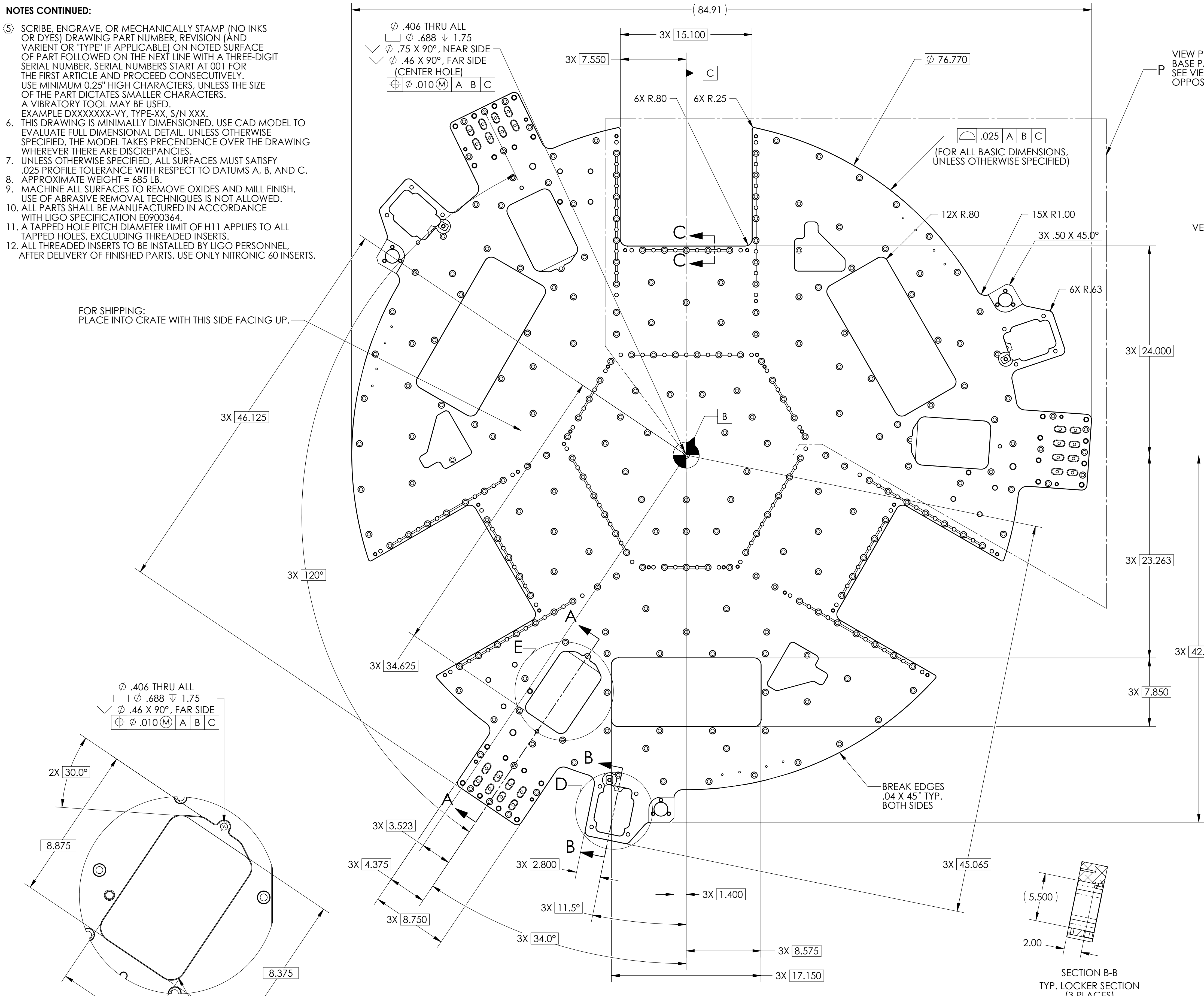


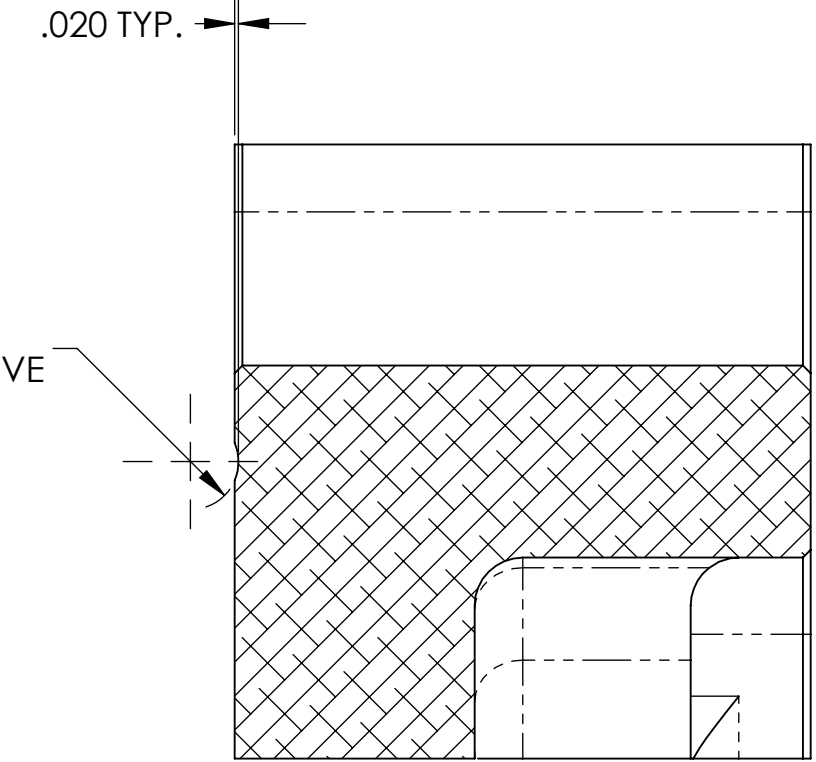
- NOTES CONTINUED:**
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE-DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.25" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
EXAMPLE DXXXXXX-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 = 685 LB.
 9. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 11. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES TO ALL TAPPED HOLES, EXCLUDING THREADED INSERTS.
 12. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS. USE ONLY NITRONIC 60 INSERTS.

FOR SHIPPING:
PLACE INTO CRATE WITH THIS SIDE FACING UP.

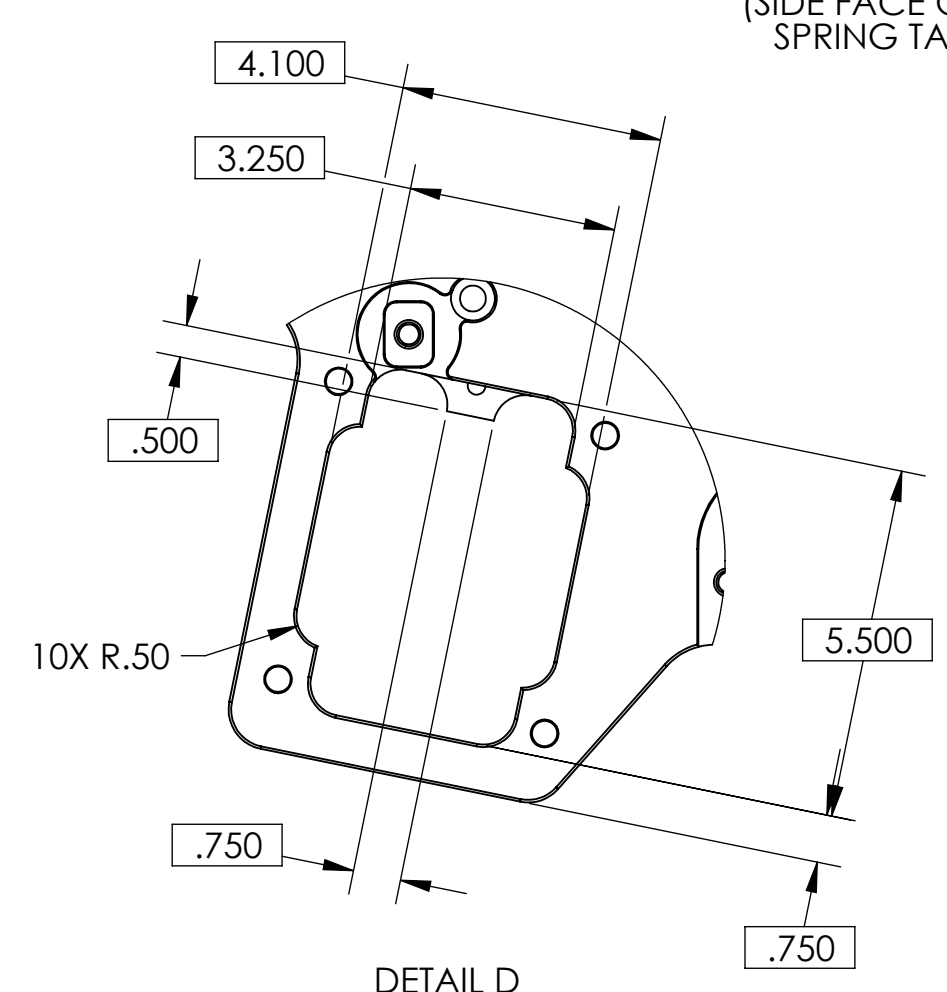


REV.	DATE	DCN #	DRAWING TREE #
v1	28 DEC 2009	E0900496	E1000025
v2	30 APR 2010	E1000129	E1000025

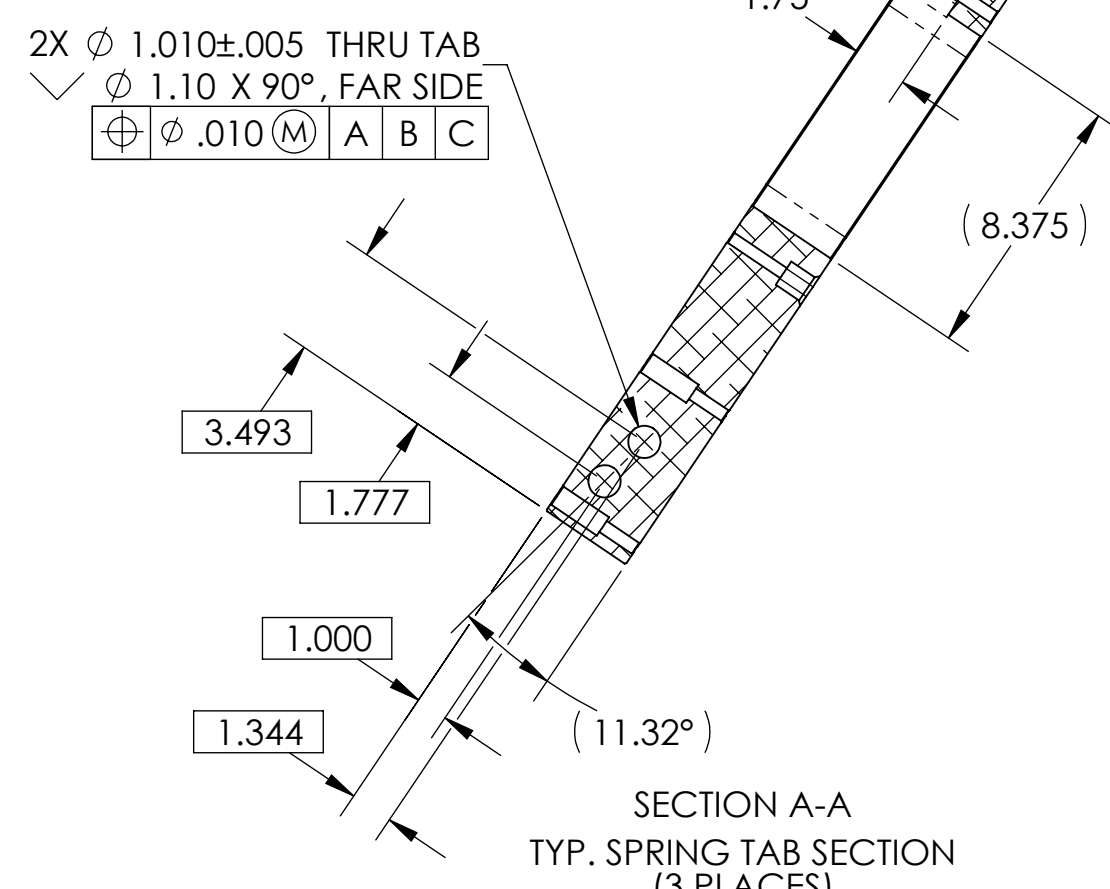
VIEW P INDICATES THE BASE PATTERN, ARRAYED 3X. SEE VIEW P ON SHEET 3, AND OPPOSITE-SIDE VIEW U ON SHEET 4.



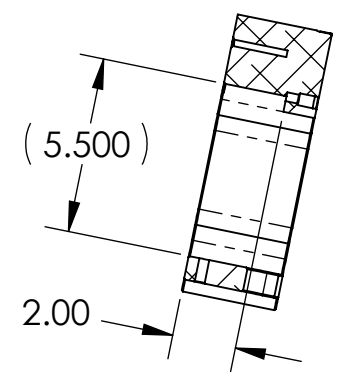
SECTION C-C
SCALE 1 : 1
TYP. VENT GROOVE SECTION
(MULTIPLE PLACES)



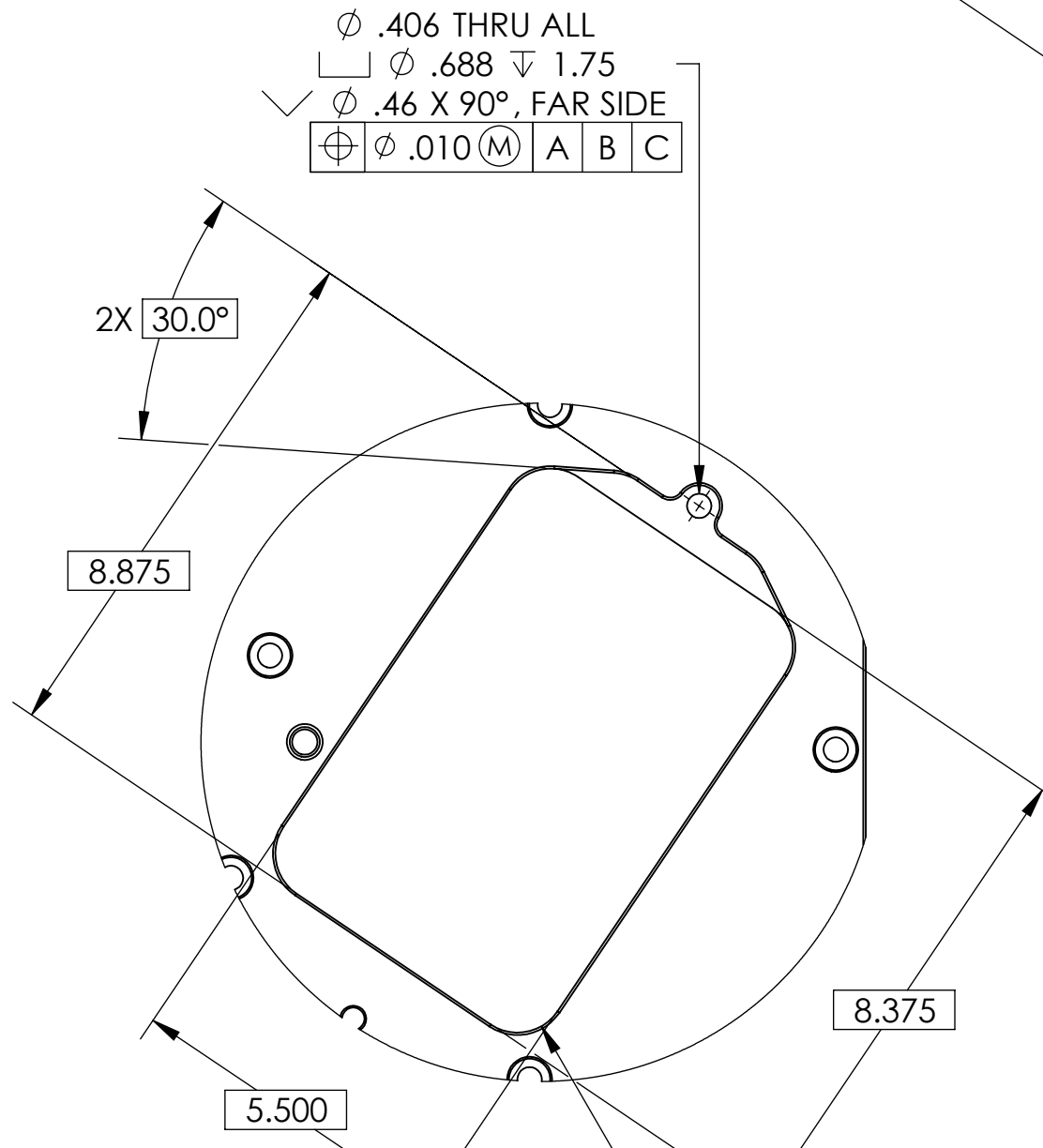
DETAIL D
SCALE 1 : 3
TYP. LOCKER DETAIL
(3 PLACES)



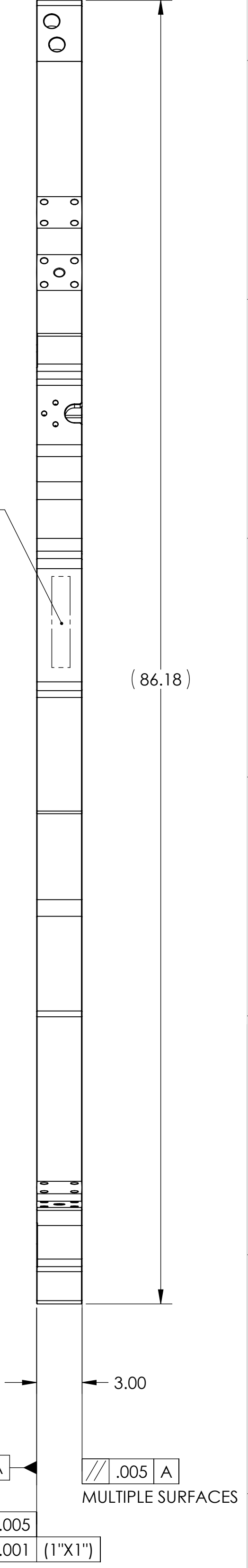
SECTION A-A
TYP. SPRING TAB SECTION
(3 PLACES)



SECTION B-B
TYP. LOCKER SECTION
(3 PLACES)

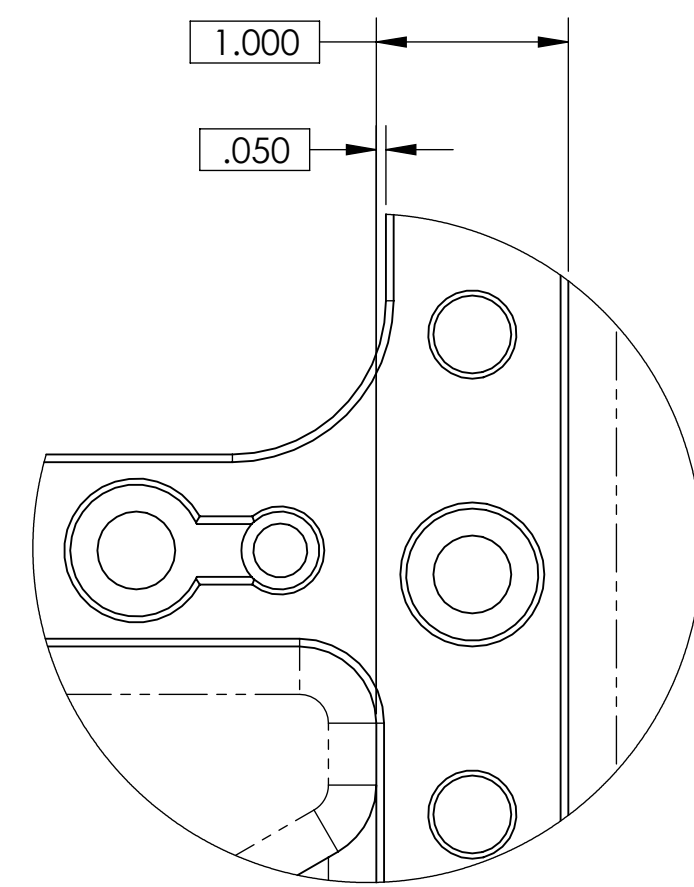
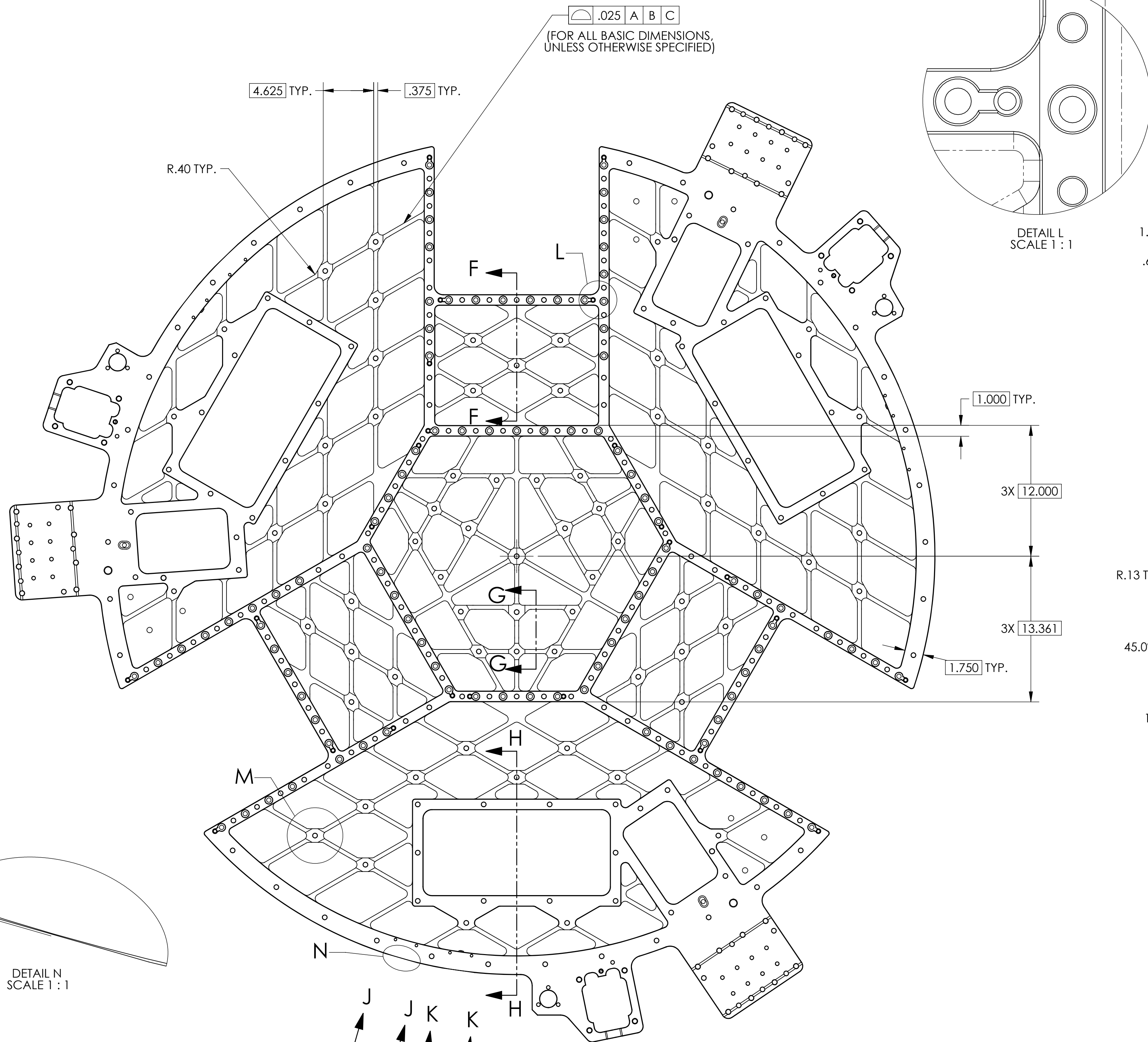
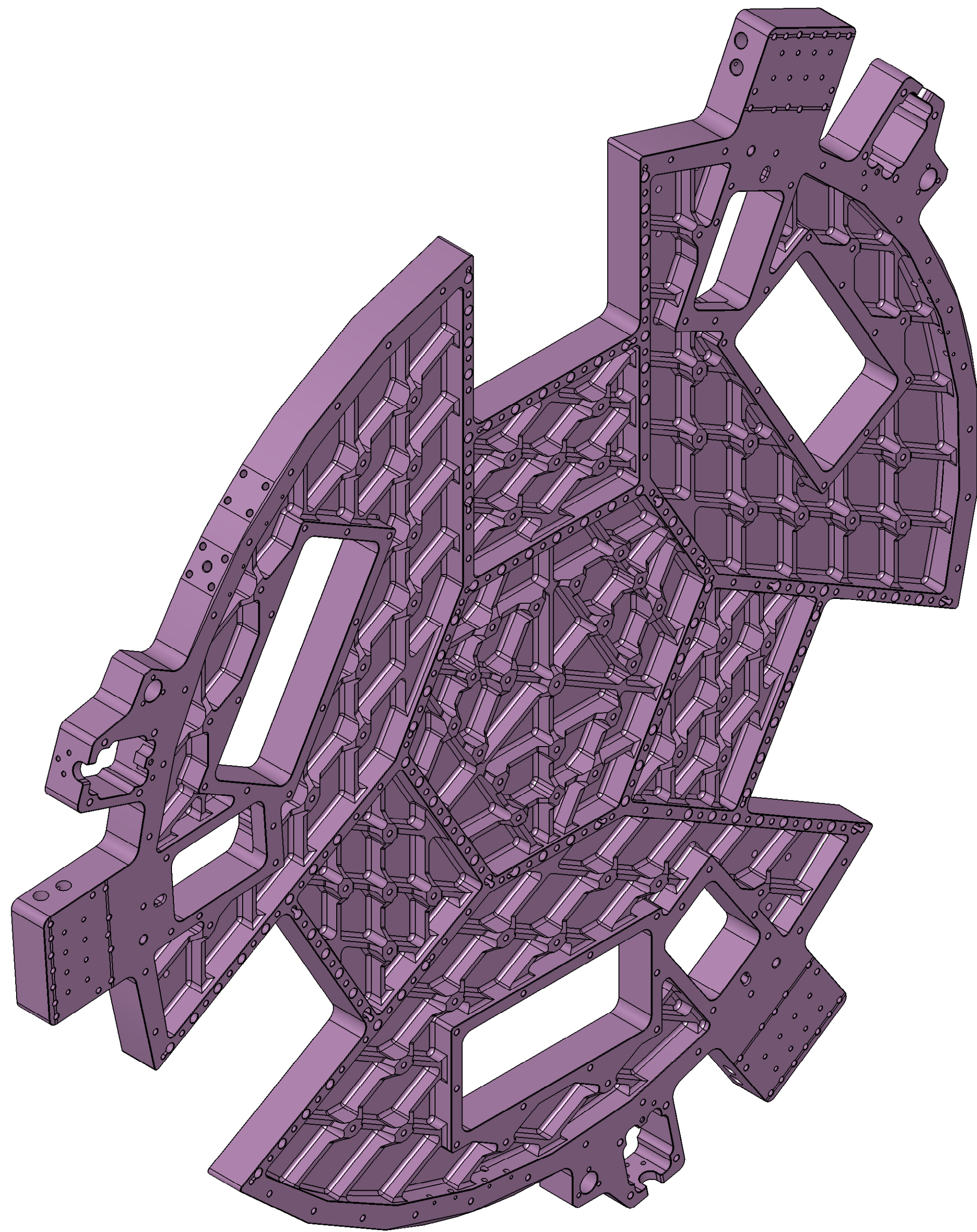


DETAIL E
SCALE 1 : 3
TYP. SPRING POCKET DETAIL
(3 PLACES)

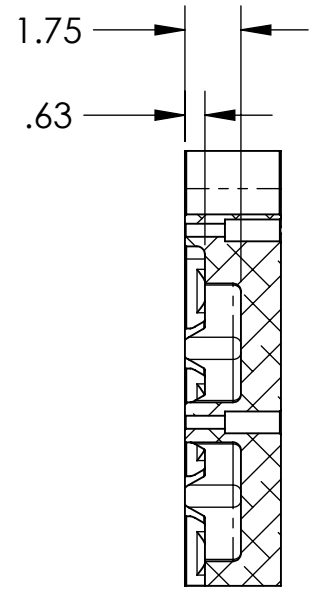


DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± .015 .XXX ± .005		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. BREAK ALL EDGES AND CORNERS .03 X 45°. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM ADVANCED LIGO		Optical Table, Up-Facing, aLIGO BSC ISI	
ANGULAR ± .5°		MATERIAL 6061-T6 Al		SUB-SYSTEM SEI		DESIGNER A.STEIN 29 Dec. 2009	
		FINISH 63 µinch		NEXT ASSY D0901181		DRAFTER M.HILLARD 28 Dec 2009	
						CHECKER F.MATCHARD 28 Dec 2009	
						APPROVAL K.MASON 28 Dec 2009	
						SIZE DWG. NO. D D0901517	
						REVISION v2	
						SCALE: 1:6 PROJECTION: SHEET 1 OF 4	

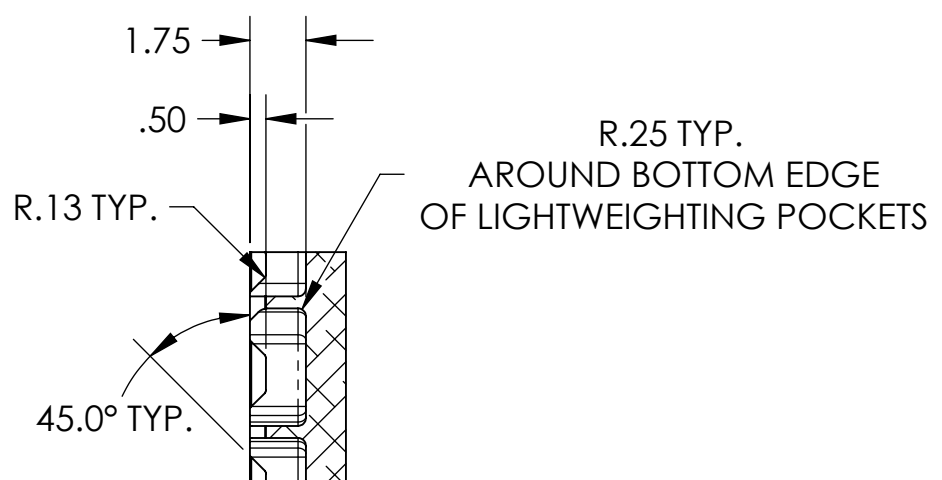
D0901517_Optical_Table_Up-Facing-BSC_ISI_PART_PDM_REV_X.0311_DRAWING_PDM_REV_X.016



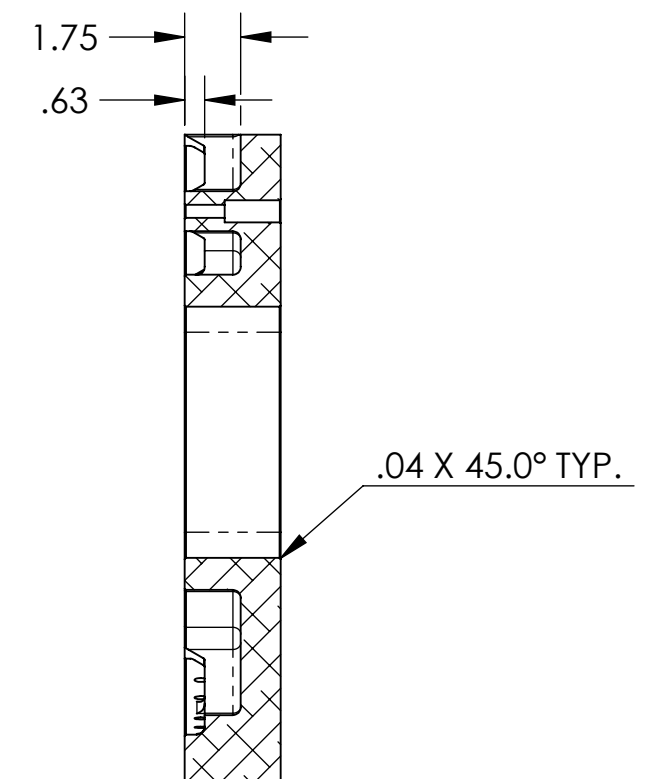
DETAIL L
SCALE 1:1



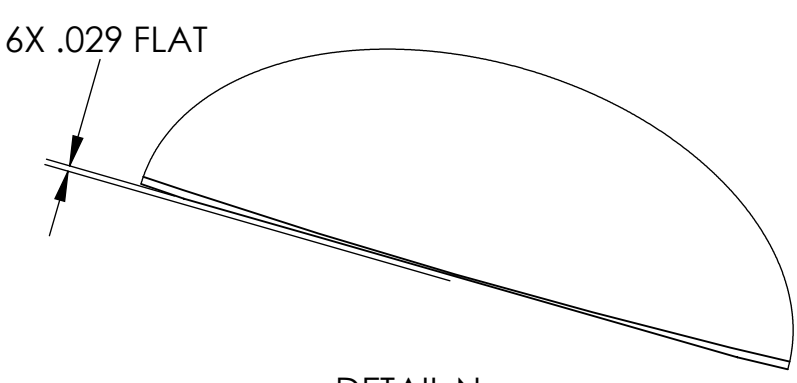
SECTION F-F



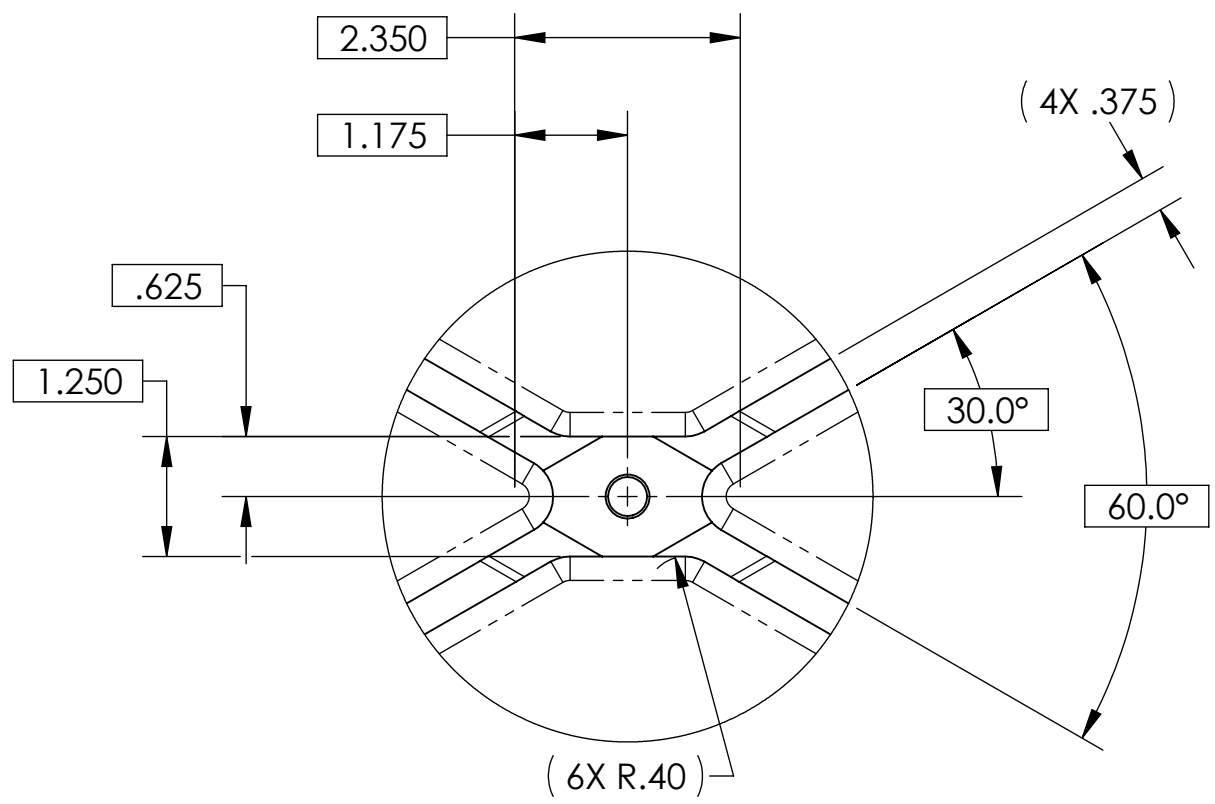
SECTION G-G



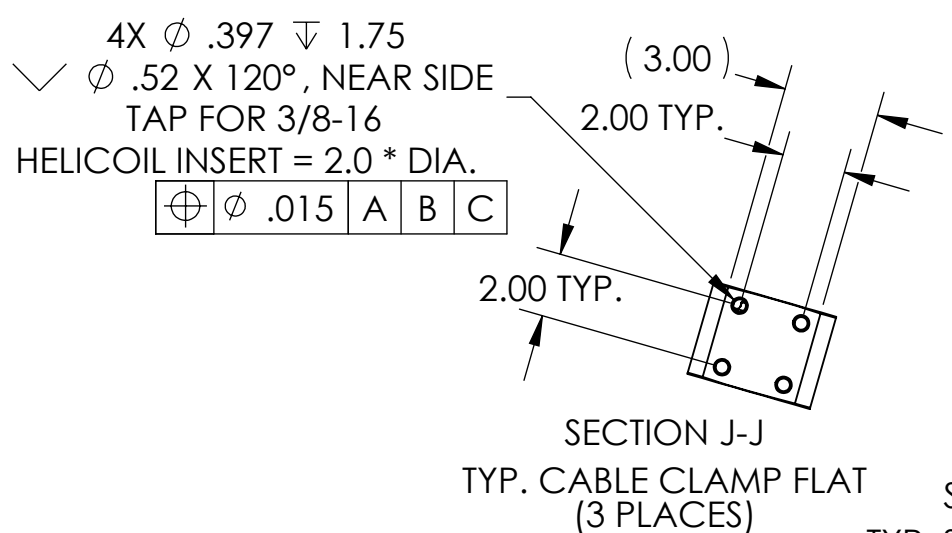
SECTION H-H



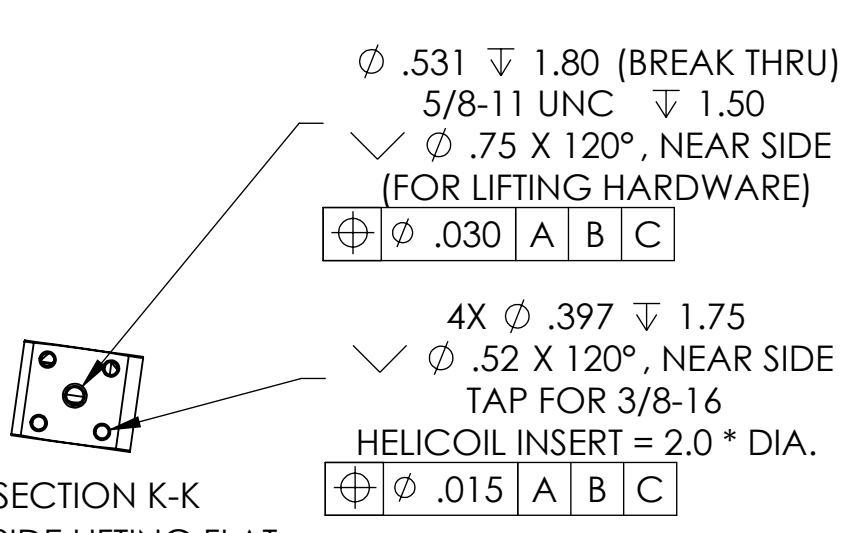
DETAIL N
SCALE 1:1



DETAIL M
SCALE 1:2
TYP. TAPPED HOLE / WEB DETAIL
(MULTIPLE PLACES)



SECTION J-J
TYP. CABLE CLAMP FLAT
(3 PLACES)



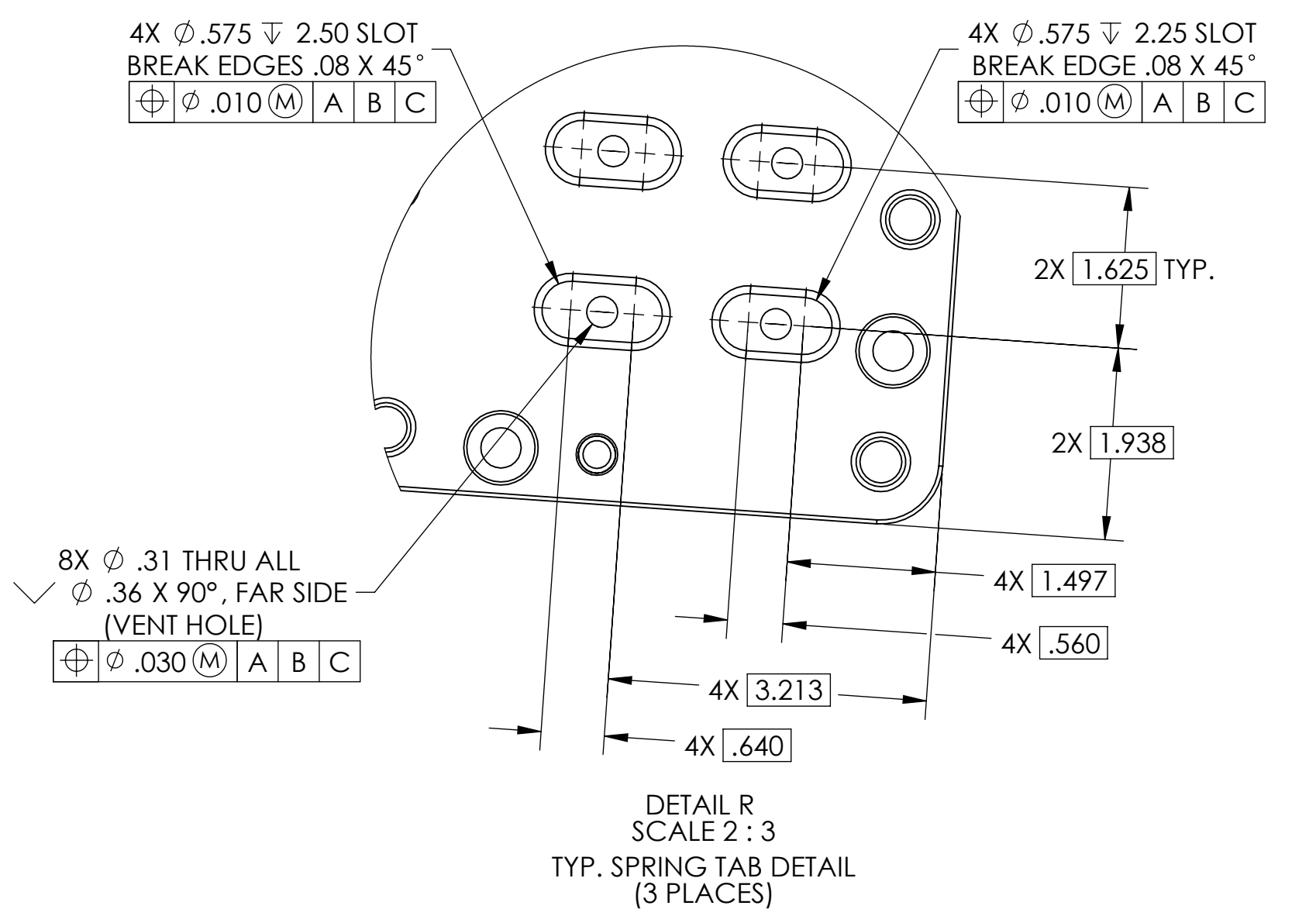
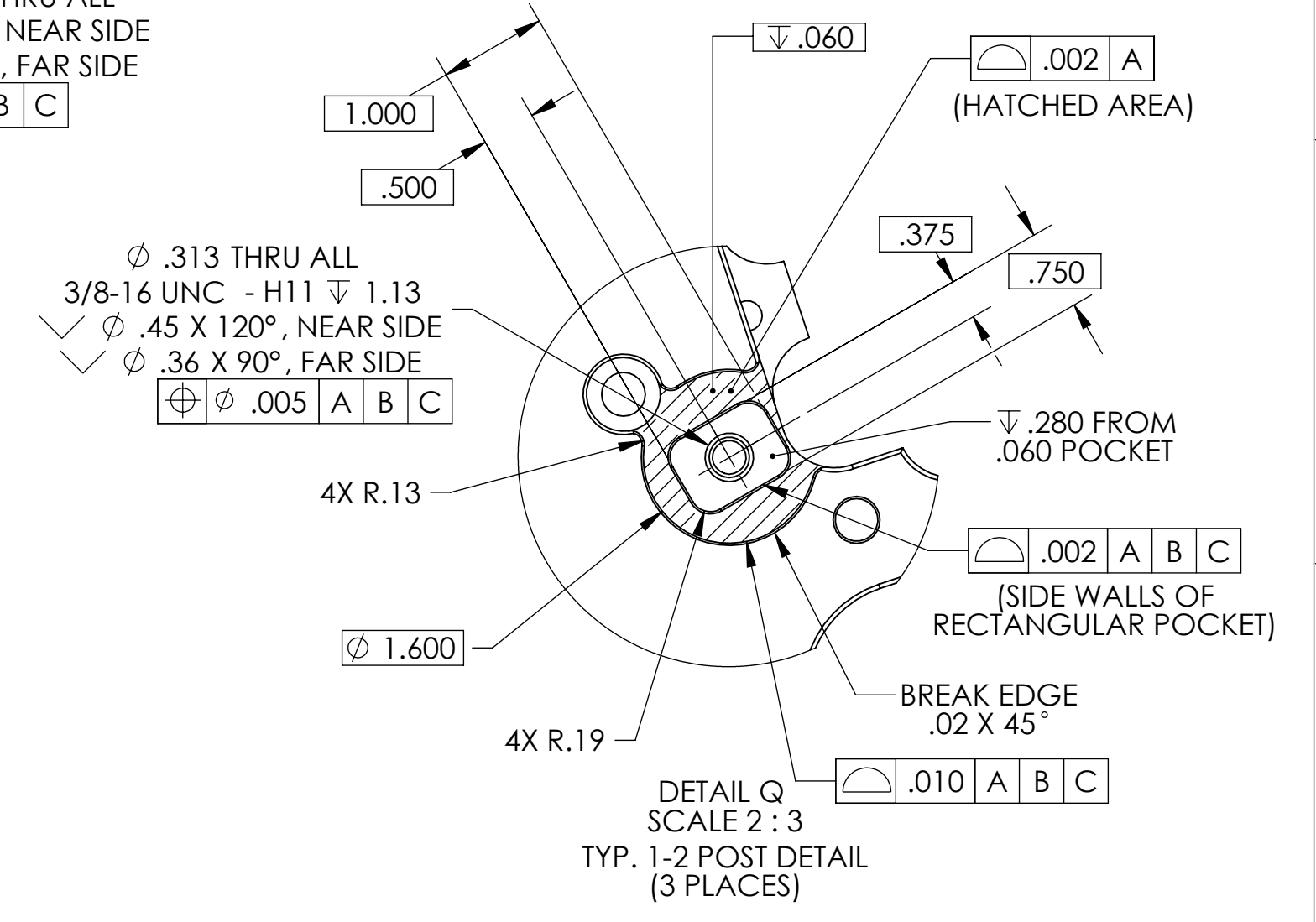
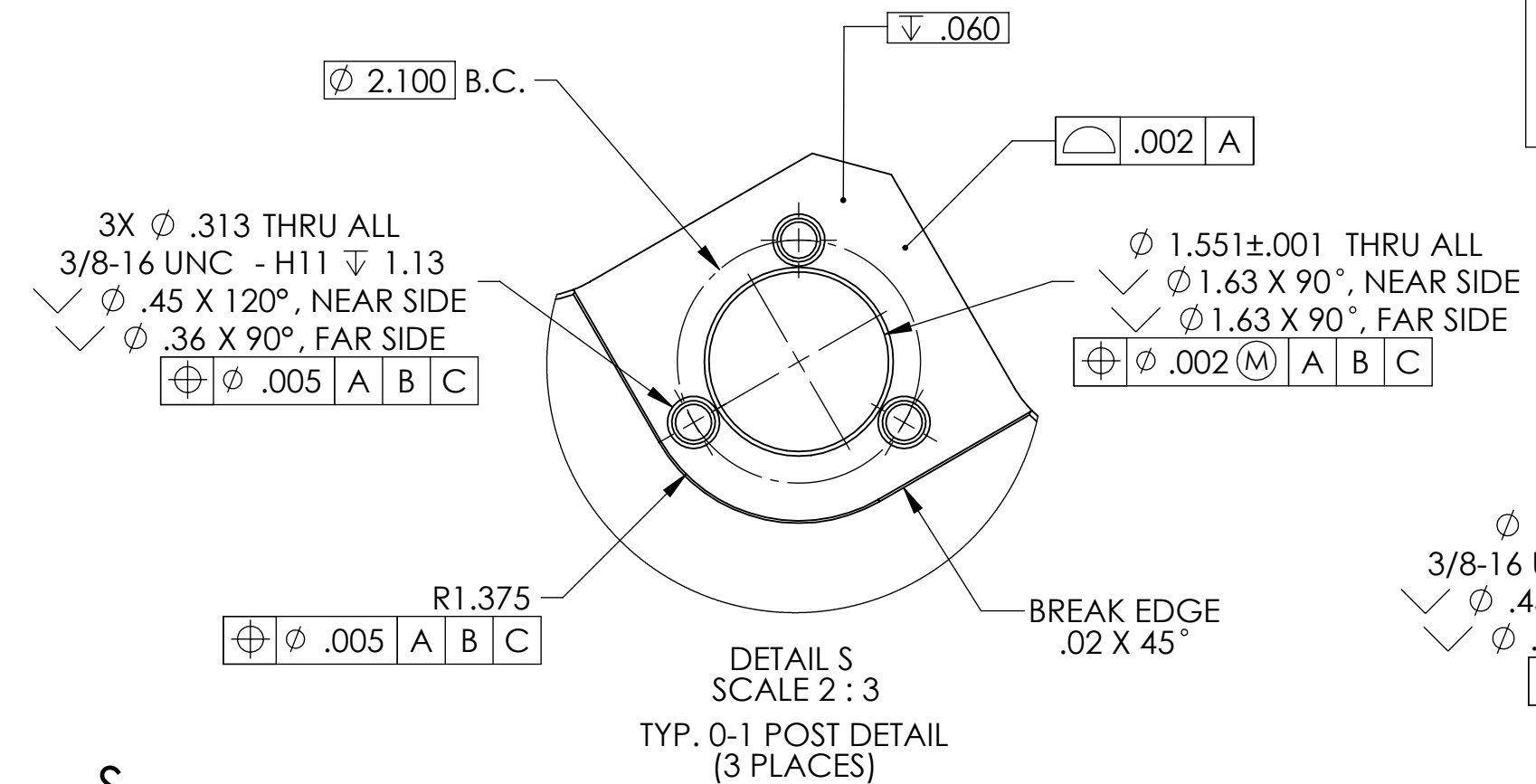
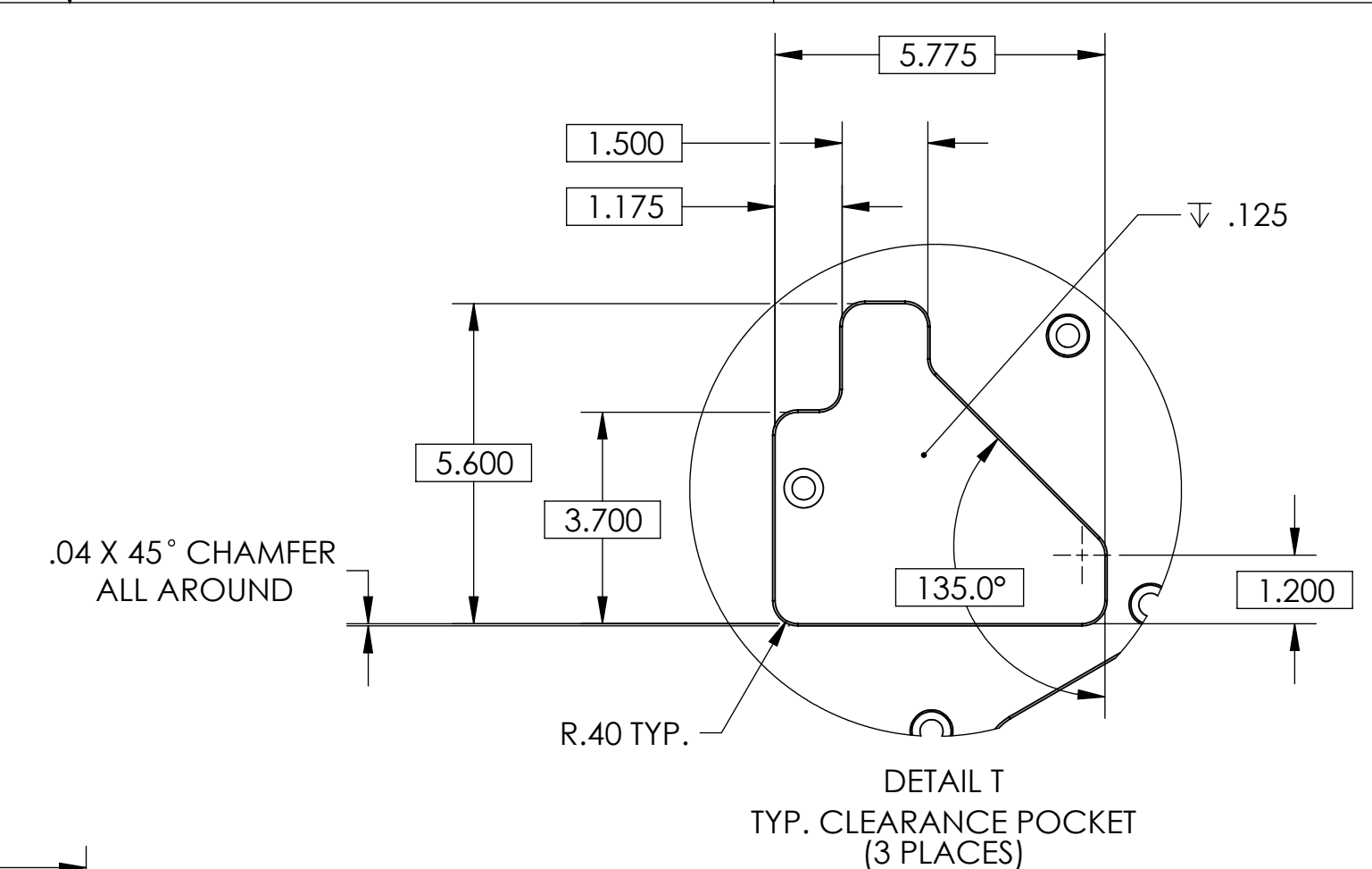
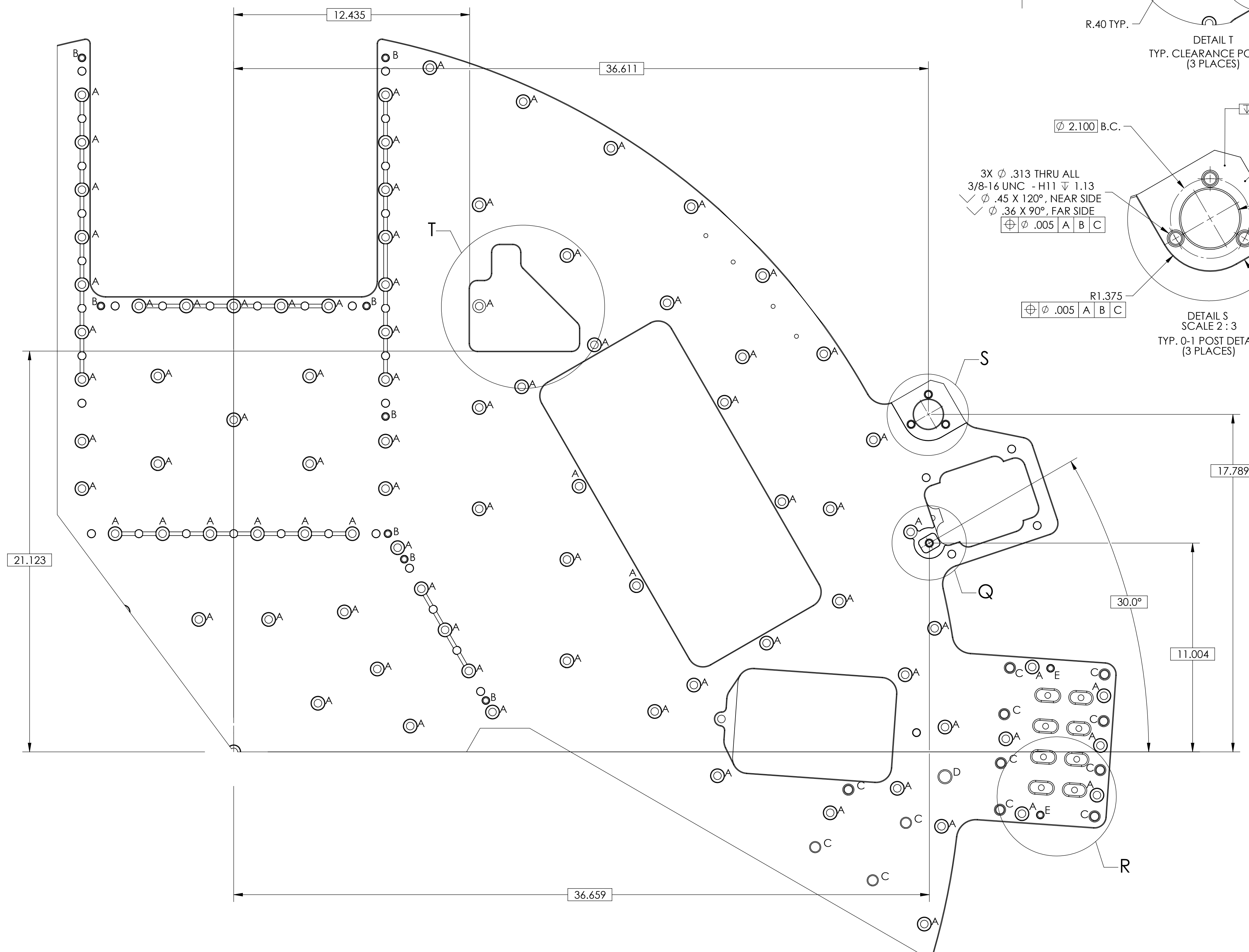
SECTION K-K
TYP. SIDE LIFTING FLAT
(3 PLACES)

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SIZE	DWG. NO.	REV.
D	D0901517	v2
SCALE: 1:6	PROJECTION:	SHEET 2 OF 4

DD901517_Opical_Table-Top-Facing-BSC_LB1_PART_PDM_REV_X-0811_DRAWING_PDM_REV_X-016

VIEW P
VIEW SHOWN INDICATES
THE BASE PATTERN ARRAYED 3X



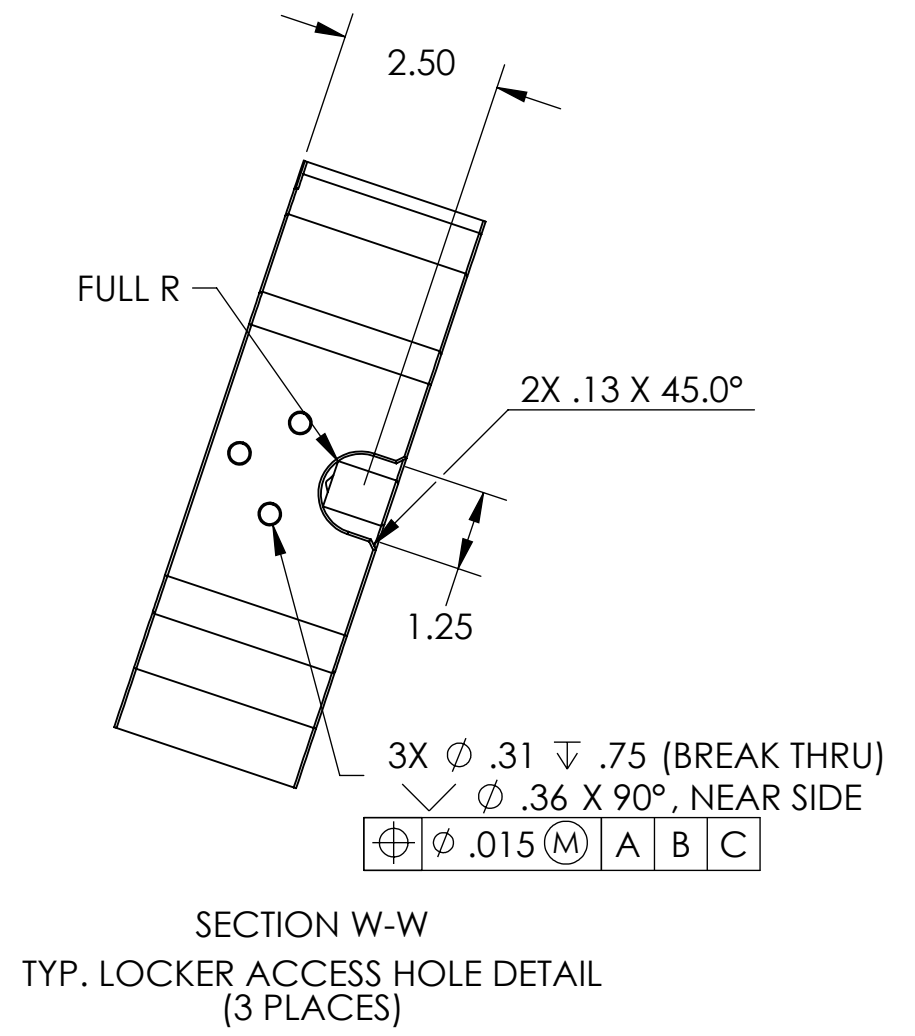
TAG	SIZE	QUANTITY	TOLERANCE
A	ϕ .406 THRU ALL ϕ .688 ∇ 1.75 \surd ϕ .75 X 90°, NEAR SIDE \surd ϕ .46 X 90°, FAR SIDE	87	ϕ .010 (M) A B C
B	ϕ .3750 $^{+.0000}_{-.0004}$ ∇ .60 \surd ϕ .377 $^{+.001}_{-.000}$ ∇ .13 \surd ϕ .42 X 90°, NEAR SIDE ϕ .28 THRU (VENT)	8	ϕ .002 (M) A B C
C	ϕ .422 THRU ALL \surd 1/2-13 UNC ∇ 1.50 \surd ϕ .60 X 120°, NEAR SIDE \surd ϕ .50 X 90°, FAR SIDE	12	ϕ .010 A B C NOTE 11
D	ϕ .531 THRU ALL \surd 5/8-11 UNC THRU ALL \surd ϕ .75 X 120°, NEAR SIDE \surd ϕ .75 X 120°, FAR SIDE	1	ϕ .030 A B C FOR LIFTING HARDWARE
E	ϕ .3750 $^{+.0000}_{-.0004}$ ∇ .60 \surd ϕ .377 $^{+.001}_{-.000}$ ∇ .13 \surd ϕ .42 X 90°, NEAR SIDE ϕ .28 ∇ 1.00 (BREAK THRU)	2	ϕ .002 (M) A B C

HOLE PATTERN ARRAYED 3X

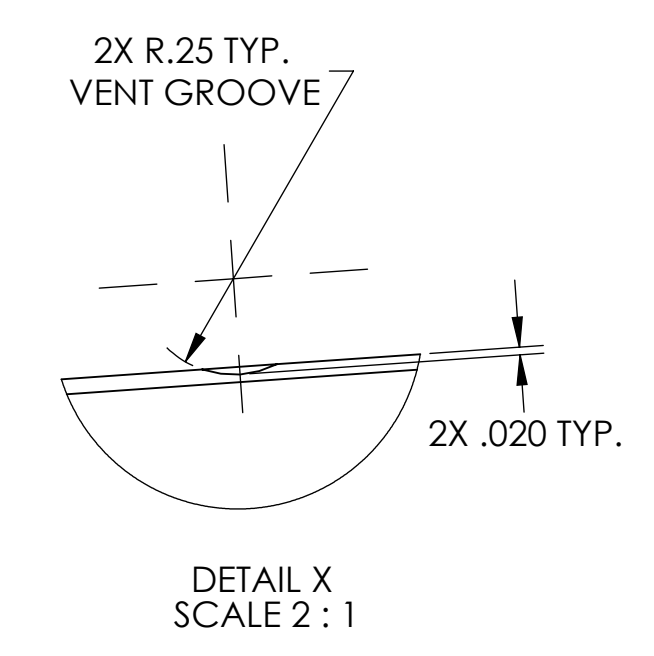
VIEW U
VIEW SHOWN INDICATES THE BASE
PATTERN ARRAYED 3X

TAG	SIZE	QUANTITY	TOLERANCE
1	ϕ .397 THRU ALL \surd ϕ .52 X 120°, NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA. \surd ϕ .45 X 90°, FAR SIDE	4	$\oplus \phi$.010 A B C
2	ϕ .375 ^{+0.000} _{-.0004} ∇ .60 \sqsubset ϕ .377 ^{+0.001} _{-.000} ∇ .13 \surd ϕ .42 X 90°, NEAR SIDE ϕ .28 ∇ 1.00 (VENT)	1	$\oplus \phi$.002 (M) A B C
3	\surd ϕ .22 THRU ALL ϕ .26 X 90°, NEAR SIDE	4	$\oplus \phi$.030 (M) A B C VENT HOLE
4	ϕ .406 THRU ALL \sqsubset ϕ .688 ∇ 1.75 \surd ϕ .75 X 90°, NEAR SIDE \surd ϕ .46 X 90°, FAR SIDE	32	$\oplus \phi$.010 (M) A B C

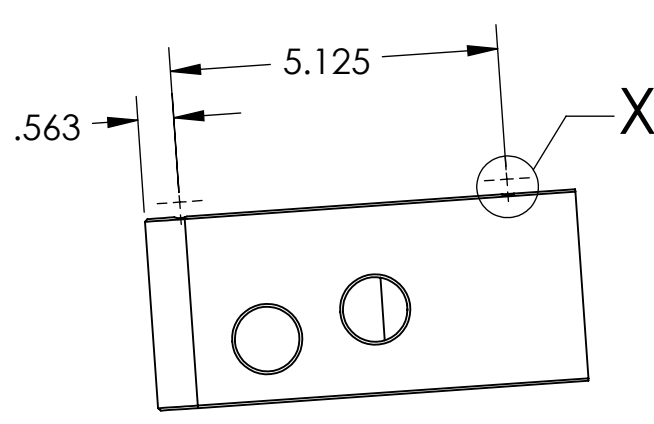
HOLE PATTERN ARRAYED 3X



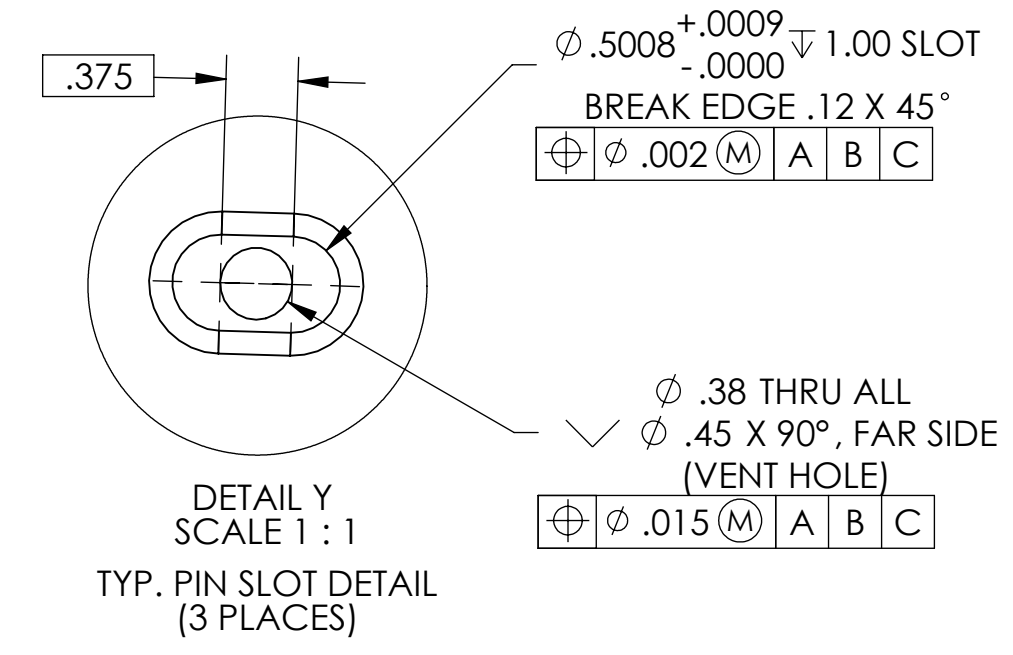
SECTION W-W
TYP. LOCKER ACCESS HOLE DETAIL
(3 PLACES)



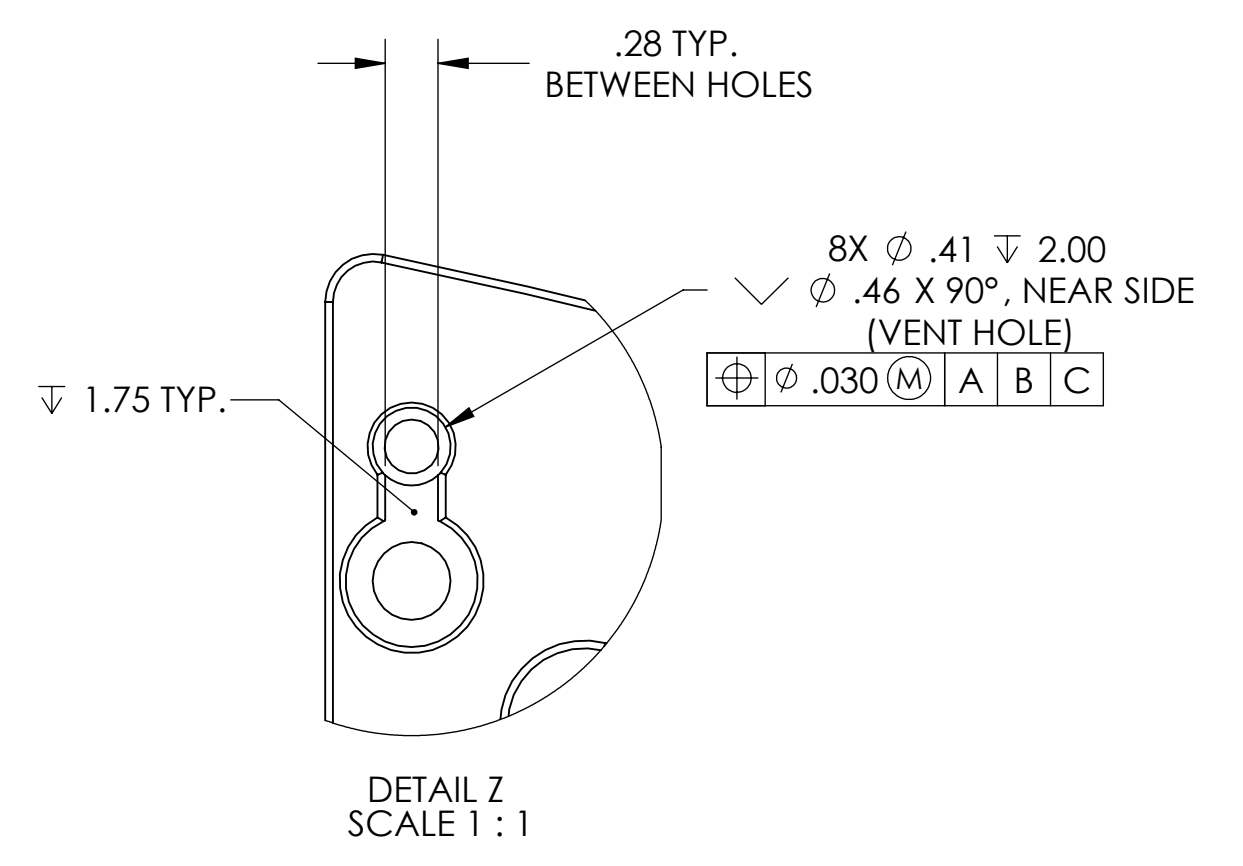
DETAIL X
SCALE 2 : 1



SECTION V-V



DETAIL Y
SCALE 1 : 1
TYP. PIN SLOT DETAIL
(3 PLACES)



DETAIL Z
SCALE 1 : 1

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SIZE DWG. NO. **D0901517** REV. **v2**

SCALE: 1:3 PROJECTION: SHEET 4 OF 4

DD901517_Optical_Table-Top-Forging-BSC_IBI_PART_PDM_REV_X-0811_DRAWING_PDM_REV_X-016