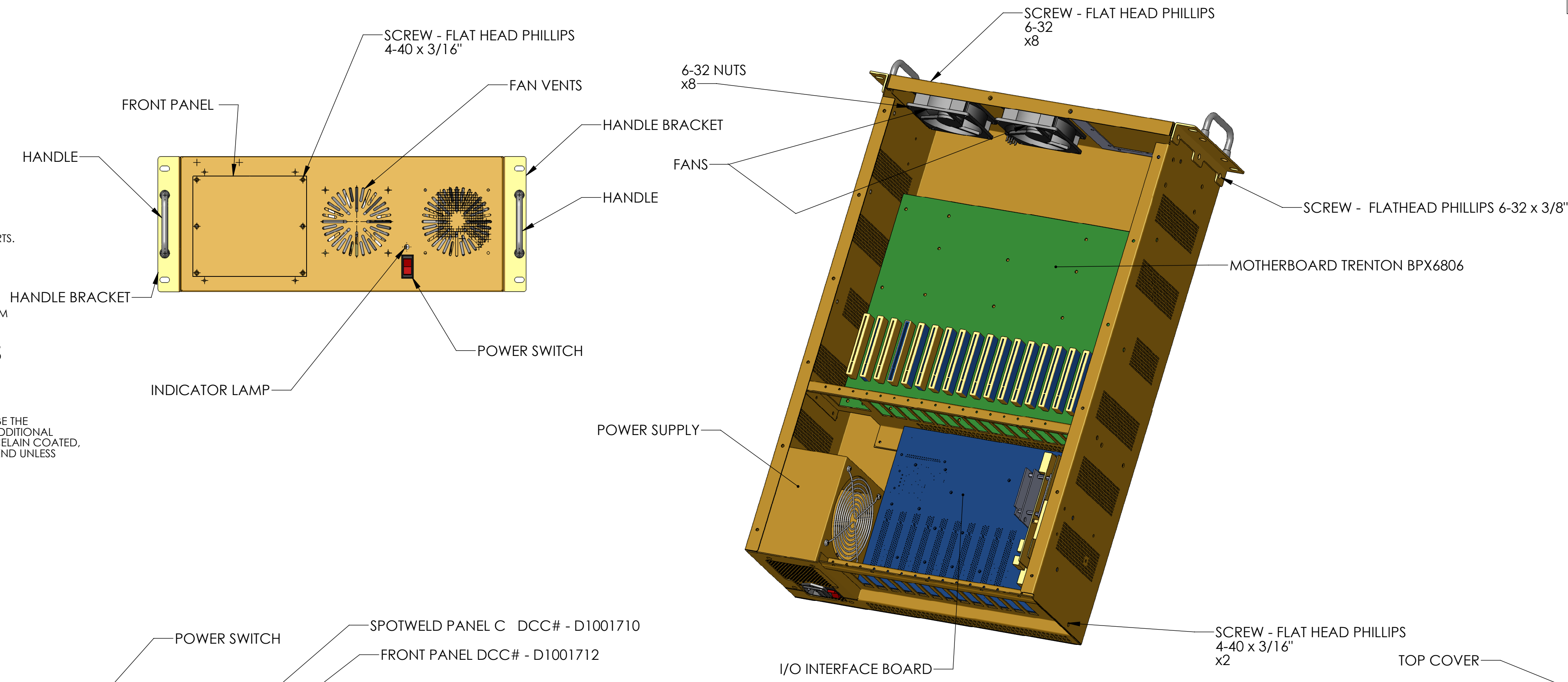
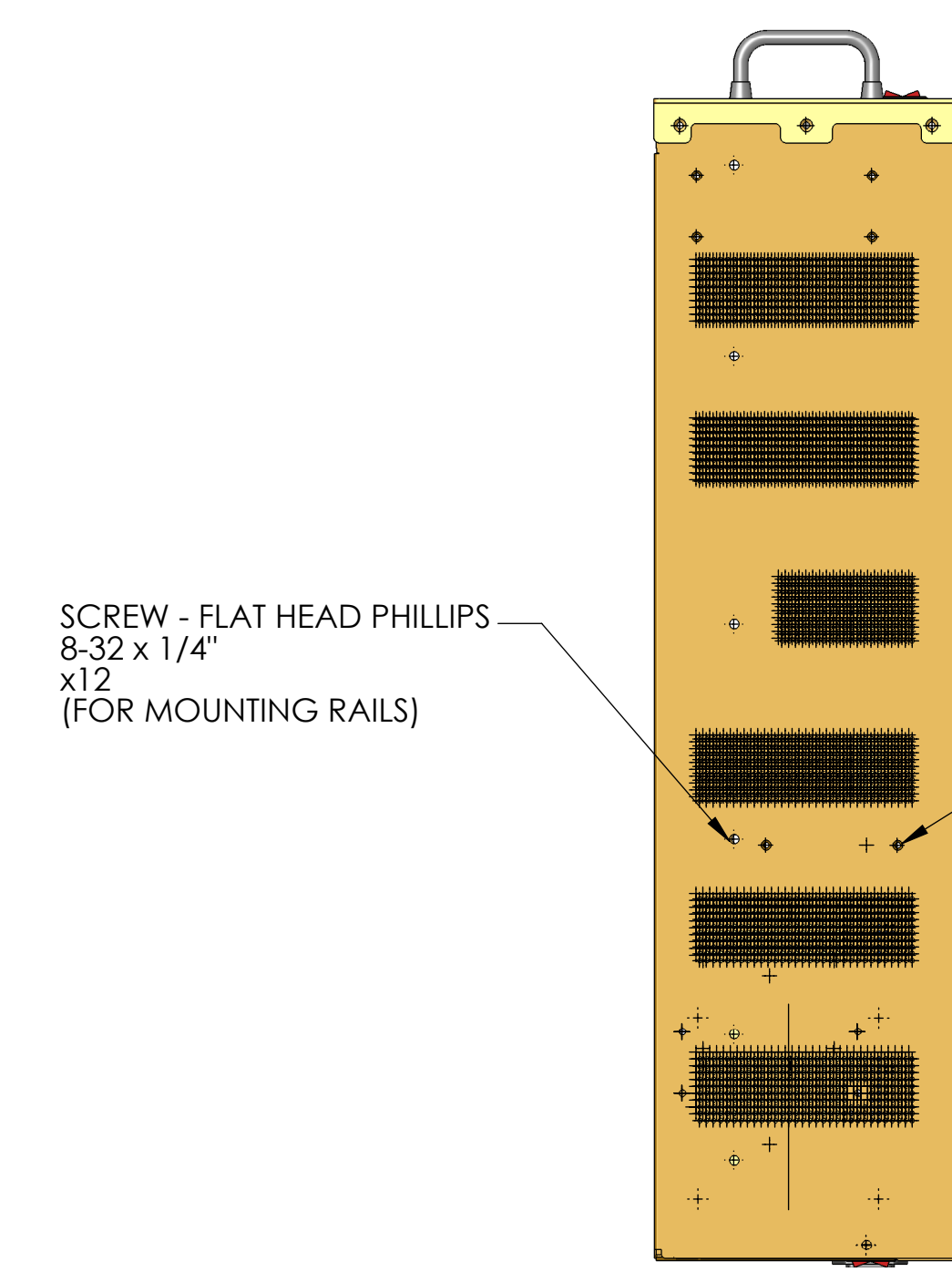
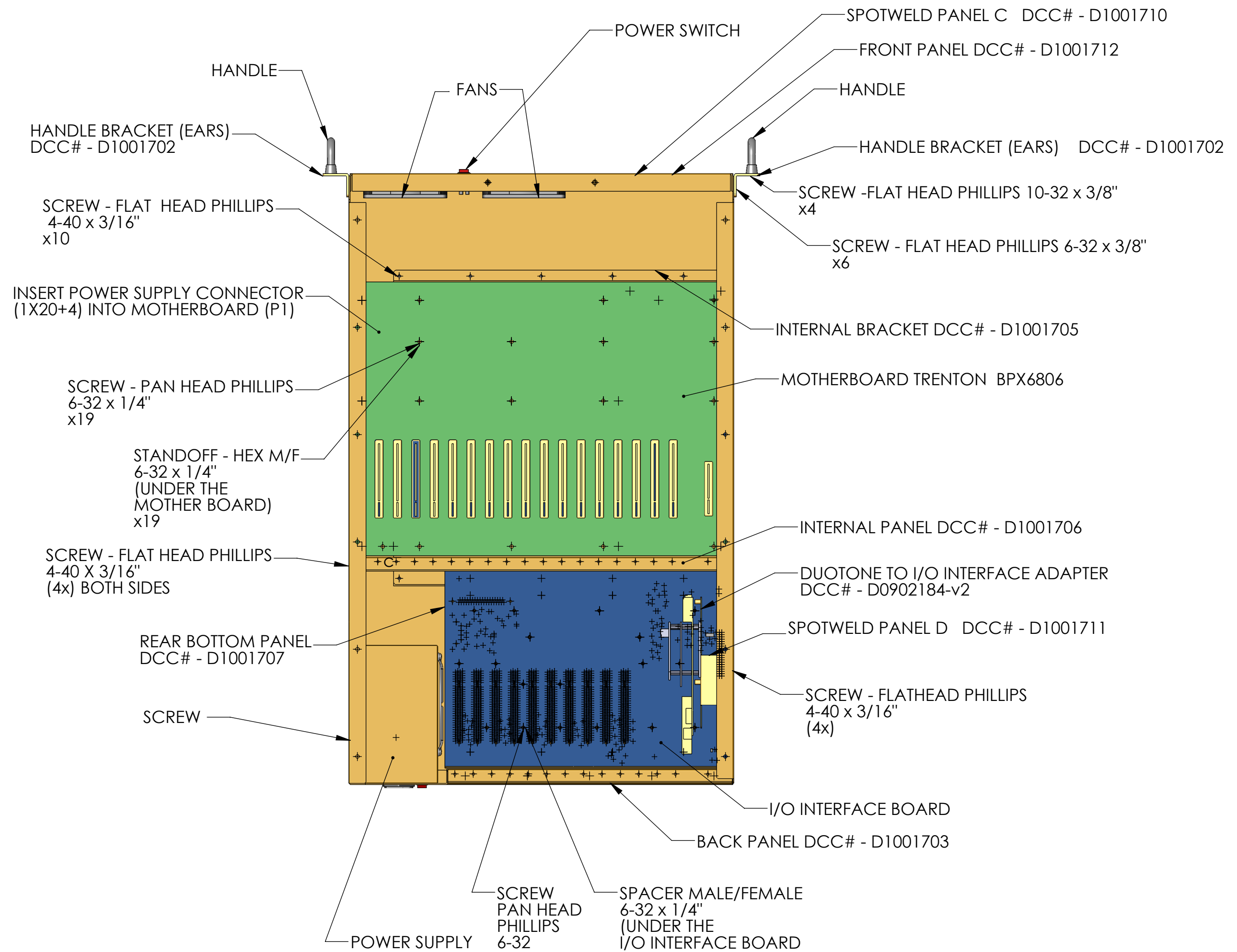
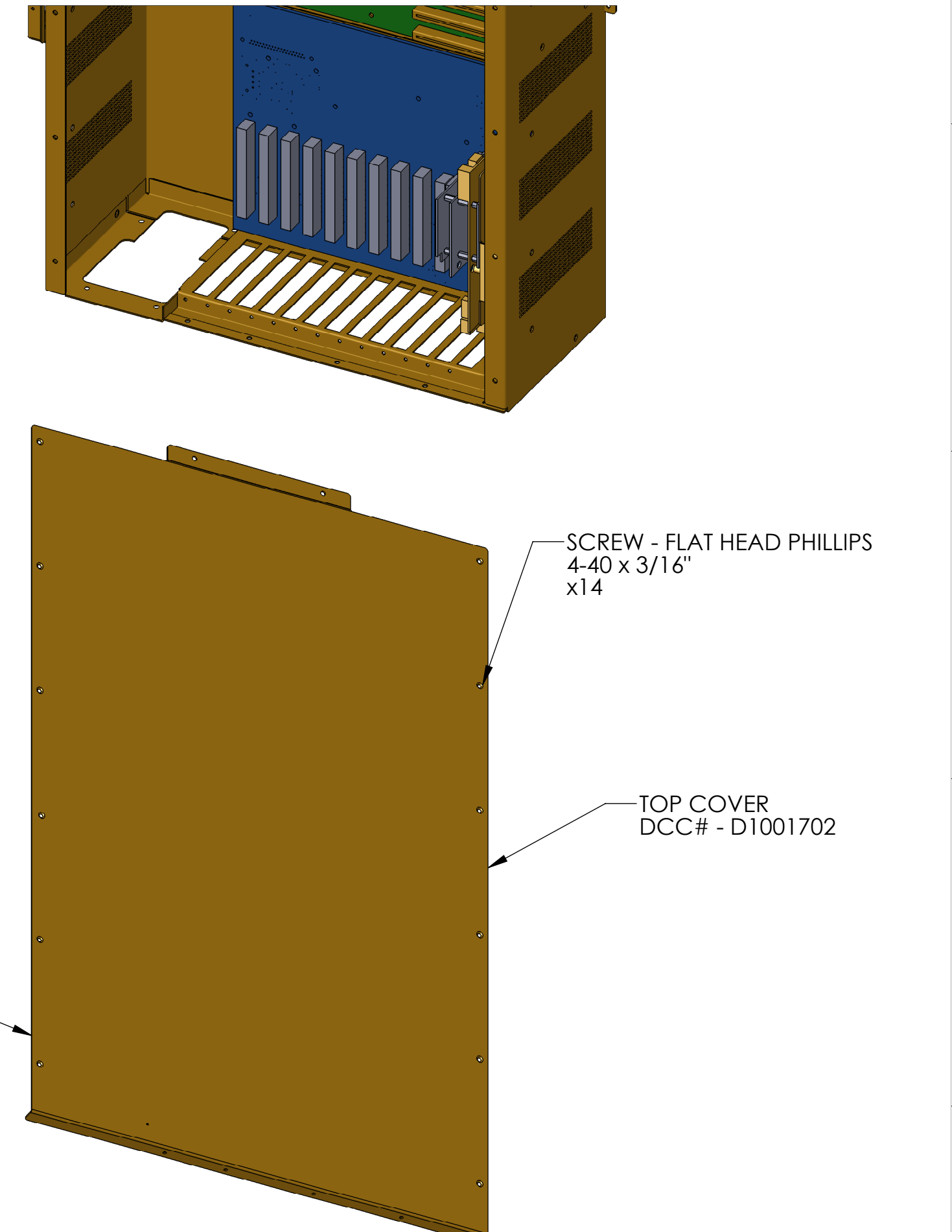


NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXX-VY, S/N 001. VIBRATORY TOOL MAY BE USED.

- 6. APPROXIMATE WEIGHT = X.XXX LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
- 10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.
- 11. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
- 12. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
- 13. PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION. THE INDICATED HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING TO APPROXIMATELY 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF THE HOLE.
- 14. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.
- 15. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.



REV.	DATE	DCN #	DRAWING TREE #
-	-	-	-
-	-	-	-
-	-	-	-



Item	DESCRIPTION / DCC #	Vendor	Qty	Part #	Area
I/O CHASSIS PARTS					
4U CHASSIS	D07055A component parts	Hamilton Metalcraft	1		
16975 CHASSIS BASE	D1001701	Hamilton Metalcraft	1		
16975 bracket	D1001702	Hamilton Metalcraft	2		
16975 rear back panel	D1001703	Hamilton Metalcraft	1		
16975 i_o bracket	D1001704	Hamilton Metalcraft	1		
16975 internal bracket	D1001705	Hamilton Metalcraft	1		
16975 internal panel	D1001706	Hamilton Metalcraft	1		
16975 rear bottom panel	D1001707	Hamilton Metalcraft	1		
16975 spotweldpanel C	D1001710	Hamilton Metalcraft	1		
16975 spotweldpanel D	D1001711	Hamilton Metalcraft	1		
16975 front panel	D1001712	Hamilton Metalcraft	1		
16975 top cover	D1001714	Hamilton Metalcraft	1		
Rails	SuperMicro	Servers Direct LLC	1	RK4003	
Handles		Mouser	2	534-7145	
Ferrules		Mouser	4	534-7164	
Screws	FLAT HEAD PHILLIPS 4-40 x 3/16"	McMaster-Carr	32	91771A111	Lid, ect.
Screws	FLAT HEAD PHILLIPS 10-32 x 3/8"	McMaster-Carr	4	91771A827	Handles, Ferrules
Screws	TRUSS HEAD PHILLIPS 10-32 x 3/8"	McMaster-Carr	2	91770A827	Rear Panel
Screws	FLAT HEAD PHILLIPS 6-32 x 3/8"	McMaster-Carr	6	91500A146	Ears
Nuts	w/ Tooth washer 6-32	McMaster-Carr	8	90675A007	Fans
Nuts	w/ Tooth washer 4-40	McMaster-Carr	8	90675A005	Partition
Male/Female Standoffs	6/32 x 1/2"	Digi-Key	10	8717K-ND	for Boards
Fans		Digi-Key	2	603-1067-ND	
Switch		Digi-Key	1	CKN2061-ND	Front Panel
Power Supply ATX 300W		Power Stream	1	PSTC-24300	
Motherboard		TRENTON TECHNOLOGY	1	BPX6806-EPS REV-C-01 (ROHS)	
I/O interface board			1		
Lamp	5v Green	Digi-Key	1	L10025-ND	Front Panel
Timing Board		Columbia University	1		

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN TOLERANCES: .XX ± .XXX ± ANGULAR ± °

MATERIAL: Material <not specified> FINISH: μinch

SYSTEM: LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME: I/O EXPANSION CHASSIS - TOP ASSEMBLY

DESIGNER: E.BROWN CHECKER: SEP/27/2011

SIZE: D DWG. NO. D1001715

REV. v2

SCALE: 1:4 PROJECTION: SHEET 1 OF 1

D1001715_03_SWD_LO chassis 16975 assembly v3 PART PDM REV: DRAWING PDM REV: