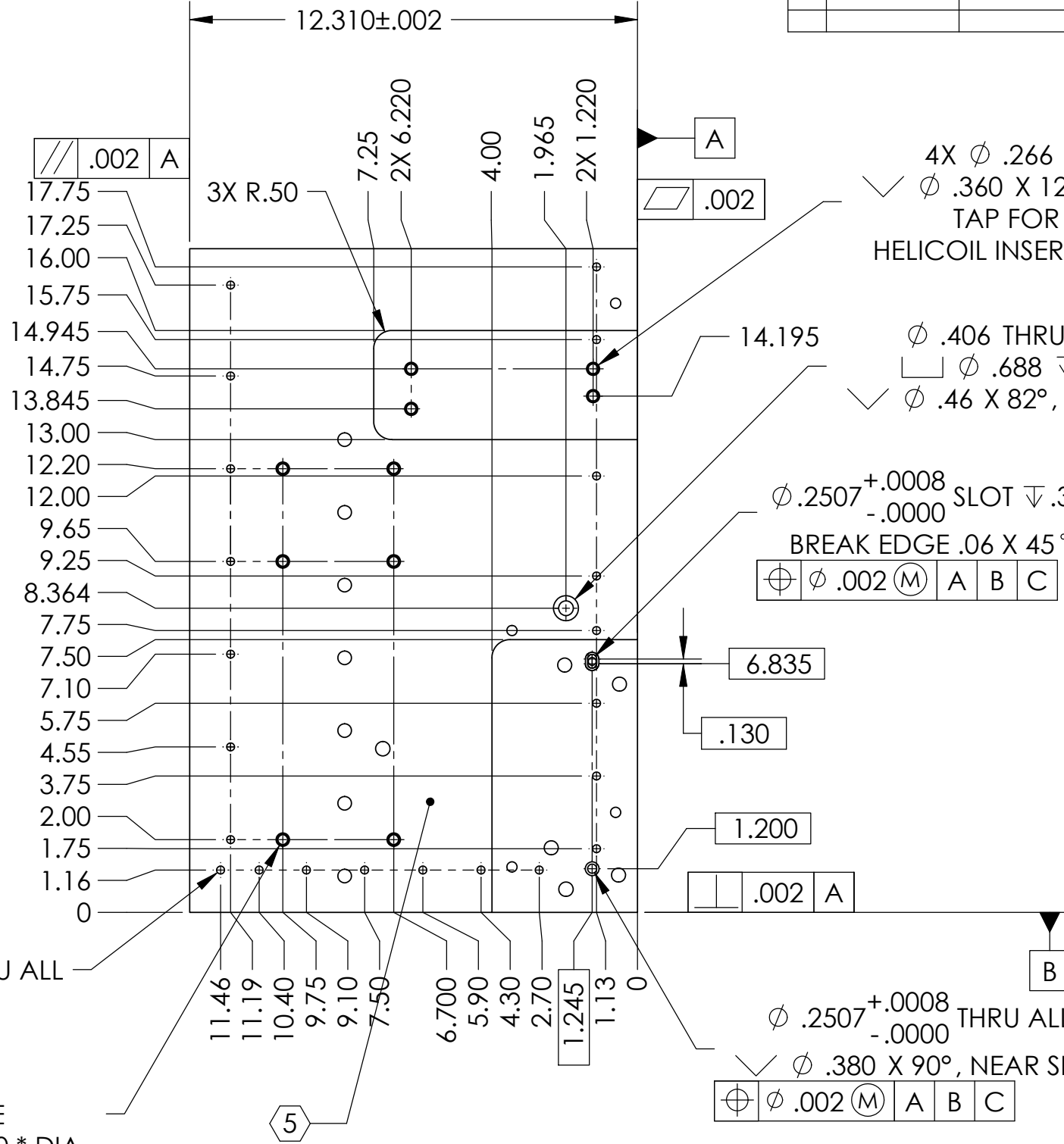
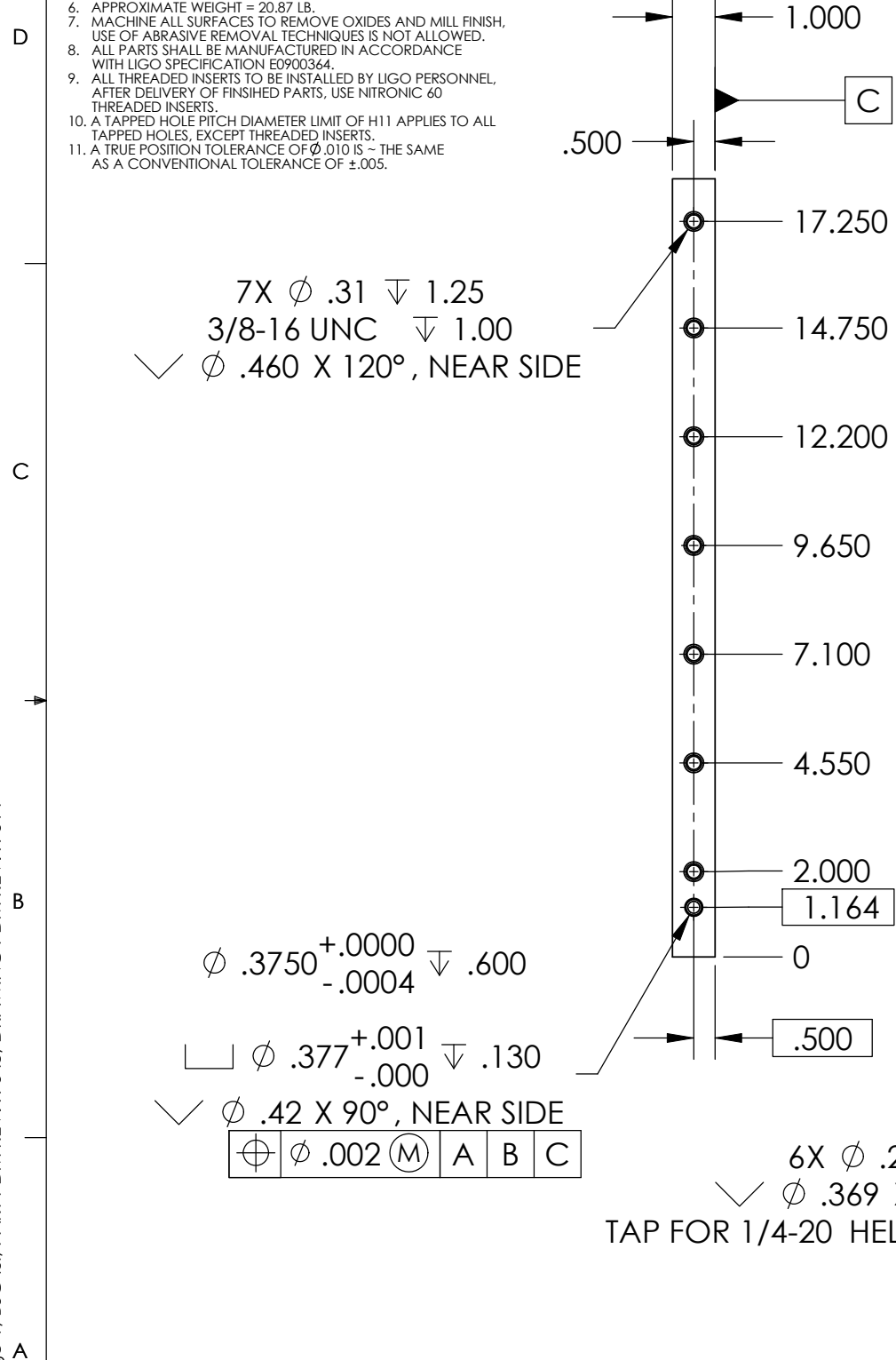


NOTES CONTINUED:

- 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 0.12 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. APPROXIMATE WEIGHT = 20.87 LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.
- 10. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES TO ALL TAPPED HOLES, EXCEPT THREADED INSERTS.
- 11. A TRUE POSITION TOLERANCE OF $\phi .010$ IS - THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.

REV.	DATE	DCN #	DRAWING TREE #
v1	12 Mar. 2010	E0900495	E1000025



4X $\phi .266$ THRU ALL
 $\phi .360 \times 120^\circ$, NEAR SIDE
 TAP FOR 1/4-20
 HELICOIL INSERT = 2.0 * DIA.

$\phi .406$ THRU ALL
 $\phi .688 \nabla .50$
 $\phi .46 \times 82^\circ$, FAR SIDE

$\phi .2507^{+.0008}_{-.0000}$ SLOT $\nabla .38$
 BREAK EDGE .06 X 45°
 $\phi .002$ (M) A B C

BOTTOM VIEW
 SHEET 2

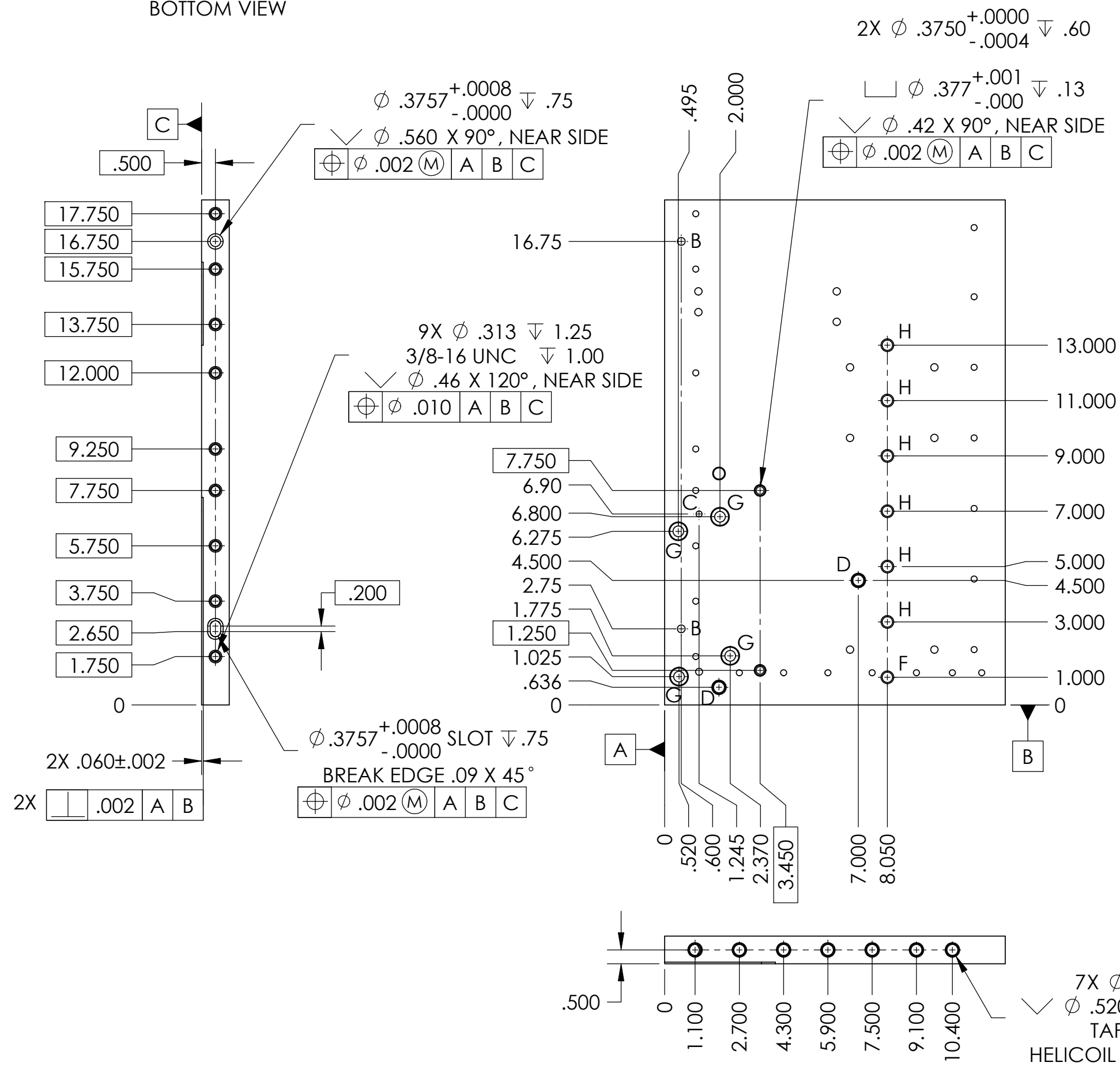
$\phi .2507^{+.0008}_{-.0000}$ THRU ALL
 $\phi .380 \times 90^\circ$, NEAR SIDE
 $\phi .002$ (M) A B C

D0902278 L4C Wall, Stage 1, BSC-ISI, PART PDM REV: X-043, DRAWING PDM REV: X-014

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX \pm .015 .XXX \pm .005 ANGULAR \pm .5°				CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		L4C WALL, STAGE 1, aLIGO BSC ISI	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 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	SUB-SYSTEM SEI	DESIGNER F.MATICHARD 15 Jan. 2010	SIZE DWG. NO. B D0902278
MATERIAL 6061-T6 Al				FINISH 63 μ inch		DRAFTER M.HILLARD 15 Jan. 2010	REV. v1
NEXT ASSY D0901180				CHECKER A.STEIN 15 Jan. 2010	APPROVAL K.MASON 15 Jan. 2010	SCALE: 1:4	PROJECTION: SHEET 1 OF 2

D0902278 L4C Wall, Stage 1, BSC-ISI, PART PDM REV: X-043, DRAWING PDM REV: X-014

BOTTOM VIEW



TAG	SIZE	QUANTITY
B	$\phi .28$ THRU ALL	2
C	$\phi .22$ THRU TO SLOT	1
D	$\phi .397$ THRU ALL $\phi .52 \times 120^\circ$, NEAR SIDE TAP FOR $3/8-16$ HELICOIL INSERT = $2.0 \times \text{DIA.}$	2
F	$\phi .313$ THRU ALL $3/8-16 \text{ UNC}$ THRU ALL $\phi .46 \times 120^\circ$, NEAR SIDE	1
G	$\phi .386$ THRU ALL $\phi .625 \nabla .375$ $\phi .68 \times 90^\circ$, NEAR SIDE	4

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D0902278	v1
SCALE: 1:4	PROJECTION:	SHEET 2 OF 2