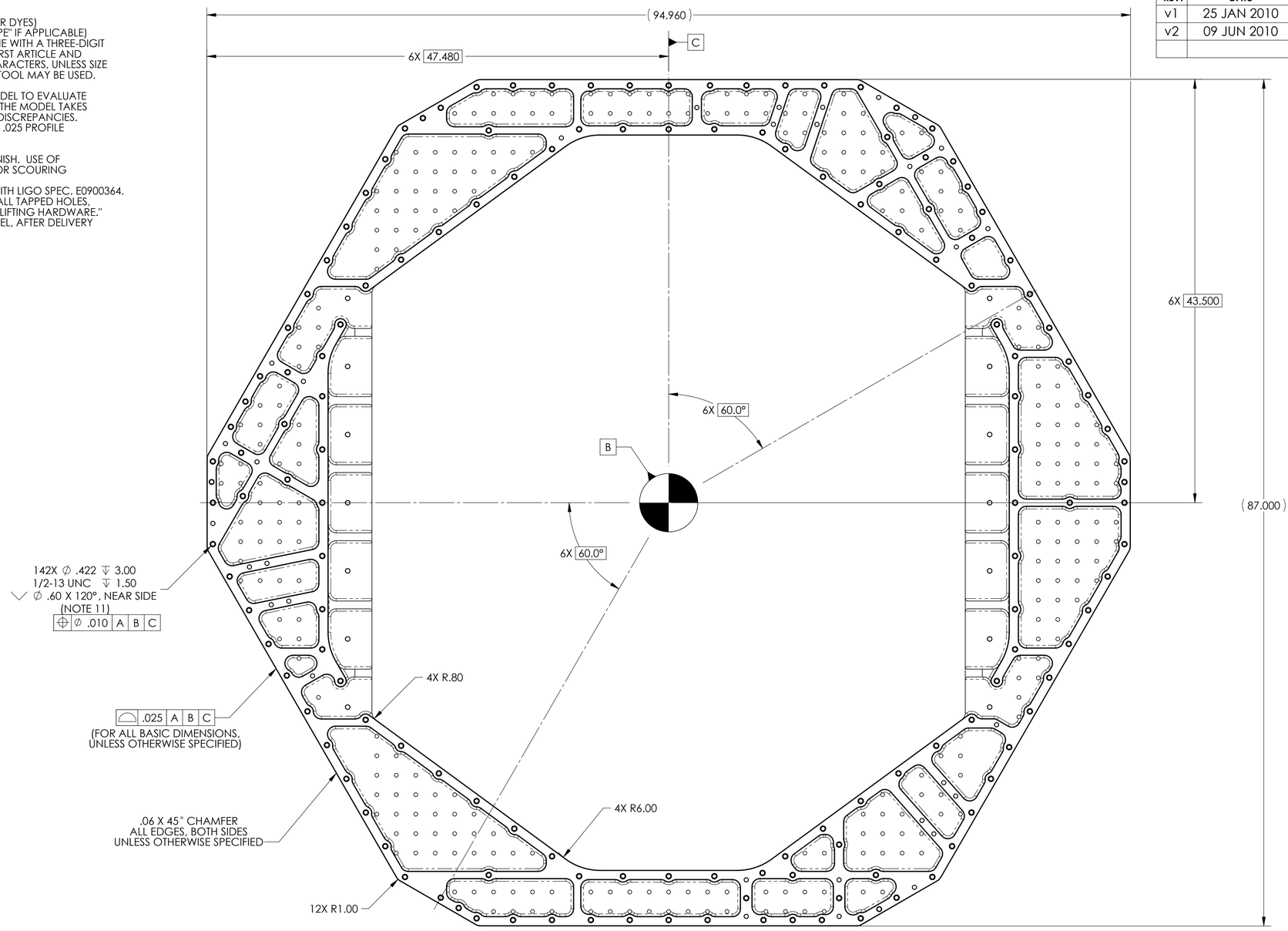
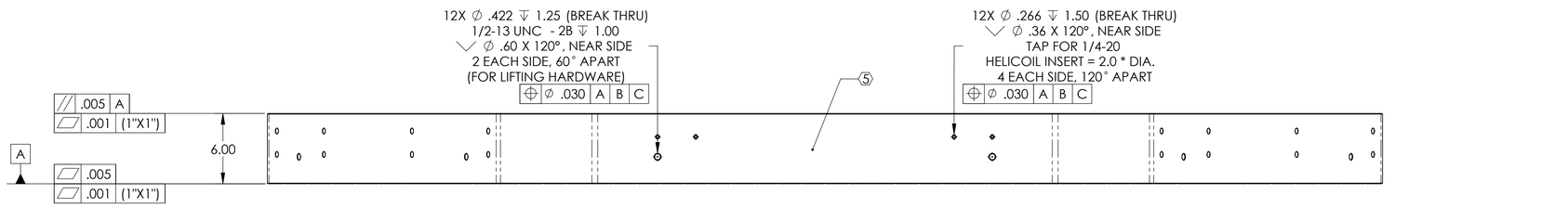
NOTES CONTINUED:

⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE-DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.25" HIGH CHARACTERS, UNLESS SIZE OF PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXXX-VY, TYPE-XX, S/N XXX.

6. THIS DRAWING IS MINIMALLY DIMENSIONED. USE CAD MODEL TO EVALUATE FULL DIMENSIONAL DETAIL. UNLESS OTHERWISE SPECIFIED, THE MODEL TAKES PRECEDENCE OVER THE DRAWING WHEREVER THERE ARE DISCREPANCIES.
7. UNLESS OTHERWISE SPECIFIED, ALL SURFACES MUST SATISFY .025 PROFILE TOLERANCE WITH RESPECT TO DATUMS A, B, AND C.
8. APPROXIMATE WEIGHT = 636 LB.
9. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES (INCLUDING SANDING OR SCOURING FOR MATTE FINISH) IS NOT ALLOWED.
10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPEC. E0900364.
11. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES TO ALL TAPPED HOLES, EXCLUDING THREADED INSERTS AND HOLES LABELED "FOR LIFTING HARDWARE."
12. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS. USE ONLY NITRONIC 60 INSERTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	25 JAN 2010	E1000013	E1000025
v2	09 JUN 2010	E1000207	E1000025





NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± 0.5°	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.				
	MATERIAL: 6061-T6 Al	FINISH: 63 µinch	NEXT ASSY: D0900896		

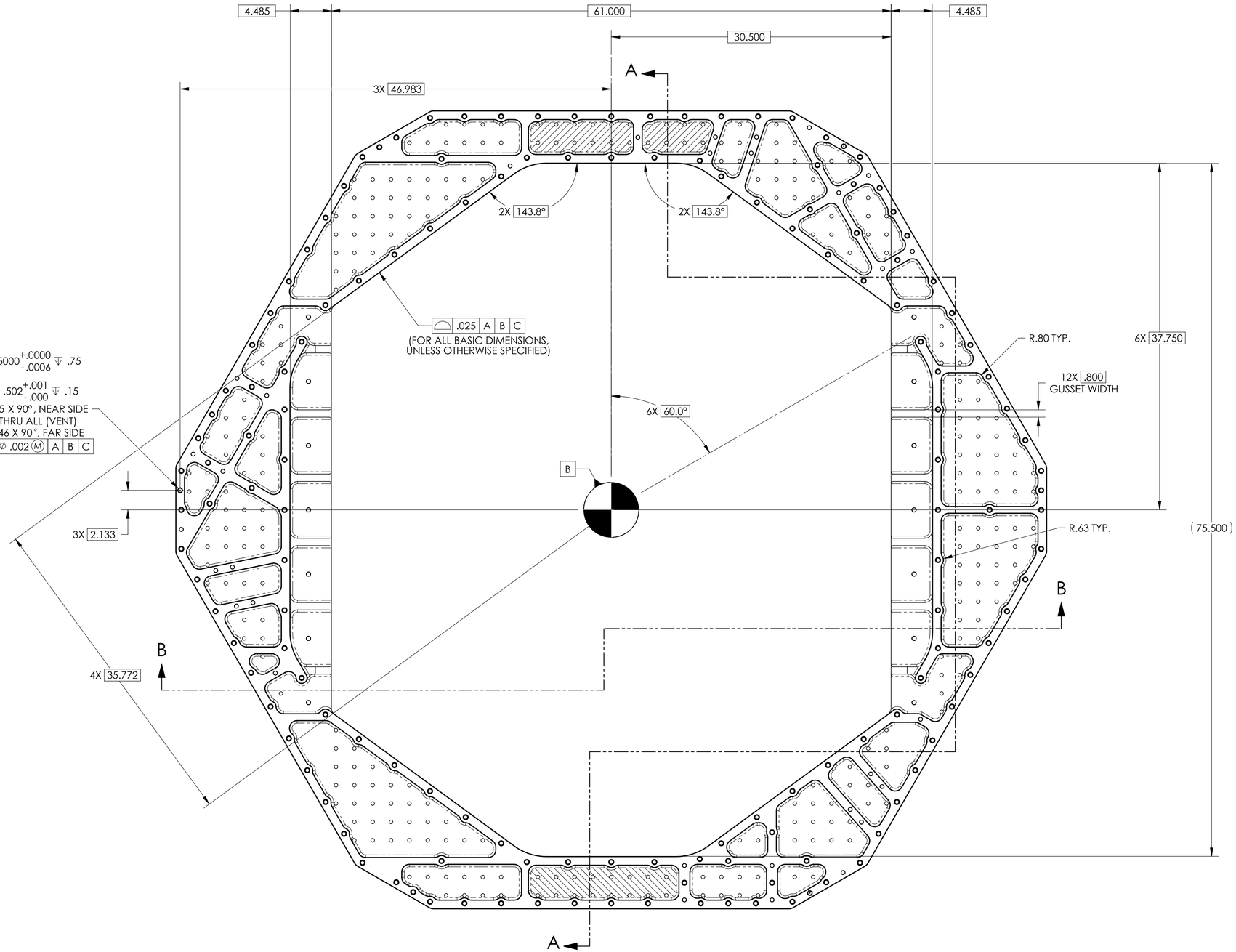
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

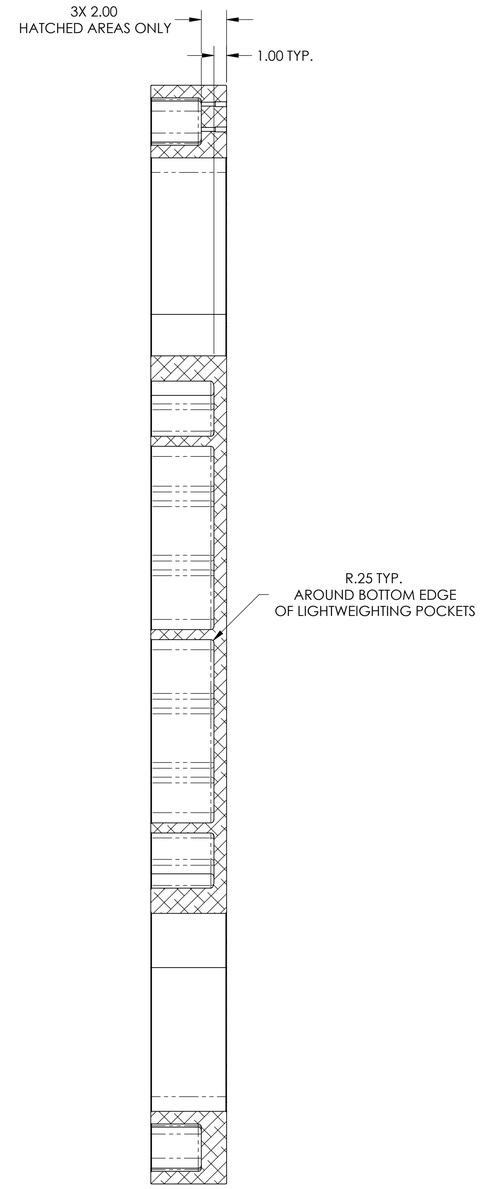
SYSTEM: ADVANCED LIGO | SUB-SYSTEM: SEI

PART NAME: Stage 0 Bottom, aLIGO BSC ISI

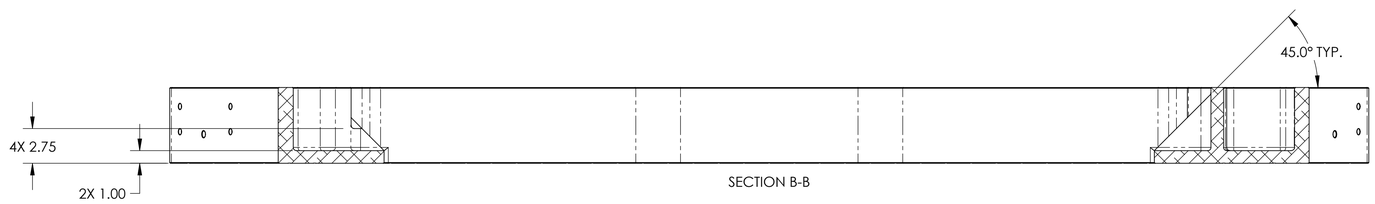
DESIGNER	C.RAMET	05 JAN 2010	SIZE	DWG. NO.	REV.
DRAFTER	M.HILLARD	05 JAN 2010	D	D0900894	v2
CHECKER	F.MATICHARD	05 JAN 2010			
APPROVAL	K.MASON	05 JAN 2010	SCALE: 1:6	PROJECTION:	SHEET 1 OF 4

D0900894 Adv LIGO SEI BSC Stage 0 Bottom, PART PDM REV- X.055, DRAWING PDM REV- X.022





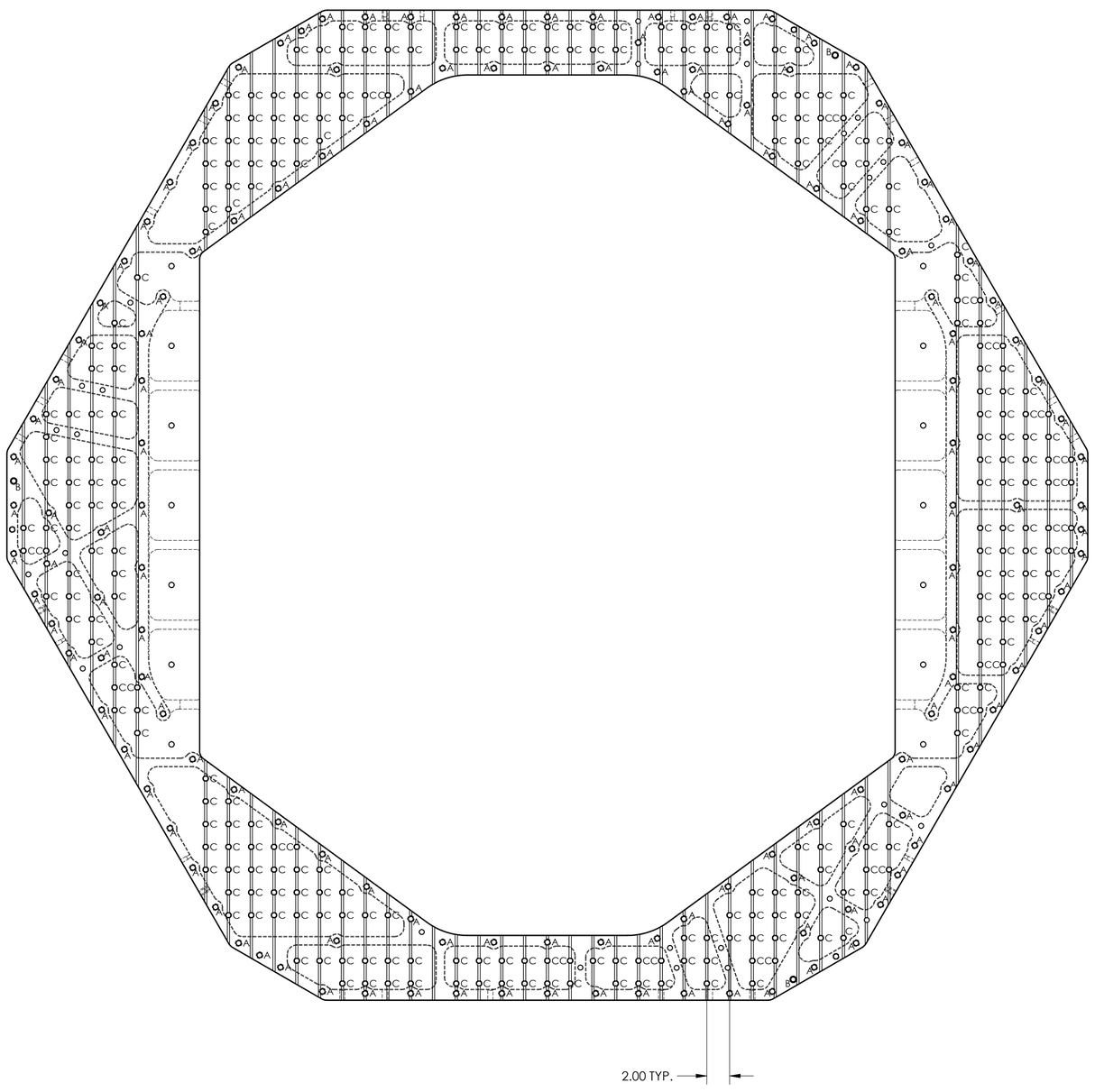
SECTION A-A

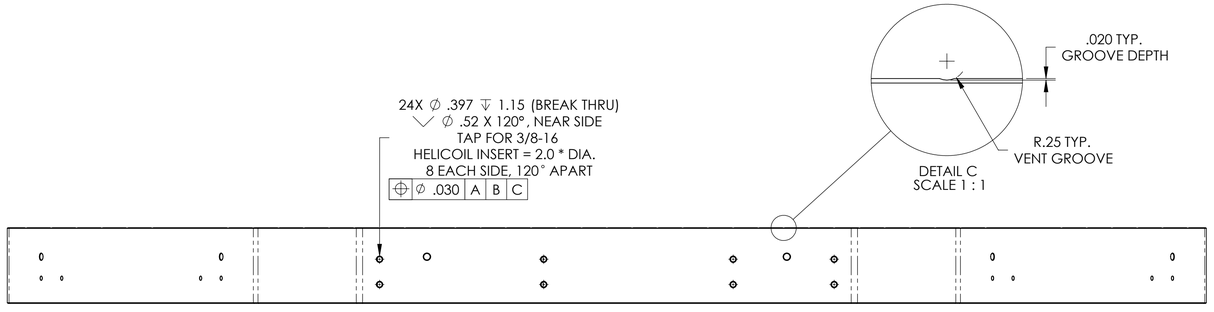


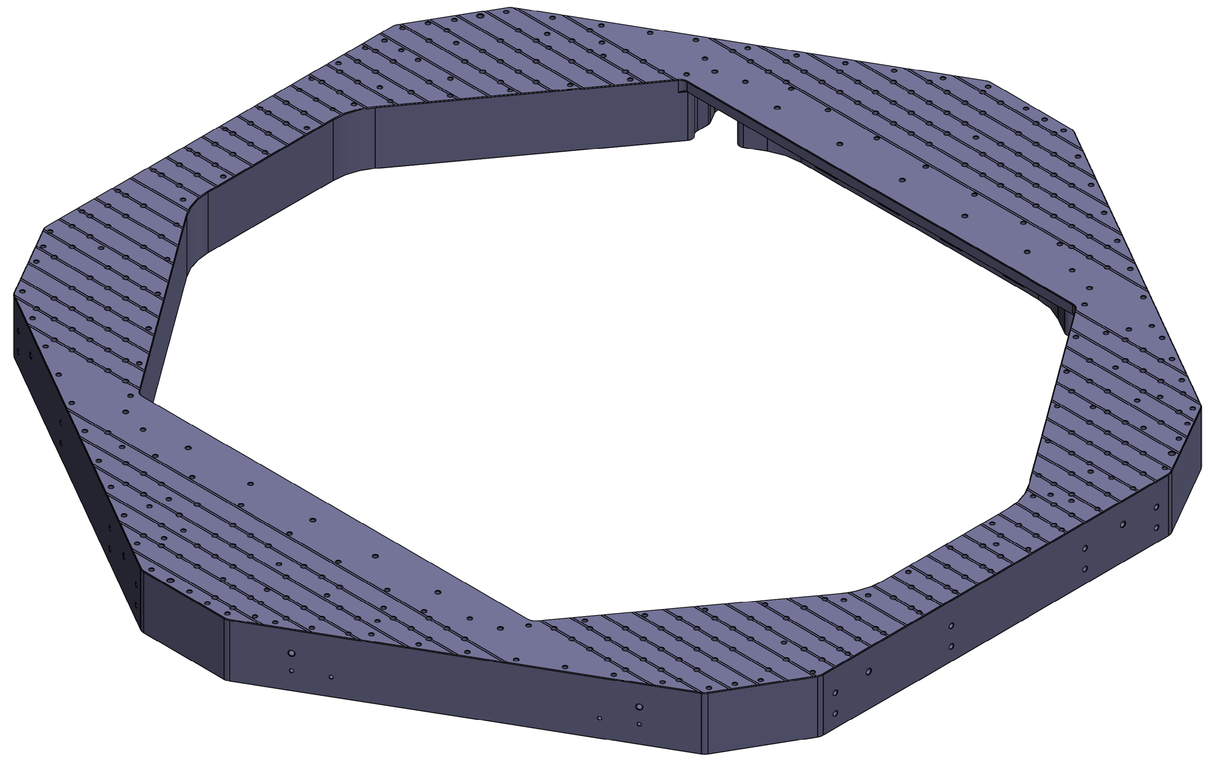
SECTION B-B

LIGO	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE	DWG. NO.	REV.
D	D0900894	v2
SCALE: 1:4	PROJECTION:	SHEET 2 OF 4

TAG	SIZE	QUANTITY	TOLERANCE
A	∅ .41 ↧ 3.00 ⌵ ∅ .46 X 90°, NEAR SIDE	145	⌖ ∅ .030 Ⓜ A B C VENT HOLE
B	∅ .422 ↧ 3.00 1/2-13 UNC - 2B ↧ 1.50 ⌵ ∅ .60 X 120°, NEAR SIDE	3	⌖ ∅ .030 A B C FOR LIFTING HARDWARE
C	∅ .397 ↧ 3.00 (BREAK THRU) ⌵ ∅ .52 X 120°, NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA.	285	⌖ ∅ .010 A B C







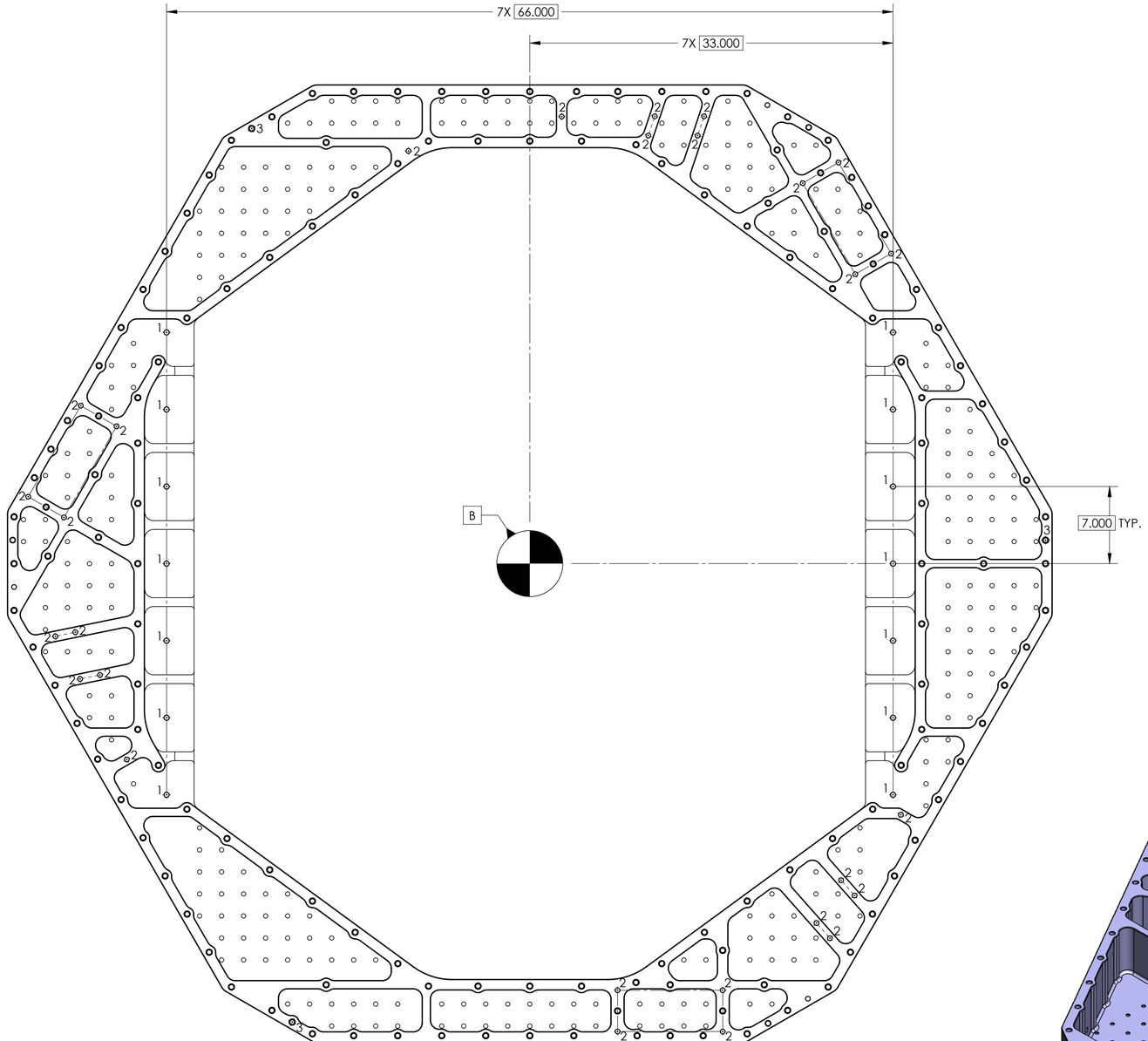
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

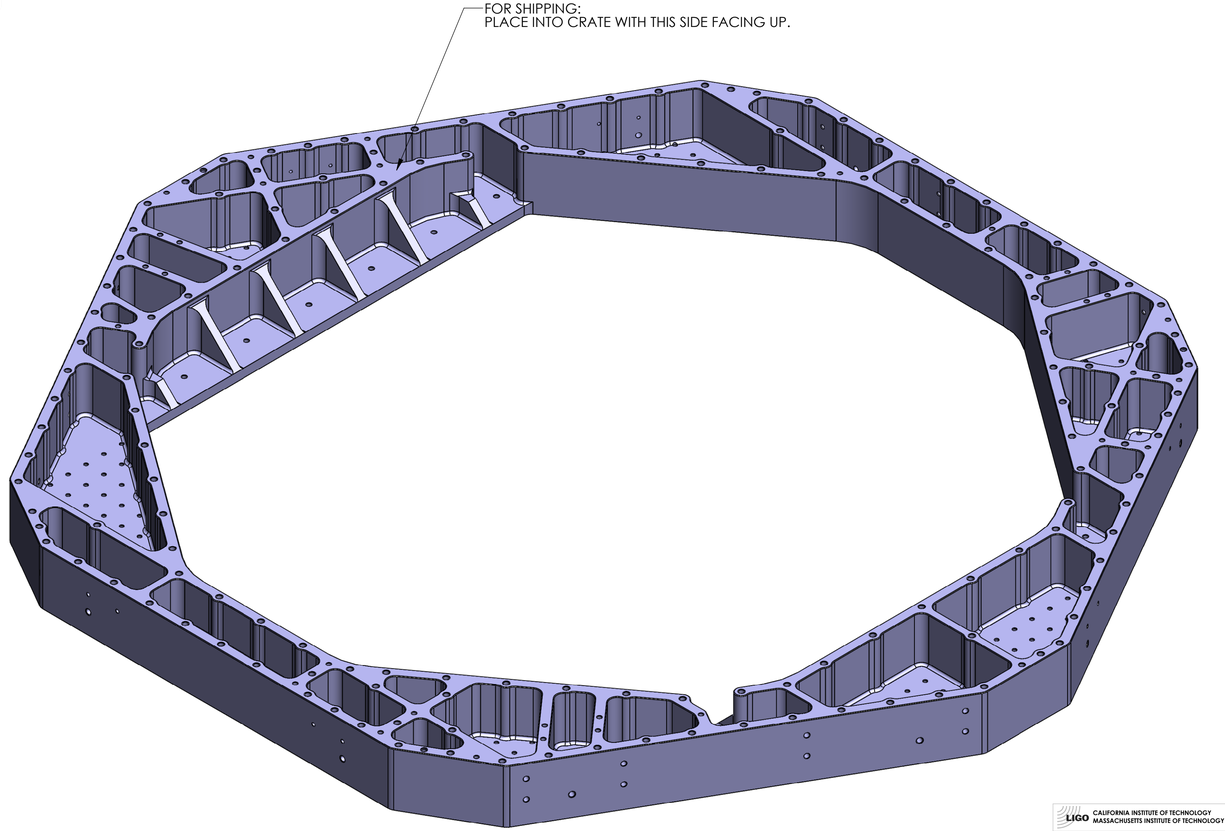
SIZE	DWG. NO.	REV.
D	D0900894	V2

SCALE: 1:6 | PROJECTION: | SHEET 3 OF 4

D0900894-Adv LIGO SEI BSC Stage 0 Bottom, PART PDM REV: X-055, DRAWING PDM REV: X-022

TAG	SIZE	QUANTITY	TOLERANCE
1	⌀ .438 THRU ALL ⌵ ⌀ .50 X 90°, NEAR SIDE ⌵ ⌀ .50 X 90°, FAR SIDE	14	⌖ ⌀ .010 Ⓜ A B C
2	⌀ .41 THRU ALL ⌵ ⌀ .46 X 90°, NEAR SIDE ⌵ ⌀ .46 X 90°, FAR SIDE	28	⌖ ⌀ .030 Ⓜ A B C
3	⌀ .422 ↧ 3.00 1/2-13 UNC - 2B ↧ 1.50 ⌵ ⌀ .60 X 120°, NEAR SIDE	3	⌖ ⌀ .030 A B C FOR LIFTING HARDWARE





D0900894 Adv LIGO SEI BSC Stage 0 Bottom, PART PDM REV= X-055, DRAWING PDM REV= X-022

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
D	D0900894	v2

SCALE: 1:6 | PROJECTION: | SHEET 4 OF 4