SSTL	1
8	98019A330	WASHER #10, NASM 15795-808	300 SSTL	1
7	N-1024-A	UC-COMP, HEX NUT, #10-24, SSTL	Ag-PLATED 300 SSTL	1
6	D1002340	SLC ACB SUSPENSION ROD	316 SSTL	1
5	C-1820-NA	U-C COMP. 5/16-18 X 1.25L, S.H.C.S.	Ag-PLATED 300 SSTL	7
4	98019A385	.312 FLAT WASHER, .34 ID X .69 OD X .06 T, NASM 15795-812	300 SSTL	7
3	D1002753	ITM Elliptical Blade	MARAGING STEEL C250	1
2	D1002609	SLC BLADE MOUNTING BRACKET	304 SSTL	1
1	D1102192	aLIGO AOS ITM BAFFLE INTERFACE MOUNTING PLATE, BSC4 H2	304 SSTL	1
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY

PARTS LIST

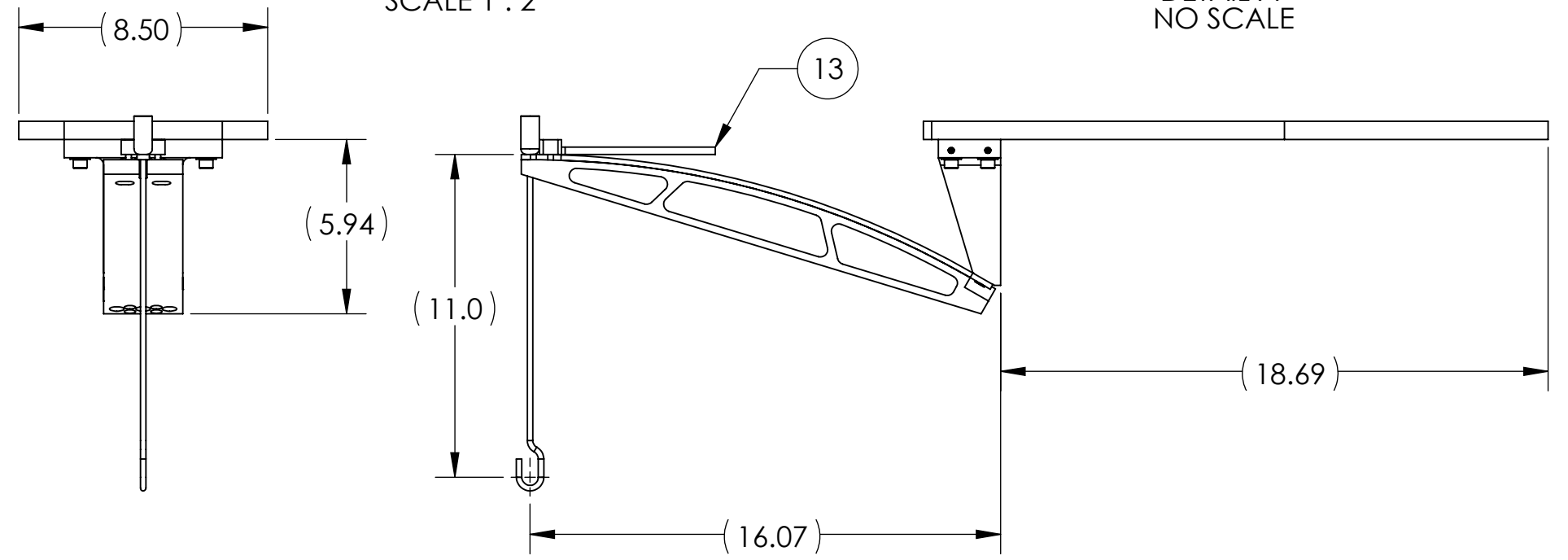
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)
 DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ± .02
 .XXX ± .005
 ANGULAR ± 1.0°
 1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES
 APPROXIMATELY R.02 FOR SHEET METAL PARTS.
 3. DO NOT SCALE FROM DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF
 SULFUR, SILICONE, AND CHLORINE.

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		aLIGO AOS ITM ELLIPTICAL BAFFLE BLADE ASSY, BSC4 H2	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	AOS	DESIGNER	31 JAN 2012
NEXT ASSY	D1101885	CHECKER	J. TERRAZAS	DRAWN	03 OCT 2011
MATERIAL			FINISH		REV.
N/A			N/A μinch		v1
SCALE: 1:4				PROJECTION:	
SHEET 1 OF 3				DWG. NO. B D1101886	

D1101886_qLIGO_AOS_ITM_ELLIPTICAL_BAFFLEBLADE_ASSY_BSC4_H2_PART_PDM_REV_X-025_DRAWING_PDM_REV_X-019



ADD WEIGHTS (~130 LB) TO FORM ITEM (3) USING ITEM (13) AS FORMING FIXTURE



ITEM NO.	PART NUMBER	DESCRIPTION	QTY
14	D1101298	BLADE SPRING BENDING HOOK ASSY	1
13	D1101184	αLIGO ACB BEND FIXTURE PLATE	1
12	92200A246	SOCKET HEAD CAP SCREW, 10-24 X .875 LG, NAS 1352C-3-14 (OR EQUIV)	2
11	C-2014-A	SCREW, SOCKET HEAD CAP, #10-24 UNC-2A X 0.375 LONG, FULLY THREADED	4
10	D1101099	αLIGO ACB BEND FIXTURE	1

PARTS LIST

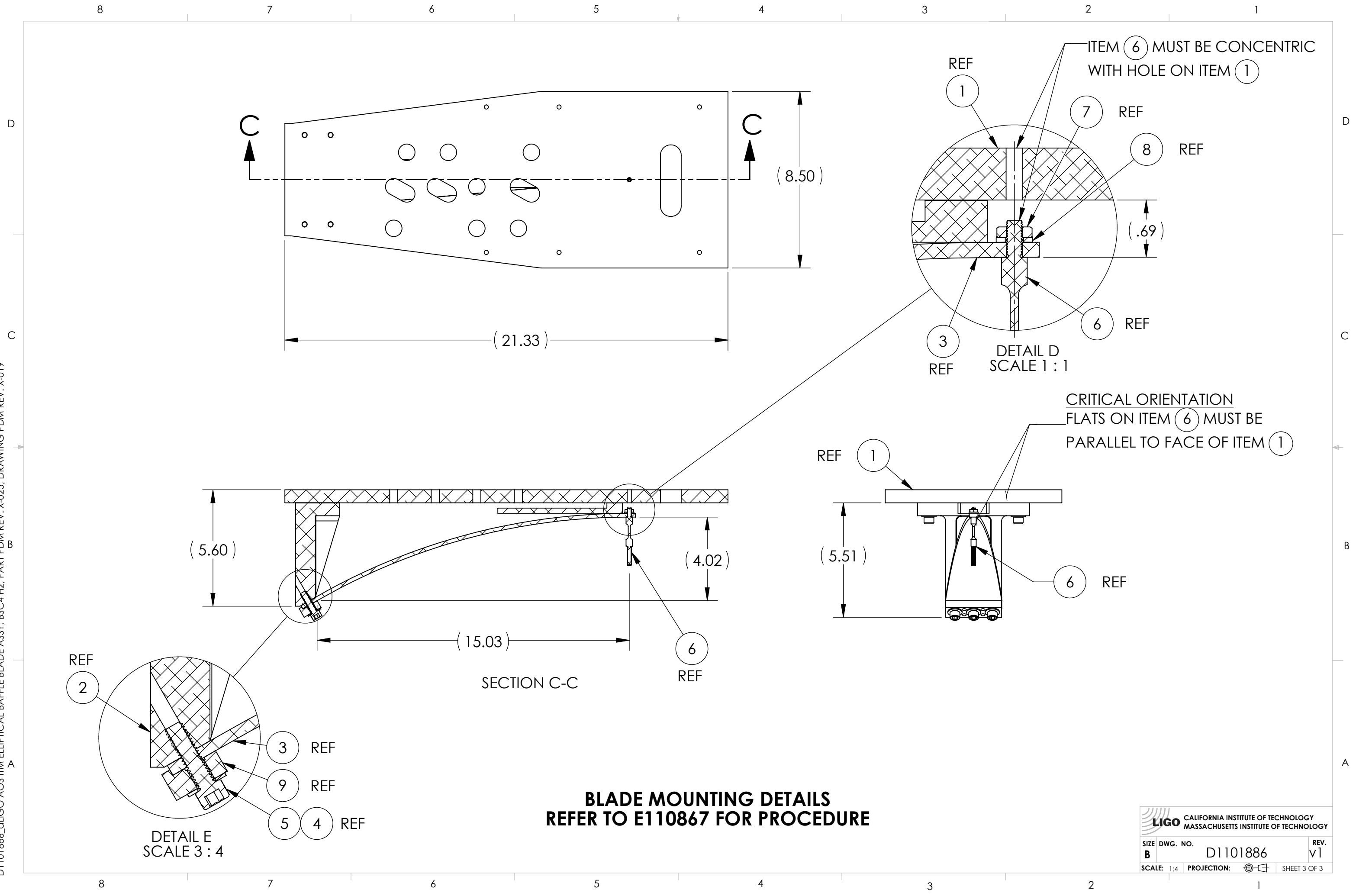
TOOLING PARTS LIST (CONT FROM SHT 1)

**BLADE FORMING DETAILS
REFER TO E110867 FOR PROCEDURE**

**CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY**

SIZE DWG. NO.	D1101886	REV.	v1
SCALE: 1:4	PROJECTION:	SHEET 2 OF 3	

D1101886_qLIGO AOS ITM ELLIPTICAL BAFFLE BLADE ASSY, BSC4 H2, PART PDM REV: X-025, DRAWING PDM REV: X-019



BLADE MOUNTING DETAILS
REFER TO E110867 FOR PROCEDURE

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
SIZE	DWG. NO.	REV.
B	D1101886	v1
SCALE: 1:4	PROJECTION:	SHEET 3 OF 3