

D1100374 Unified Plate Flipper Tooling Single End, BSC-ISI, PART PDM REV: X-000, DRAWING PDM REV:

NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

6. ENGRAVE IN LOCATION INDICATED, 3/8" HIGH CHARACTERS:

D0902279 = 2A 9X 3/8"- 16 x 3" & Nuts
 D0902273 = C 3X 3/8"- 16 x 1.5" & 6X 3/8"- 16 x 4.5" & Nuts
 D0901520 = 1A 10X 3/8"- 16 x 1.5"
 D0901518 = B 10X 1/4"- 20 x 4.5" & Nut
 D0901519 = B 10X 1/4"- 20 x 4.5" & Nut

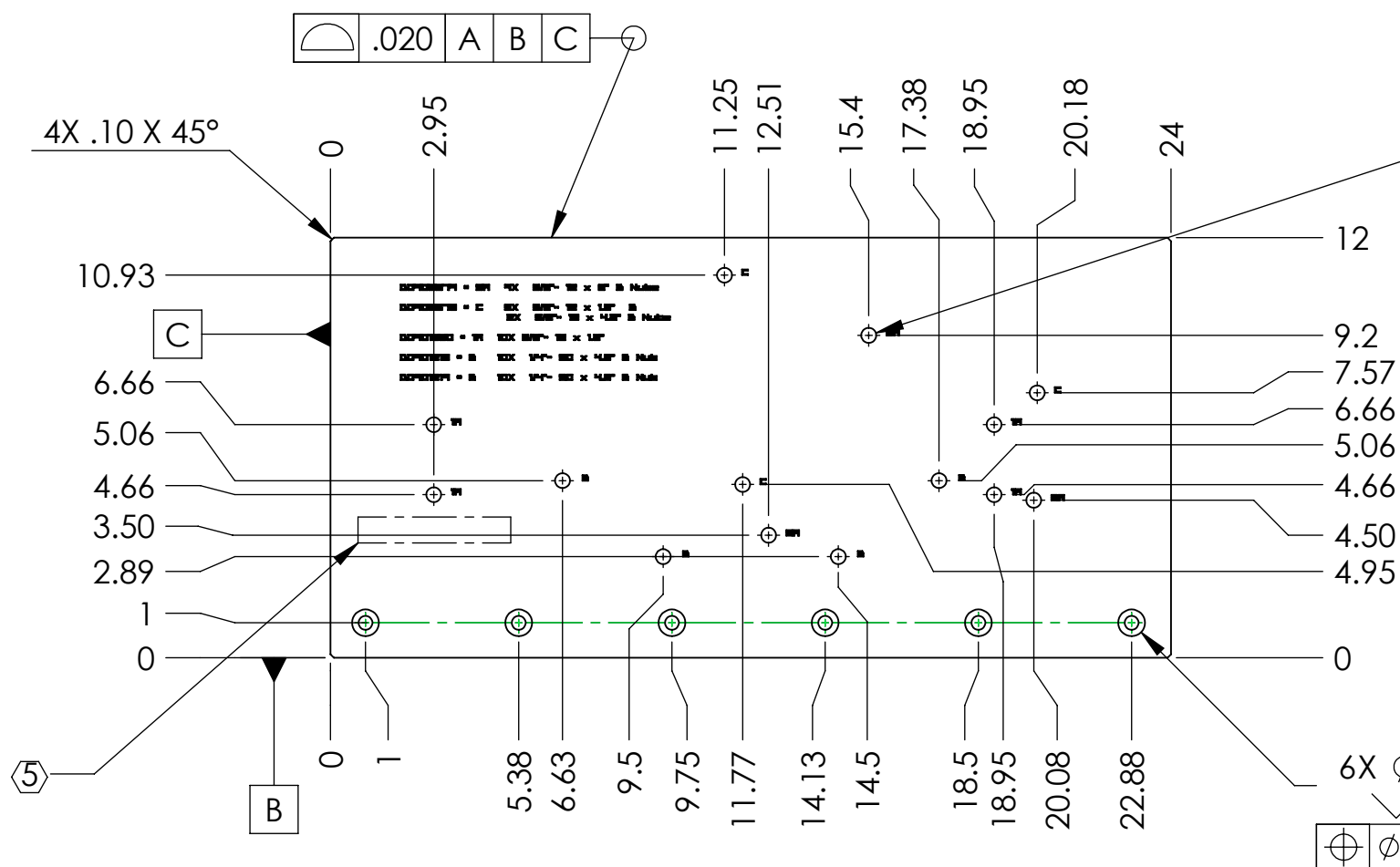
7. ENGRAVE IN LOCATIONS INDICATED, 3/8" HIGH CHARACTERS:

1A, 2A, B, C (3/8" FROM EDGE OF ASSOCIATED HOLE)

8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH.

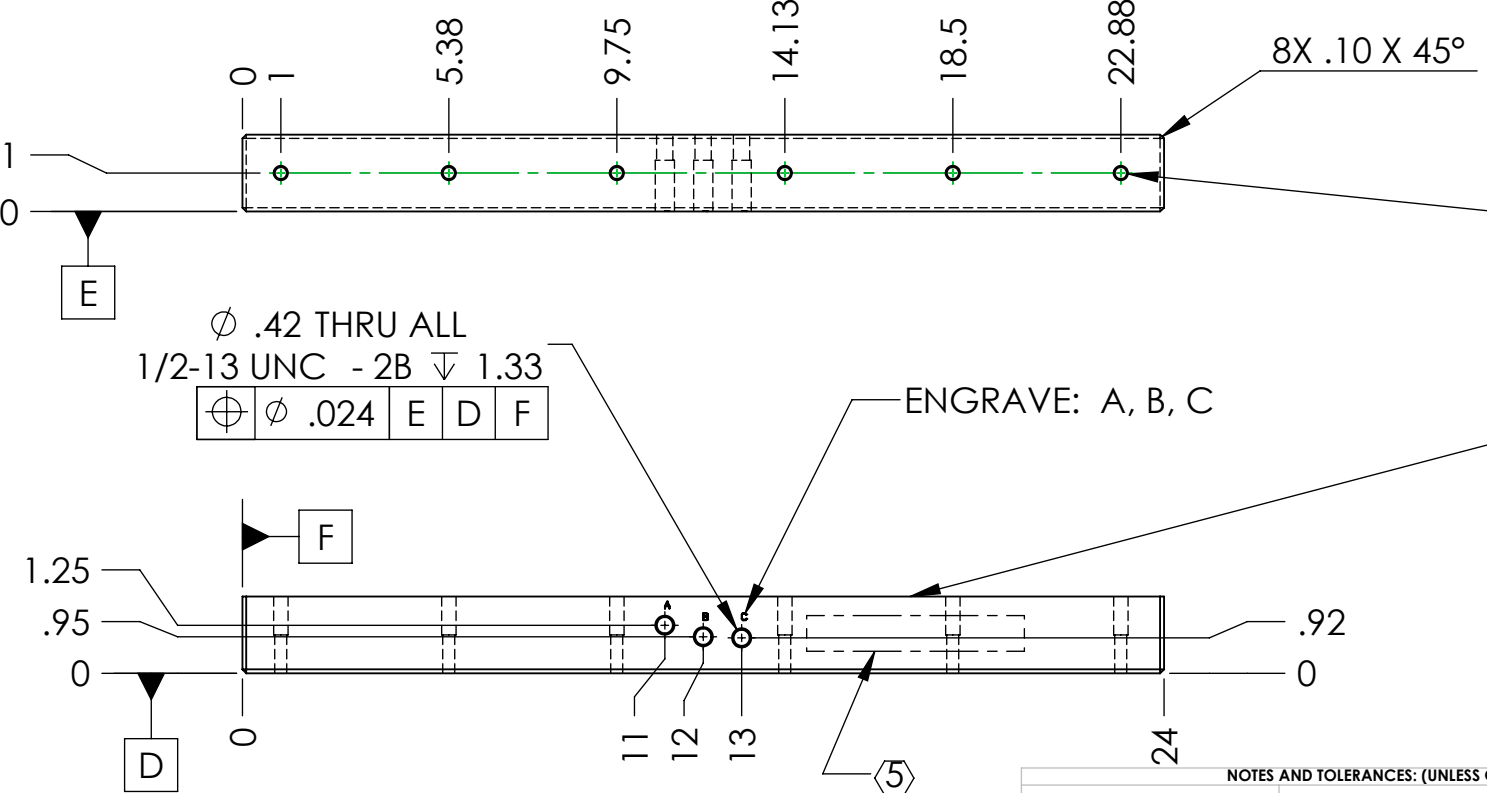
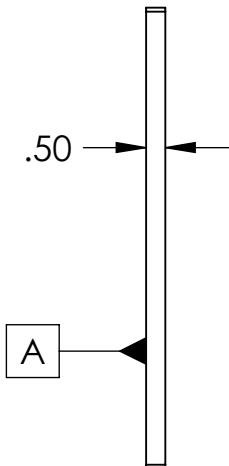
9. ALL DIMENSIONS ARE BASIC UNLESS OTHERWISE SPECIFIED.

REV.	DATE	DCN #	DRAWING TREE #
-	-	-	-
-	-	-	-
-	-	-	-



14X $\phi .43 \pm .01$ THRU
 $\phi .016$ A B C

6X $\phi .40 \pm .01$ $\nabla .50$
 $\phi .76$ X 82°
 $\phi .016$ A B C

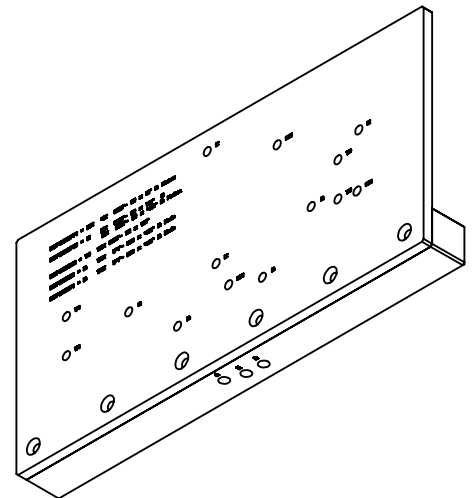


6X $\phi .31$ $\nabla 2.00$
 3/8-16 UNC - 2B $\nabla 1.00$
 $\phi .024$ D E F

$\phi .42$ THRU ALL
 1/2-13 UNC - 2B $\nabla 1.33$
 $\phi .024$ E D F

ENGRAVE: A, B, C

.020 D E F



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ±
 .XXX ±

ANGULAR ± °

1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
 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 6061-T6 Al **FINISH** 63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO **SUB-SYSTEM** SEI

NEXT ASSY D0901182

PART NAME Unified Plate Flipper Tooling Single End, BSC-ISI

DESIGNER	SBARNUM	15 FEB 2011	SIZE	DWG. NO.	D1100374	REV. v1
DRAFTER	SBARNUM	1 MAR 2011	B			
CHECKER	FMATCHARD	29 FEB 2011	SCALE:	1:5		
APPROVAL	KMASON		PROJECTION:			

SHEET 1 OF 1