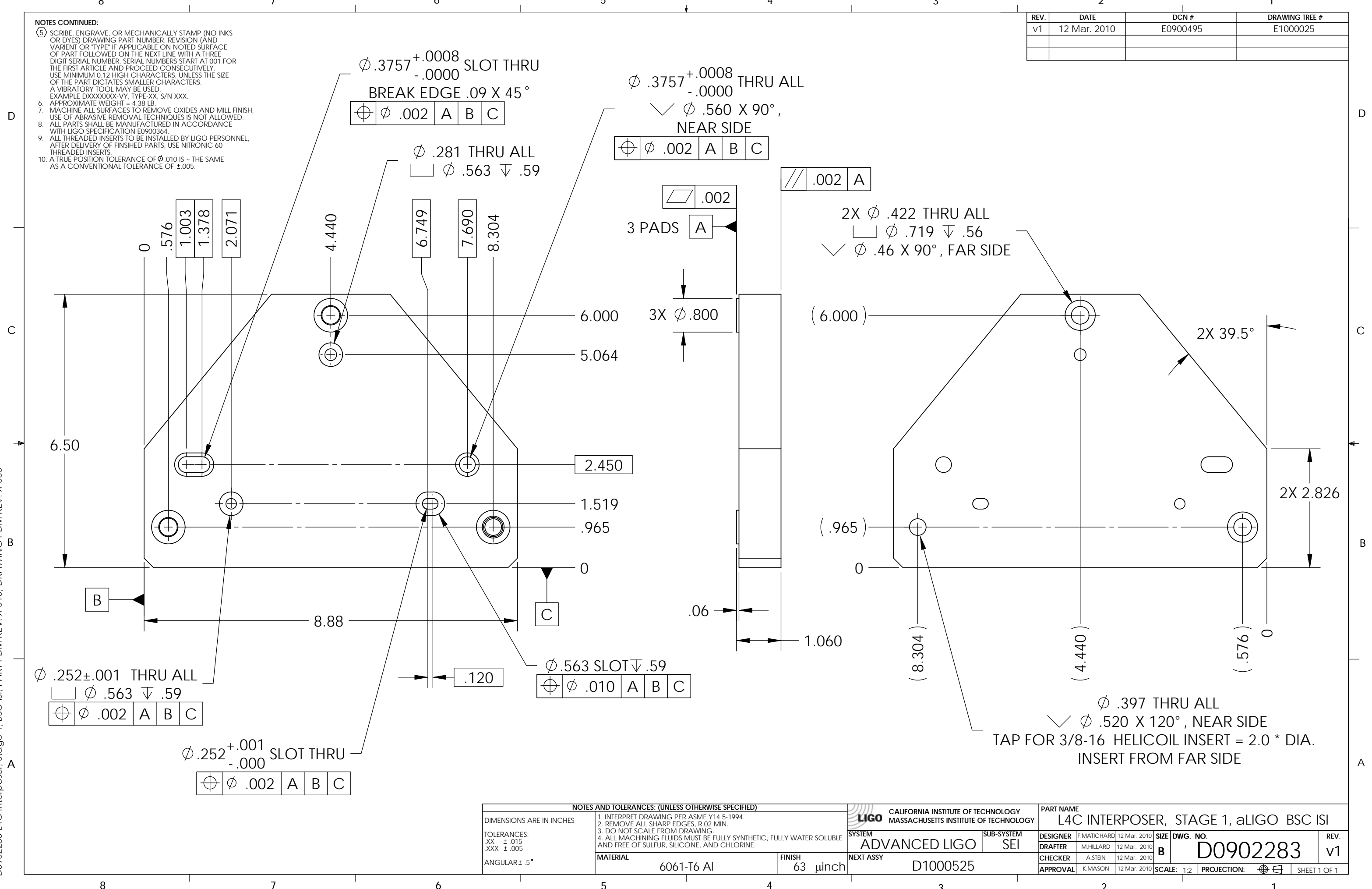


D0902283 L4C Interposer, Stage 1, BSC-ISI, PART PDM REV: X-010, DRAWING PDM REV: X-005

REV.	DATE	DCN #	DRAWING TREE #
v1	12 Mar. 2010	E0900495	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 0.12 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 = 4.38 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 $\pm .005$.



$\phi .252 \pm .001$ THRU ALL
 $\sqrt{\text{ }}$ $\phi .563 \downarrow .59$
 $\oplus \phi .002$ A B C

$\phi .252^{+.001}_{-.000}$ SLOT THRU
 $\oplus \phi .002$ A B C

$\phi .3757^{+.0008}_{-.0000}$ SLOT THRU
 BREAK EDGE $.09 \times 45^\circ$
 $\oplus \phi .002$ A B C

$\phi .3757^{+.0008}_{-.0000}$ THRU ALL
 $\sqrt{\text{ }}$ $\phi .560 \times 90^\circ$,
 NEAR SIDE
 $\oplus \phi .002$ A B C

$\sqrt{\text{ }}$ $.002$ A

2X $\phi .422$ THRU ALL
 $\sqrt{\text{ }}$ $\phi .719 \downarrow .56$
 $\sqrt{\text{ }}$ $\phi .46 \times 90^\circ$, FAR SIDE

$\phi .563$ SLOT $\downarrow .59$
 $\oplus \phi .010$ A B C

$\phi .397$ THRU ALL
 $\sqrt{\text{ }}$ $\phi .520 \times 120^\circ$, NEAR SIDE
 TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA.
 INSERT FROM FAR SIDE

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX $\pm .015$.XXX $\pm .005$	
ANGULAR $\pm .5^\circ$	
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.	
MATERIAL	FINISH
6061-T6 Al	63 μ inch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM ADVANCED LIGO		SUB-SYSTEM SEI	
MATERIAL		NEXT ASSY	
6061-T6 Al		D1000525	
DESIGNER	F.MATICHARD	12 Mar. 2010	SIZE
DRAFTER	M.HILLARD	12 Mar. 2010	DWG. NO.
CHECKER	A.STEIN	12 Mar. 2010	B
APPROVAL	K.MASON	12 Mar. 2010	D0902283
SCALE: 1:2		PROJECTION:	
SHEET 1 OF 1		REV.	v1