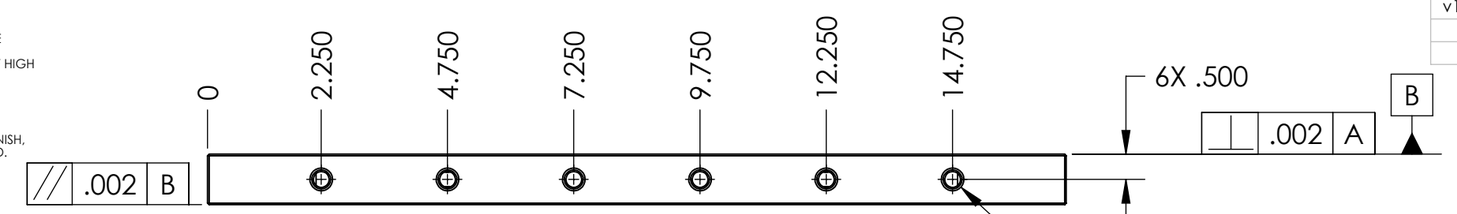
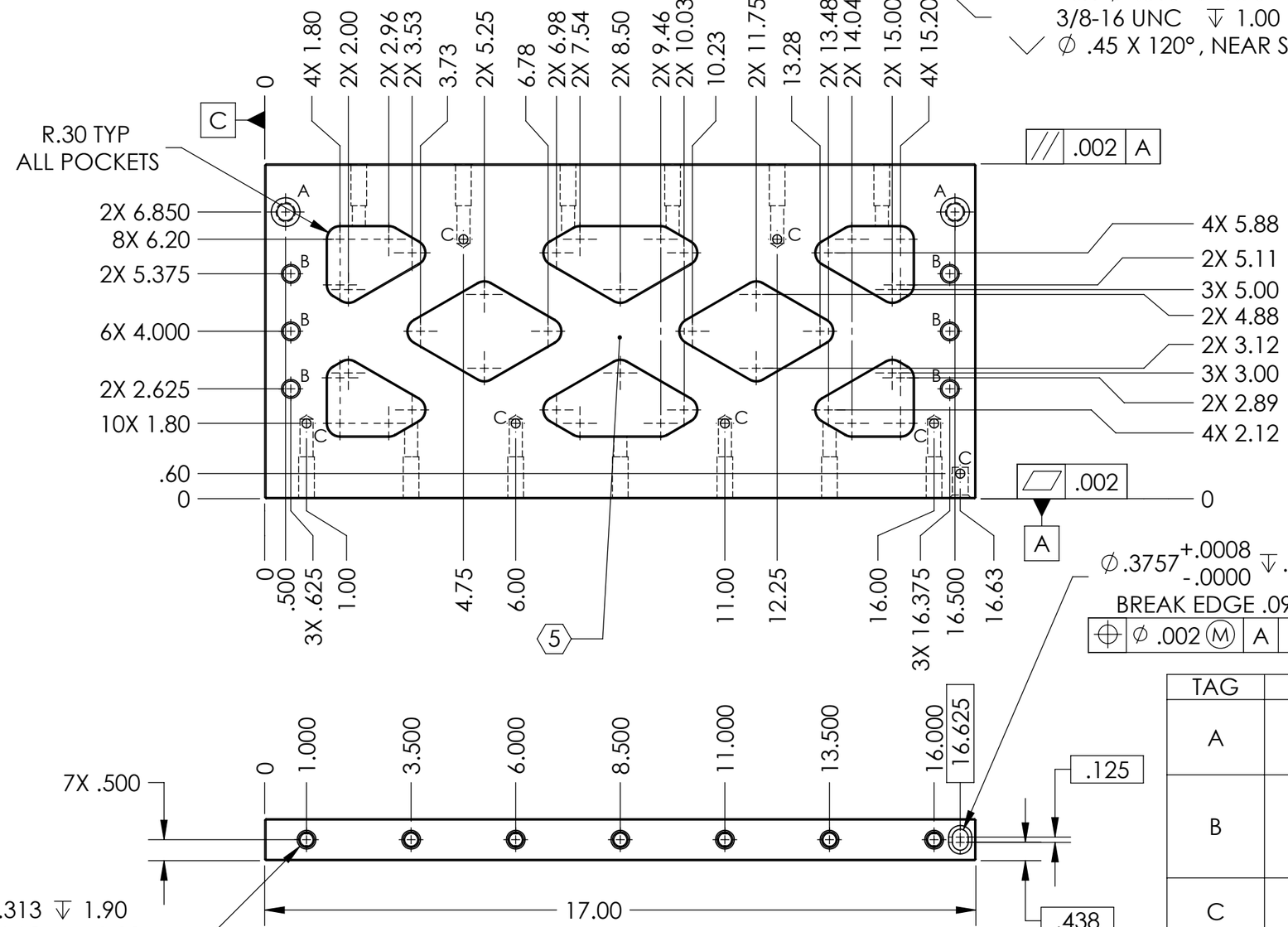
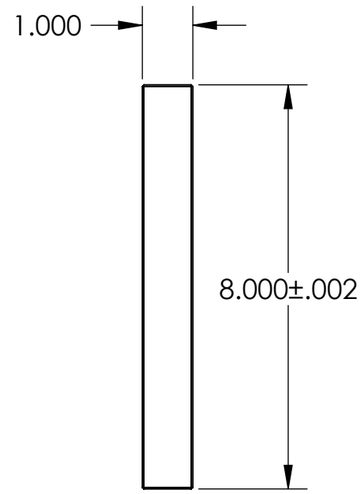
NOTES CONTINUED:

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. A VIBRATORY TOOL MAY BE USED.
6. APPROXIMATE WEIGHT = 9.8 LB.
7. A TRUE POSITION TOLERANCE OF Ø.010 IS ~ THE SAME AS A CONVENTIONAL TOLERANCE OF ±.005.
8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
9. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES.
10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E09000364.

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







TAG	SIZE	QUANTITY
A	Ø .406 THRU ALL ⌴ Ø .688 ↧ .50 Ø .46 X 90°, FAR SIDE	2
B	Ø .313 THRU ALL 3/8-16 UNC THRU ALL Ø .45 X 120°, NEAR SIDE Ø .45 X 120°, FAR SIDE	6
C	Ø .22 THRU ALL	7

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. 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.

MATERIAL 6061-T6 Al

FINISH 63 µinch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME Hex Wall, Lower, Large, aLIGO BSC ISI

SYSTEM ADVANCED LIGO

SUB-SYSTEM SEI

NEXT ASSY D0901181

DESIGNER	A.STEIN	11 Jan. 2010	
DRAFTER	M.HILLARD	11 Jan. 2010	
CHECKER	F.MATICHARD	11 Jan. 2010	
APPROVAL	K.MASON	11 Jan. 2010	

SIZE B **DWG. NO.** D0901524 **REV.** v1

SCALE: 1:3 **PROJECTION:** SHEET 1 OF 1

D0901524_Hex_Wall-Lower-Large-BSC_ISI, PART PDM REV: X-021, DRAWING PDM REV: X-008