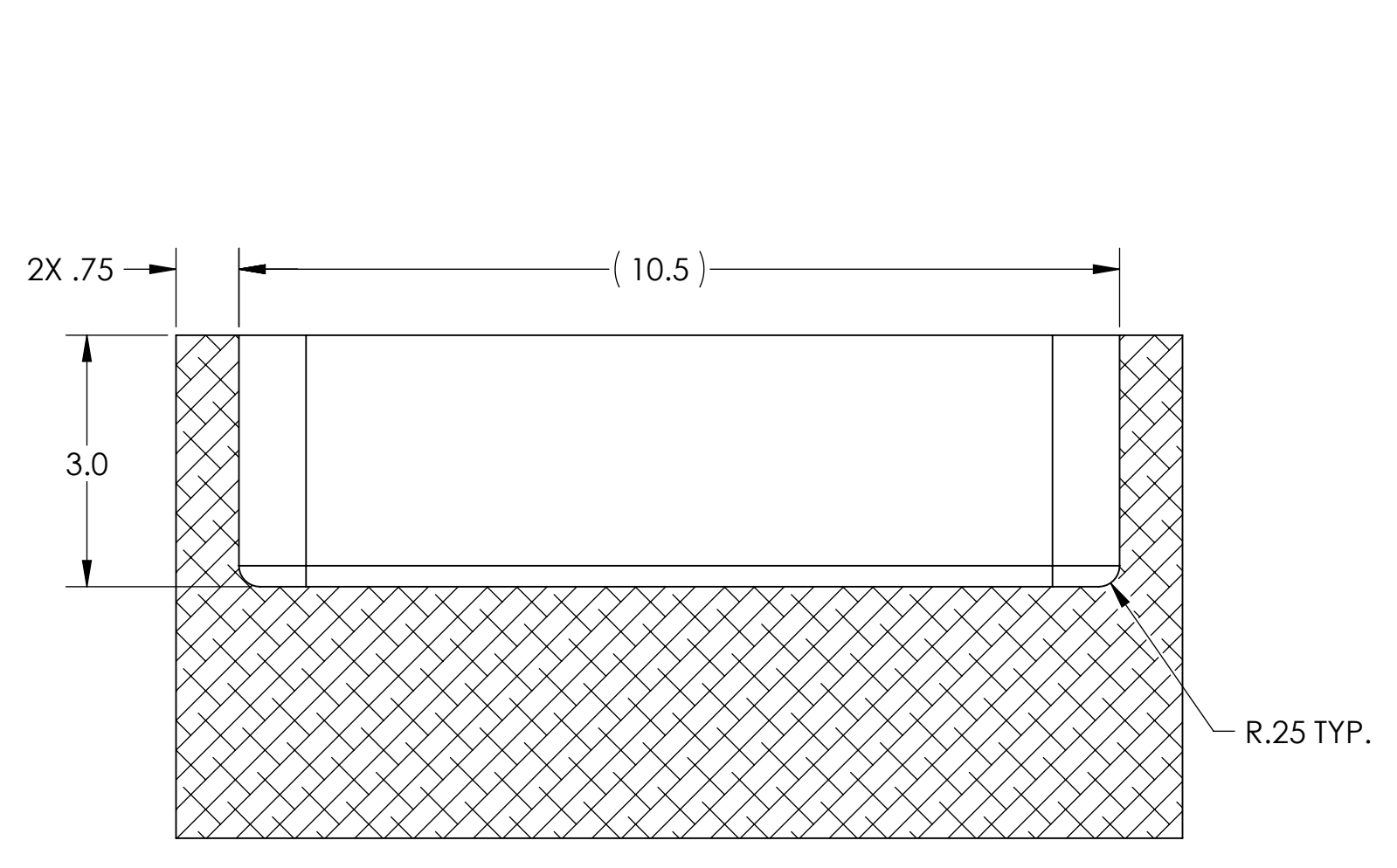
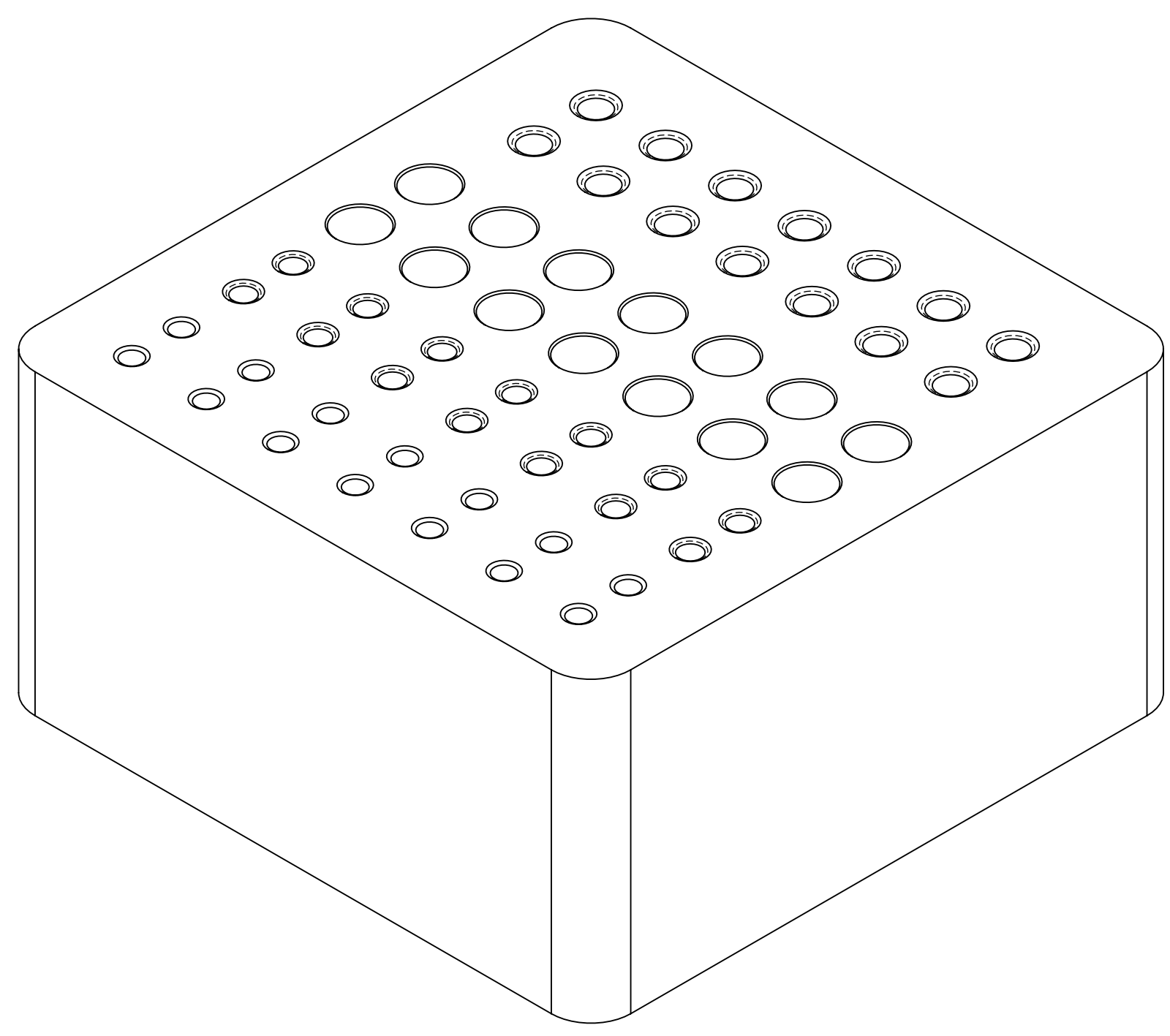
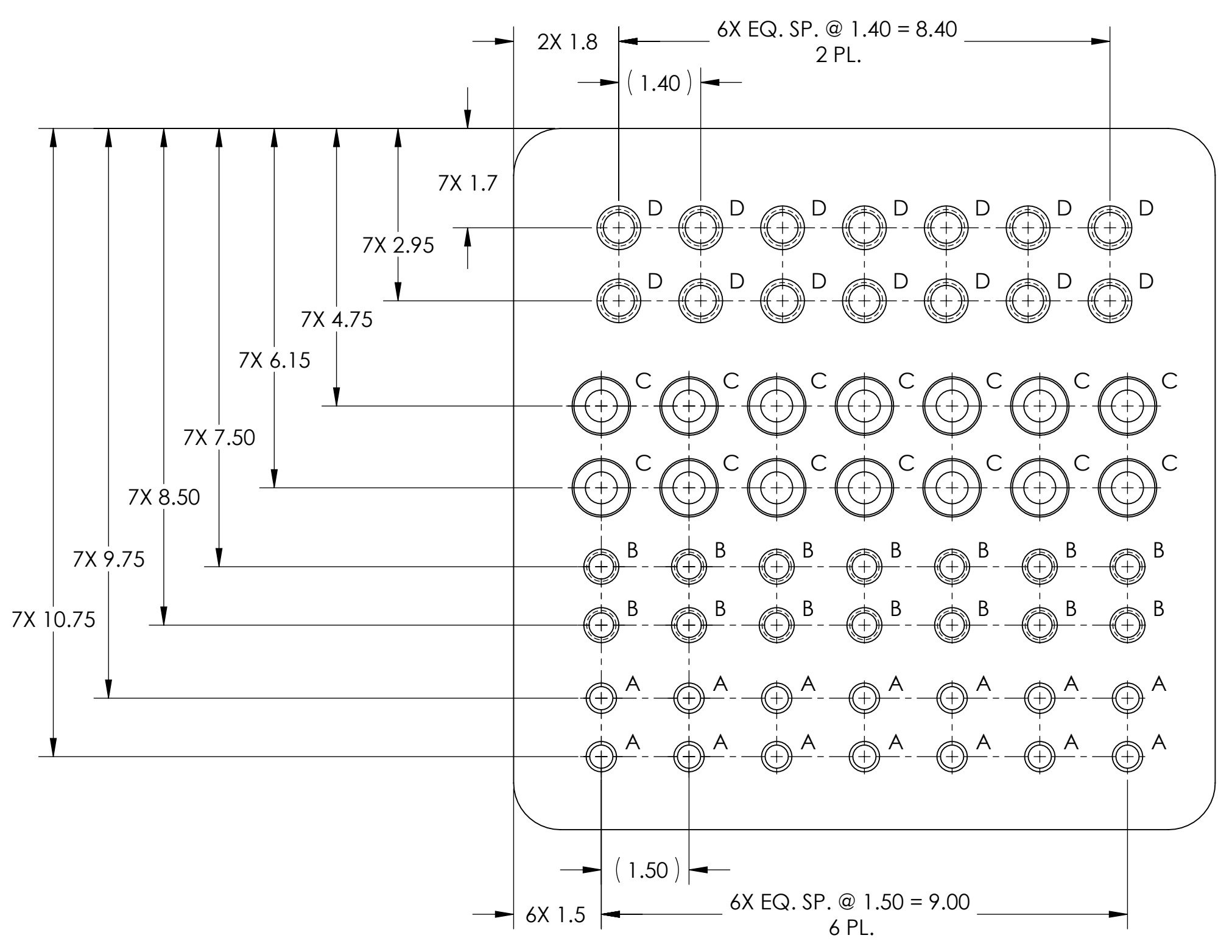
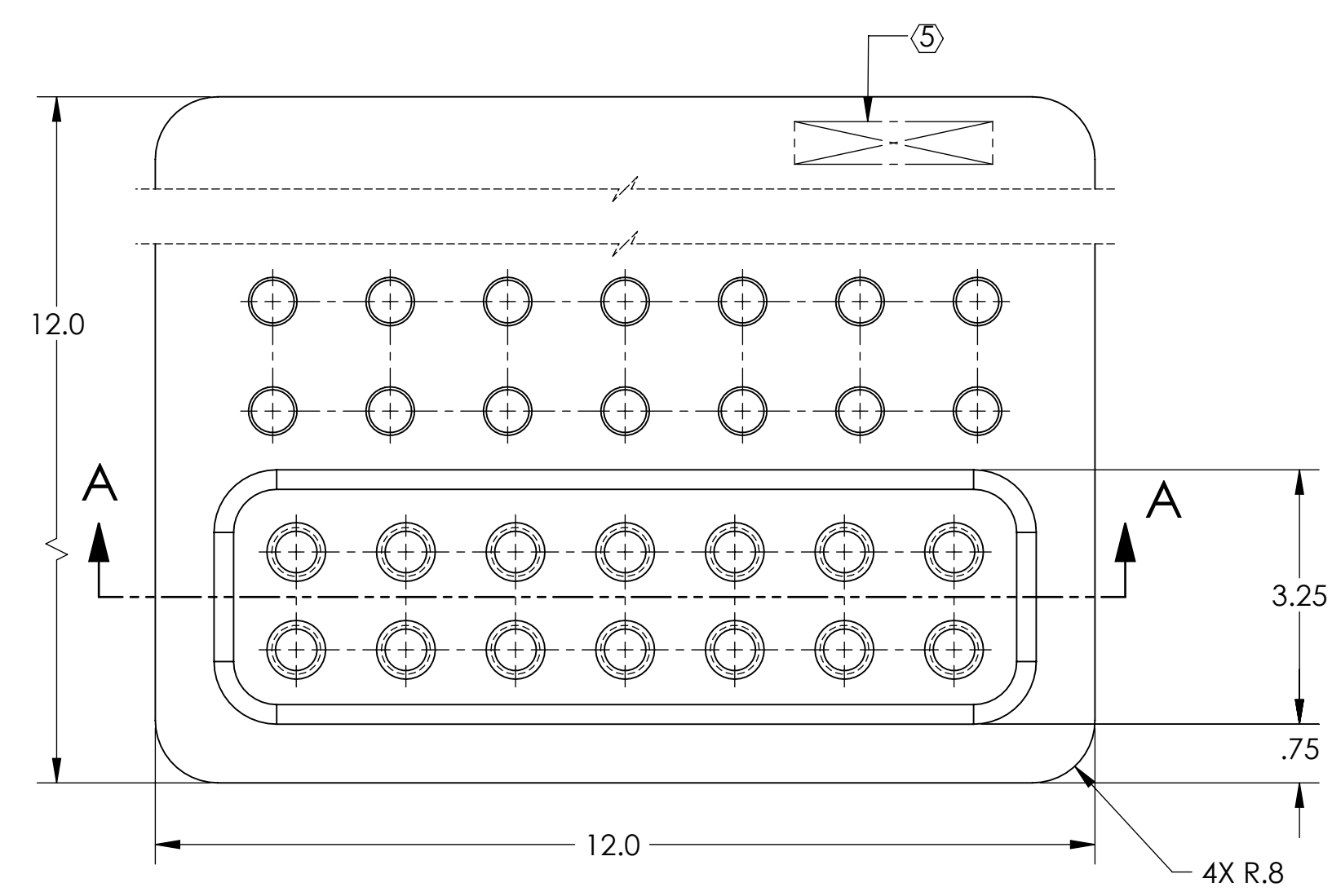


- NOTES CONTINUED:
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-ED900364.
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION ED900364.
 8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-ED900364.
 9. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

REV.	DATE	DCN #	DRAWING TREE #
v1	20 APR 2011	E1100382-x0	-
v2	22 APR 2011	E1100388-x0	-
-	-	-	-



SECTION A-A



Hole Table			
TAG	SIZE	QUANTITY	REFERENCE
A	ϕ .397 ∇ 1.55 ∇ ϕ .52 X 120°, NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT 2.0"DIA	14	D0901516-v2, SHEET 1, 3217X
B	ϕ .422 ∇ 3.00 1/2-13 UNC H11 ∇ 1.5 ∇ ϕ .60 X 120°, NEAR SIDE	14	D0900894-v2, SHEET 1, 142X
C	ϕ .547 THRU ALL ∇ ϕ .938 ∇ 4.00 ∇ ϕ 1.00 X 90°, NEAR SIDE ∇ ϕ .62 X 90°, FAR SIDE	14	D0900895-v2, SHEET 1, 142X
D	ϕ .531 THRU ALL 5/8-11 UNC -2B H11 THRU ALL ∇ ϕ .75 X 120°, NEAR SIDE ∇ ϕ .75 X 120°, FAR SIDE	14	D0901516-v2, SHEET 3, 3X

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
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.	
DIMENSIONS ARE IN	
TOLERANCES:	
.XX ± .01	
.XXX ± .005	
ANGULAR ± 1.0°	
MATERIAL	6061-T6 (SS)
FINISH	63 μ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
ADVANCED LIGO		ALIGO BSC CLEANING TEST PLATE	
DESIGNER	JEFF LEWIS	20 APR 2011	SIZE DWG. NO.
DRAFTER	Esanchez	21 APR 2011	D D1100760
CHECKER			REV. v2
APPROVAL			SCALE: 1:2 PROJECTION: SHEET 1 OF 1

D1100760 ALIGO BSC CLEANING TEST PLATE, PART PDM REV: X-000, DRAWING PDM REV: X-000