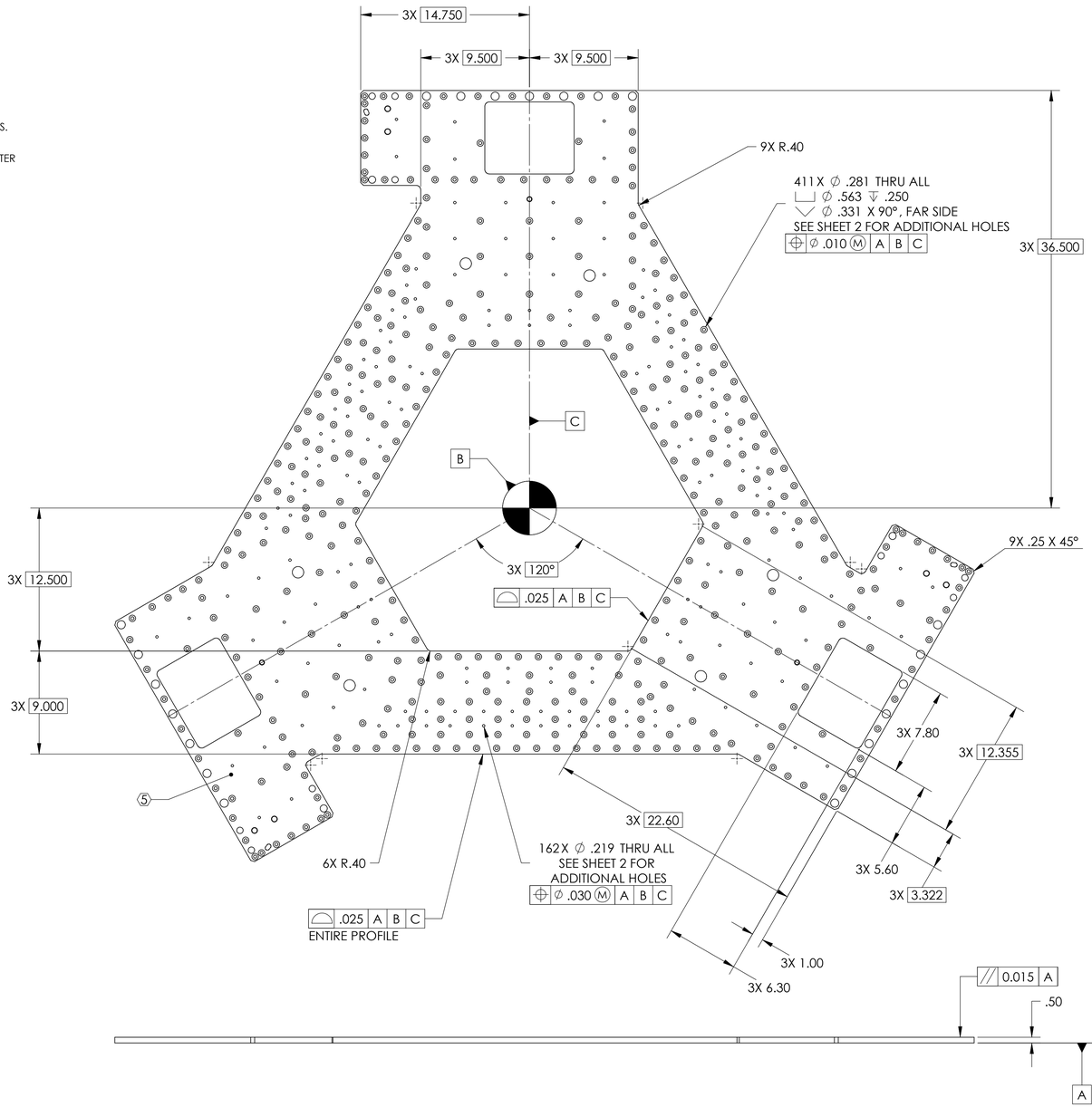
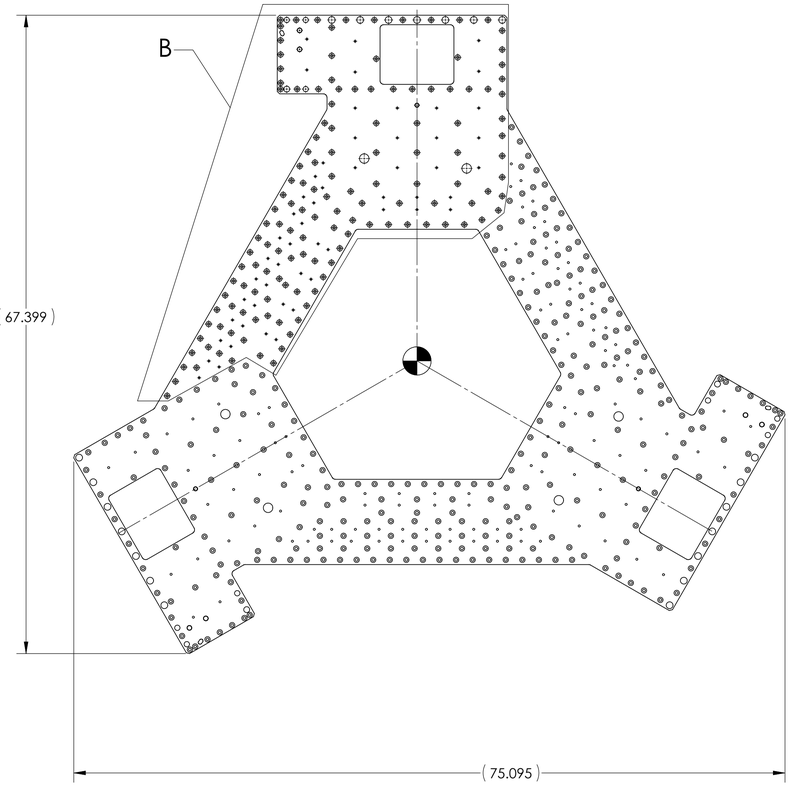
NOTES CONTINUED:

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: DXXXXXXX-VY, S/N 001. A
6. VIBRATORY TOOL MAY BE USED.
6. THIS PART IS TO BE PRODUCED USING THE CAD MODEL. IF THERE ARE DISCREPANCIES BETWEEN THIS DRAWING AND THE CAD MODEL, THE MODEL WILL TAKE PRECEDENCE.
7. SURFACES WITH PROFILE CONTROL ARE LOCATED BASIC WITH RESPECT TO REFERENCED DATUMS. A SURFACE PROFILE TOLERANCE OF .025 SHALL APPLY TO THE ENTIRE PART UNLESS SPECIFICALLY TOLERANCED ELSEWHERE ON THE DRAWING.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E048225.
9. APPROXIMATE WEIGHT = 88LB.
10. A TRUE POSITION TOLERANCE OF ∅.010 IS ~ THE SAME AS A CONVENTIONAL TOLERANCE OF ±.005.
11. MULTIPLE SHEET DRAWING; SHEETS MAY HAVE DIFFERENT SCALES.
12. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.
13. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONEL, AFTER DELIVERY OF FINISHED PARTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	25 Jan 2010	E0900487	T0900600



VIEW SHOWN INDICES THE BASE HOLE PATTERN ARRAYED 3X
SEE DETAIL B SHEET 2



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)			
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± .5°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. BREAK ALL EDGES AND SHARP 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.	MATERIAL: 6061-T6 Al FINISH: 63 µinch	NEXT ASSY: D0901180

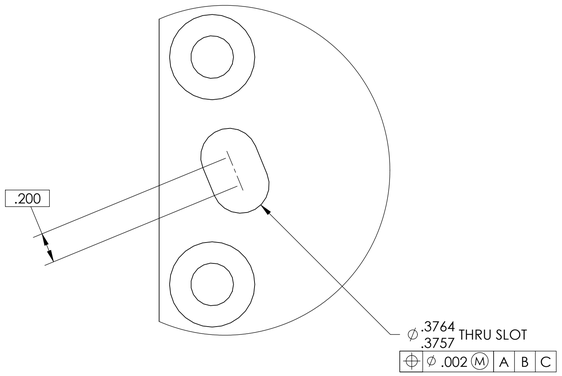
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO | SUB-SYSTEM: SEI

PART NAME: BSC-ISI, Stage 1, Close Out Plate Cover

DESIGNER	F.Matichard	17 Dec. 2009	SIZE: D	DWG. NO.: D0902503	REV.: v1
DRAFTER	M.Hillard	25 Jan 2010			
CHECKER	A.Stein	25 Jan 2010			
APPROVAL	K.Mason	25 Jan 2010	SCALE: 1:6	PROJECTION:	SHEET 1 OF 2

D0902503 BSC-ISI, Stage 1, Close out plate cover, PART PDM REV= X-022, DRAWING PDM REV= X-008



DETAIL D
SCALE 2 : 1

VIEW B
VIEW SHOWN INDICES THE BASE
HOLE PATTERN ARRAYED 3X

TAG	SIZE	QUANTITY	GD&T
A	∅ .63 THRU ALL	1	⌖ ∅ .030 Ⓜ A B C
B	∅ .56 THRU ALL	3	⌖ ∅ .030 Ⓜ A B C
C	∅ .40 THRU ALL ⌵ ∅ .52 X 120°, NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA.	2	⌖ ∅ .010 Ⓜ A B C
D	∅ .72 THRU ALL	7	⌖ ∅ .030 Ⓜ A B C
E	∅ 1.00 THRU ALL	2	⌖ ∅ .030 Ⓜ A B C
F	∅ .31 THRU ALL 3/8-16 UNC - 2B THRU ALL ⌵ ∅ .45 X 120°, NEAR SIDE	1	⌖ ∅ .010 Ⓜ A B C

HOLE PATTERN TYP QTY 3X

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
D	D0902503	V1

SCALE: 1:8 | PROJECTION: | SHEET 2 OF 2