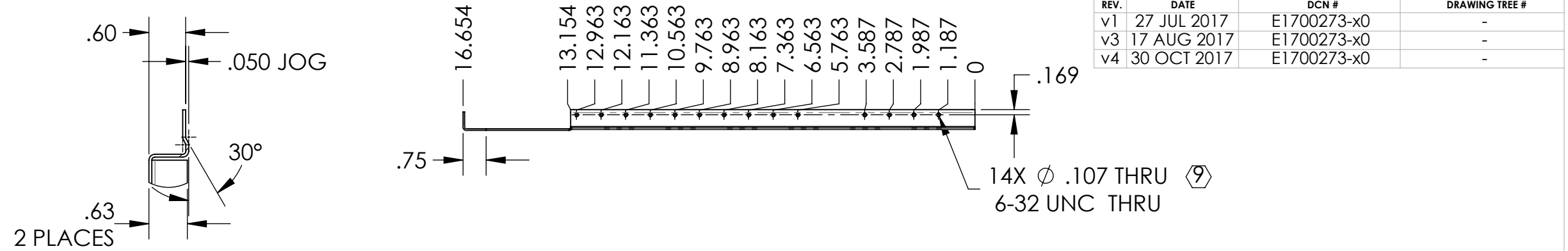
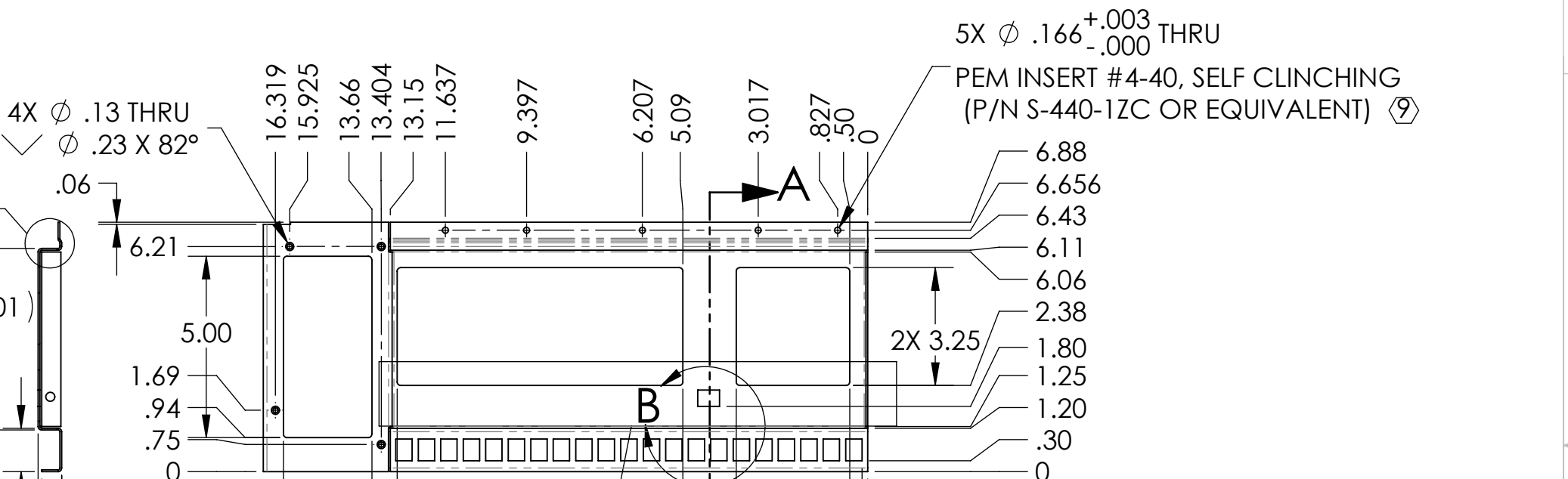


NOTES CONTINUED:
 (5) SILKSCREEN (COLOR: WHITE) PART NUMBER AND VERSION ON INDICATED SURFACE.
 EXAMPLE: DXXXXXX-VY
 6. APPROXIMATE WEIGHT = 1.4 LB.
 7. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
 (8) FINISH: PAINT BLACK WITH INDICATED SILK SCREENING
 (9) MASK ALL TAPPED HOLES AND INSERTS PRIOR TO FINISHING STEP (8)

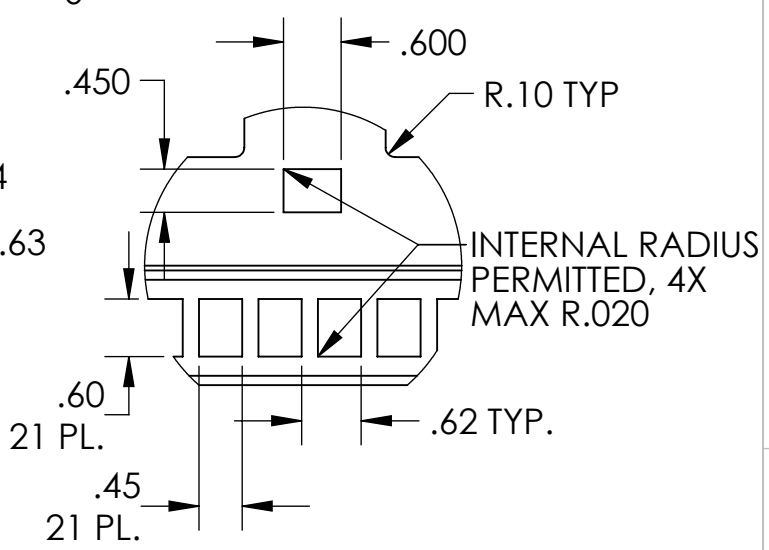
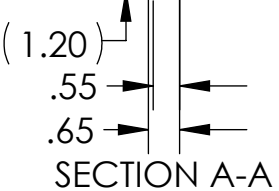
REV.	DATE	DCN #	DRAWING TREE #
v1	27 JUL 2017	E1700273-x0	-
v3	17 AUG 2017	E1700273-x0	-
v4	30 OCT 2017	E1700273-x0	-



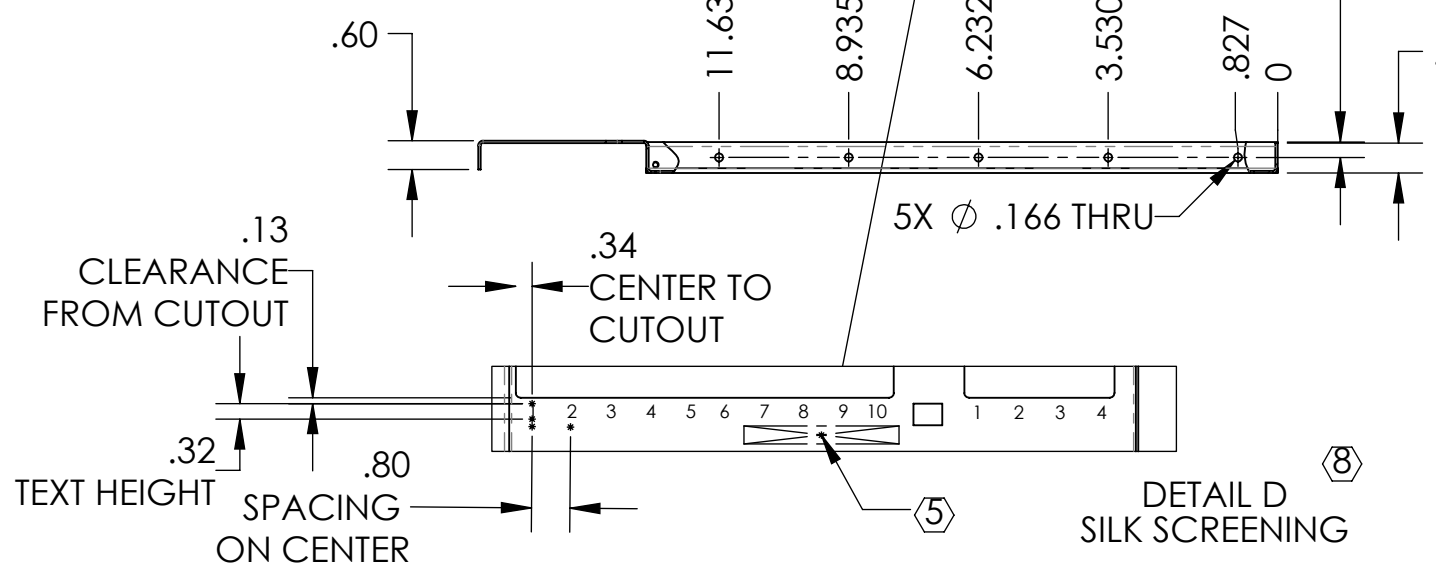
DETAIL C
SCALE 1:2



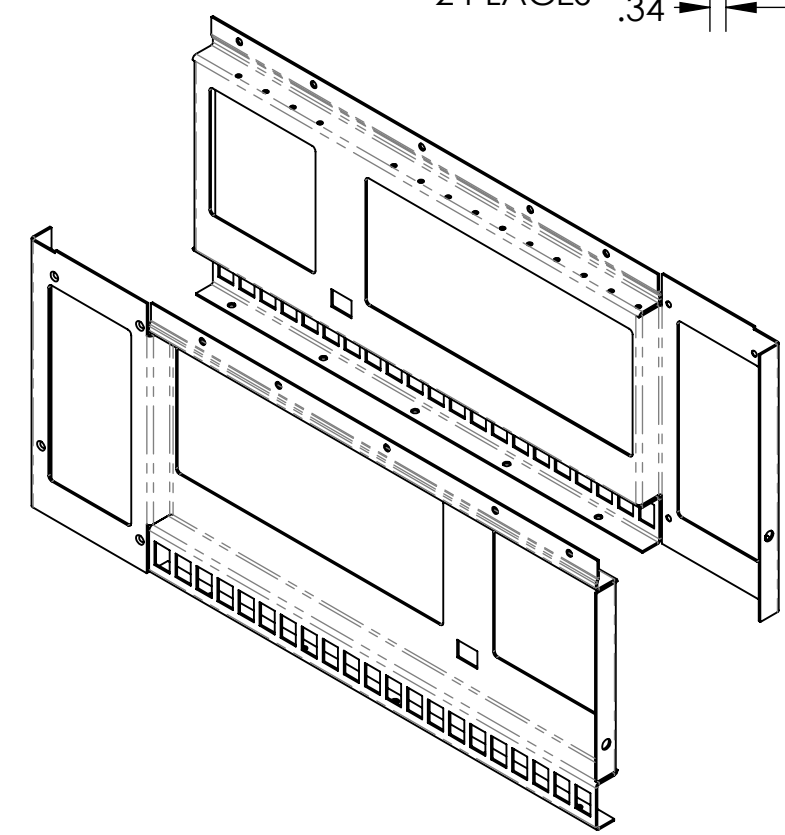
5X Ø .166^{+0.003}/_{-.000} THRU
 PEM INSERT #4-40, SELF CLINCHING
 (P/N S-440-1ZC OR EQUIVALENT)



DETAIL B
SCALE 1:2



DETAIL D
SILK SCREENING



ISOMETRIC VIEWS, FRONT AND BACK

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .05
 .XXX ± .010
 ANGULAR ± 1°

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.

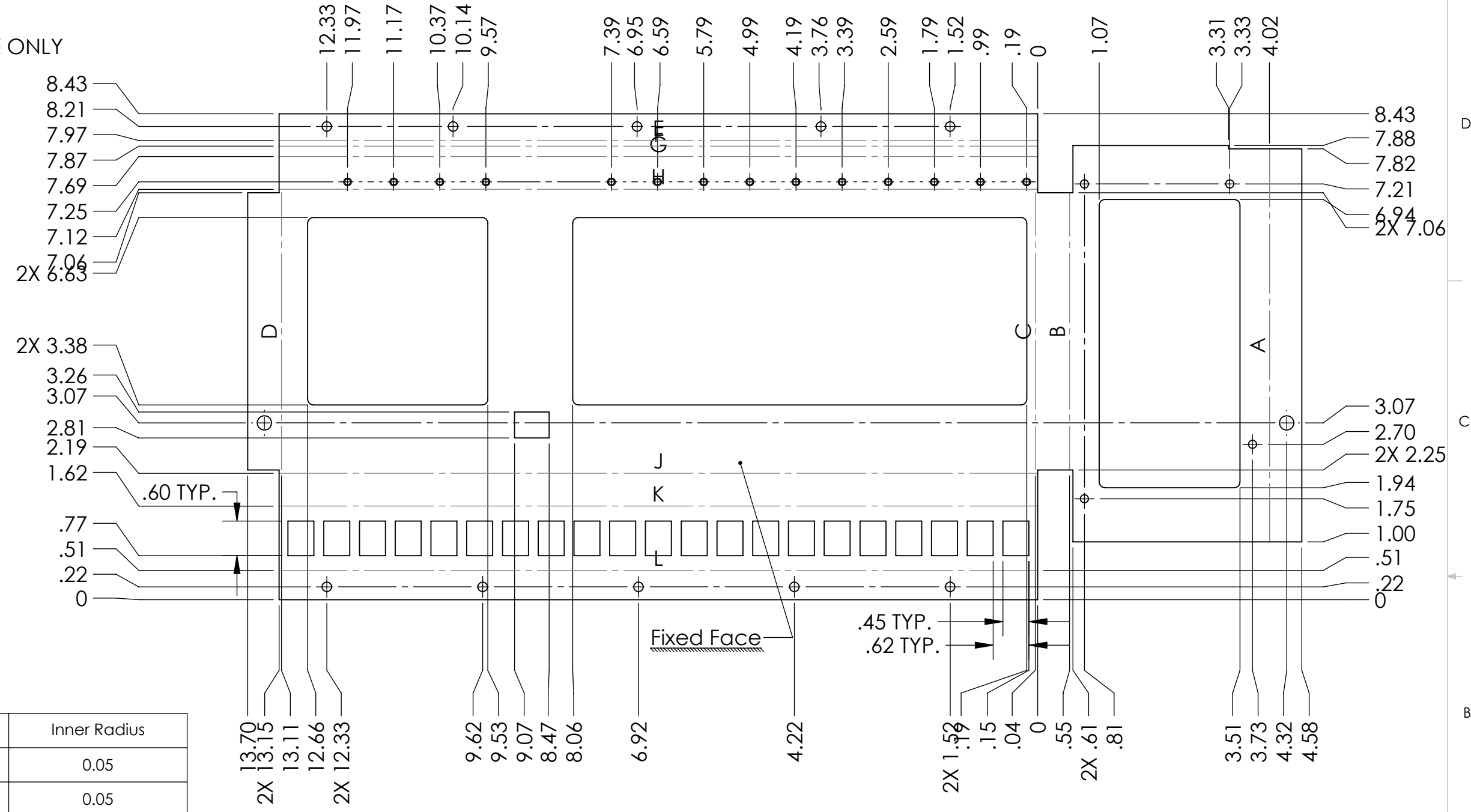
MATERIAL: CRS, 18 GAGE
 FINISH: (8) µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME LIGO, DAS, IO EXPANSION CHASSIS, BACK PANEL	
SYSTEM aLIGO	SUB-SYSTEM DAS	DESIGNER S APPERT	DATE 27 JUL 2017
DRAFTER S APPERT	CHECKER SEE DCC	SIZE B	DWG. NO. D1700344
NEXT ASSY D1101715	APPROVAL SEE DCC	REV. v4	SHEET 1 OF 2

D1700344 QLIGO, DAS, IO EXPANSION CHASSIS, BACK PANEL, PART PDM REV: X-001, DRAWING PDM REV: X-001

D1700344.dwg, DAS, IO EXPANSION CHASSIS, BACK PANEL, PART PDM REV: X-001, DRAWING PDM REV: X-001

FLAT PATTERN
ALL DIMENSIONS FOR REFERENCE ONLY



Tag	Direction	Angle	Inner Radius
A	UP	90°	0.05
B	UP	90°	0.05
C	DOWN	90°	0.05
D	DOWN	90°	0.05
E	DOWN	30°	0.05
F	UP	30°	0.05
G	UP	90°	0.05
H	DOWN	90°	0.05
J	DOWN	90°	0.05
K	UP	90°	0.05
L	UP	90°	0.05

 CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY
 SIZE DWG. NO. **B** D1700344 REV. v4
 SCALE: 1:2 PROJECTION:  SHEET 2 OF 2