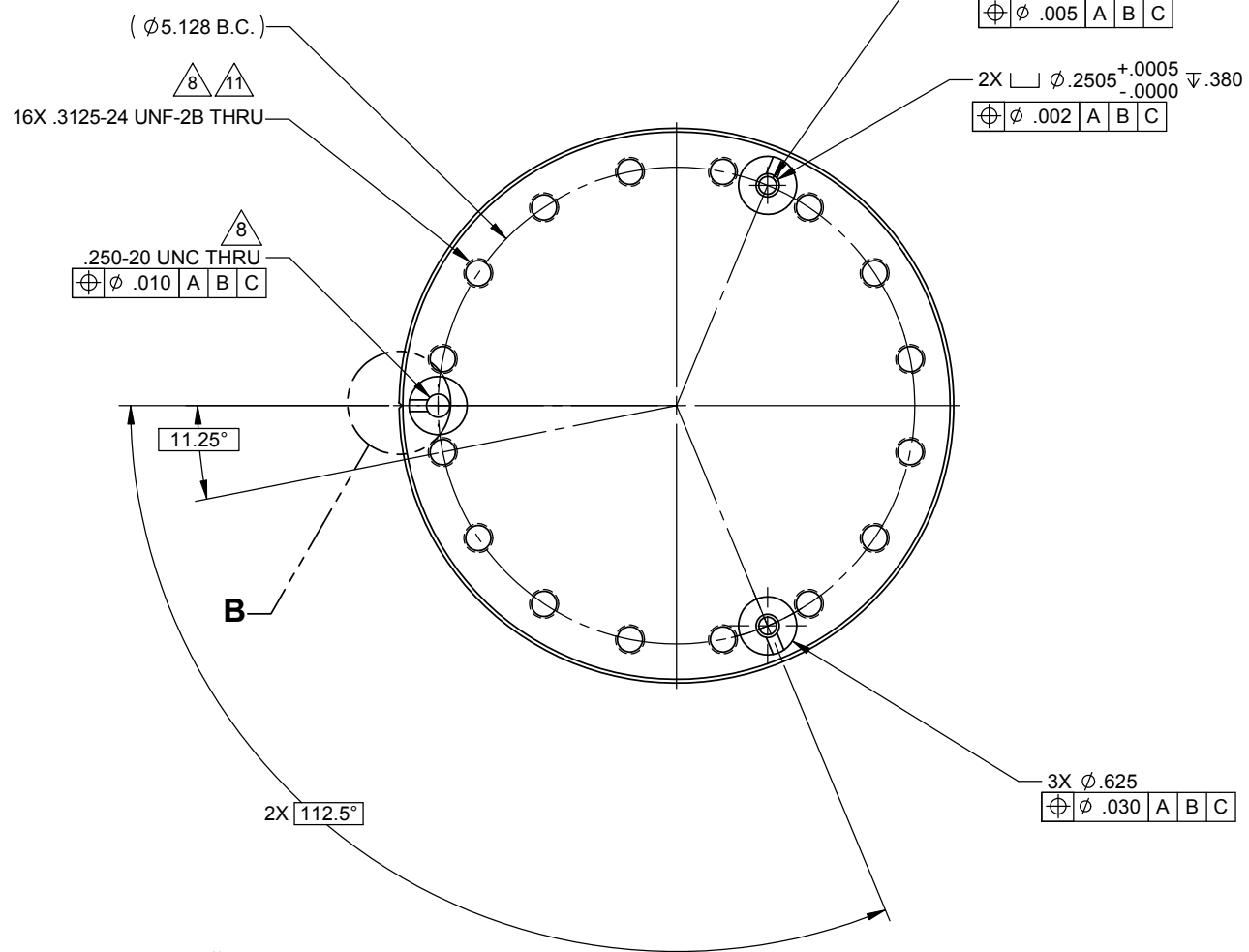
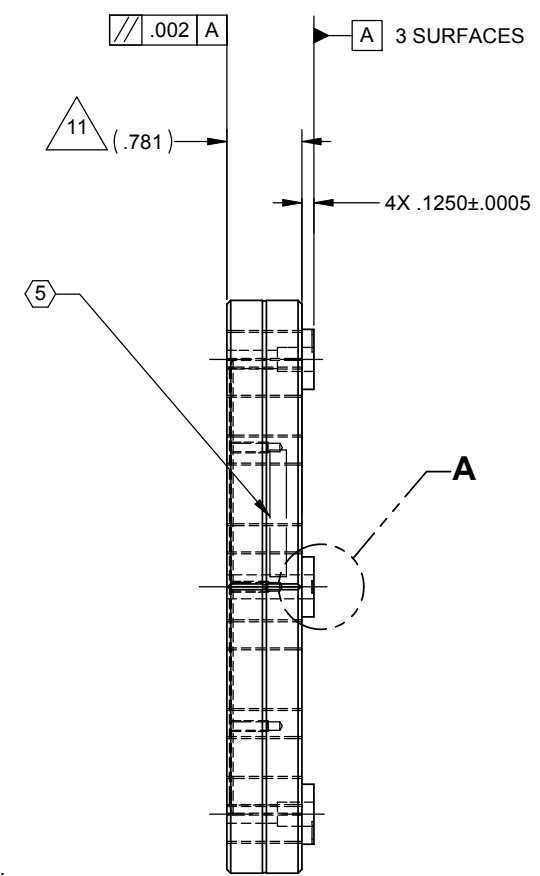
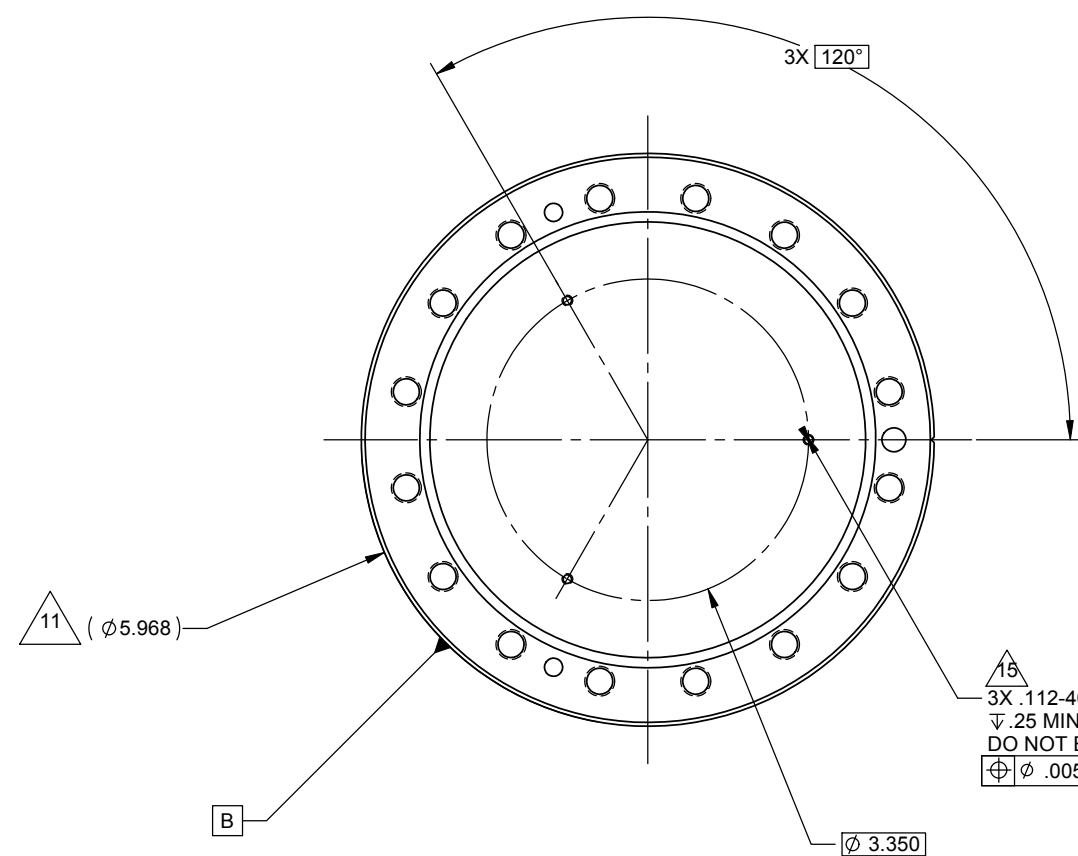
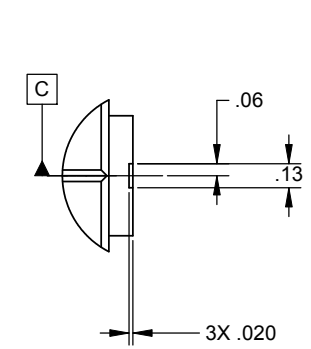


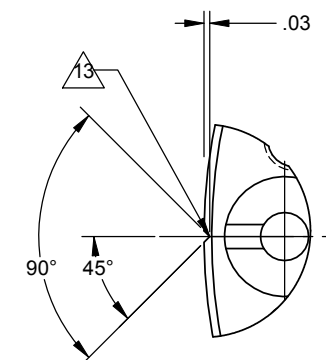
REV.	DATE	DCN #	DRAWING TREE #
V1	02 DEC 2004	-	-
V2	10 JUN 2009	-	-
V3	26 JAN 2010	E0900436	T0900600
V4	20 FEB 2010	E1000048	T0900600



- 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.
  - 6. ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.
  - 7. MACHINE FILET RADII .003-.015
  - 8. THREADED HOLES SHALL BE PRODUCED TO A .004-.006 OVERSIZE CONDITION ON THE PITCH DIAMETER BASED ON A 2B CONDITION. THIS DOES NOT APPLY TO THREADED INSERT HOLES.
  - 9. COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/-0.00.
  - 10. COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
  - 11. FEATURES THAT ARE REFERENCED OR UNDIMENSIONED SHALL CONFORM TO TO NOR-CAL PRODUCTS PART NUMBER 600-000NT (EXCEPT OVERALL THICKNESS).
  - 12. REFERENCE MATING PART DRAWING D047823.
  - 13. PHYSICAL CONFIGURATION OF VISUAL CLOCKING AID MAY VARY AT MANUFACTURERS OPTION BUT SHALL BE LOCATED AS SPECIFIED.
  - 14. ESTIMATED WEIGHT IS 5.8 LBS.
  - 15. NOTE 8 DOES NOT APPLY.
  - 16. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION LIGO DOCUMENT E0900364.
  - 17. EXTERIOR OF POD WILL BE EXPOSED TO UHV.



**DETAIL A**  
SCALE: 2 / 1  
3X



**DETAIL B**  
SCALE: 2 / 1  
13

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				CALIFORNIA INSTITUTE OF TECHNOLOGY LIGO MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.				<b>ADVANCED LIGO</b>		<b>Base Plate Flange, L4C Pod</b>	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± 0.5°				MATERIAL: <b>AISI 304</b> FINISH: <b>63 μinch</b>		DESIGNER: ASI 02 DEC 2004 DRAFTER: F.MATICHARD 20 FEB 2010 CHECKER: S.BARNUM 20 FEB 2010 APPROVAL: K.MASON 20 FEB 2010	
				NEXT ASSY: <b>D047820</b>		SIZE: <b>D</b> DWG. NO.: <b>D047822</b> REV.: <b>v4</b>	
				SCALE: 2:1 PROJECTION:		SHEET 1 OF 1	

D047822 Baseplate Flange, L4C Pod, d:\lco\rec\si\part\pdm\rev\ v3, drawing pdm rev\ v3\001  
 D047822 Baseplate Flange, L4C Pod, d:\lco\rec\si\part\pdm\rev\ v3, drawing pdm rev\ v3\001