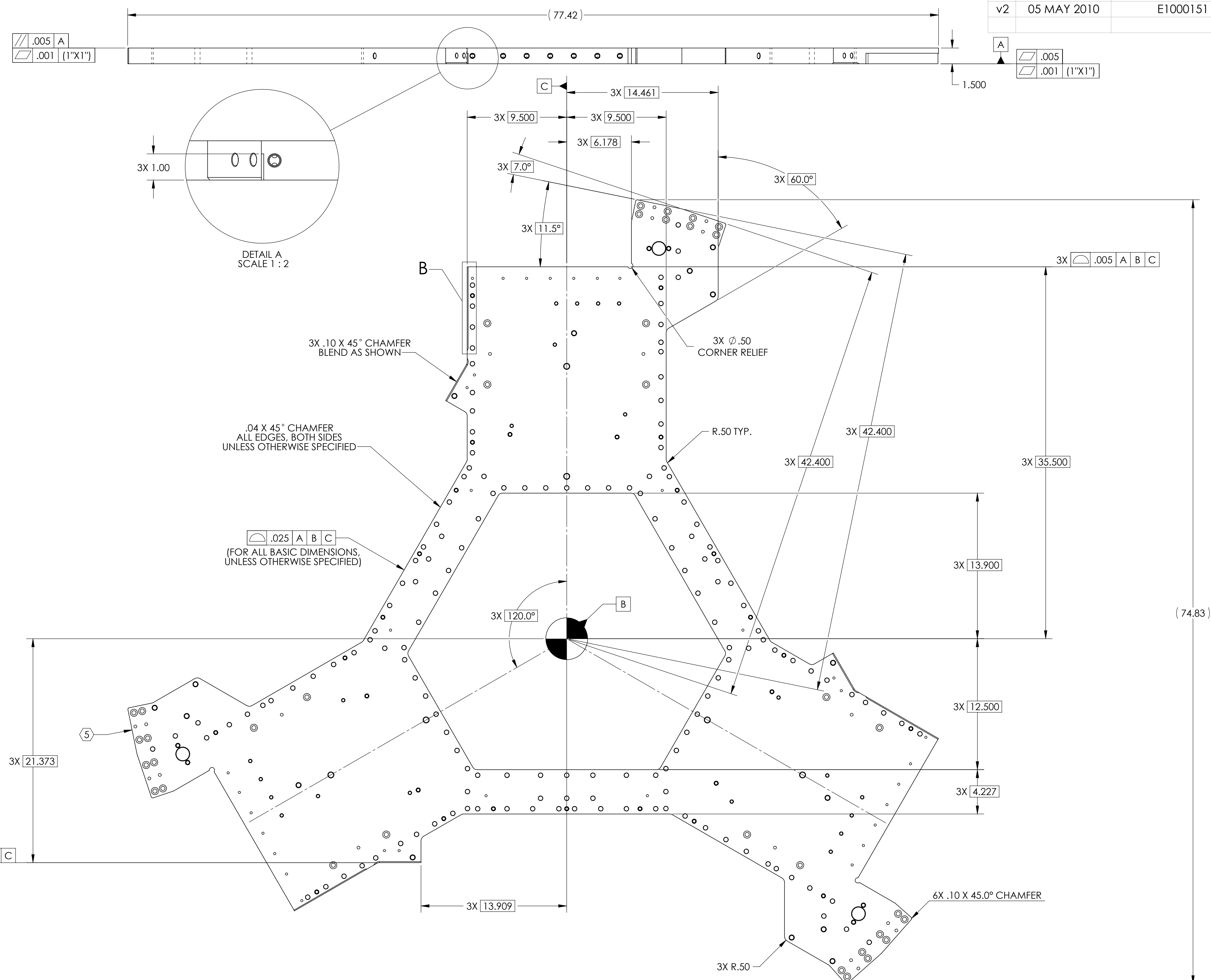


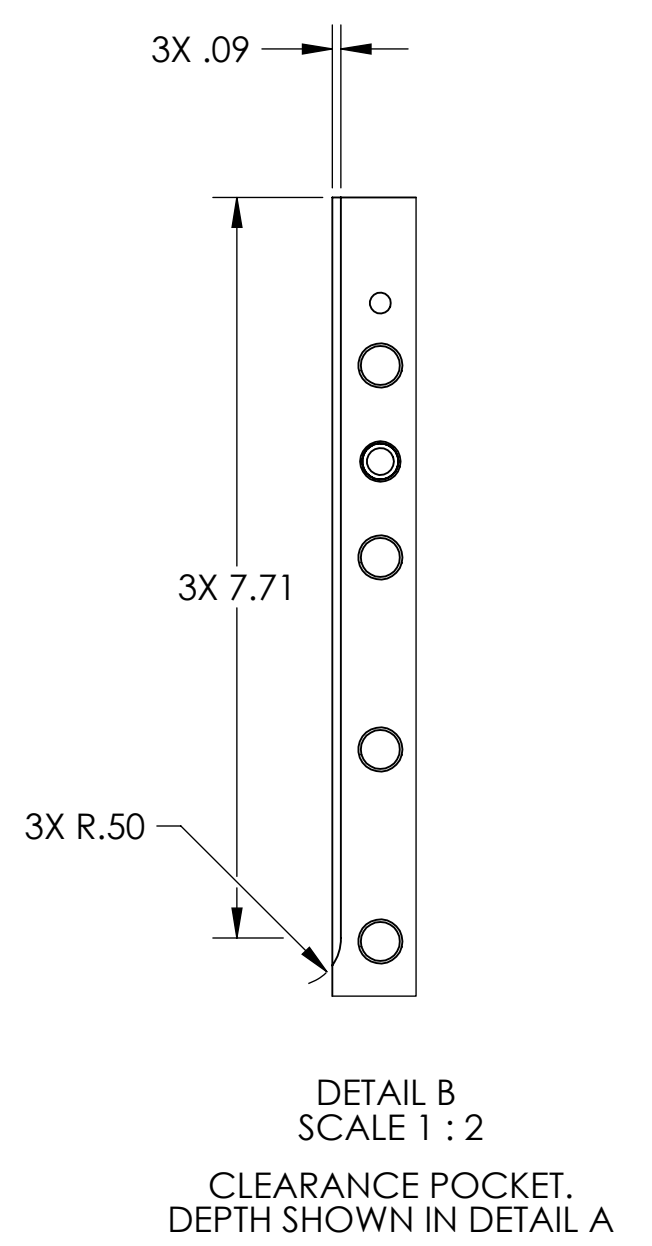
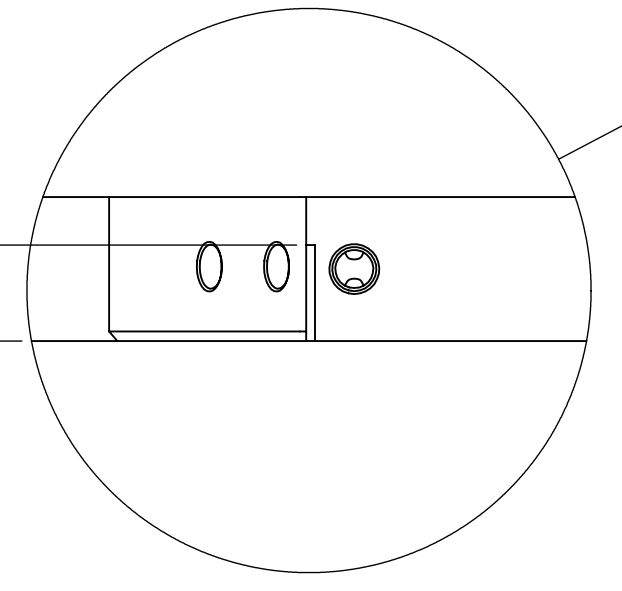
REV.	DATE	DCN #	DRAWING TREE #
v1	25 JAN 2010	E0900487	E1000025
v2	05 MAY 2010	E1000151	E1000025

- 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 DXXXXXX-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 = 232 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.



$\sqrt{\text{A}}$.005
$\sqrt{\text{B}}$.001 (1"X1")

$\sqrt{\text{A}}$.005
$\sqrt{\text{B}}$.001 (1"X1")



$\sqrt{\text{A}}$.025	A	B	C
-------------------	------	---	---	---

(FOR ALL BASIC DIMENSIONS, UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ± .015
 .XXX ± .005
 ANGULAR ± .5°

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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.

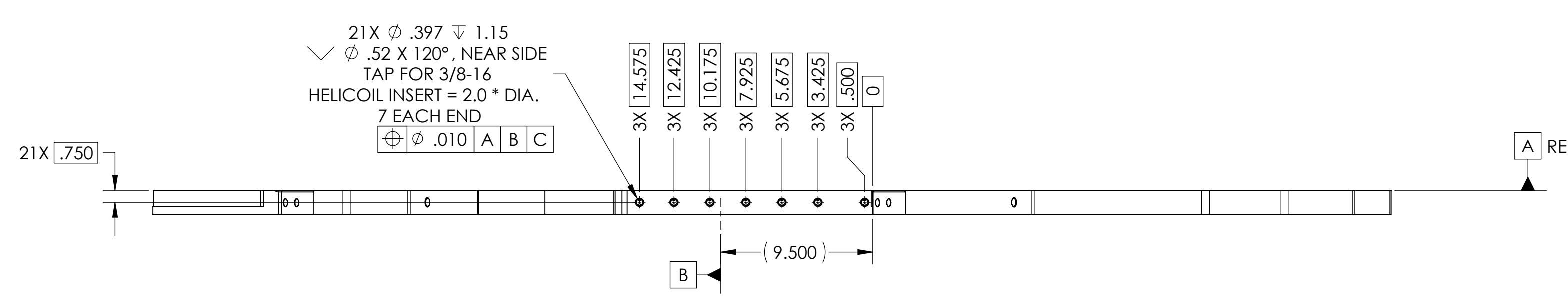
MATERIAL 6061-T6 Al **FINISH** 63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO **SUB-SYSTEM** SEI

NEXT ASSY D0901180

PART NAME		DESIGNER		SIZE		DWG. NO.		REV.
Base Plate, Stage 1, aLIGO BSC-ISI		F.MATCHARD	28 DEC 2009	D	D0902279			v2
DRAFTER	M.HILLARD	28 DEC 2009						
CHECKER	A.STEIN	28 DEC 2009						
APPROVAL	K.MASON	28 DEC 2009	SCALE: 1:5	PROJECTION:			SHEET 1 OF 3	

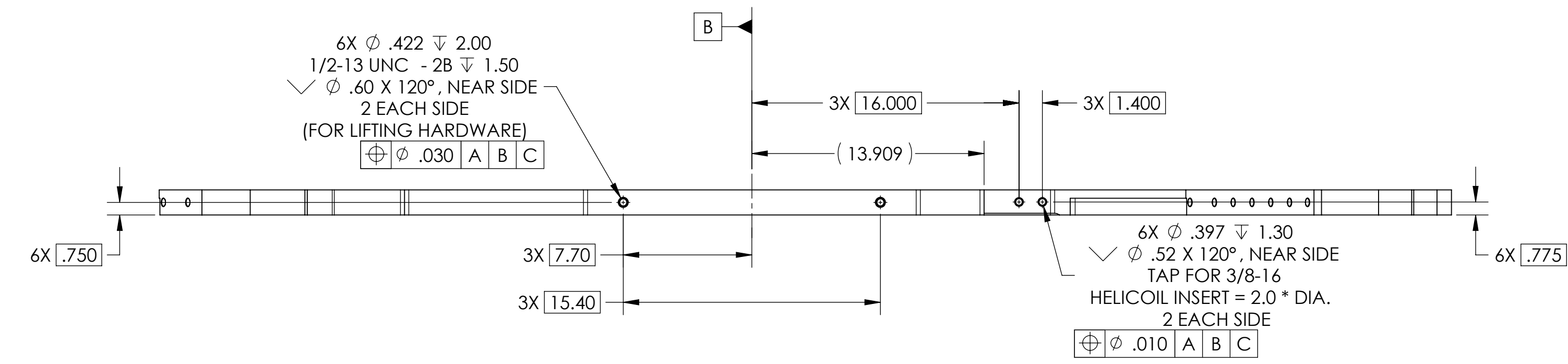
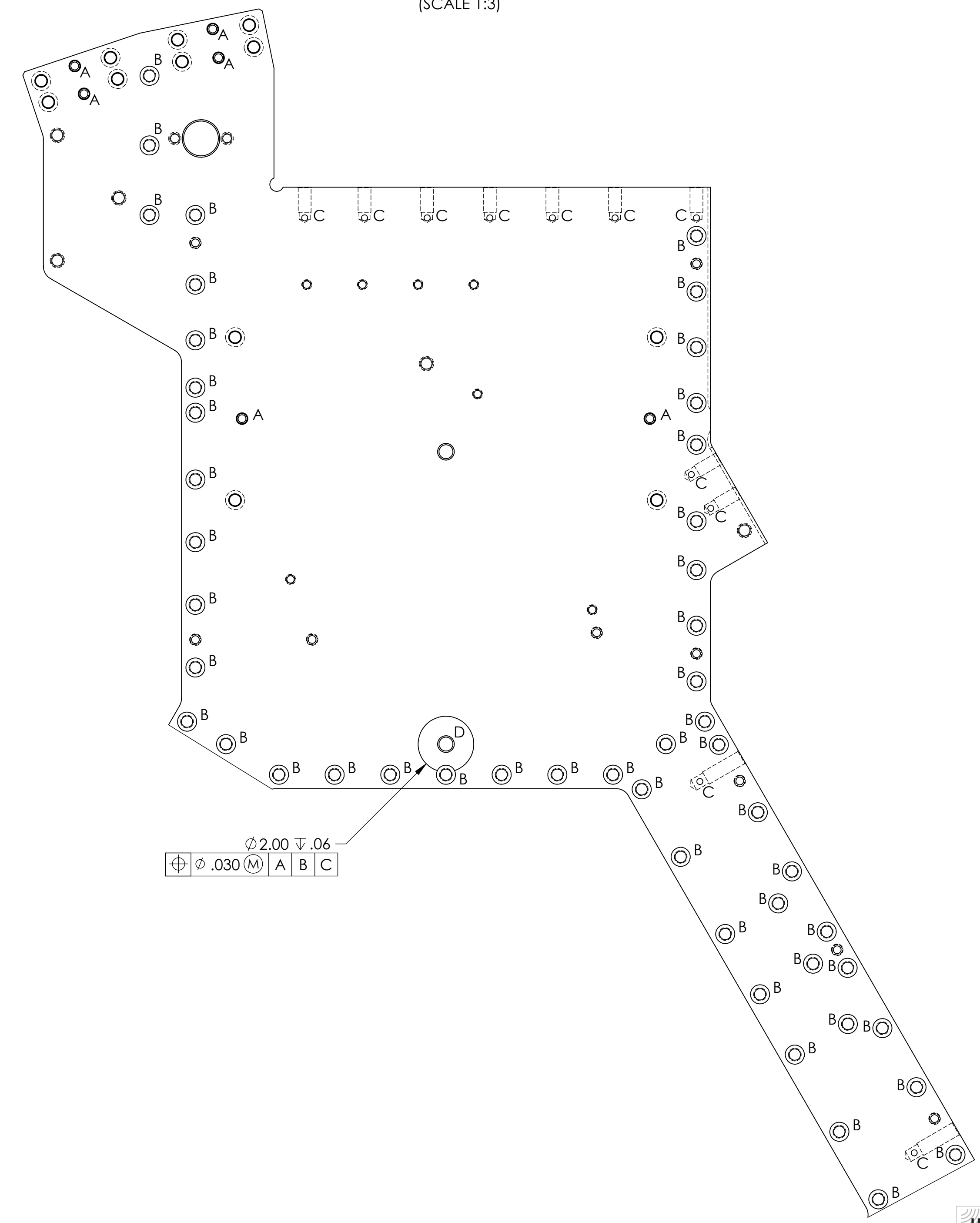
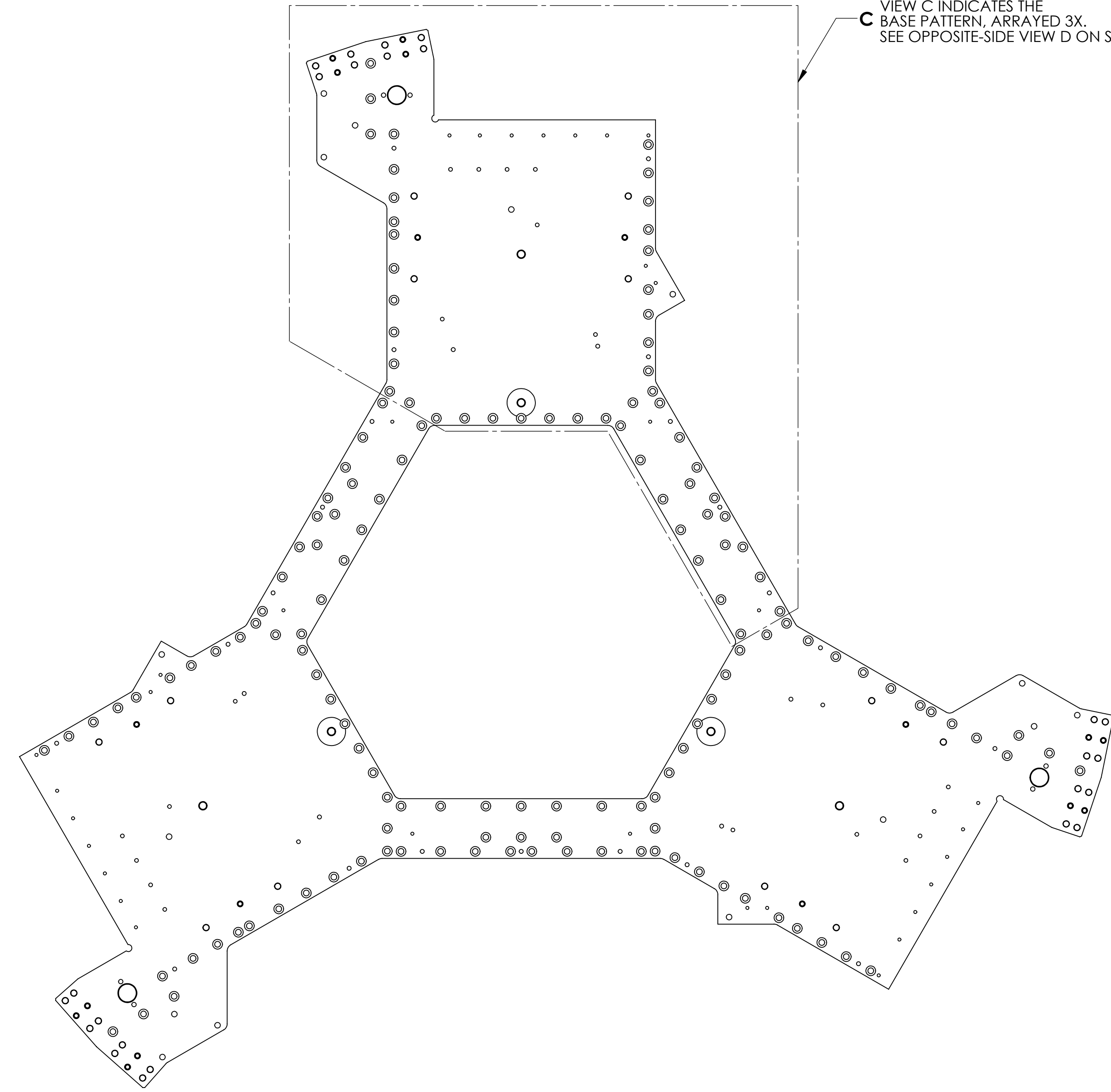


TAG	SIZE	QUANTITY	TOLERANCE
A	$\phi .3750^{+0.0000}_{-.0004} \downarrow .60$ $\square \phi .377^{+0.001}_{-.000} \downarrow .13$ $\checkmark \phi .42 \times 90^\circ$, NEAR SIDE $\phi .28$ THRU (VENT)	6	$\oplus \phi .002 (M) A B C$
B	$\phi .406$ THRU ALL $\checkmark \phi .688 \downarrow 1.00$ $\phi .46 \times 90^\circ$, FAR SIDE	50	$\oplus \phi .010 (M) A B C$
C	$\phi .22$ THRU ALL	11	$\oplus \phi .030 (M) A B C$ VENT HOLE
D	$\phi .422$ THRU ALL $1/2-13$ UNC THRU ALL $\checkmark \phi .60 \times 120^\circ$, NEAR SIDE $\phi .60 \times 120^\circ$, FAR SIDE	1	$\oplus \phi .030 A B C$ NOTE 11

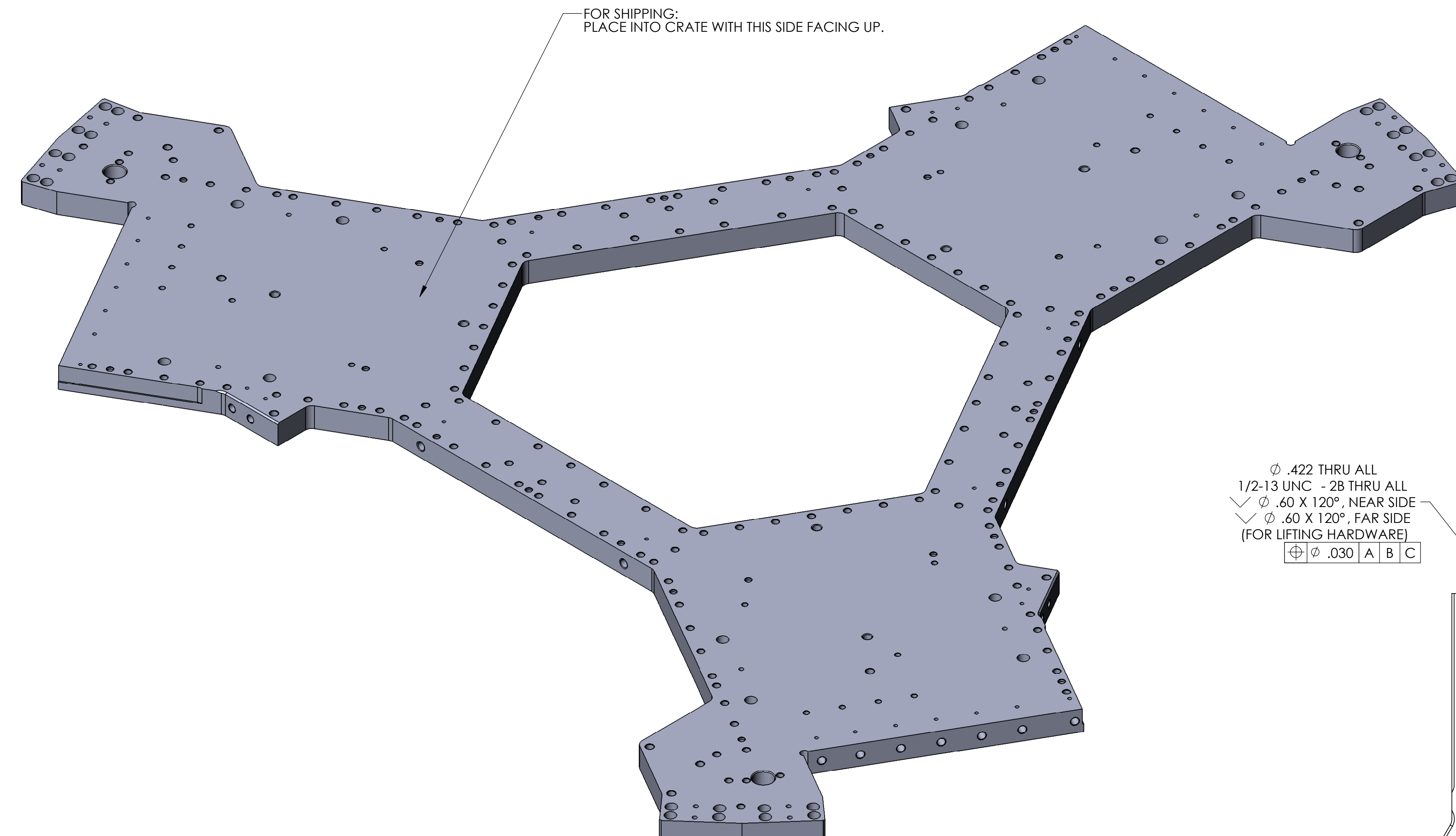
HOLE PATTERN ARRAYED 3X

VIEW C INDICATES THE
BASE PATTERN, ARRAYED 3X.
SEE OPPOSITE-SIDE VIEW D ON SHEET 3.

VIEW C
VIEW SHOWN INDICATES
THE BASE PATTERN ARRAYED 3X
(SCALE 1:3)



D0902279 Base Plate_Stage1.dwg BSC:SI PART PDM REV: X-089 DRAWING PDM REV: X-022



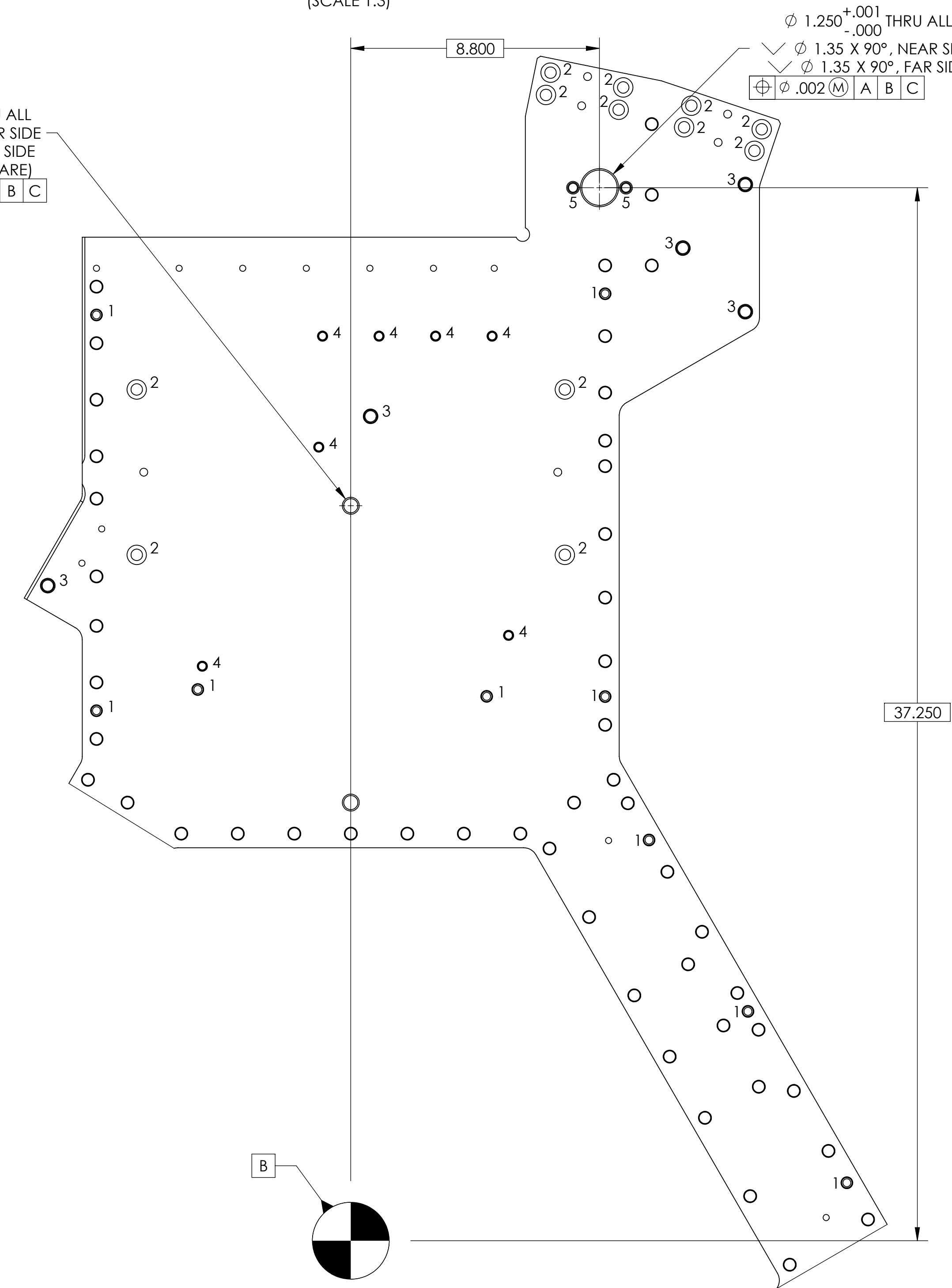
TAG	SIZE	QUANTITY	TOLERANCE
1	$\phi .3750^{+.0000}_{-.0004} \downarrow .60$ $\sqsupset \phi .377^{+.001}_{-.000} \downarrow .13$ $\surd \phi .42 \times 90^\circ$, NEAR SIDE $\phi .28$ THRU (VENT)	9	$\oplus \phi .002 \text{ (M)} \text{ A B C}$
2	$\phi .406$ THRU ALL $\sqsupset \phi .688 \downarrow 1.00$ $\surd \phi .46 \times 90^\circ$, FAR SIDE	12	$\oplus \phi .010 \text{ (M)} \text{ A B C}$
3	$\phi .397$ THRU ALL $\surd \phi .52 \times 120^\circ$, NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA.	5	$\oplus \phi .010 \text{ A B C}$
4	$\phi .266$ THRU ALL $\surd \phi .36 \times 120^\circ$, NEAR SIDE TAP FOR 1/4-20 HELICOIL INSERT = 2.0 * DIA.	7	$\oplus \phi .010 \text{ A B C}$
5	$\phi .313$ THRU ALL 3/8-16 UNC $\downarrow 1.13$ $\surd \phi .45 \times 120^\circ$, NEAR SIDE	2	$\oplus \phi .005 \text{ A B C}$ NOTE 11

HOLE PATTERN ARRAYED 3X

VIEW D
 VIEW SHOWN INDICATES
 THE BASE PATTERN ARRAYED 3X
 (SCALE 1:3)

$\phi .422$ THRU ALL
 1/2-13 UNC - 2B THRU ALL
 $\surd \phi .60 \times 120^\circ$, NEAR SIDE
 $\surd \phi .60 \times 120^\circ$, FAR SIDE
 (FOR LIFTING HARDWARE)
 $\oplus \phi .030 \text{ A B C}$

$\phi 1.250^{+.001}_{-.000}$ THRU ALL
 $\surd \phi 1.35 \times 90^\circ$, NEAR SIDE
 $\surd \phi 1.35 \times 90^\circ$, FAR SIDE
 $\oplus \phi .002 \text{ (M)} \text{ A B C}$



D0902279 Base Plate_Stage1.dwg BSC-ISI PART PDM REV. X-089 DRAWING PDM REV. X-022