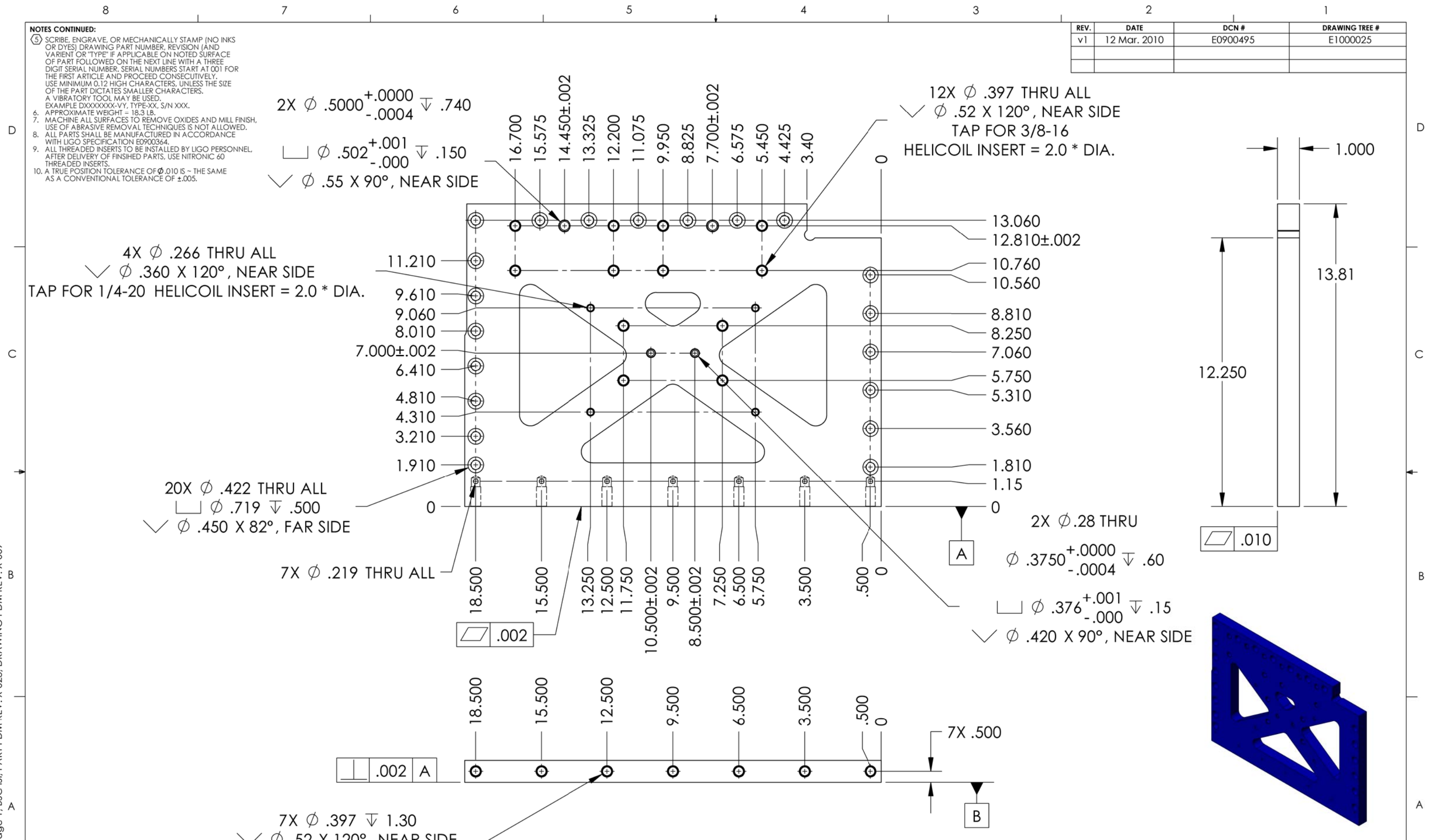


D0902281 Door, Stage 1, BSC ISI, PART PDM REV: X-023, DRAWING PDM REV: X-009

- NOTES CONTINUED:
- 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.
 - APPROXIMATE WEIGHT = 18.3 LB.
 - MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 - ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.
 - 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



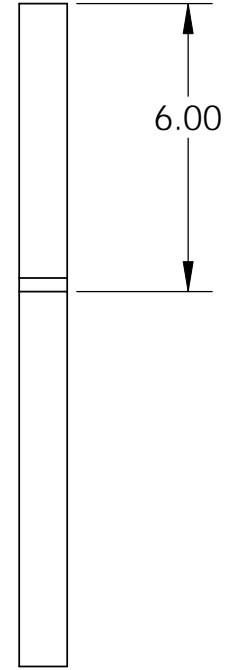
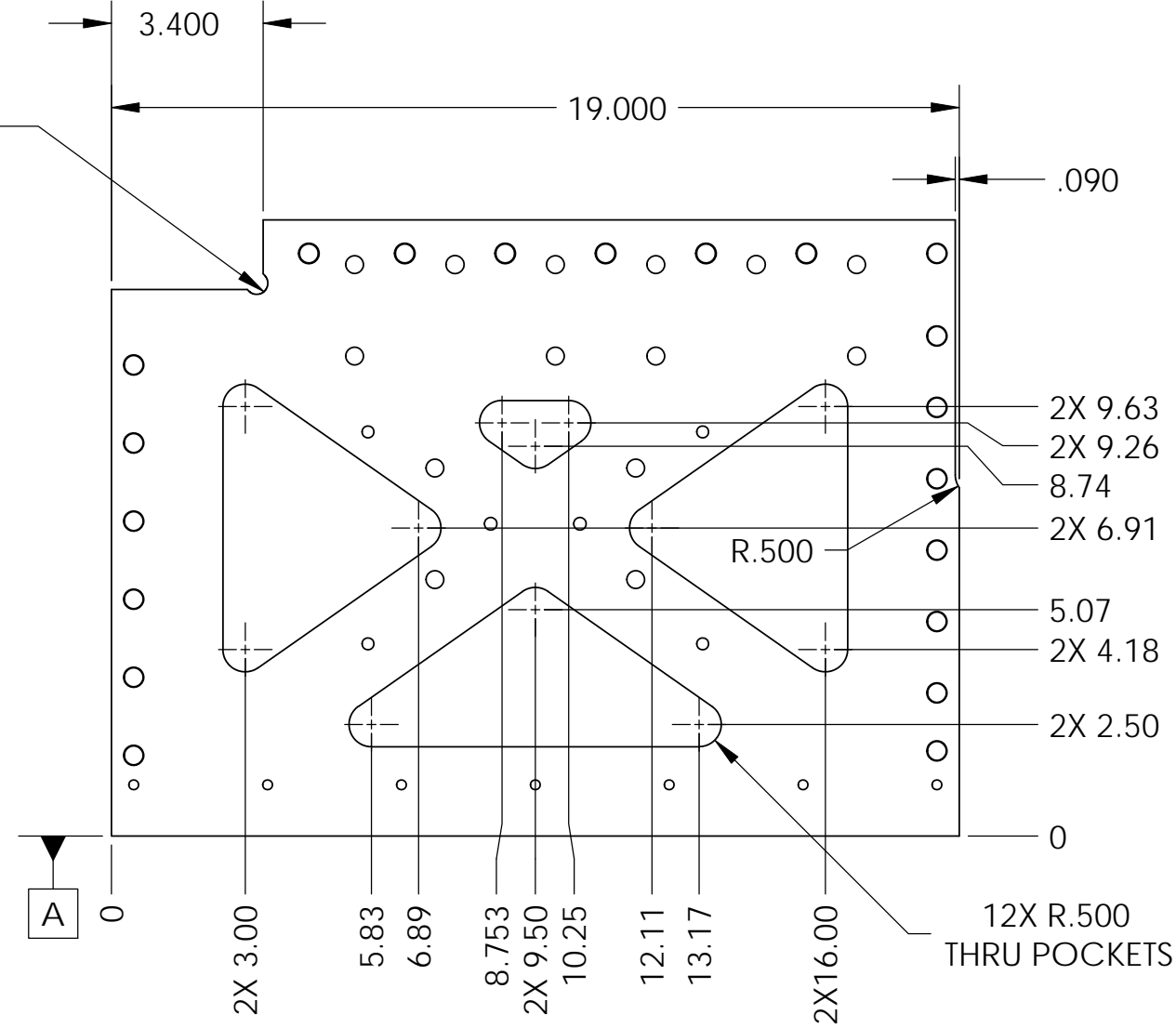
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± .5°				Door, Stage 1, aLIGO BSC ISI	
1. INTERPRET DRAWING PER ASME Y14.5-1994, 2. BREAK ALL EDGES AND CORNERS .03 X 45°. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.				Door, Stage 1, aLIGO BSC ISI	
MATERIAL 6061-T6 Al		FINISH 63 μ inch		SCALE 1:4	
SYSTEM ADVANCED LIGO		SUB-SYSTEM SEI		PROJECTION 	
NEXT ASSY D0901180		DESIGNER F.MATICHARD 15 Jan. 2010		SIZE DWG. NO. B D0902281	
APPROVAL K.MASON 15 Jan. 2010		CHECKER A.STEIN 15 Jan. 2010		REV. v1	
APPROVAL K.MASON 15 Jan. 2010				SHEET 1 OF 2	

D0902281 Door, Stage 1, BSC ISI, PART PDM REV: X-023, DRAWING PDM REV: X-009

D
C
B
A

8 7 6 5 4 3 2 1

RELIEVE CORNER
CONSTRUCTION
VENDOR OPTION



D
C
B
A

8 7 6 5 4 3 2 1

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE B	DWG. NO. D0902281	REV. V1
SCALE: 1:4		PROJECTION: SHEET 2 OF 2