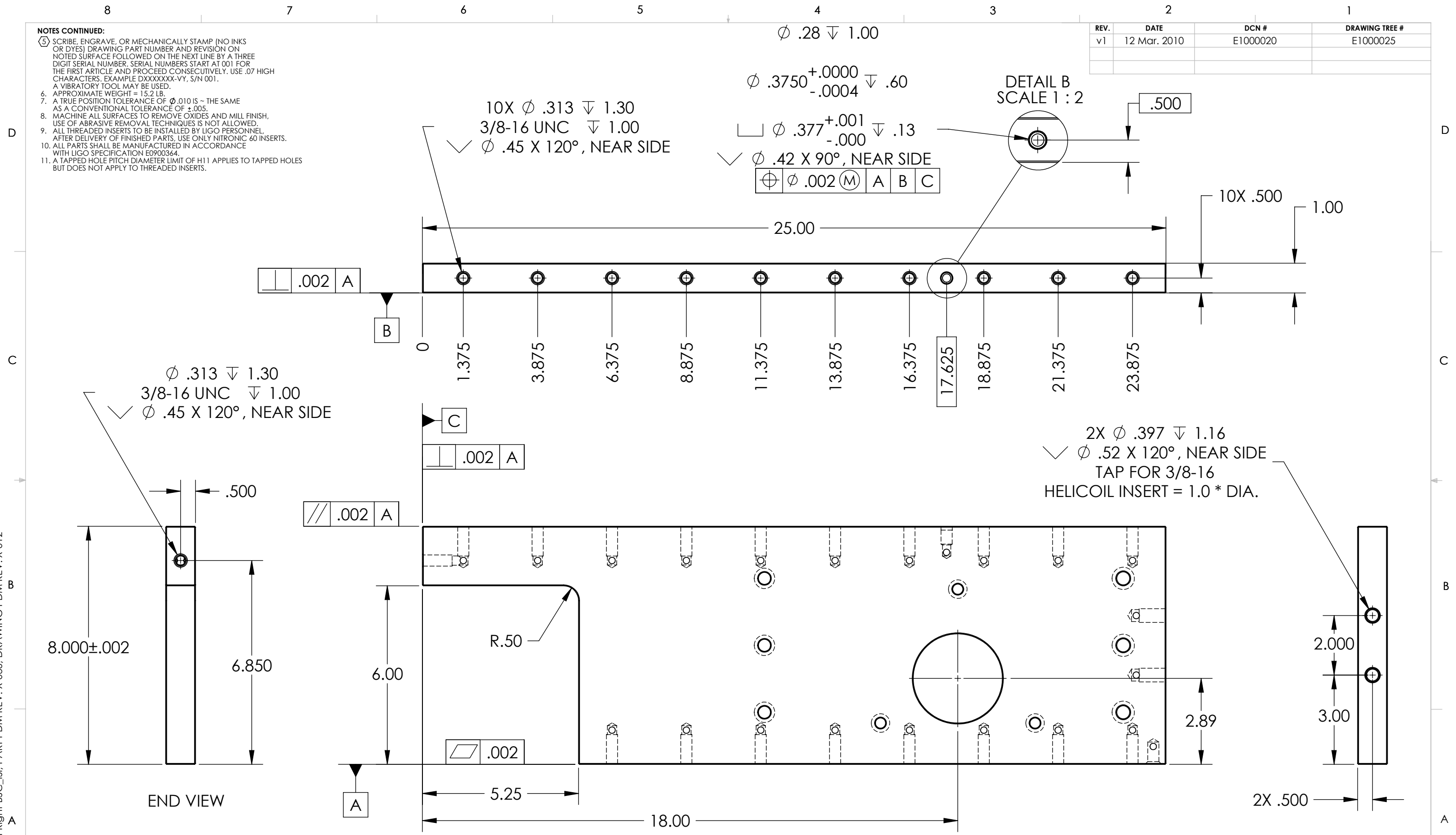


D0901522_Radial_Wall-Right-BSC_ISI, PART PDM REV: X-036, DRAWING PDM REV: X-012

- 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 DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.
 6. APPROXIMATE WEIGHT = 15.2 LB.
 7. A TRUE POSITION TOLERANCE OF $\phi .010$ IS THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.
 8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 9. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE ONLY NITRONIC 60 INSERTS.
 10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 11. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES TO TAPPED HOLES BUT DOES NOT APPLY TO THREADED INSERTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	12 Mar. 2010	E1000020	E1000025



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. BREAK ALL EDGES AND CORNERS $.03 \times 45^\circ$.
 3. DO NOT SCALE FROM DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX $\pm .015$
 .XXX $\pm .005$

ANGULAR $\pm 0.5^\circ$

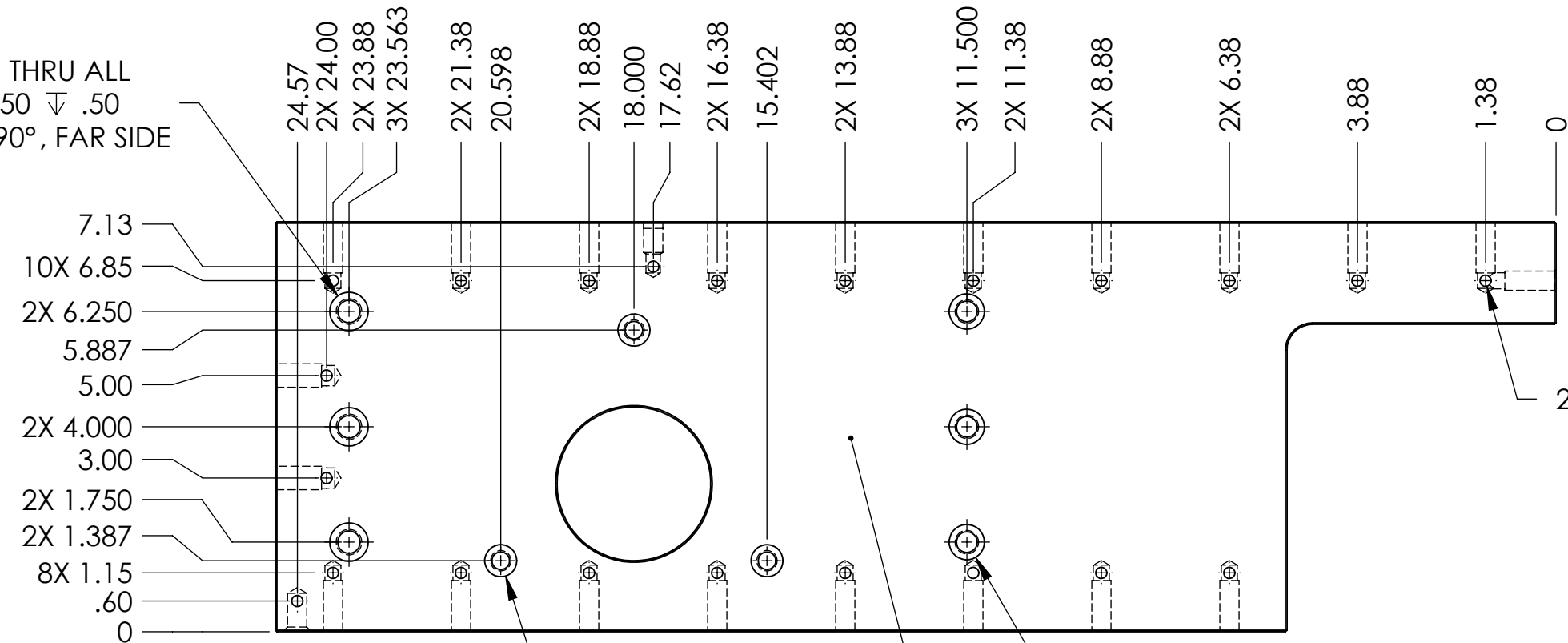
MATERIAL	6061-T6 Al	FINISH	63 μinch
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM ADVANCED LIGO		SUB-SYSTEM SEI	
NEXT ASSY		D0901181	
DESIGNER	A.STEIN	11 Jan. 2010	SIZE DWG. NO.
DRAFTER	M.Hillard	11 Jan. 2010	B
CHECKER	F.MATICHARD	11 Jan. 2010	D0901522
APPROVAL	K.MASON	11 Jan. 2010	REV. v1
SCALE: 1:3		PROJECTION:	
SHEET 1 OF 2			

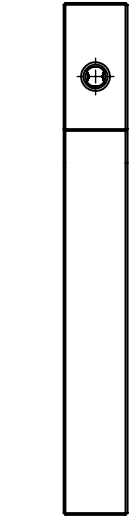
D0901522_Radial_Wall-Right-BSC_ISI_PART PDM REV: X-036, DRAWING PDM REV: X-012

8 7 6 5 4 3 2 1

3X ϕ .438 THRU ALL
 \square ϕ .750 ∇ .50
 \sphericalangle ϕ .50 X 90°, FAR SIDE



22X ϕ .22 THRU ALL

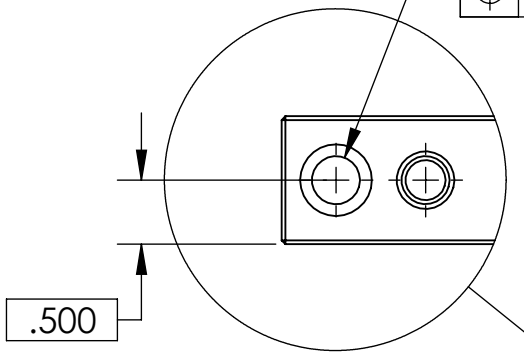


END VIEW

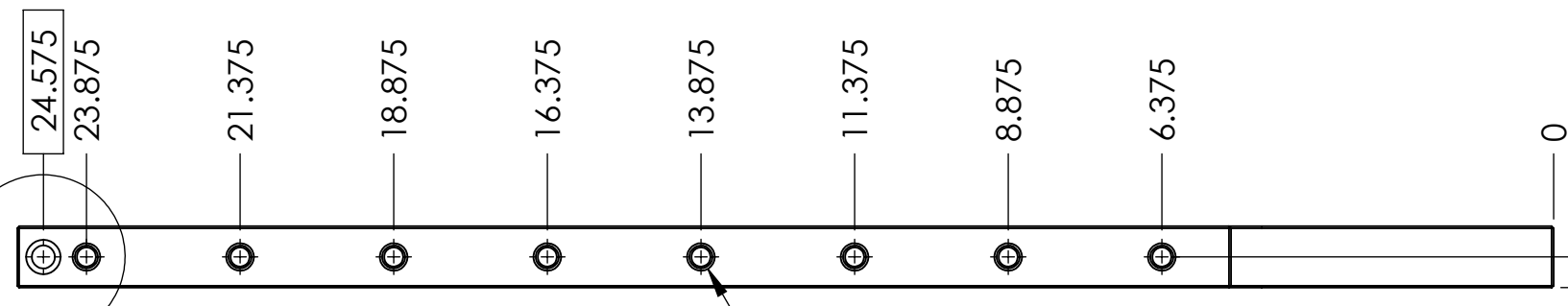
3X ϕ .344 THRU ALL
 \square ϕ .625 ∇ .50
 \sphericalangle ϕ .40 X 90°, FAR SIDE

3X ϕ .406 THRU ALL
 \square ϕ .688 ∇ .50
 \sphericalangle ϕ .46 X 90°, FAR SIDE

ϕ .3757^{+0.0008}/_{-.0000} ∇ .75
 \sphericalangle ϕ .56 X 90°, NEAR SIDE
 \oplus ϕ .002 (M) A B C



DETAIL C
SCALE 2 : 3



8X ϕ .313 ∇ 1.30
3/8-16 UNC ∇ 1.00
 \sphericalangle ϕ .45 X 120°, NEAR SIDE

8X .500

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D0901522	v1
SCALE: 1:3	PROJECTION:	SHEET 2 OF 2

8 7 6 5 4 3 2 1