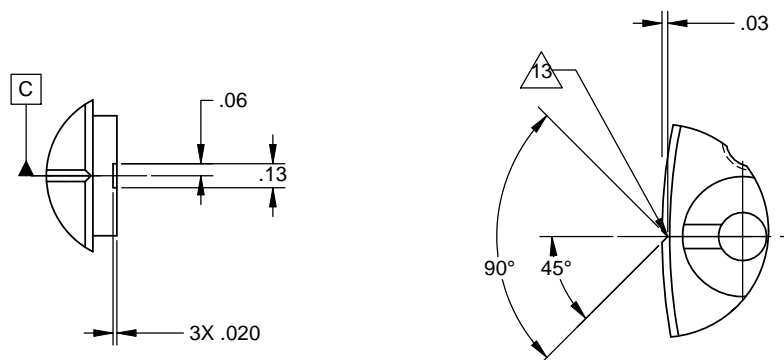
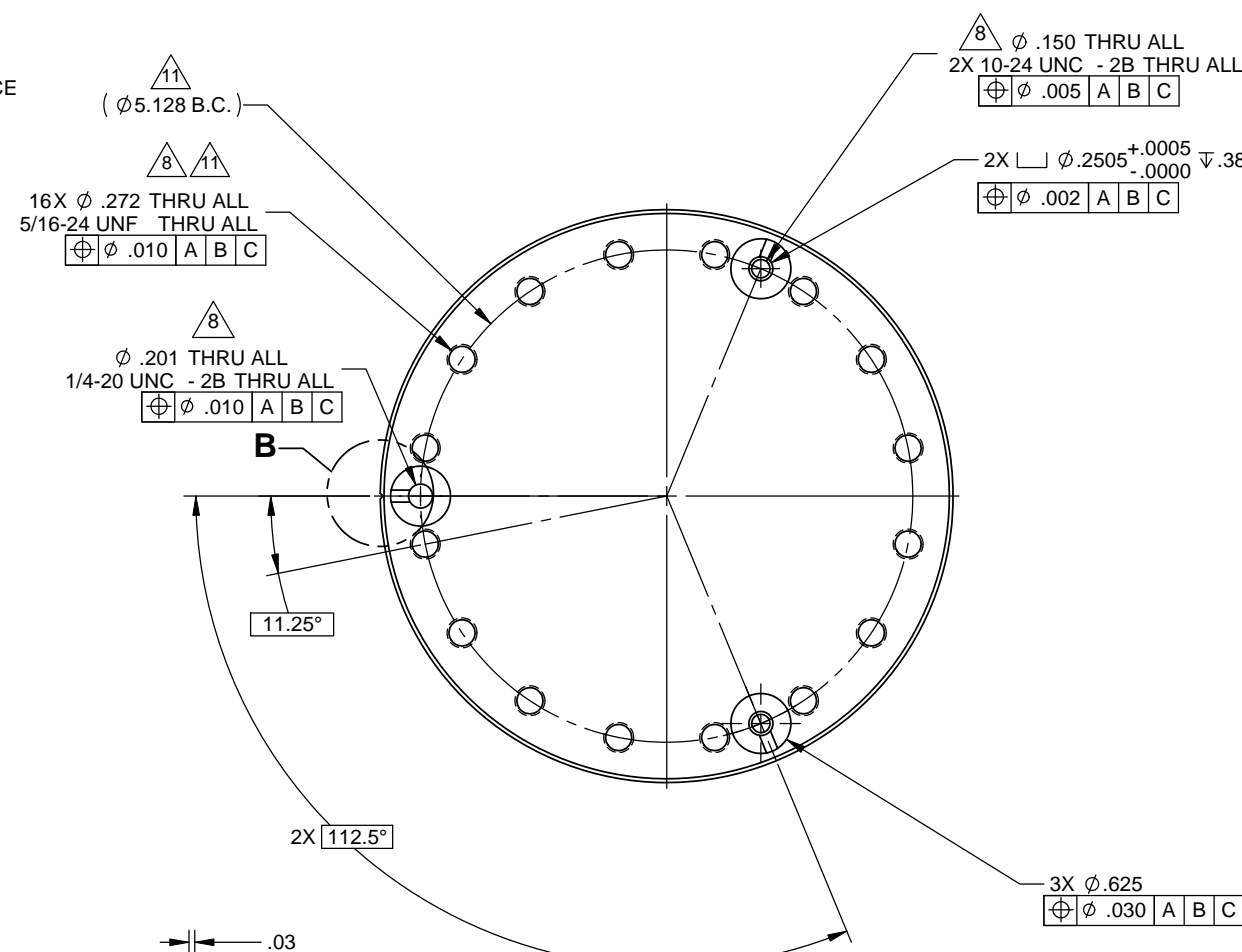
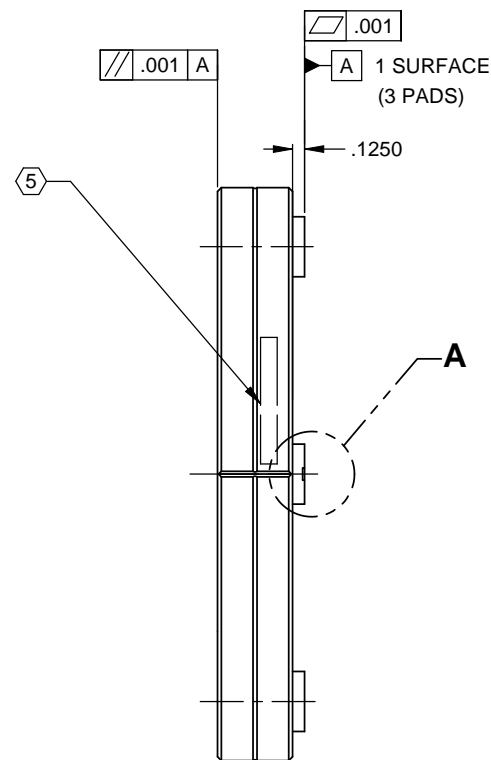
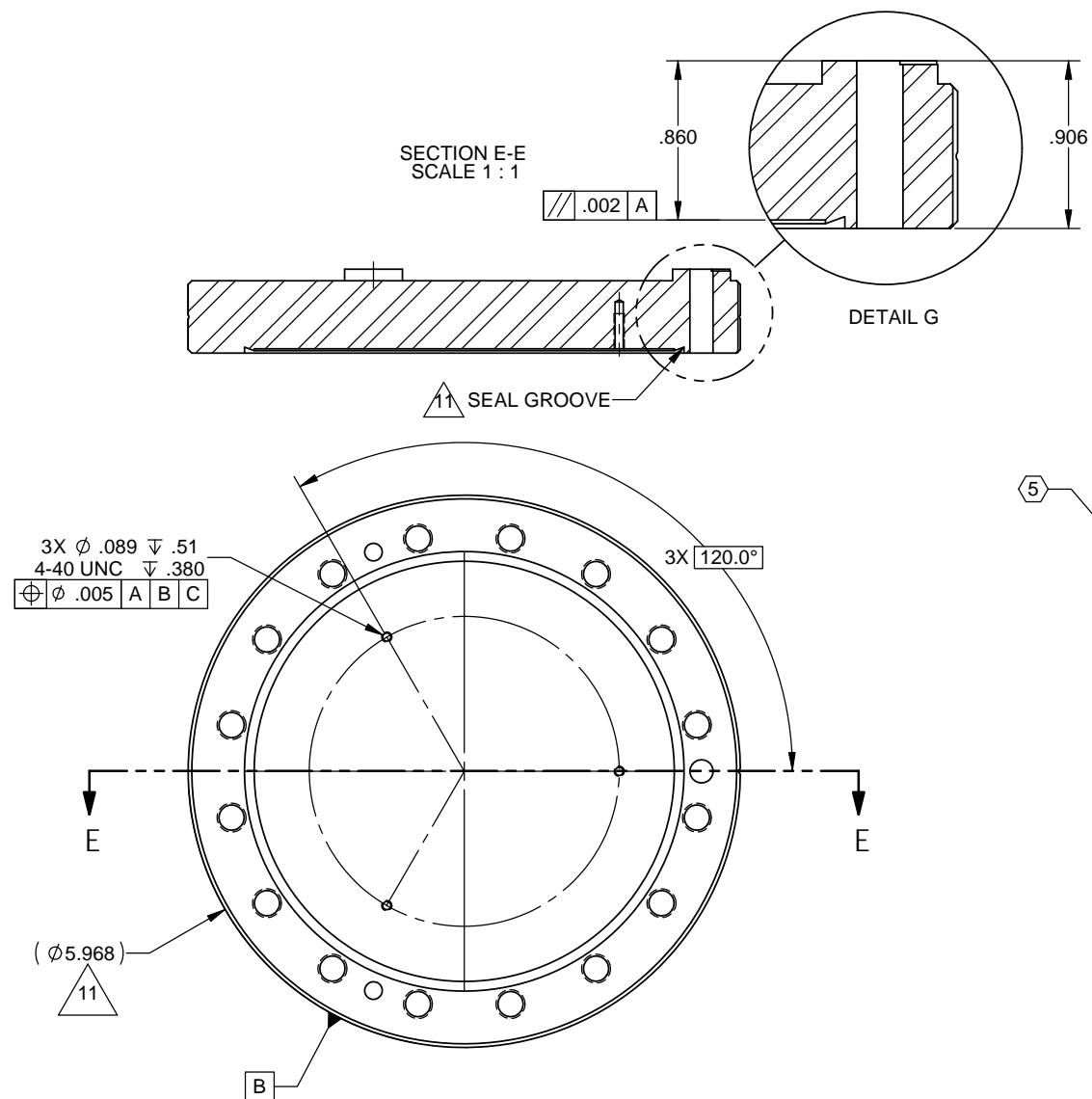


REV.	DATE	DCN #	DRAWING TREE #
V1	02 Dec. 2004		
V2	10 Jun. 2009		
V3	26 Jan. 2010	E0900436-x0	E1000025
V4	20 Feb. 2010	E1000048-x0	E1000025
V5	23 Apr. 2010	E1000140-v1	E1000025



NOTES CONTINUED:

- 5 SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INK 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. ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.
- 7. MACHINE FILET RADII .003-.015
- 8 A PITCH DIAMETER LIMIT OF H11 APPLIES AS NOTED
- 9. COUNTERSINK 82° ALL TAPPED HOLES TO MAJOR DIAMETER +.015/- .000.
- 10. COUNTERSINK 82° ALL DRILLED HOLES .015-.030 DEEP BOTH SIDES.
- 11 FEATURES THAT ARE REFERENCED OR UNDIMENSIONED SHALL CONFORM TO TO NOR-CAL PRODUCTS PART NUMBER 600-000NT (EXCEPT OVERALL THICKNESS).
- 12. REFERENCE MATING PART DRAWING D047823.
- 13 PHYSICAL CONFIGURATION OF VISUAL CLOCKING AID MAY VARY AT MANUFACTURERS OPTION BUT SHALL BE LOCATED AS SPECIFIED.
- 14. ESTIMATED WEIGHT IS 5.8 LBS.
- 15. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION LIGO DOCUMENT E0900364.
- 16. EXTERIOR OF POD WILL BE EXPOSED TO UHV.

DETAIL A  
SCALE: 2/1  
3X

DETAIL B  
SCALE: 2/1  
13

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.				LIGO		Base Plate Flange, L4C Pod	
DIMENSIONS ARE IN INCHES				SYSTEM	ADVANCED LIGO	SUB-SYSTEM	SEI
TOLERANCES: .XX ± .015 .XXX ± .005				MATERIAL	AISI 304	FINISH	63 $\mu$ inch
ANGULAR ± 0.5°				NEXT ASSY	D047820	DESIGNER	ASI 02 DEC 2004
						DRAFTER	F.MATICHARD 20 FEB 2010
						CHECKER	S.BARNUM 20 FEB 2010
						APPROVAL	K.MASON 20 FEB 2010
				SIZE	D	DWG. NO.	D047822
				SCALE:	2:1	PROJECTION:	1
						REV.	v5
						SHEET 1 OF 1	