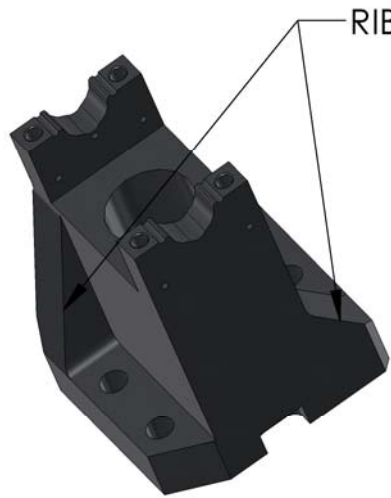
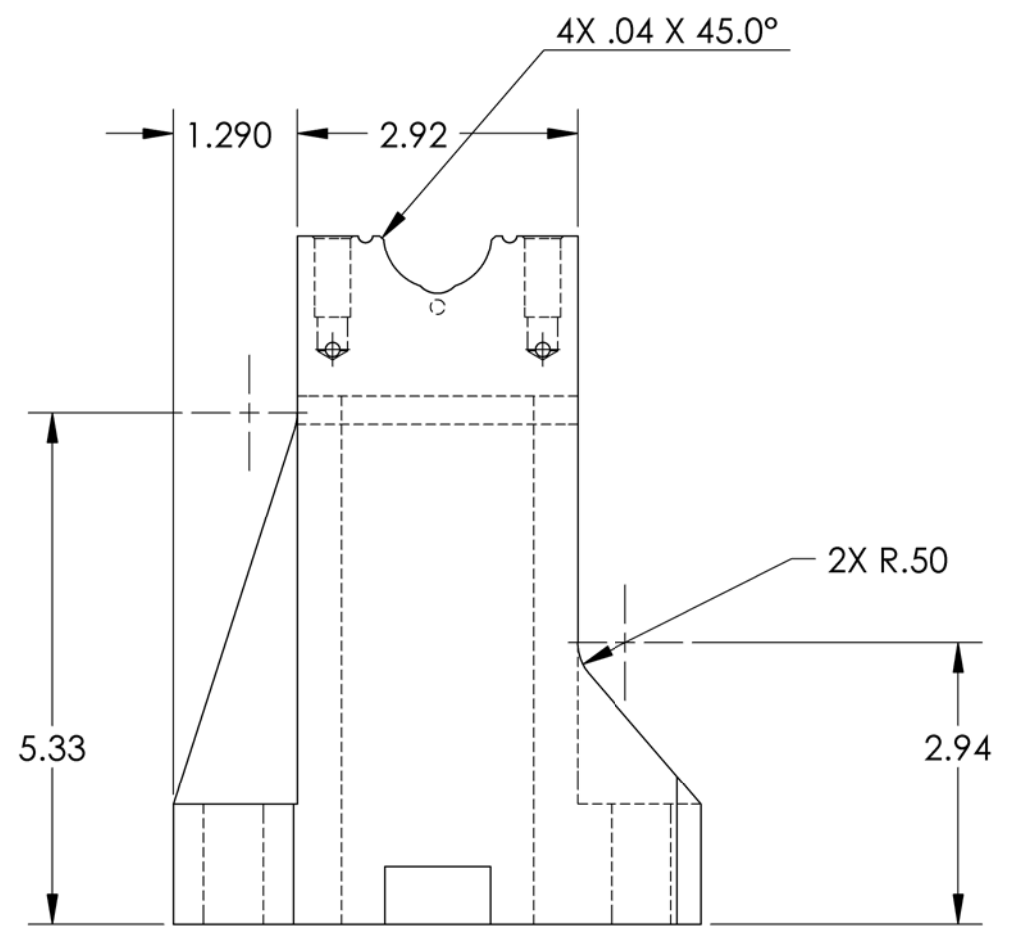
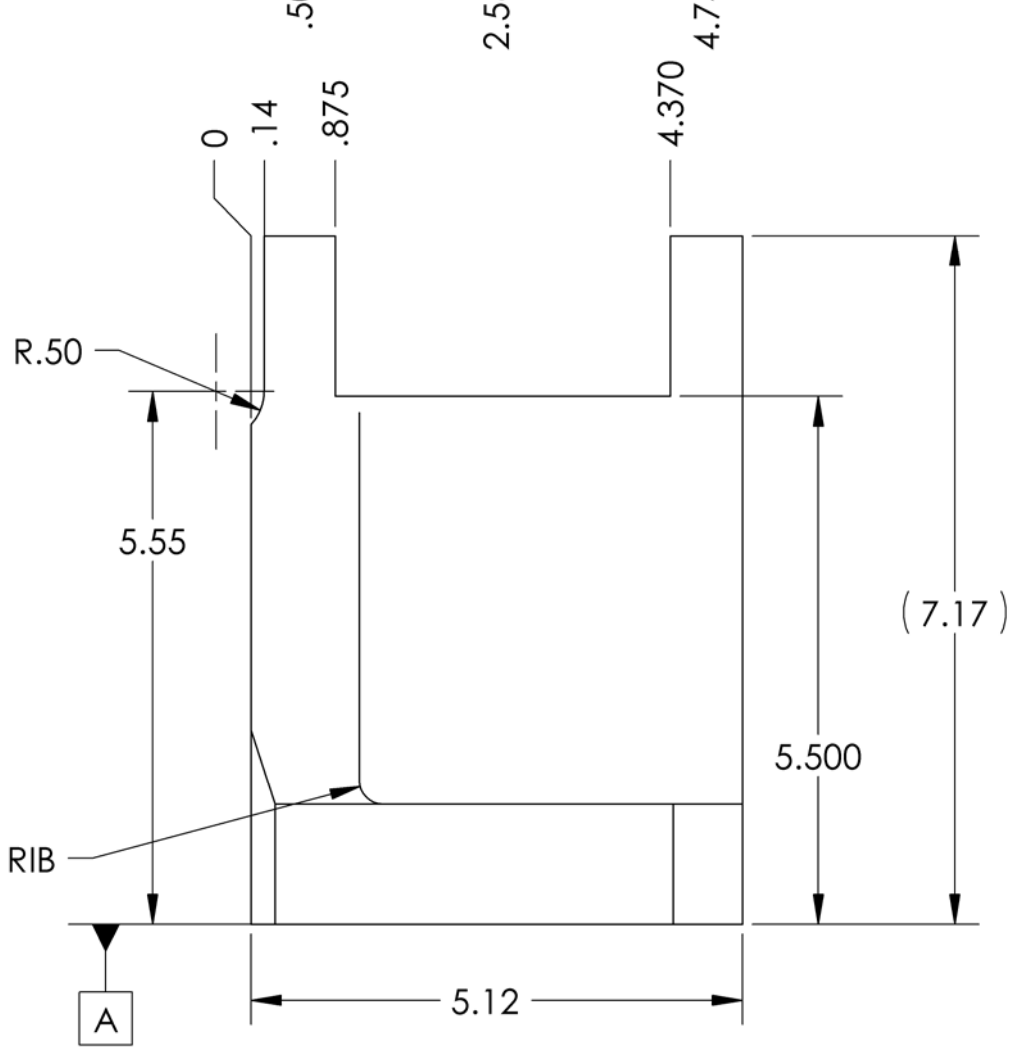
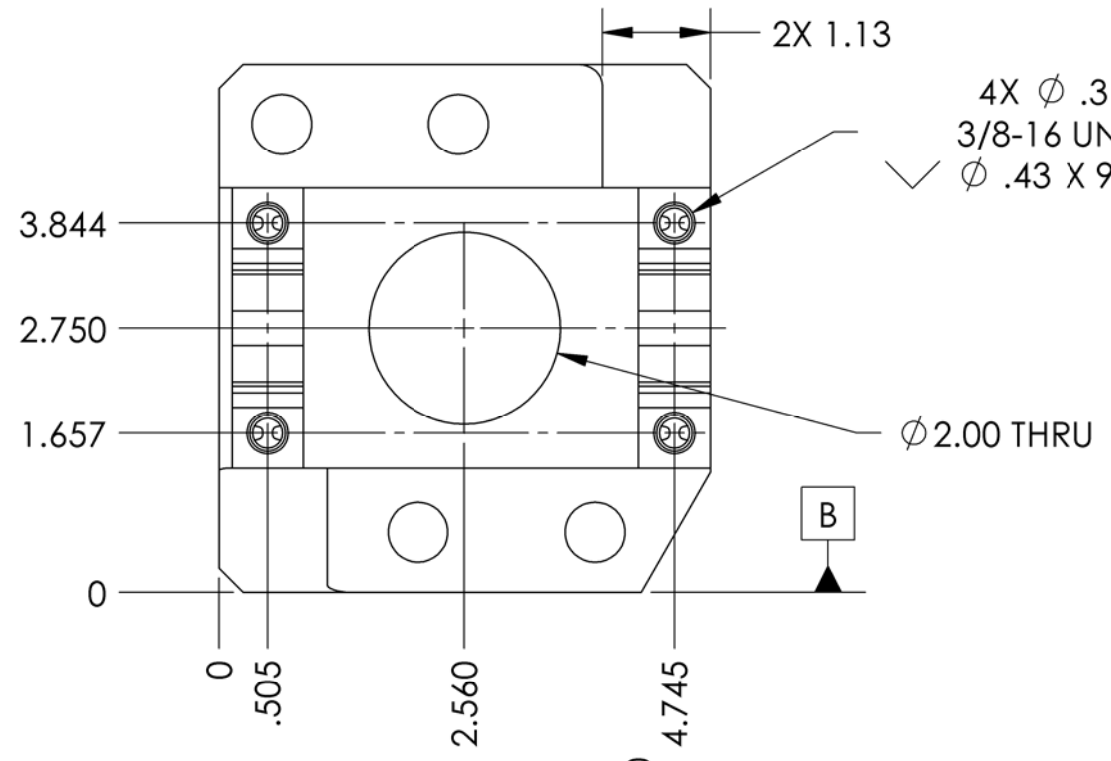


D1000861 Post, Stage 0-1 Locker, aLIGO BSC-ISI, PART PDM REV: X-008, DRAWING PDM REV: X-007

NOTES CONTINUED:
 ③ 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 = 4.046 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. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES.

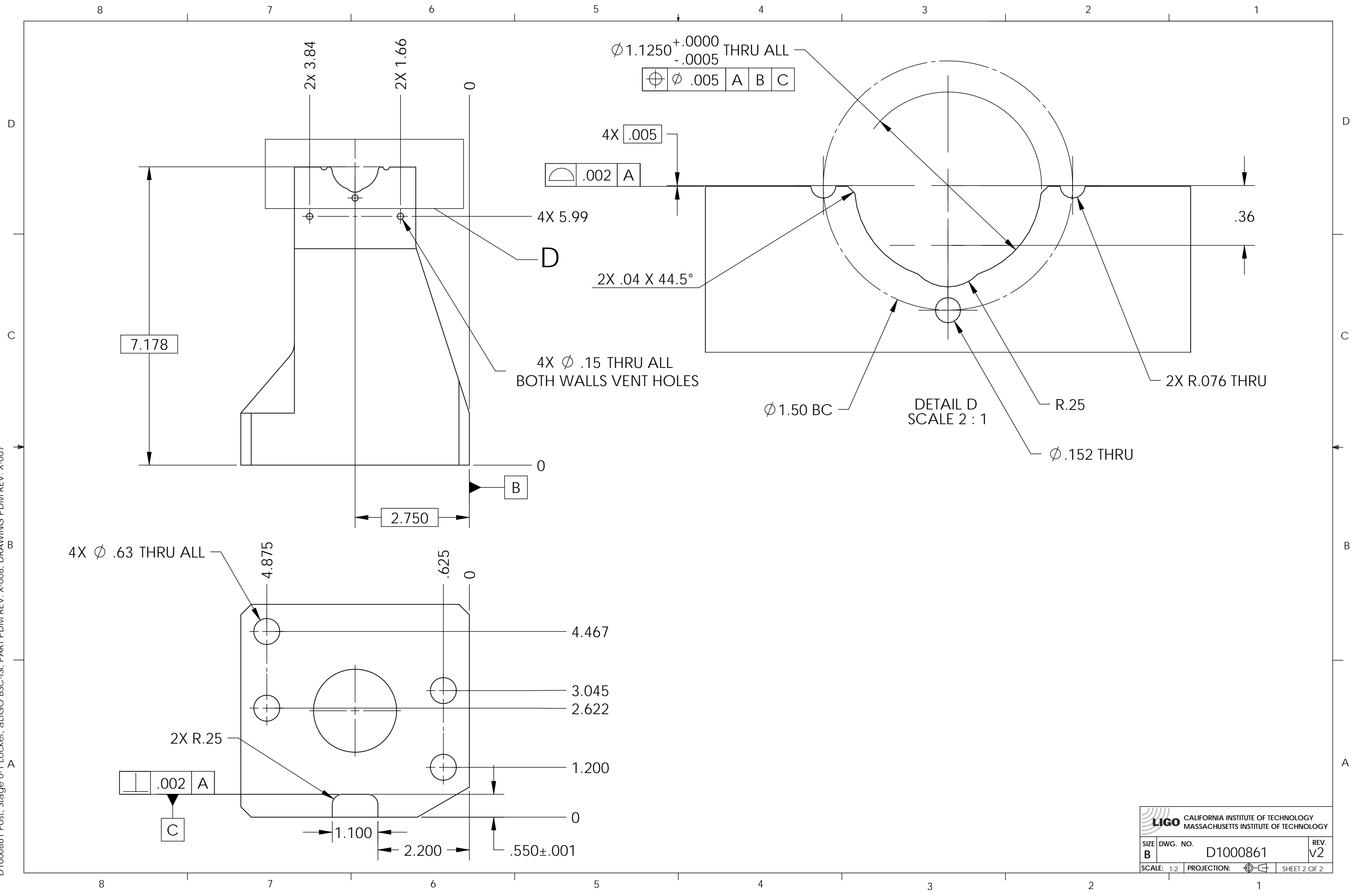
REV.	DATE	DCN #	DRAWING TREE #
v1	01 Mar. 2010	E1000115	E1000025
v2	20 July 2010	E1000263	E1000025



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± .5°	
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.	
MATERIAL	FINISH
2024-T351 AL	63 μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME POST, STAGE 0-1 LOCKER, aLIGO BSC ISI	
SYSTEM	SUB-SYSTEM	DESIGNER	DATE
ADVANCED LIGO	SEI	A.STEIN	01 Mar. 2010
NEXT ASSY	D1000854	DRAFTER	DATE
		M.HILLARD	01 Mar. 2010
		CHECKER	DATE
		F.MATICHARD	01 Mar. 2010
		APPROVAL	DATE
		K.MASON	01 Mar. 2010
SIZE	DWG. NO.	REV.	
B	D1000861	v2	
SCALE: 1:2	PROJECTION:	SHEET 1 OF 2	

D1000861 Post, Stage 0-1 Locker, aLIGO BSC-ISI, PART PDM REV: X-008, DRAWING PDM REV: X-007



7.178

2X 3.84

2X 1.66

$\phi 1.1250^{+.0000}_{-.0005}$ THRU ALL
 $\phi .005$ A B C

4X .005

.002 A

4X 5.99

4X $\phi .15$ THRU ALL
BOTH WALLS VENT HOLES

2X .04 X 44.5°

$\phi 1.50$ BC

DETAIL D
SCALE 2 : 1

R.25

$\phi .152$ THRU

2X R.076 THRU

.36

2.750

4X $\phi .63$ THRU ALL

4.875

.625

4.467

3.045

2.622

1.200

2X R.25

.002 A

1.100

2.200

.550±.001

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D1000861	v2
SCALE: 1:2	PROJECTION:	SHEET 2 OF 2