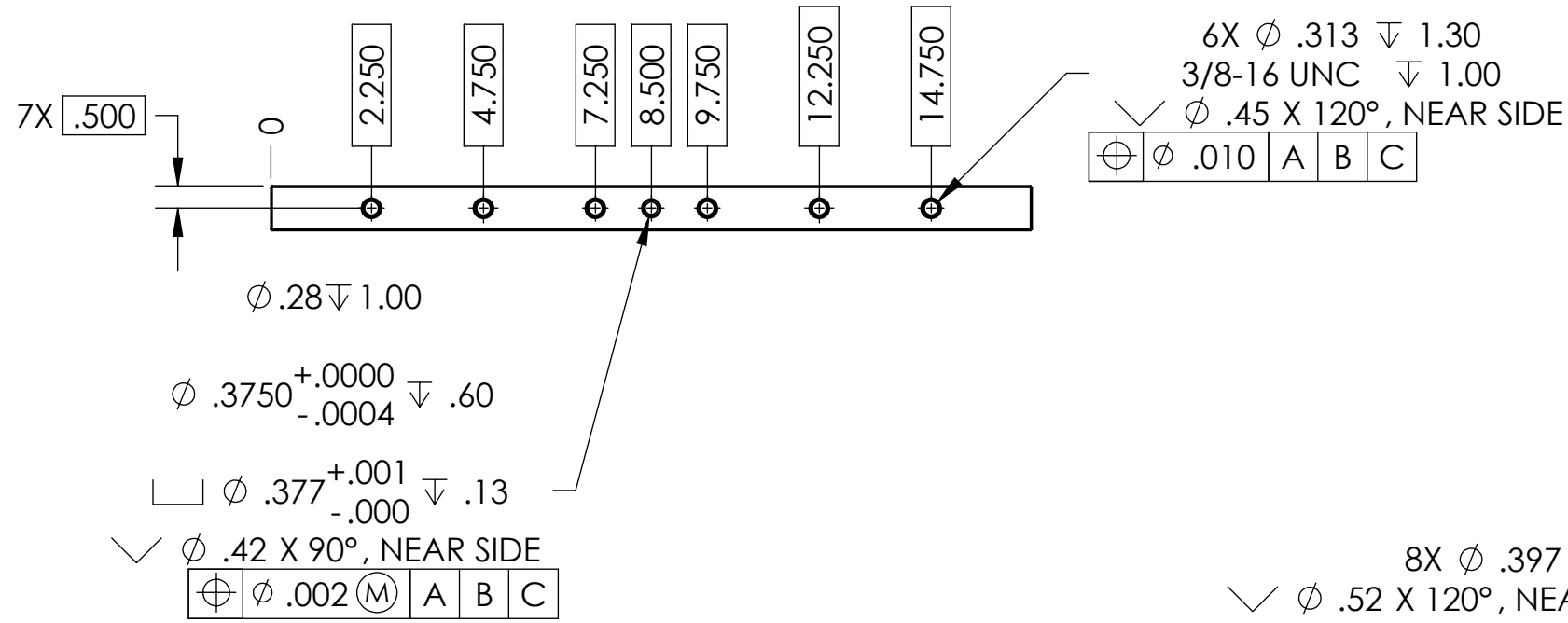


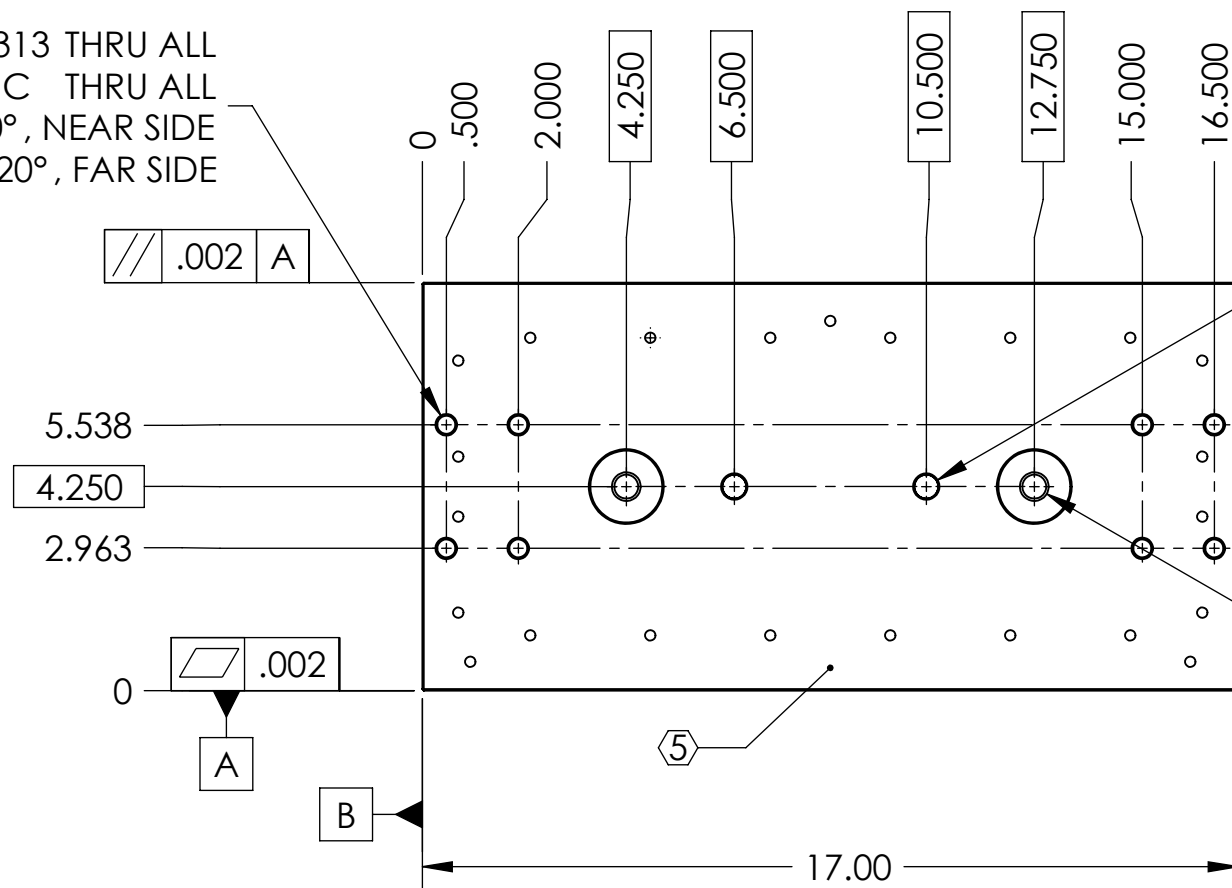
D0901533_Outer_Wall-Upper-BSC_ISI, PART PDM REV: X-036, DRAWING PDM REV: X-008

- 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 = 13.4 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.
 10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 11. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES.

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



8X Ø .313 THRU ALL
3/8-16 UNC THRU ALL
✓ Ø .45 X 120°, NEAR SIDE
✓ Ø .45 X 120°, FAR SIDE

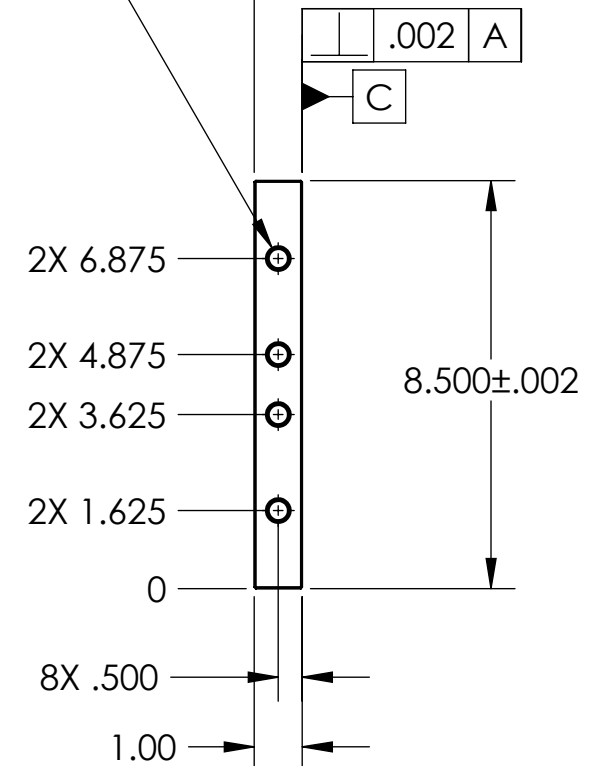


2X Ø .5000^{+.0000}_{-.0006} THRU ALL
 ✓ Ø .502^{+.001}_{-.000} 1.25
 ✓ Ø .55 X 90°, BOTH SIDES
 ⊕ Ø .010 (M) A B C

2X Ø .422 THRU ALL
 1/2-13 UNC THRU ALL
 ✓ Ø .60 X 120°, NEAR SIDE
 ✓ Ø .70 X 120°, FAR SIDE
 1.50 1.45
 ✓ 1.56 X 90°
 ⊕ Ø .010 A B C

8X Ø .397 1.00
 ✓ Ø .52 X 120°, NEAR SIDE
 TAP FOR 3/8-16
 HELICOIL INSERT = 1.0 * DIA.
 4 NEAR SIDE
 4 FAR SIDE

/// .005 C



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .015
 .XXX ± .005
 ANGULAR ± 0.5°

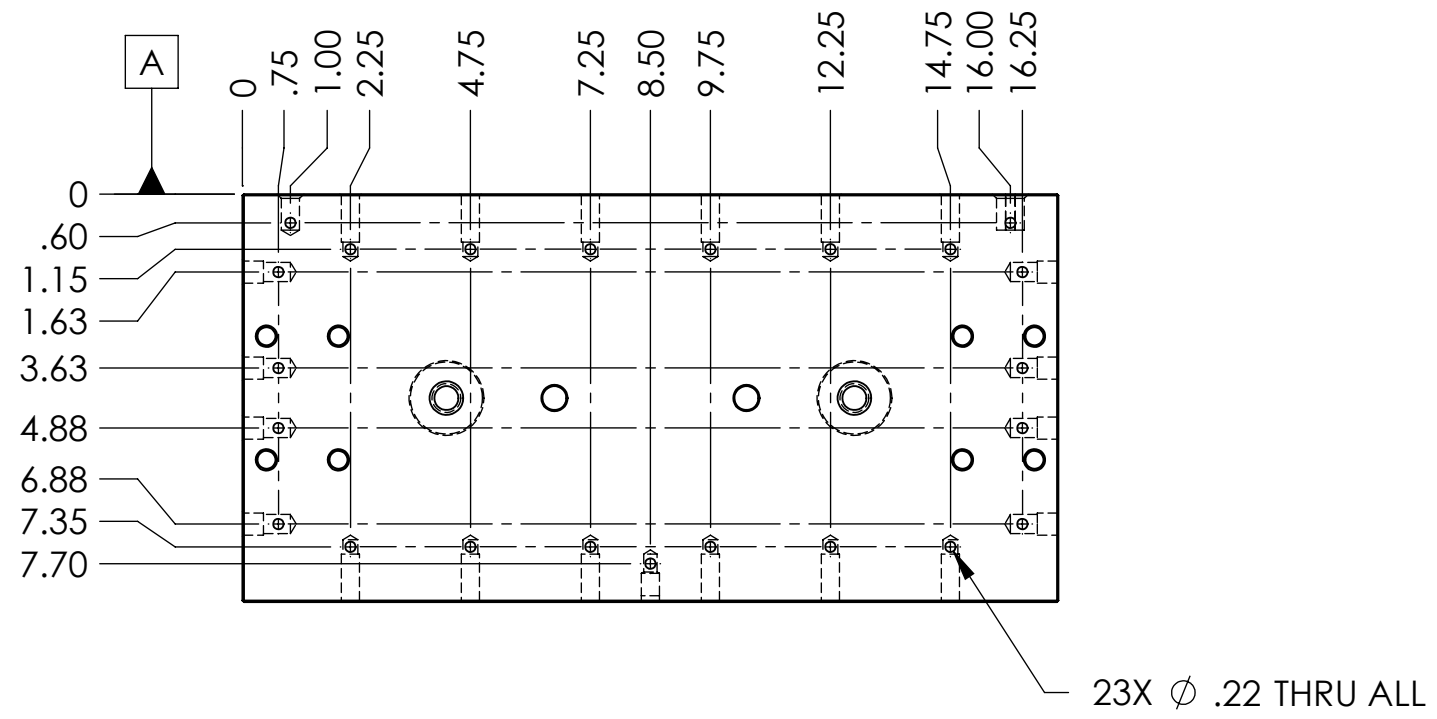
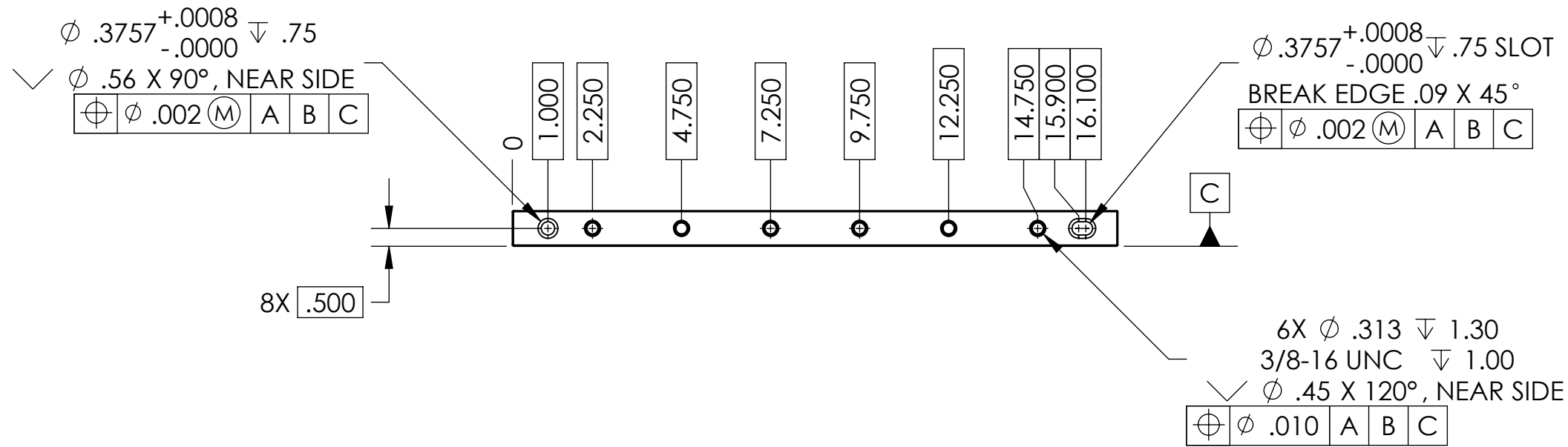
1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. BREAK ALL EDGES AND CORNERS .03 X 45°.
 3. DO NOT SCALE FROM DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL	6061-T6 Al	FINISH	63 μinch
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	SEI
NEXT ASSY		D1000053	

PART NAME				Outer Wall, Upper, aLIGO BSC ISI			
DESIGNER	A.STEIN	14 Jan. 2010	SIZE	DWG. NO.		REV.	
DRAFTER	M.HILLARD	14 Jan. 2010	B	D0901533		v1	
CHECKER	F.MATICHARD	14 Jan. 2010	SCALE:	1:4		PROJECTION:	ASME
APPROVAL	K.MASON	11 Jan. 2010	SHEET	1 OF 2			

D0901533_Outer_Wall-Upper-BSC_ISI, PART PDM REV: X-036, DRAWING PDM REV: X-008



 CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY
 SIZE DWG. NO. REV.
B D0901533 v1
 SCALE: 1:4 PROJECTION:  SHEET 2 OF 2