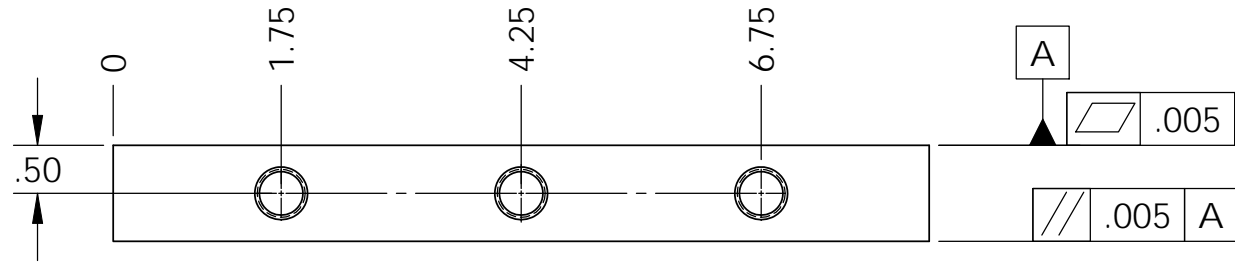


8 7 6 5 4 3 2 1

REV.	DATE	DCN #	DRAWING TREE #
v2	5 Apr. 2011	E1100015	E1100016

NOTES CONTINUED:

- 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE.
- 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 DXXXXXXX-VY, TYPE-XX, S/N XXX.
- 6. APPROXIMATE WEIGHT = 8.974 LB.
- 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 8. PAINT: ALL VISIBLE SURFACES (exclude fastening hardware) EXCEPT AREAS IDENTIFIED BY M MEDIUM BLUE SHERWIN WILLIAMS (POLANE (R) T-PLUS POLYURETHANE ENAMEL) #SW-F63TX-L-2822-5864 PRIME WITH SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER P60G2
- 9. "OXI SOLV RUST INHIBITOR" TO BE APPLIED PER MFG. INSTRUCTIONS TO ALL UNPAINTED SURFACES. BOTH TAPPED AND THRU HOLES WILL BE PLUGGED DURING APPLICATION.

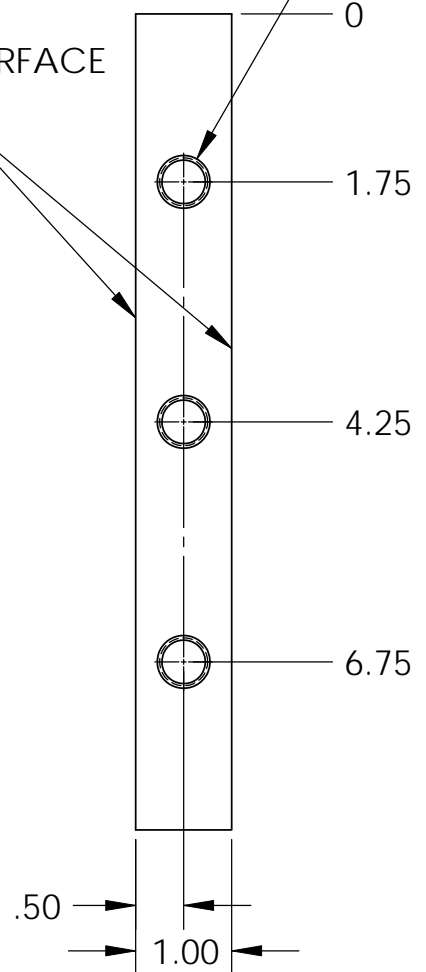


6X ϕ .45 ∇ .78
 1/2-20 UNF ∇ .63
 ϕ .55 X 82°, NEAR SIDE
 M

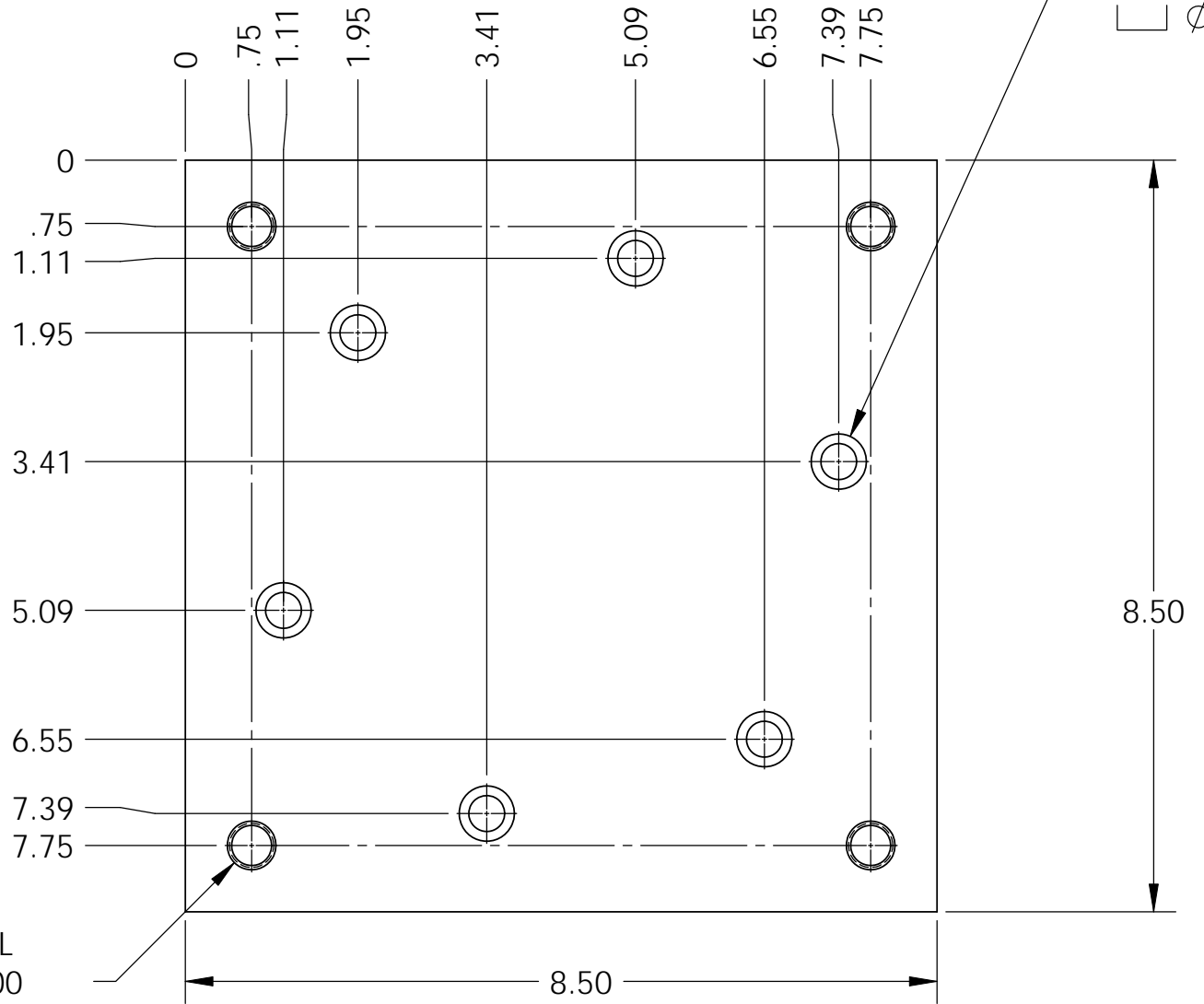
6X ϕ .41 THRU ALL
 ϕ .63 ∇ .41
 M

TOP AND BOTTOM SURFACE

M



4X ϕ .45 THRU ALL
 1/2-20 UNF ∇ 1.00
 ϕ .55 X 82°, NEAR SIDE
 M



D020008, PART PDM REV: X-000, DRAWING PDM REV: X-000

8 7 6 5 4 3 2 1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME CROSSBEAM ATTACHMENT PLATE, aLIGO HEPI BSC						
DIMENSIONS ARE IN INCHES		1. INTERPRET DRAWING PER ASME Y14.5-1994.		SYSTEM ADVANCED LIGO		SUB-SYSTEM SEI		DESIGNER K.MASON	29 May 2002	SIZE DWG. NO. B	D020008	REV. v2
TOLERANCES: .XX ± .015 .XXX ± .005		2. REMOVE ALL SHARP EDGES, .03 x 45°.		MATERIAL AISI 1018 Steel, Cold Rolled		FINISH 63 μinch		DRAFTER M.HILLARD	5 Apr. 2011	SCALE: 1:2		PROJECTION:
ANGULAR ± .5°		3. DO NOT SCALE FROM DRAWING.		NEXT ASSY D1100242, D1100241		CHECKER O.SPJELD		20 Oct. 2003	APPROVAL K.MASON		5 Apr. 2011	SHEET 1 OF 1