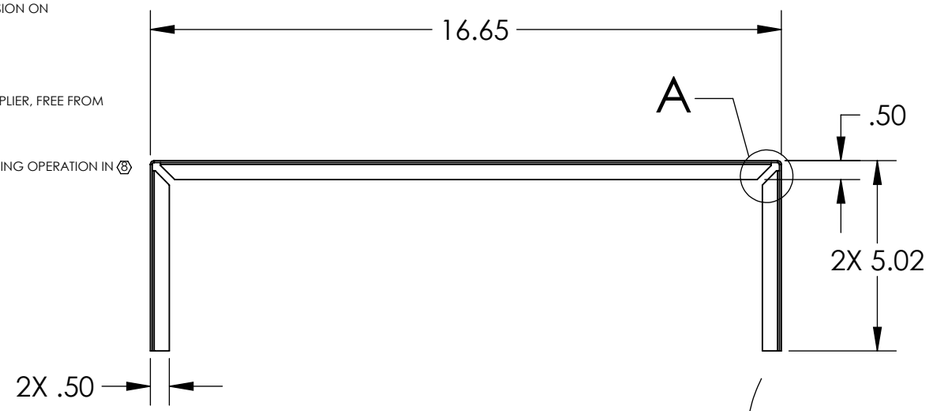
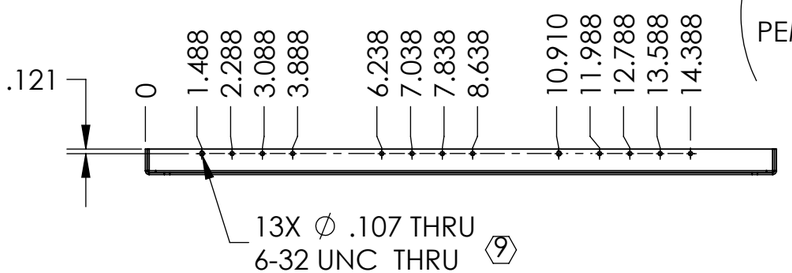
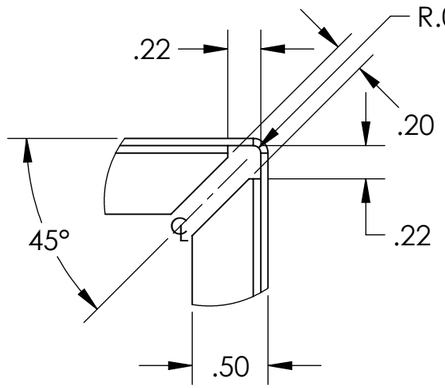
**NOTES CONTINUED:**

5. SILKSCREEN (COLOR: WHITE) PART NUMBER AND VERSION ON INDICATED SURFACE.
   EXAMPLE: DXXXXXXX-VY
6. APPROXIMATE WEIGHT = .31 LB.
7. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
8. FINISH: PAINT BLACK
9. MASK ALL TAPPED HOLES AND INSERTS DURING FINISHING OPERATION IN 8

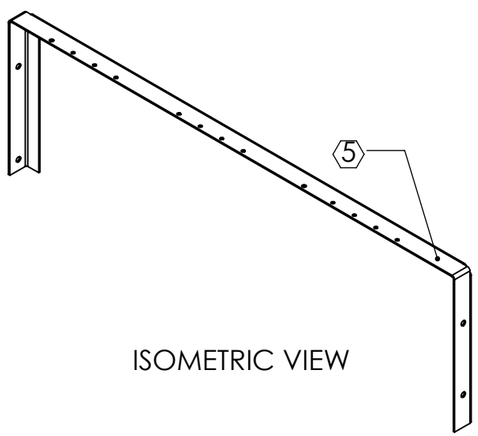
| REV. | DATE | DCN # | DRAWING TREE # |
|---|---|---|---|
| v1 | 27 JUL 2017 | E1700273-x0 | - |
| v4 | 30 OCT 2017 | E1700273-x0 | - |
| v5 | 30 OCT 2017 | E1700273-x0 | - |



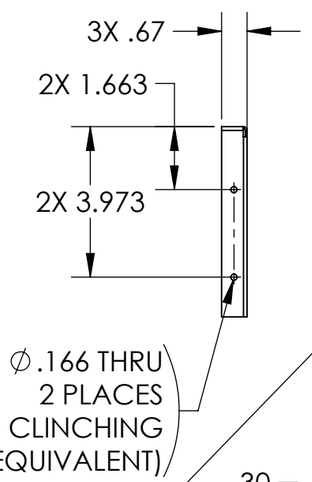



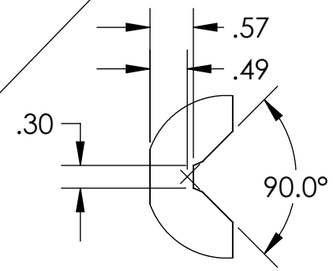




DETAIL A
SCALE 1 : 1
2 PLACES




ISOMETRIC VIEW

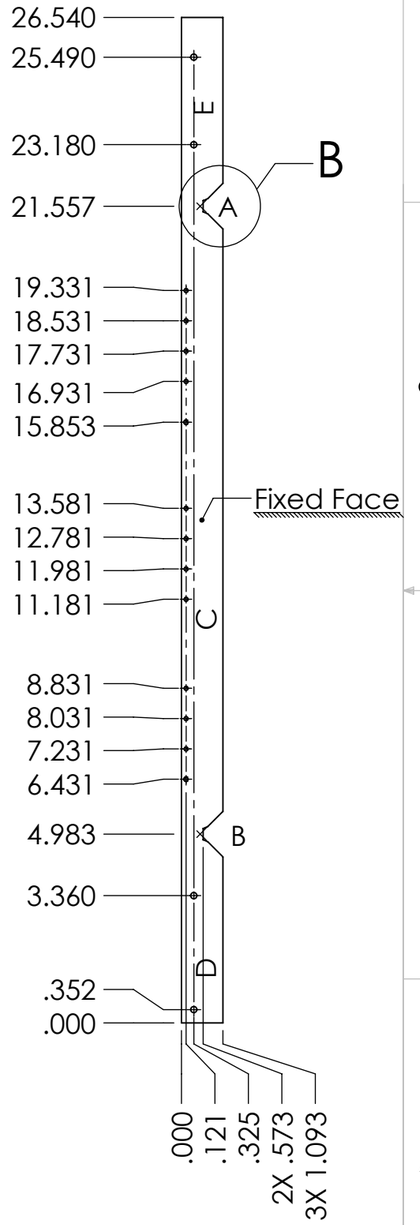



DETAIL B
SCALE 1 : 2
2 PLACES

FLAT PATTERN
ALL DIMENSIONS FOR REFERENCE ONLY

| Tag | Direction | Angle | Inner Radius |
|---|---|---|---|
| A | UP | 90° | 0.05 |
| B | UP | 90° | 0.05 |
| C | UP | 90° | 0.05 |
| D | UP | 90° | 0.05 |
| E | UP | 90° | 0.05 |




**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .05
.XXX ± .010

ANGULAR ± 1°

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.

MATERIAL: CRS, 18 GAGE
FINISH: 8 µinch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: aLIGO
SUB-SYSTEM: DAS
NEXT ASSY: D1001715

PART NAME: aLIGO, DAS, IO EXPANSION CHASSIS, MID BRACKET

| | | |
|---|---|---|
| DESIGNER | S APPERT | 27 JUL 2017 |
| DRAFTER | S APPERT | 14 AUG 2017 |
| CHECKER | SEE DCC | SEE DCC |
| APPROVAL | SEE DCC | SEE DCC |

SIZE: B | DWG. NO.: D1700343 | REV.: v5
SCALE: 1:4 | PROJECTION: | SHEET 1 OF 1

D1700343 aLIGO, DAS, IO EXPANSION CHASSIS, MID BRACKET, PART PDM REV: X-001, DRAWING PDM REV: X-001