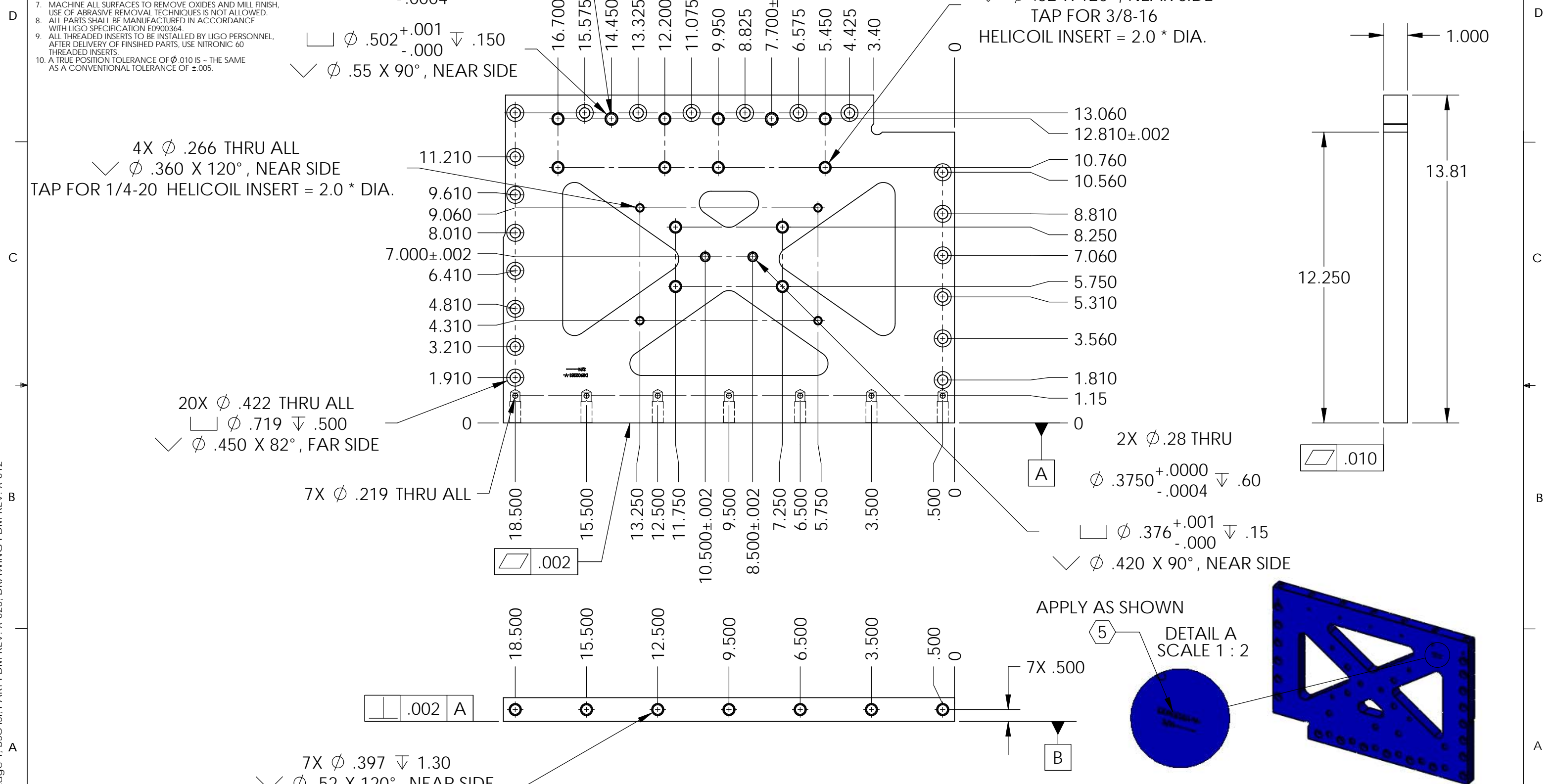


D0902281 Door, Stage 1, BSC ISI, PART PDM REV: X-025, DRAWING PDM REV: X-012

**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-VV, 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
v2	04 Aug 2010	E1000290	E1000025



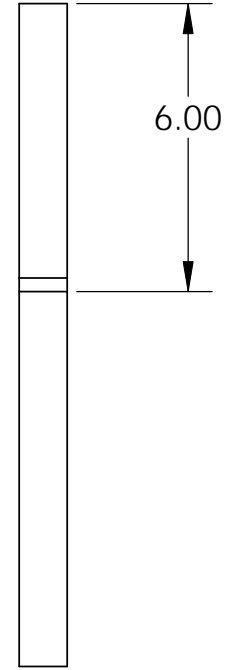
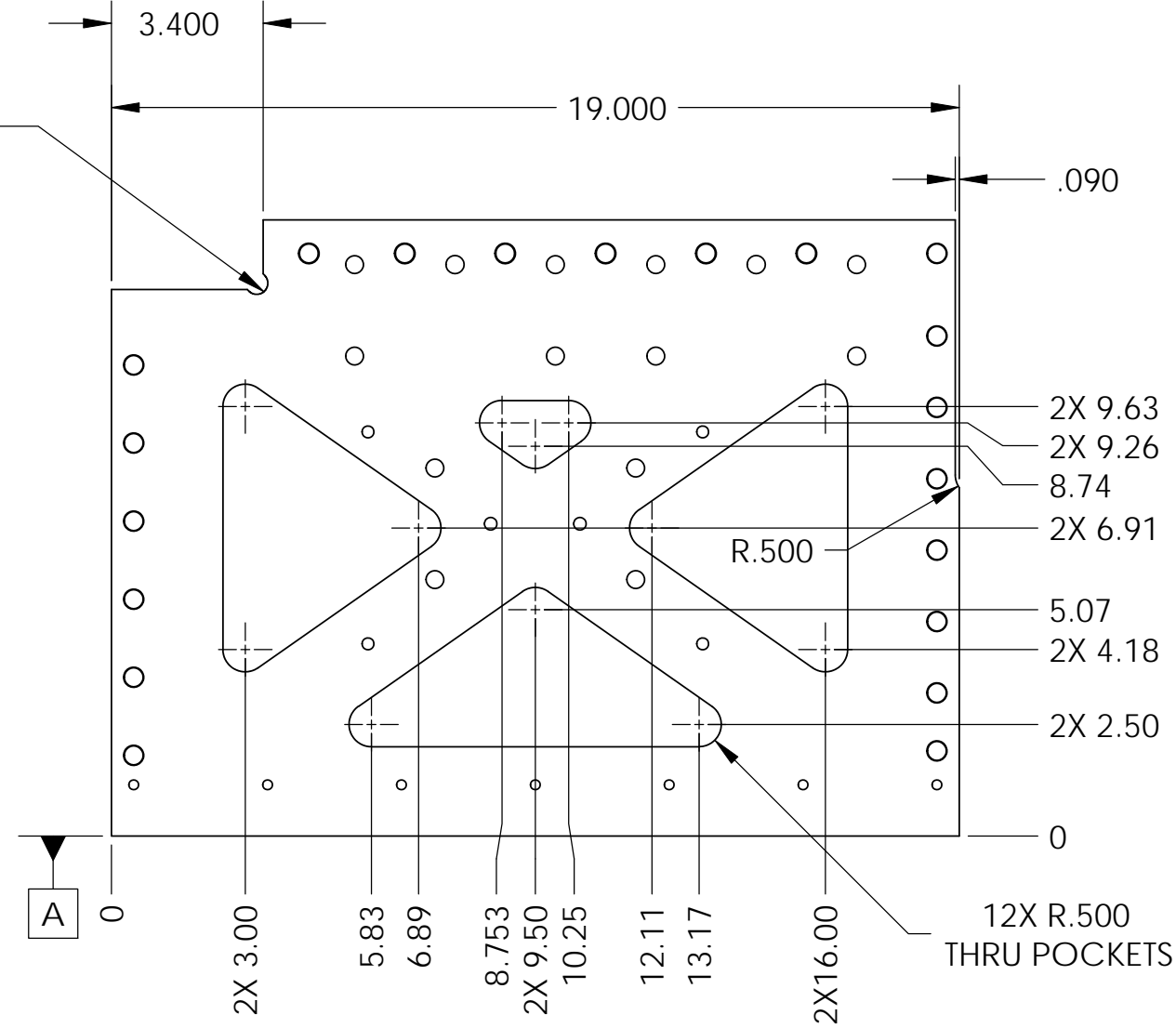
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		Door, Stage 1, aLIGO BSC ISI	
TOLERANCES: .XX $\pm .015$ .XXX $\pm .005$				SEI		DESIGNER	F.MATICHARD 15 Jan. 2010
ANGULAR $\pm .5^\circ$				NEXT ASSY		DRAWN	M.HILLARD 15 Jan. 2010
MATERIAL		FINISH		D0901180		CHECKER	A.STEIN 15 Jan. 2010
6061-T6 Al		63 $\mu$ inch				APPROVAL	K.MASON 15 Jan. 2010
						SIZE	DWG. NO.
						B	D0902281
						SCALE: 1:4	PROJECTION:
							SHEET 1 OF 2
						REV.	v2

D0902281 Door, Stage 1, BSC ISI, PART PDM REV: X-025, DRAWING PDM REV: X-012

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

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MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE <b>B</b>	DWG. NO. D0902281	REV. v2
SCALE: 1:4		PROJECTION:  SHEET 2 OF 2