

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 = 18.3 LB.

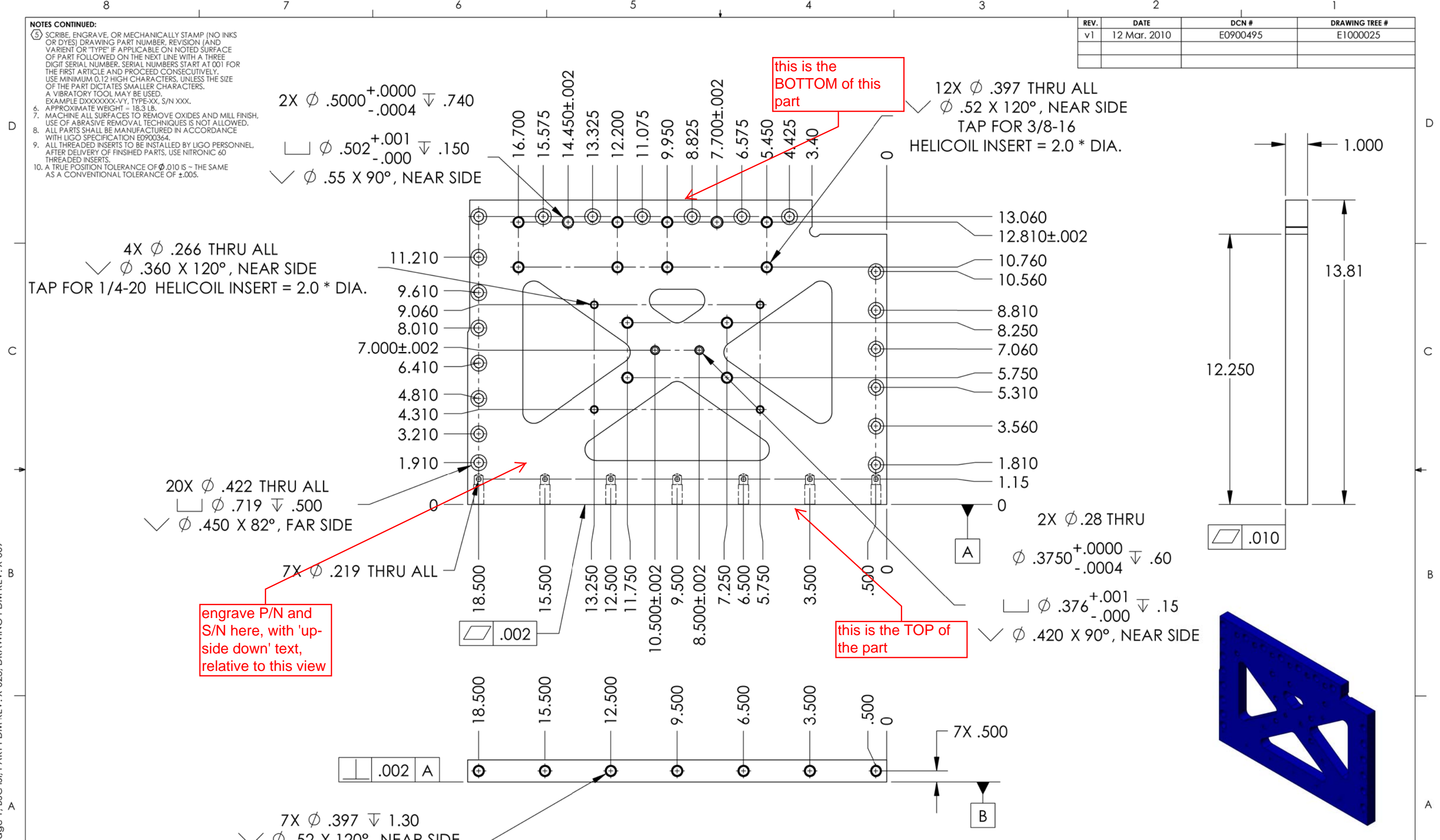
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.

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 TRUE POSITION TOLERANCE OF $\phi .010$ IS THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.

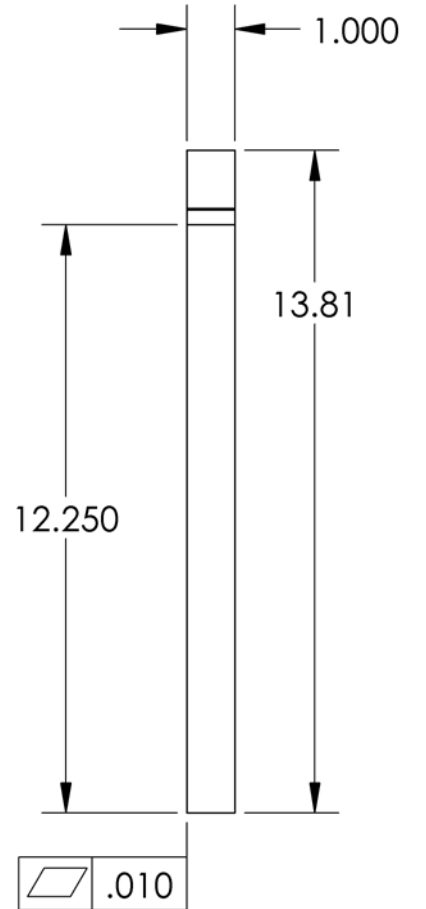
REV.	DATE	DCN #	DRAWING TREE #
v1	12 Mar. 2010	E0900495	E1000025



engrave P/N and S/N here, with 'upside down' text, relative to this view

this is the BOTTOM of this part

this is the TOP of the part



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

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.

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .015
.XXX ± .005

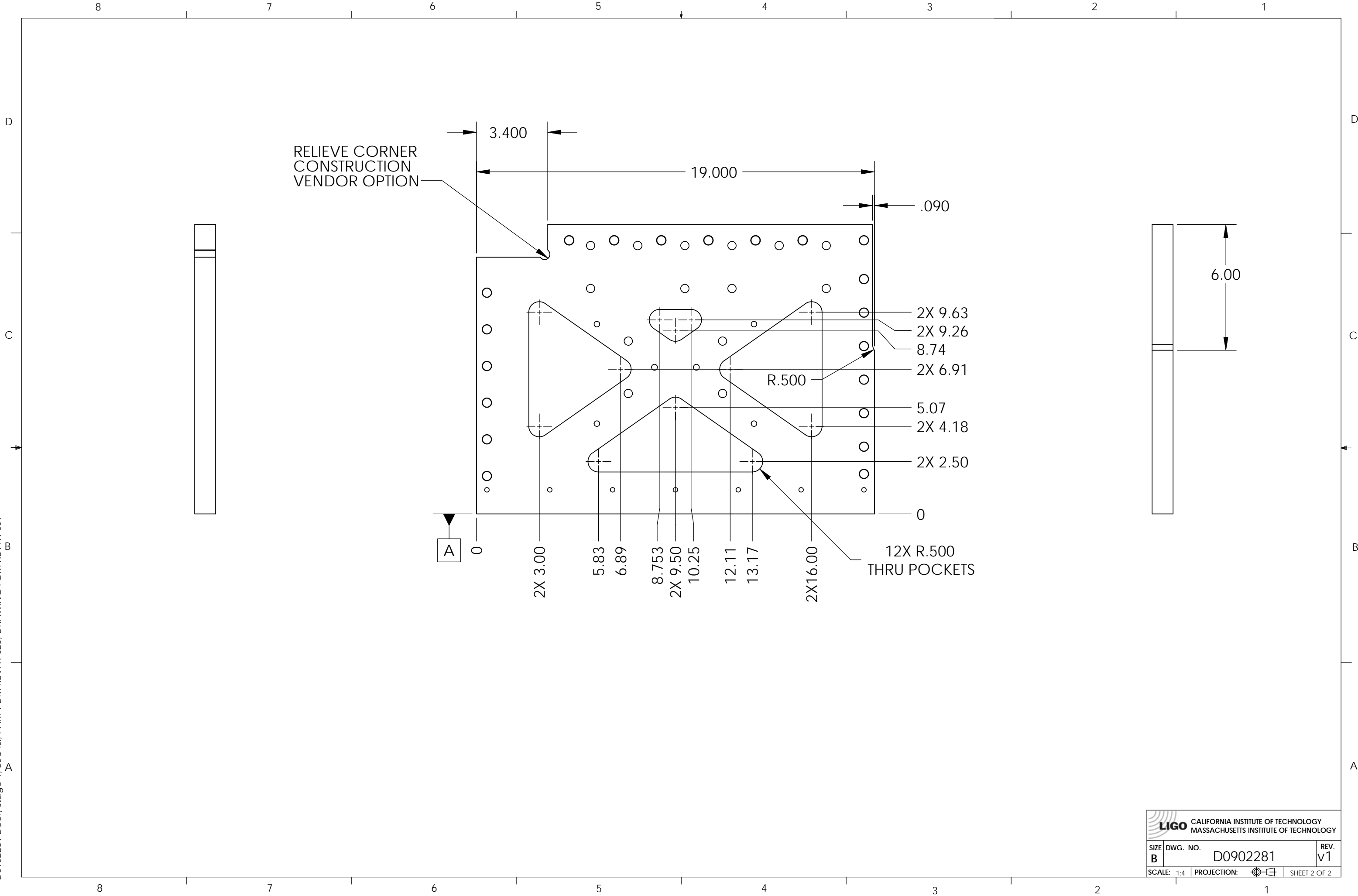
ANGULAR ± .5°

MATERIAL	6061-T6 Al	FINISH	63 μinch
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		Door, Stage 1, aLIGO BSC ISI	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	SEI	DESIGNER	F.MATICHARD 15 Jan. 2010
NEXT ASSY	D0901180	CHECKER	A.STEIN 15 Jan. 2010	SIZE	DWG. NO.
APPROVAL	K.MASON 15 Jan. 2010	APPROVAL	K.MASON 15 Jan. 2010	B	D0902281
SCALE: 1:4				PROJECTION:	SHEET 1 OF 2
				REV.	v1

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

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



RELIEVE CORNER
CONSTRUCTION
VENDOR OPTION

3.400
19.000
.090

A

2X 3.00
5.83
6.89
8.753
2X 9.50
10.25
12.11
13.17
2X 16.00
2X 9.63
2X 9.26
8.74
2X 6.91
R.500
5.07
2X 4.18
2X 2.50
0

12X R.500
THRU POCKETS

6.00

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