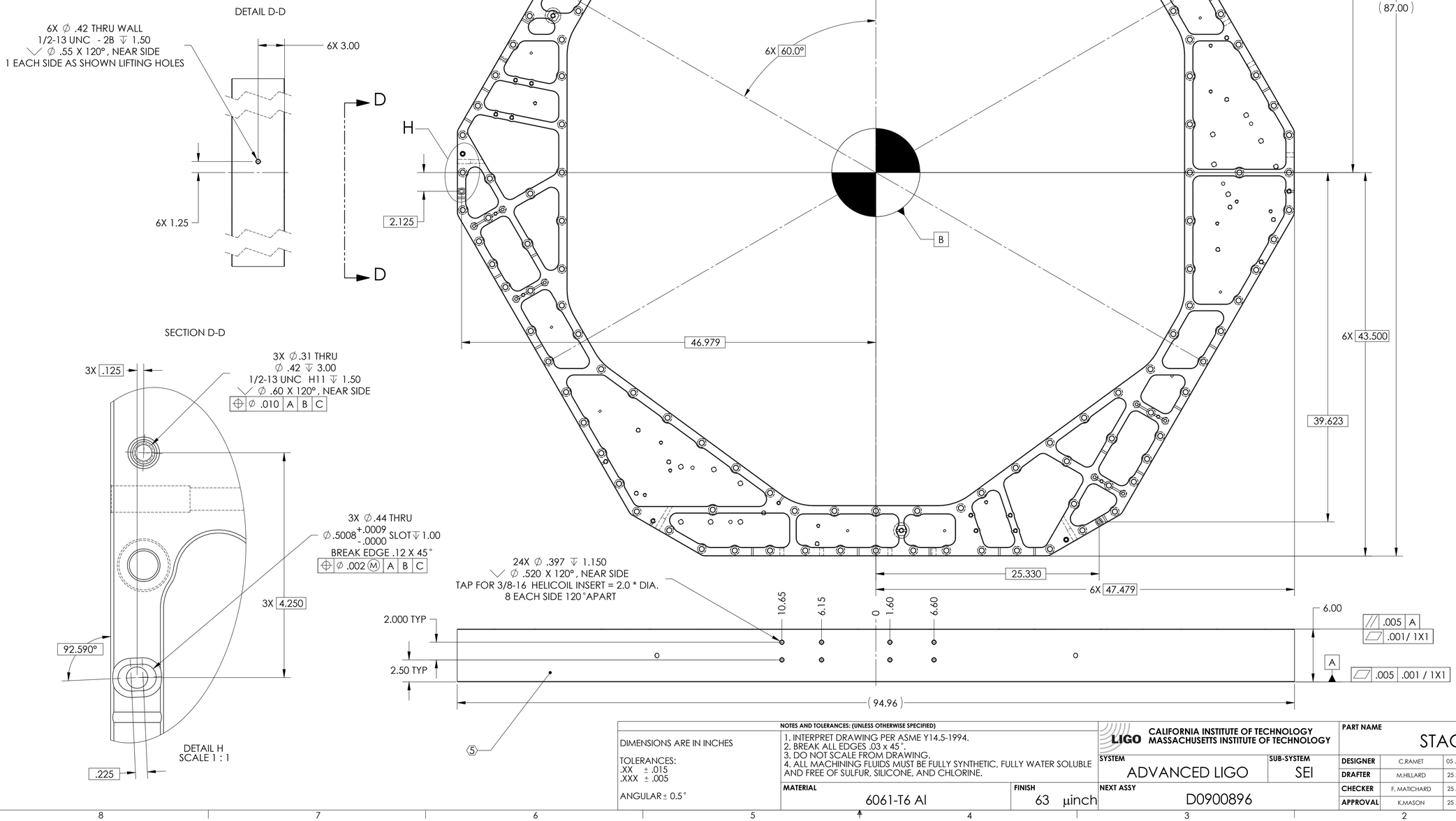
REV.	DATE	DCN #	DRAWING TREE #
v1	25 Jan 2010	E1000013	T0900600

NOTES CONTINUED:

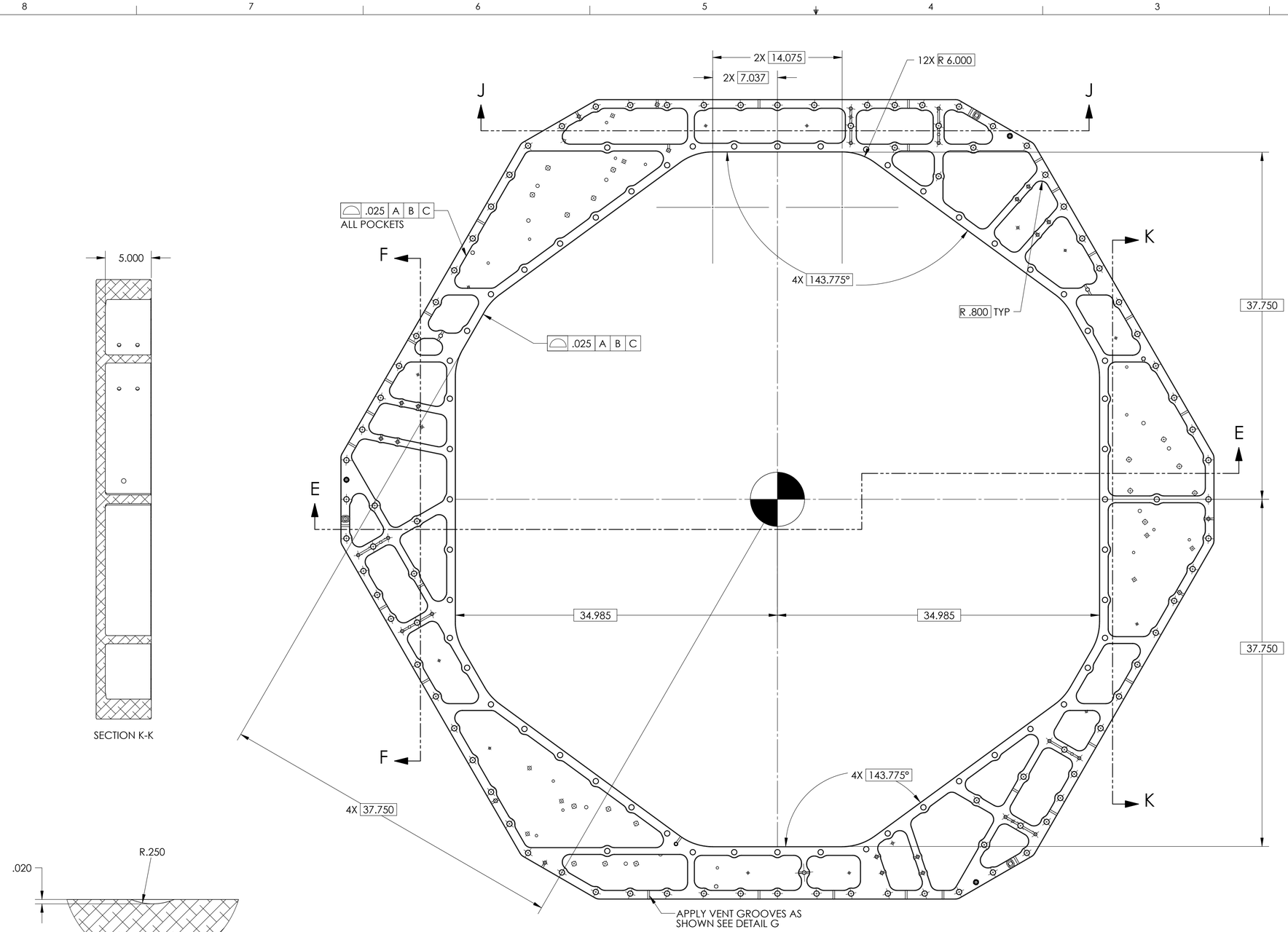
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.
6. THIS PART IS TO BE PRODUCED USING THE CAD MODEL. IF THERE ARE DISCREPANCIES BETWEEN THIS DRAWING AND THE CAD MODEL, THE MODEL WILL TAKE PRECEDENCE.
7. SURFACES WITH PROFILE CONTROL ARE LOCATED BASIC WITH RESPECT TO REFERENCED DATUMS. A SURFACE PROFILE TOLERANCE OF .025 SHALL APPLY TO THE ENTIRE PART UNLESS SPECIFICALLY TOLERANCED ELSEWHERE ON THE DRAWING.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E048225.
9. APPROXIMATE WEIGHT = 572LB.
10. A TRUE POSITION TOLERANCE OF Ø.010 IS ~ THE SAME AS A CONVENTIONAL TOLERANCE OF ±.005.
11. MULTIPLE SHEET DRAWING: SHEETS MAY HAVE DIFFERENT SCALES.
12. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.
13. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONEL, AFTER DELIVERY OF FINISHED PARTS.



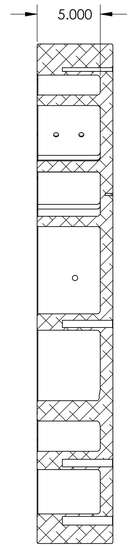
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)					
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± 0.5°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. BREAK ALL EDGES .03 x 45°. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: STAGE 0 TOP, aLIGO BSC-ISI
	MATERIAL: 6061-T6 Al	FINISH: 63 µinch	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: SEI	
			NEXT ASSY: D0900896		

DESIGNER	C.RAMET	05 Jan. 2010	SIZE	DWG. NO.	REV.
DRAFTER	M.HILLARD	25 Jan 2010	D	D0900895	v1
CHECKER	F. MATICHARD	25 Jan 2010			
APPROVAL	K.MASON	25 Jan 2010	SCALE: 1:6	PROJECTION:	SHEET 1 OF 3

D0900895 Adv LIGO SEI BSC Stage 0 Top, PART PDM REV- X-065, DRAWING PDM REV- X-020

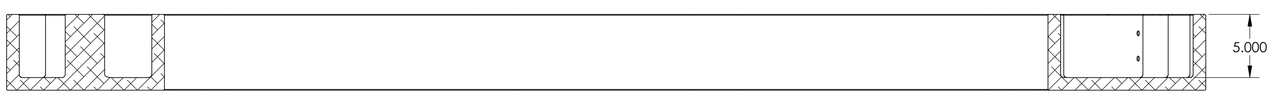


SECTION K-K

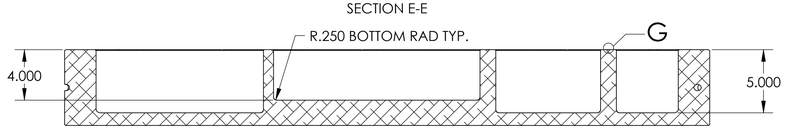


SECTION F-F

DETAIL G
SCALE 4 : 1

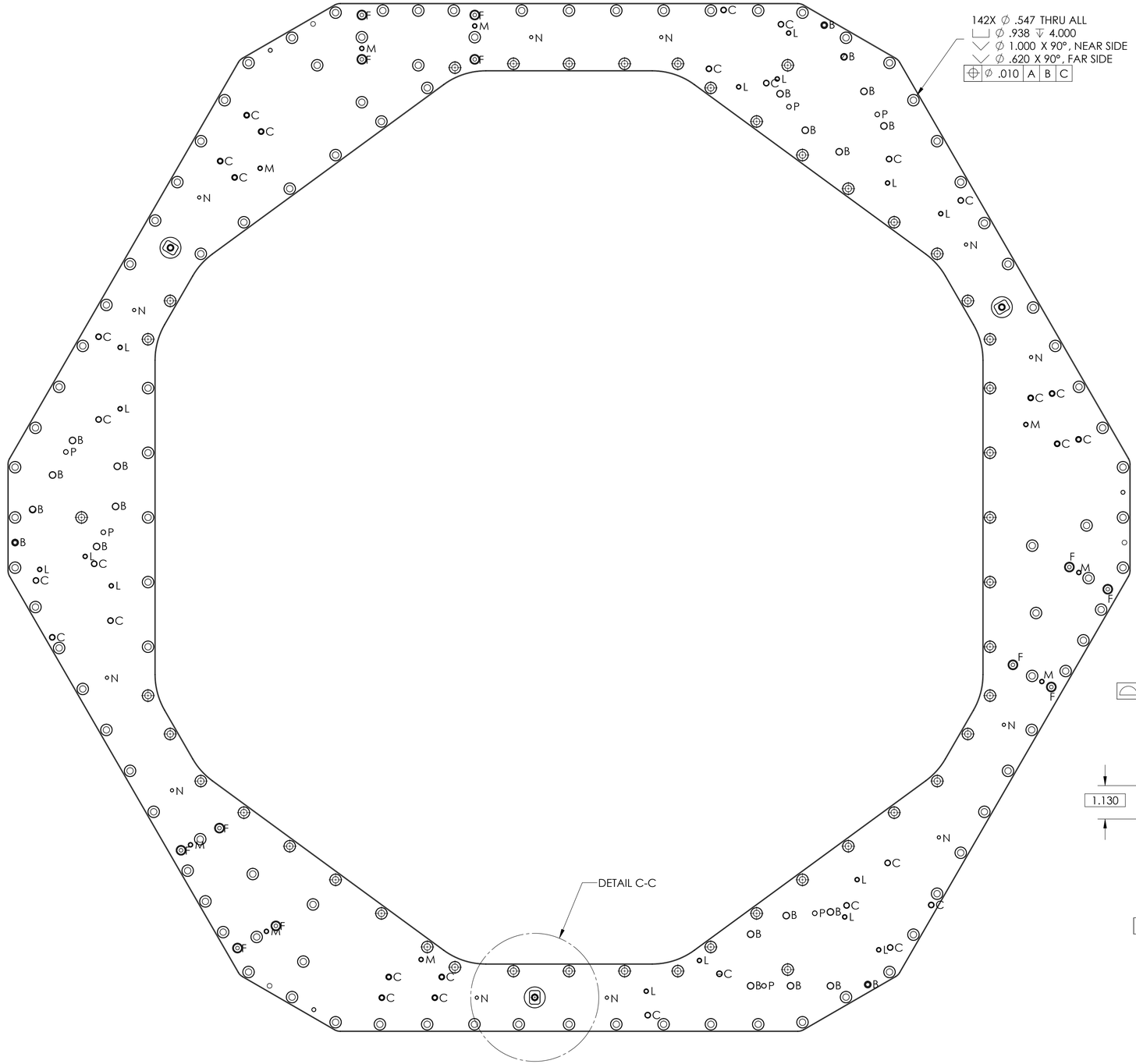


SECTION E-E



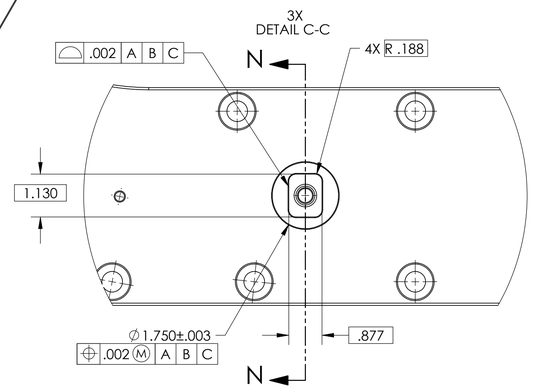
SECTION J-J

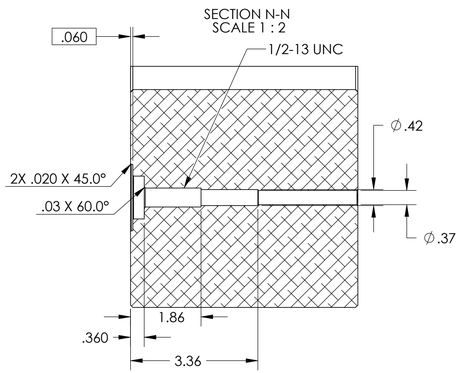
LIGO	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SIZE D	DWG. NO. D0900895	REV. v1
SCALE: 1:6	PROJECTION:	SHEET 2 OF 3



TAG	SIZE	QUANTITY	GD&T
B	∅ .42 ↧ 1.50 1/2-13 UNC ↧ 1.00 ◡ ∅ .60 X 120°, NEAR SIDE ∅ .31 THRU	21	⌖ ∅ .010 A B C H11 tapped hole oversize apply
C	∅ .40 ↧ 2.00 ◡ ∅ .52 X 120°, NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA. ∅ .31 THRU	30	⌖ ∅ .010 A B C
F	∅ .66 ↧ 3.00 ◡ ∅ .85 X 120°, NEAR SIDE TAP FOR 5/8-11 HELICOIL INSERT = 2.0 * DIA. ∅ .31 THRU	12	⌖ ∅ .010 A B C
L	∅ $.3750^{+.0004}_{-.0000}$ ↧ .60 ⌴ ∅ $.377^{+.001}_{-.000}$ ↧ .13 ◡ ∅ .42 X 90°, NEAR SIDE ∅ .28 THRU	15	⌖ ∅ .002 Ⓜ A B C
M	∅ $.3750^{+.0004}_{-.0000}$ ↧ .60 ⌴ ∅ $.377^{+.001}_{-.000}$ ↧ .13 ◡ ∅ .42 X 90°, NEAR SIDE ∅ .28 THRU	9	⌖ ∅ .002 Ⓜ A B C
N	∅ .20 THRU ALL 1/4-20 UNC THRU ALL ◡ ∅ .30 X 120°, NEAR SIDE	12	⌖ ∅ .010 A B C H11 tapped hole oversize apply
P	∅ $.375^{+.000}_{-.000}$ THRU ALL ⌴ ∅ $.377^{+.001}_{-.000}$ ↧ .130 ◡ ∅ .420 X 90°, NEAR SIDE	6	⌖ ∅ .002 Ⓜ A B C

"L" HOLES = "M" HOLES = "P" HOLES





LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
D	D0900895	v1
SCALE: 1:12	PROJECTION:	SHEET 3 OF 3

D0900895 Adv LIGO SEI BSC Stage 0 Top, PART PDM REV: X-065, DRAWING PDM REV: X-020