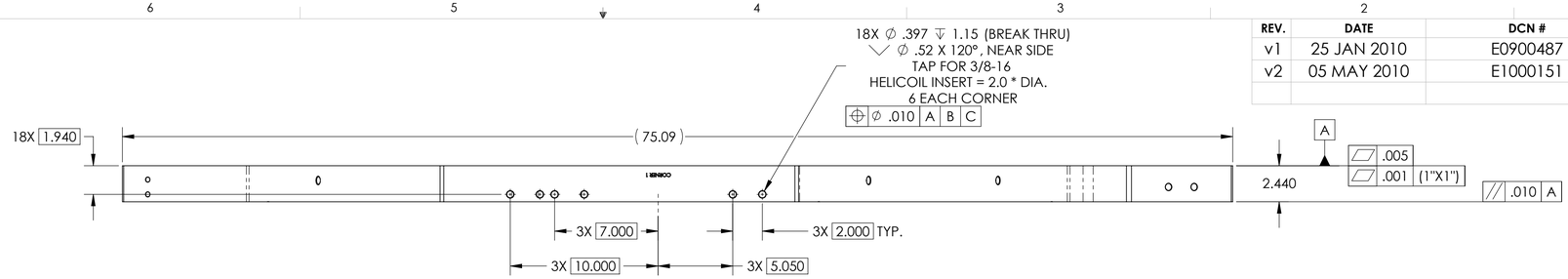
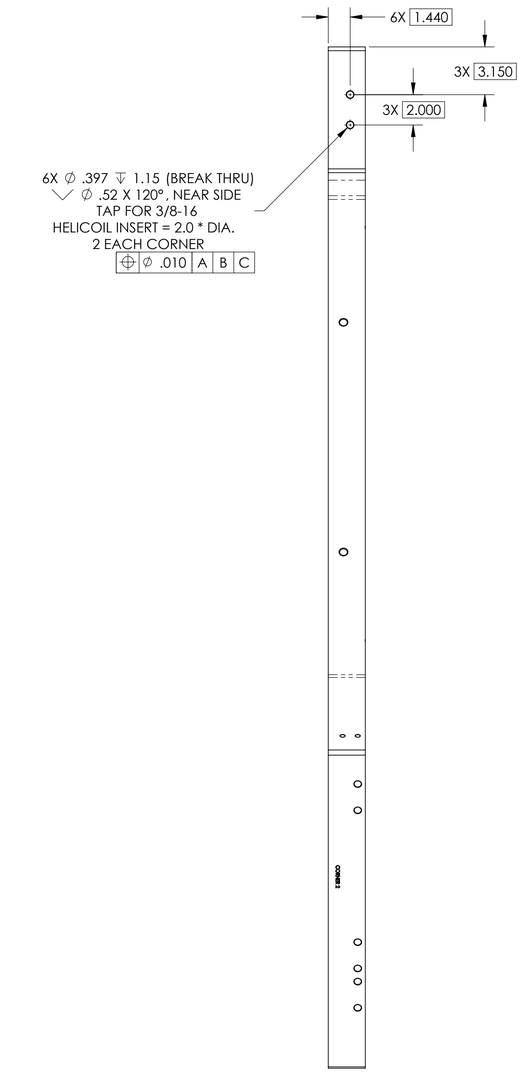
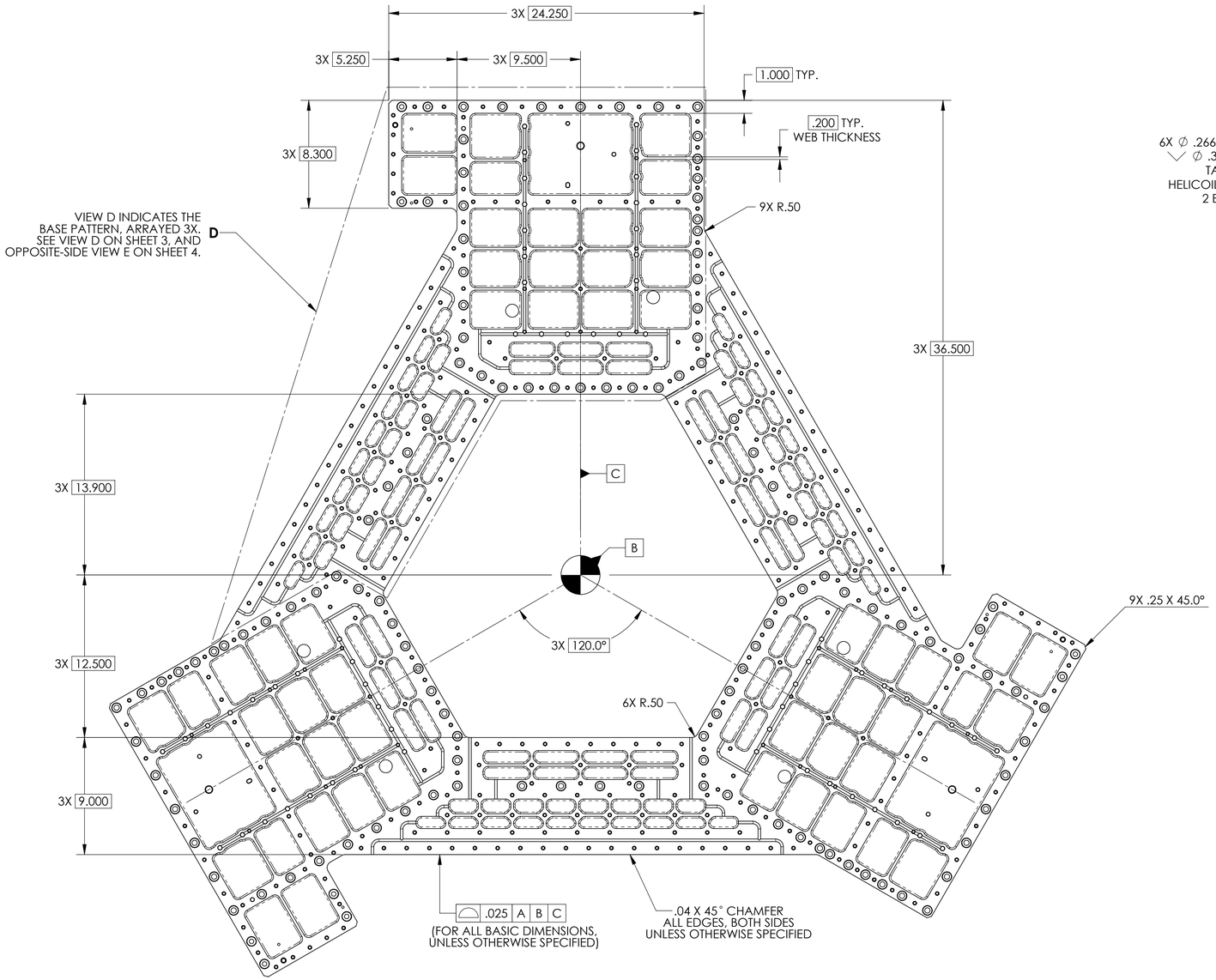
NOTES CONTINUED:

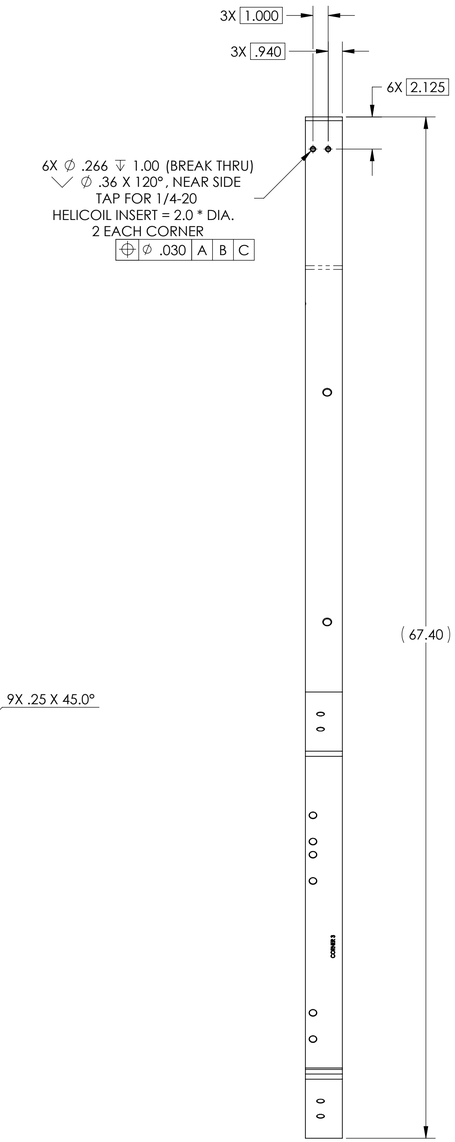
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE-DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 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 = 286 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.
13. ENGRAVE OR MECHANICALLY STAMP (NO INKS OR DYES) "CORNER 1," "CORNER 2," AND "CORNER 3," WHERE INDICATED ON DRAWING. USE 0.25" HIGH CHARACTERS.

REV.	DATE	DCN #	DRAWING TREE #
v1	25 JAN 2010	E0900487	E1000025
v2	05 MAY 2010	E1000151	E1000025



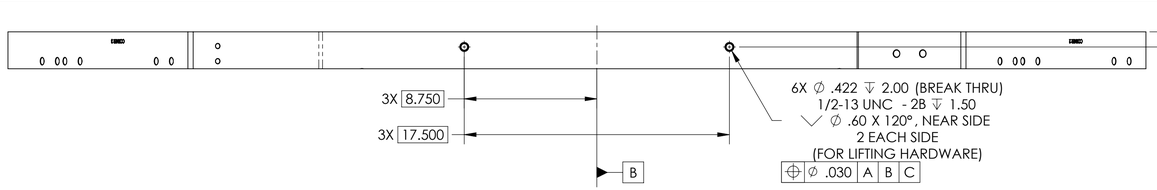


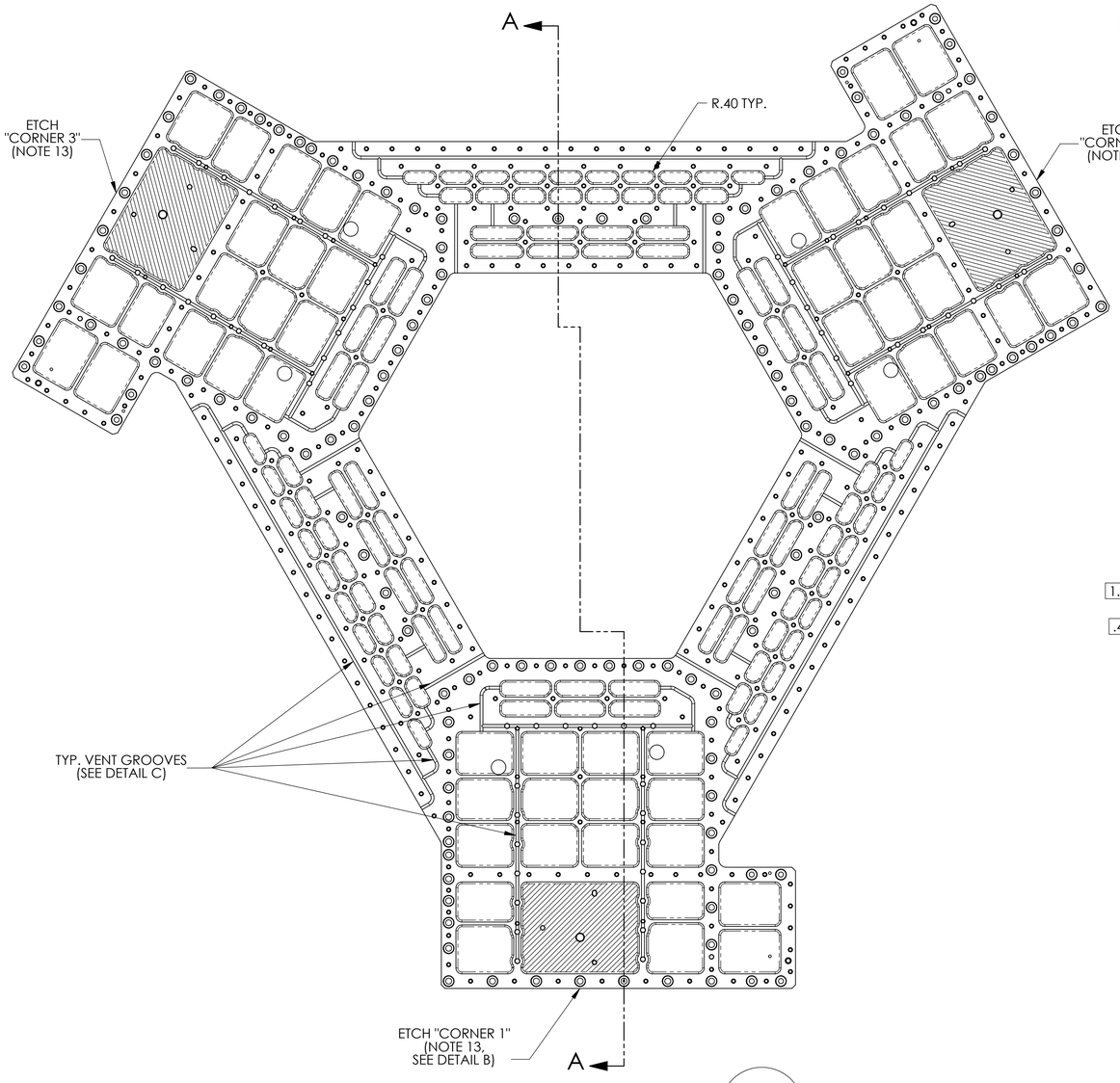


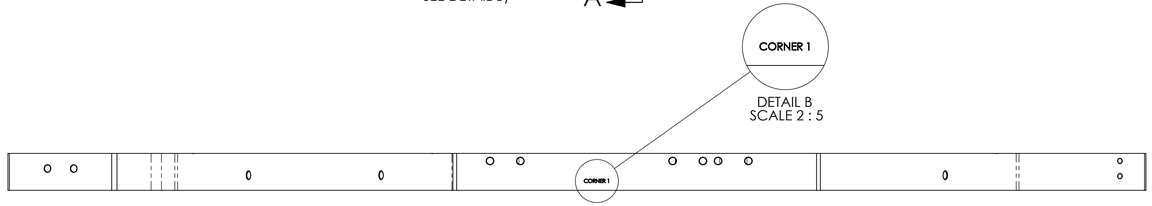


NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± .5°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. BREAK ALL EDGES AND SHARP CORNERS .03 X 45°. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: Close Out Plate, Stage 1 aLIGO BSC-ISI
	MATERIAL: 6061-T6 Al	FINISH: 63 µinch	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: SEI	
			NEXT ASSY: D0901180		

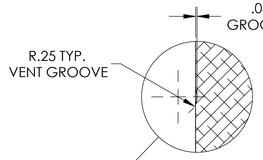
DESIGNER	F.MATICHARD	17 DEC 2009	SIZE: D	DWG. NO.: D0902273	REV.: v2
DRAFTER	M.HILLARD	17 DEC 2009			
CHECKER	A.STEIN	17 DEC 2009	SCALE: 1:5	PROJECTION:	SHEET 1 OF 4
APPROVAL	K.MASON	17 DEC 2009			



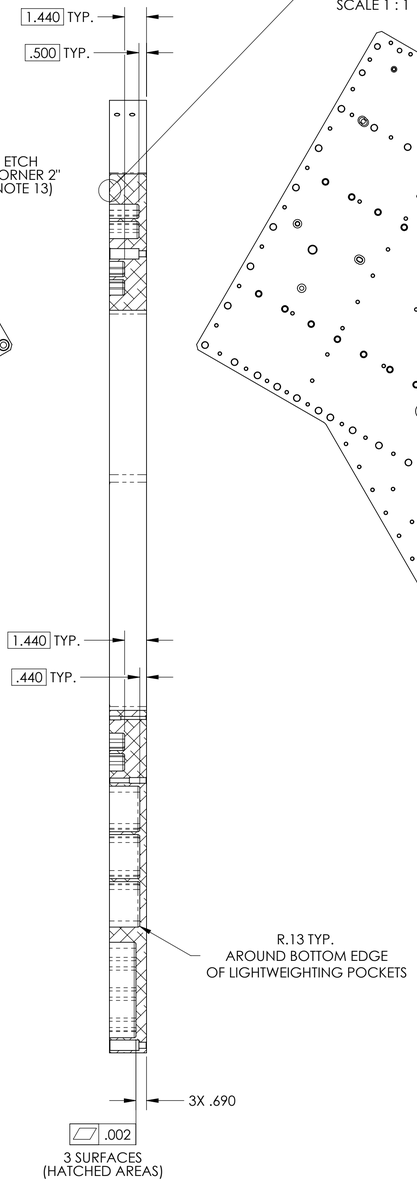




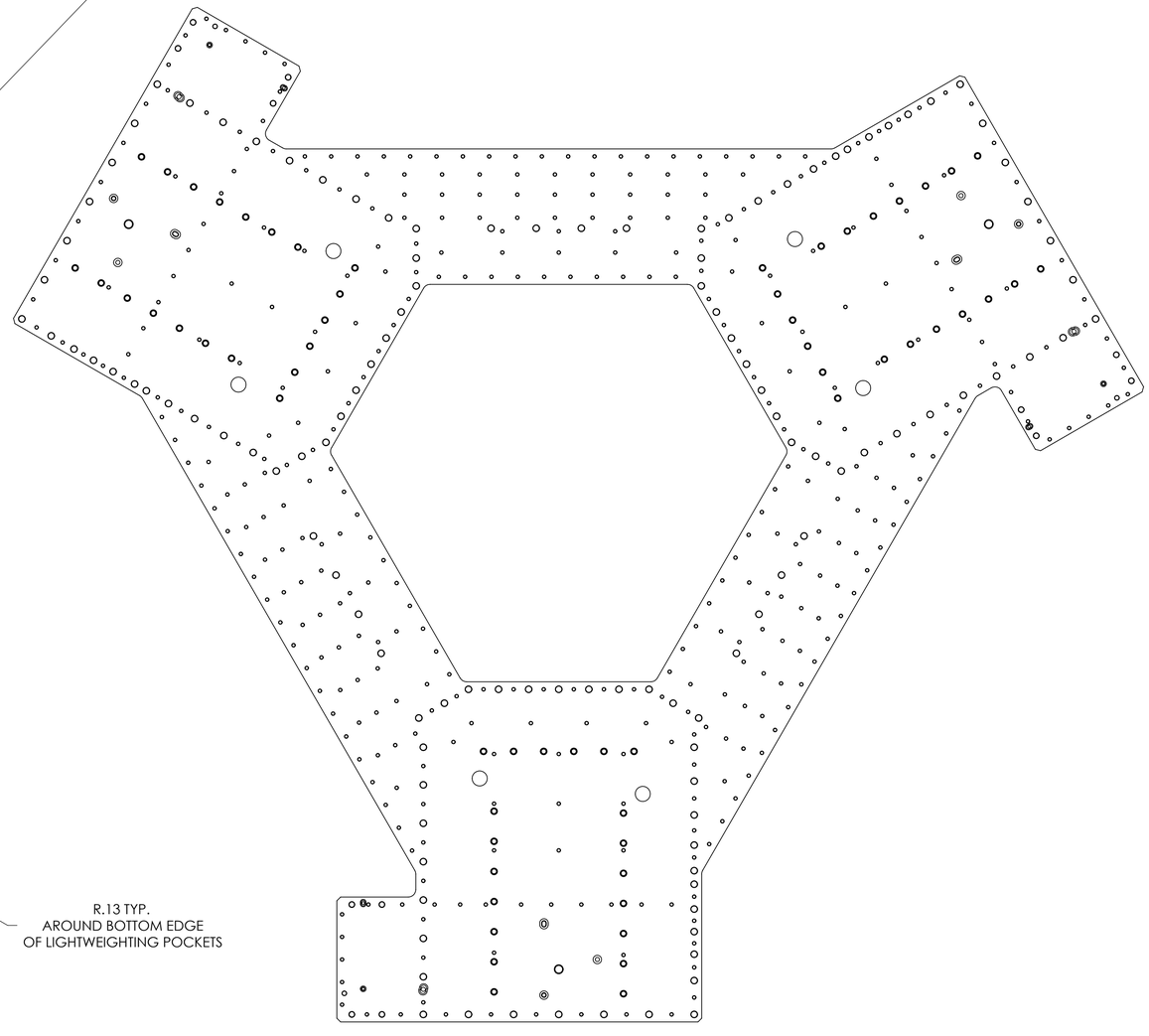
DETAIL B
SCALE 2 : 5



DETAIL C
SCALE 1 : 1



SECTION A-A



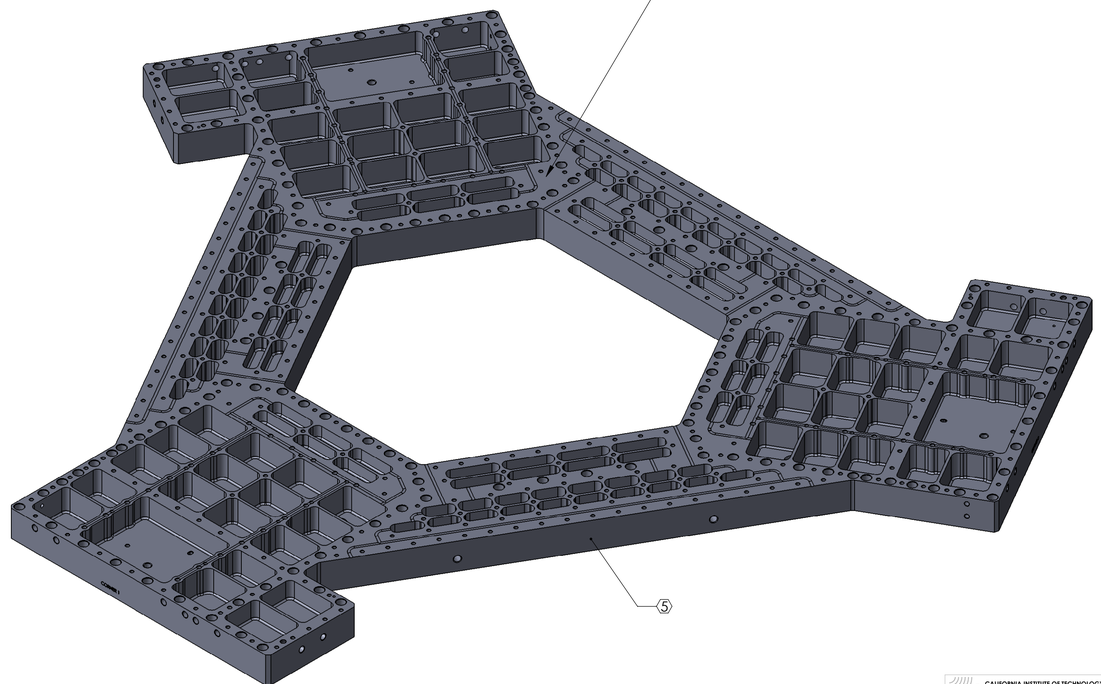
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
SIZE D | DWG. NO. D0902273 | REV. V2
SCALE: 1:5 | PROJECTION: | SHEET 2 OF 4

TAG	SIZE	QUANTITY	TOLERANCE
A	⌀ .201 THRU ALL 1/4-20 UNC ↧ .75 ⌵ ⌀ .30 X 120°, NEAR SIDE ⌵ ⌀ .25 X 90°, FAR SIDE	135	⌖ ⌀ .010 A B C NOTE 11
B	⌀ .344 THRU ALL ⌴ ⌀ .688 ↧ 1.94 ⌵ ⌀ .75 X 90°, NEAR SIDE ⌵ ⌀ .40 X 90°, FAR SIDE	4	⌖ ⌀ .010 Ⓜ A B C
C	⌀ .406 THRU ALL ⌴ ⌀ .688 ↧ 1.94 ⌵ ⌀ .75 X 90°, NEAR SIDE ⌵ ⌀ .46 X 90°, FAR SIDE	39	⌖ ⌀ .010 Ⓜ A B C
D	⌀ $.3750^{+.0000}_{-.0004}$ ↧ .60 ⌴ ⌀ $.377^{+.001}_{-.000}$ ↧ .13 ⌵ ⌀ .42 X 90°, NEAR SIDE ⌀.28 THRU (VENT) ⌵ ⌀.32 X 90°, FAR SIDE	1	⌖ ⌀ .002 Ⓜ A B C

HOLE PATTERN ARRAYED 3X

VIEW D
VIEW SHOWN INDICATES
THE BASE PATTERN ARRAYED 3X.

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

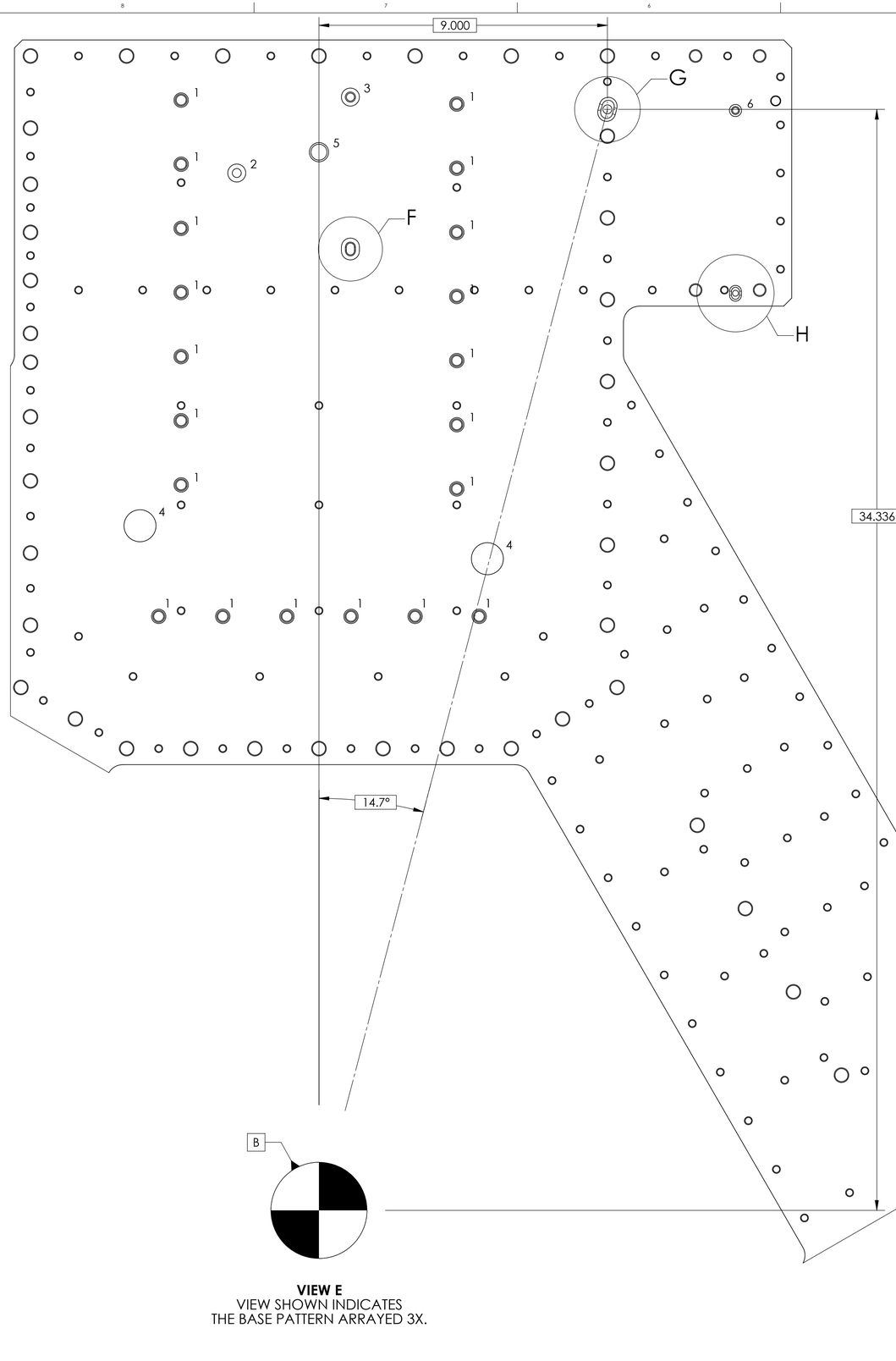


LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

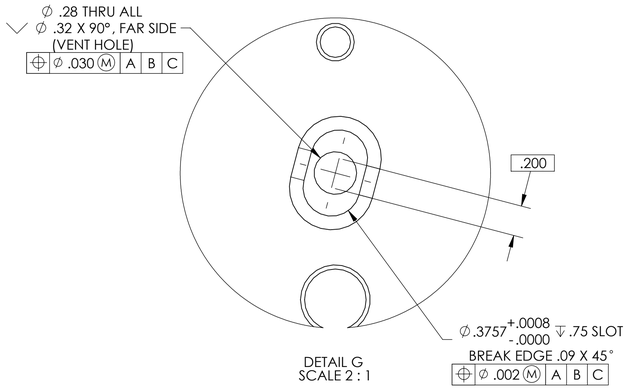
SIZE	DWG. NO.	REV.
D	D0902273	v2

SCALE: 1:5 | PROJECTION: | SHEET 3 OF 4

D0902273 Close Out Plate, Stage 1, BSC-ISI, PART PDM REV: X-093, DRAWING PDM REV: X-008



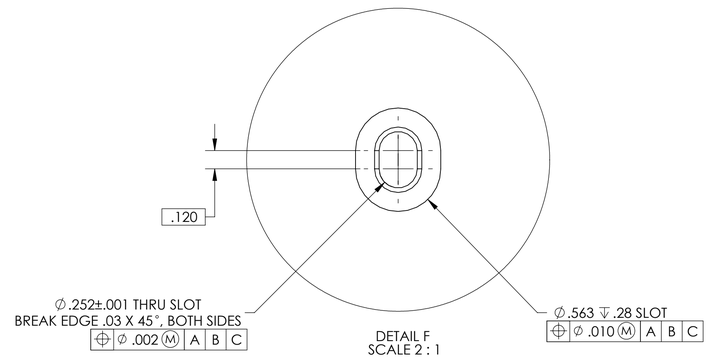
VIEW E
VIEW SHOWN INDICATES
THE BASE PATTERN ARRAYED 3X.



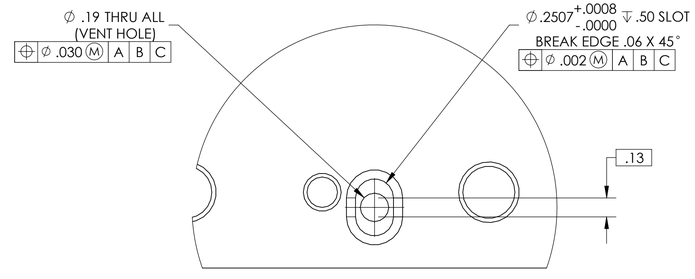
DETAIL G
SCALE 2 : 1

TAG	SIZE	QUANTITY	TOLERANCE
1	∅ .313 THRU ALL 3/8-16 UNC ↧ 1.13 ∨ ∅ .45 X 120°, NEAR SIDE ∨ ∅ .36 X 90°, FAR SIDE	20	⌖ ∅ .010 A B C NOTE 11
2	∅ .281 THRU ⌴ ∅ .563 ↧ .28 ∨ ∅ .32 X 90°, FAR SIDE	1	⌖ ∅ .005 Ⓜ A B C
3	∅ .252±.001 THRU ⌴ ∅ .563 ↧ .28 ∨ ∅ .32 X 90°, MID SIDE ∨ ∅ .32 X 90°, FAR SIDE	1	⌖ ∅ .002 Ⓜ A B C
4	∅ 1.00 THRU ALL	2	⌖ ∅ .030 Ⓜ A B C
5	∅ .422 THRU ALL 1/2-13 UNC - 2B THRU ALL ∨ ∅ .60 X 120°, NEAR SIDE ∨ ∅ .60 X 120°, FAR SIDE	1	⌖ ∅ .030 A B C FOR LIFTING HARDWARE
6	∅ .2507 +.0008 -.0000 ↧ .50 ∨ ∅ .38 X 90°, NEAR SIDE ∅ .19 THRU (VENT)	1	⌖ ∅ .002 Ⓜ A B C

HOLE PATTERN ARRAYED 3X



DETAIL F
SCALE 2 : 1



DETAIL H
SCALE 2 : 1

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SIZE	DWG. NO.	REV.
D	D0902273	V2

SCALE: 1:2 | PROJECTION: | SHEET 4 OF 4