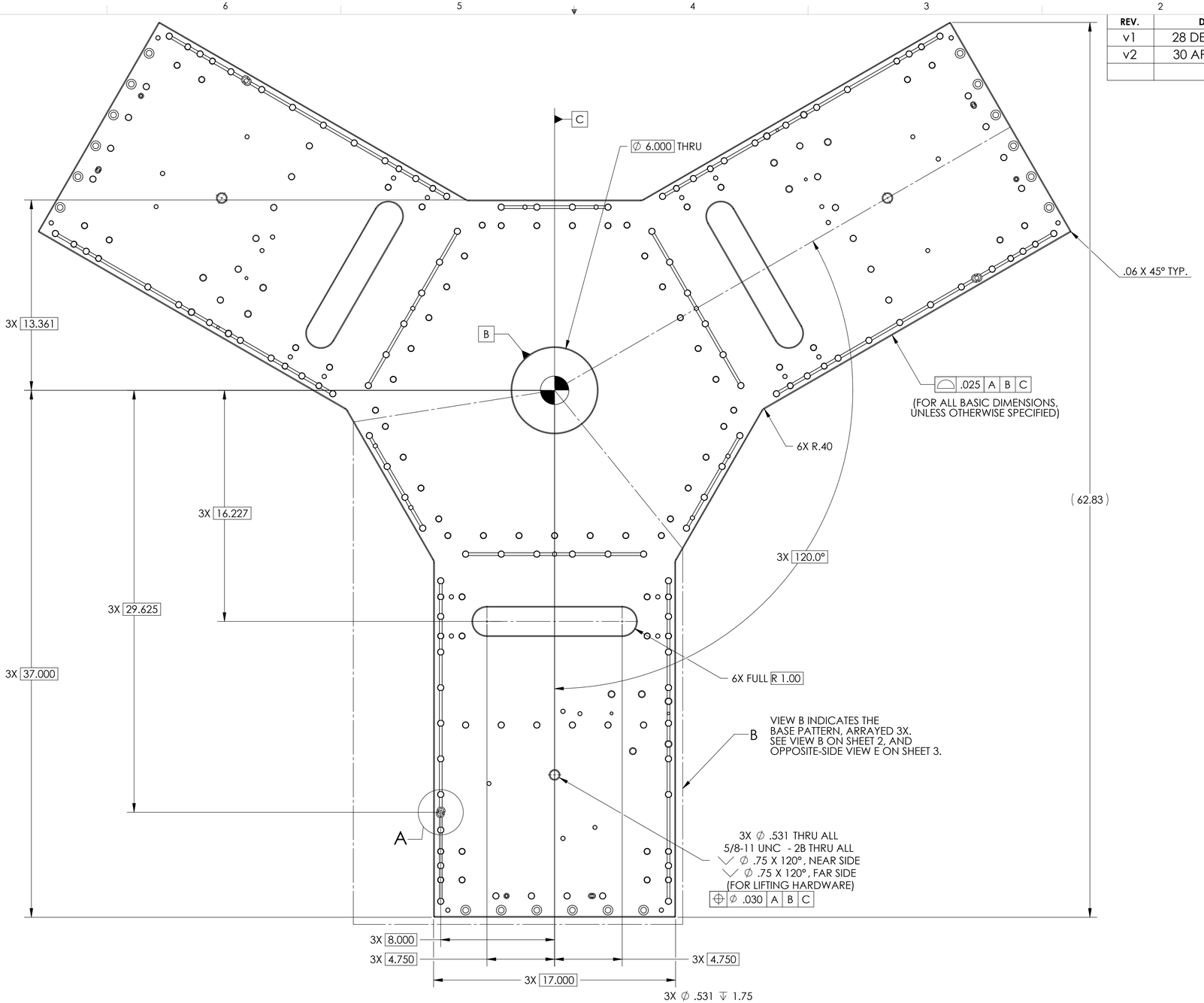
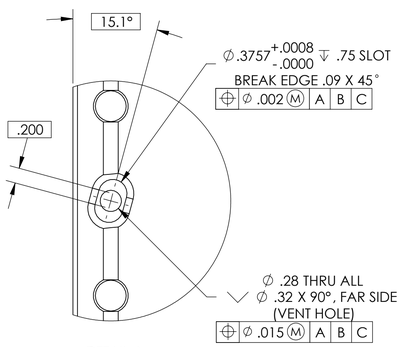
NOTES CONTINUED:

⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIENT 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 0.25" 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.

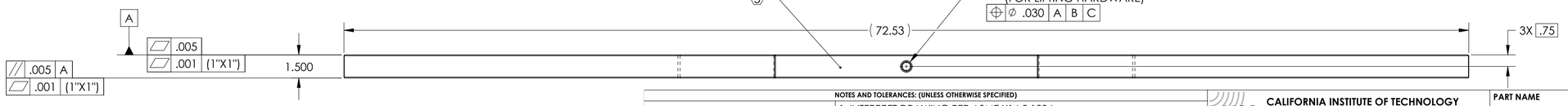
6. THIS DRAWING IS MINIMALLY DIMENSIONED. USE CAD MODEL TO EVALUATE FULL DIMENSIONAL DETAIL. UNLESS OTHERWISE SPECIFIED, THE MODEL TAKES PRECENDENCE OVER THE DRAWING WHEREVER THERE ARE DISCREPANCIES.
7. UNLESS OTHERWISE SPECIFIED, ALL SURFACES MUST SATISFY .025 PROFILE TOLERANCE WITH RESPECT TO DATUMS A, B, AND C.
8. APPROXIMATE WEIGHT = 245 LB.
9. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
11. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES TO ALL TAPPED HOLES, EXCLUDING THREADED INSERTS AND HOLES LABELED "FOR LIFTING HARDWARE."
12. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS. USE ONLY NITRONIC 60 INSERTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	28 DEC 2009	E0900496	E1000025
v2	30 APR 2010	E1000129	E1000025





DETAIL A
SCALE 1 : 1
TYP. PIN SLOT DETAIL
(3 PLACES)



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .015
.XXX ± .005

ANGULAR ± .5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. BREAK ALL EDGES AND CORNERS .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.

MATERIAL: 6061-T6 Al
FINISH: 63 µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SEI
NEXT ASSY: D0901181

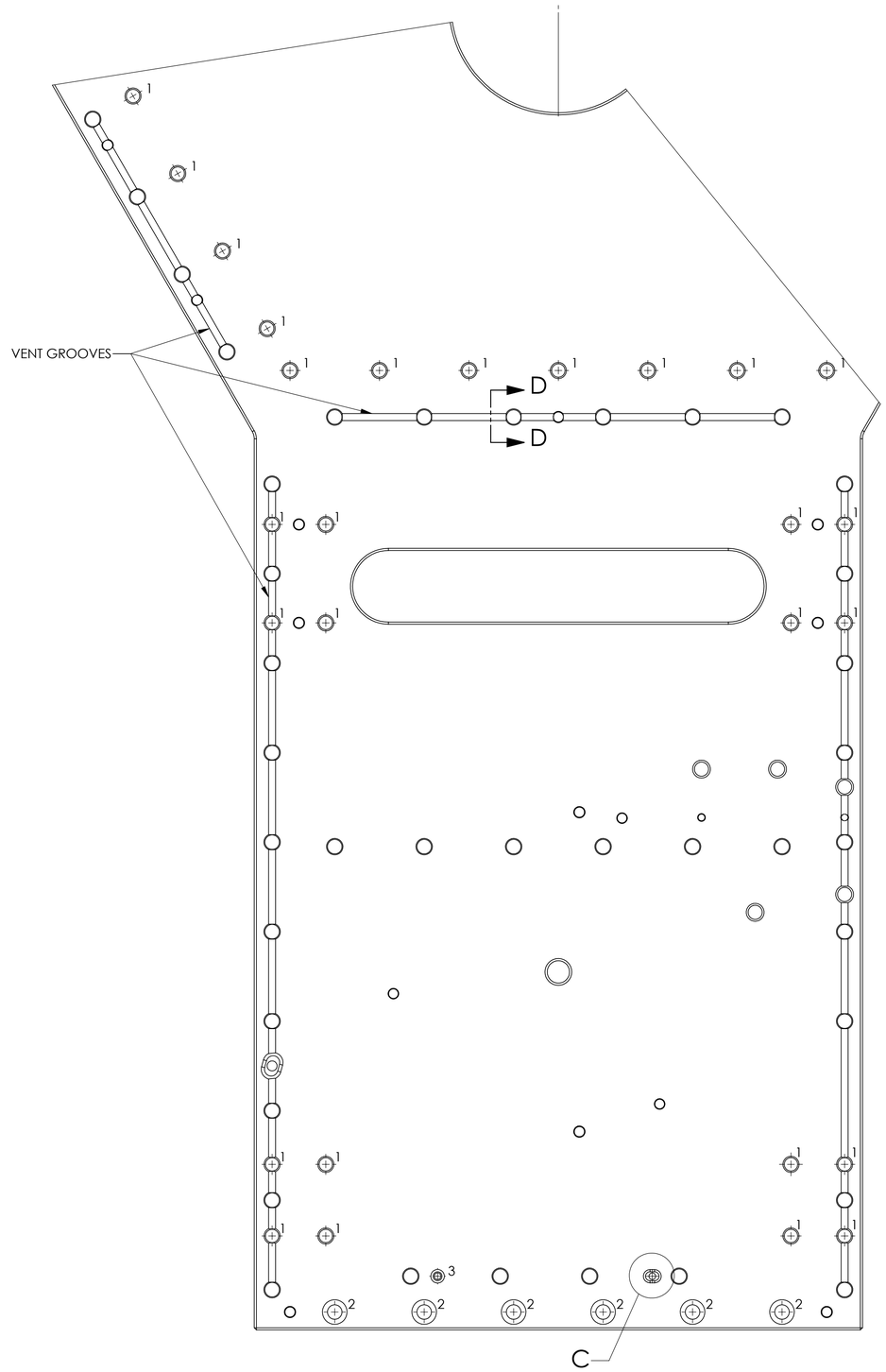
PART NAME: Mid-Plate, aLIGO BSC ISI

DESIGNER	A.STEIN	28 Dec. 2009	
DRAFTER	M.HILLARD	28 Dec. 2009	
CHECKER	F.MATICHARD	28 Dec. 2009	
APPROVAL	K.MASON	28 Dec. 2009	

SIZE: D
DWG. NO.: D0901520
REV.: v2
SCALE: 1:4
PROJECTION:
SHEET 1 OF 3

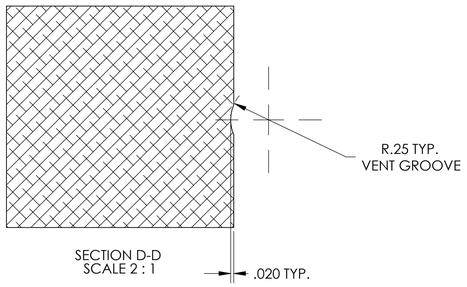
D0901520_Mid-Plate-BSC_ISI_PART PDM REV: X-040, DRAWING PDM REV: X-011

VIEW B
VIEW SHOWN INDICATES
THE BASE PATTERN, ARRAYED 3X

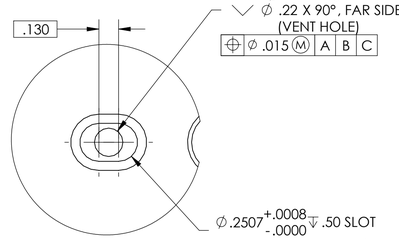


TAG	SIZE	QUANTITY	GD&T
1	∅ .313 THRU ALL 3/8-16 UNC THRU ALL ⌵ ∅ .45 X 120°, NEAR SIDE ⌵ ∅ .45 X 120°, FAR SIDE	27	⌖ ∅ .010 A B C NOTE 11
2	∅ .406 THRU ALL ⌴ ∅ .688 ↧ .95 ⌵ ∅ .46 X 90°, FAR SIDE	6	⌖ ∅ .010 Ⓜ A B C
3	∅ $.2507^{+.0008}_{-.0000}$ ↧ .50 ⌵ ∅ .38 X 90°, NEAR SIDE ∅.19 THRU ALL (VENT) ⌵ .22 X 90°, FAR SIDE	1	⌖ ∅ .002 Ⓜ A B C

HOLE PATTERN ARRAYED 3X



SECTION D-D
SCALE 2 : 1



DETAIL C
SCALE 2 : 1

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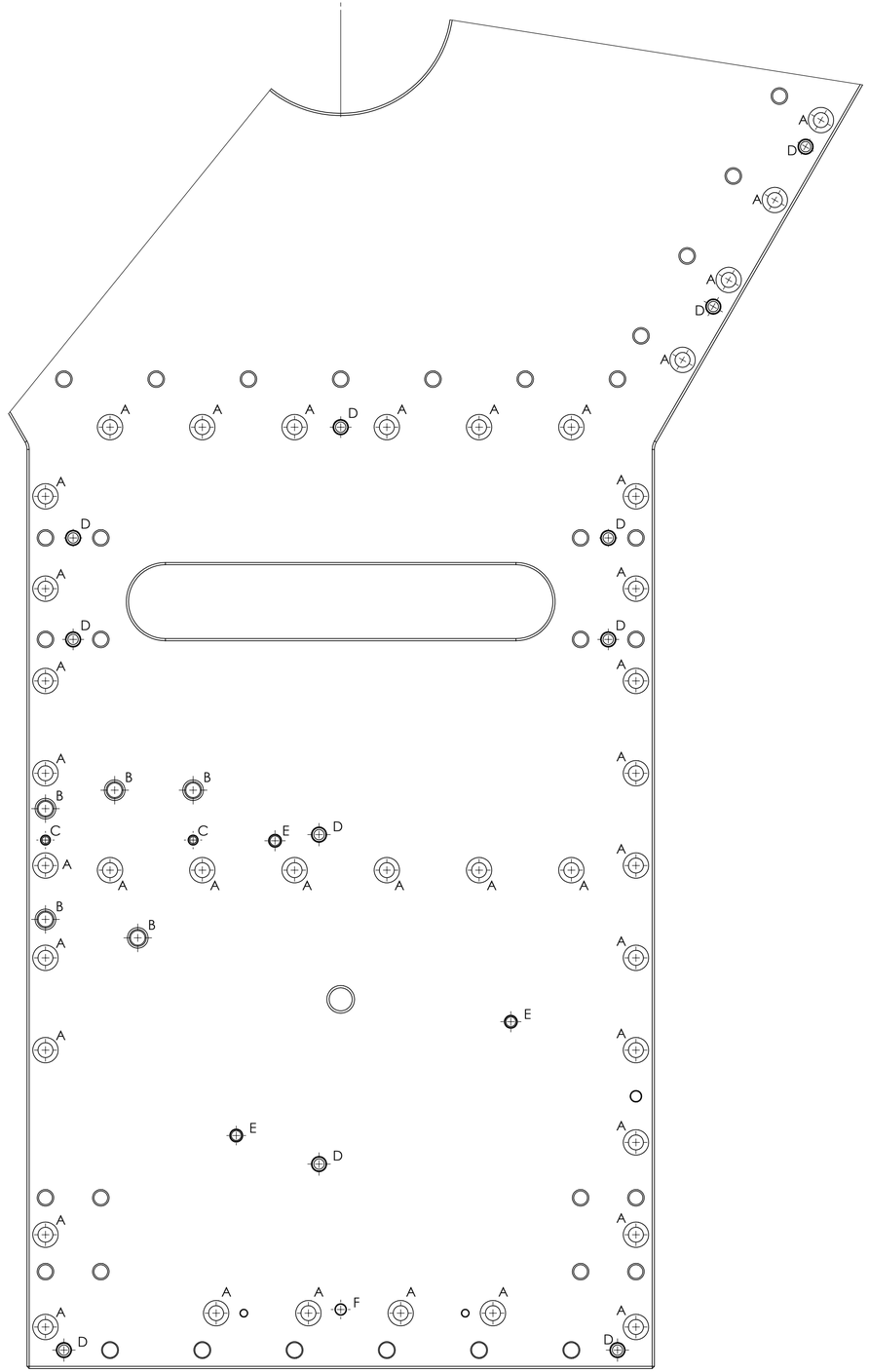
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
D	D0901520	v2
SCALE: 1:2	PROJECTION:	SHEET 2 OF 3

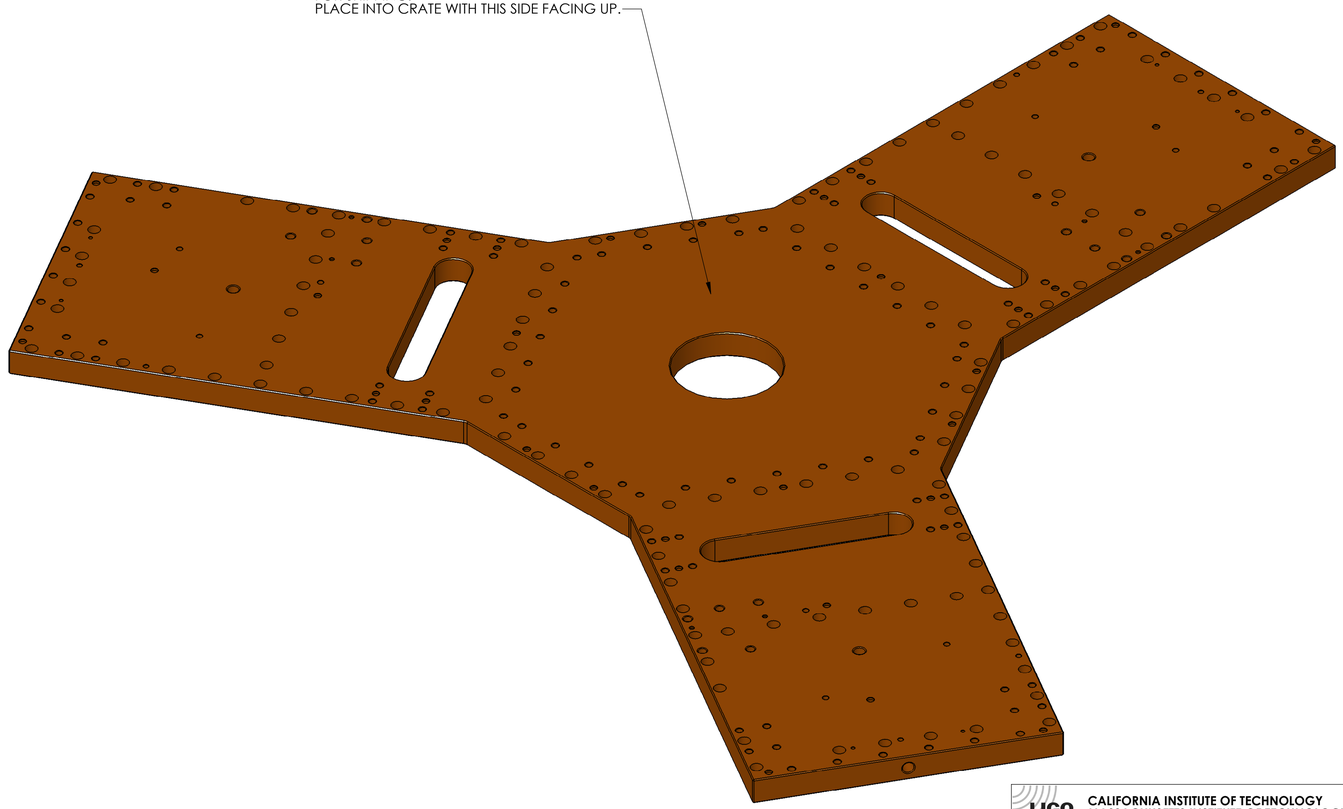
VIEW E
VIEW SHOWN INDICATES
THE BASE PATTERN, ARRAYED 3X



TAG	SIZE	QUANTITY	TOLERANCE
A	∅ .406 THRU ALL ⌴ ∅ .688 ↧ 1.00 ◡ ∅ .46 X 90°, FAR SIDE	39	⌖ ∅ .010 Ⓜ A B C
B	∅ .397 THRU ALL ◡ ∅ .56 X 120°, NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA. ◡ ∅ .50 X 90°, FAR SIDE	5	⌖ ∅ .010 A B C
C	∅ $.2500^{+.0000}_{-.0004}$ ↧ .38 ⌴ ∅ $.251^{+.001}_{-.000}$ ↧ .10 ◡ ∅ .28 X 90°, NEAR SIDE ∅.19 THRU ALL (VENT) ◡ ∅.22 X 90°, FAR SIDE	2	⌖ ∅ .002 Ⓜ A B C
D	∅ $.3750^{+.0000}_{-.0004}$ ↧ .60 ⌴ ∅ $.377^{+.001}_{-.000}$ ↧ .13 ◡ ∅ .42 X 90°, NEAR SIDE ∅.28 THRU ALL (VENT) ◡ ∅.32 X 90°, FAR SIDE	11	⌖ ∅ .002 Ⓜ A B C
E	∅ .266 THRU ALL ◡ ∅ .36 X 120°, NEAR SIDE TAP FOR 1/4-20 HELICOIL INSERT = 2.0 * DIA. ◡ ∅ .30 X 90°, FAR SIDE	3	⌖ ∅ .010 A B C
F	∅ .28 ↧ .75 ◡ ∅ .32 X 90°, NEAR SIDE	1	⌖ ∅ .030 A B C VENT HOLE

HOLE PATTERN ARRAYED 3X

FOR SHIPPING:
PLACE INTO CRATE WITH THIS SIDE FACING UP.



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SIZE	DWG. NO.	REV.
D	D0901520	v2
SCALE: 1:2	PROJECTION:	SHEET 3 OF 3