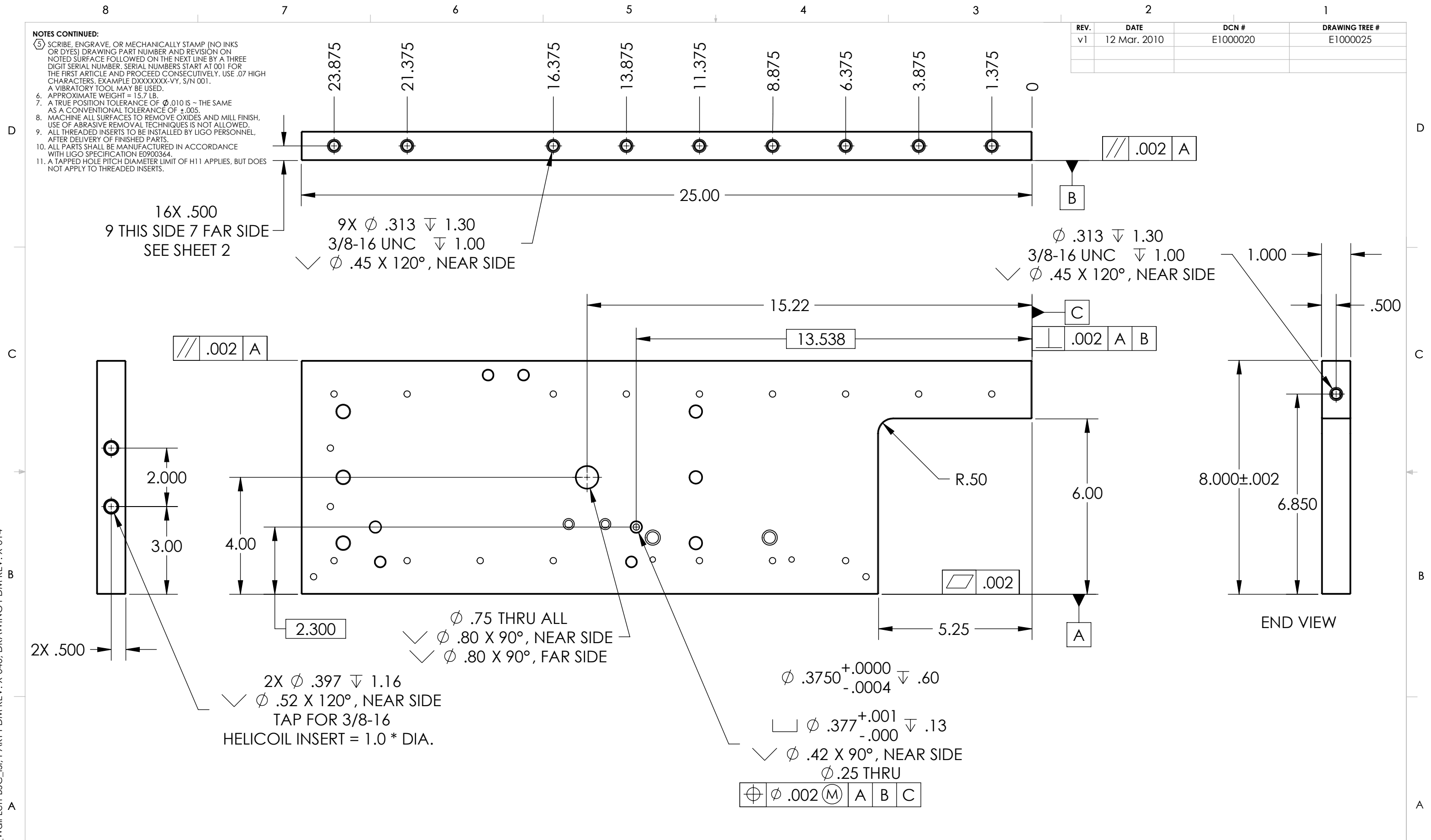


D0901521_Radial_Wall-Left-BSC_ISI, PART PDM REV: X-040, DRAWING PDM REV: X-014

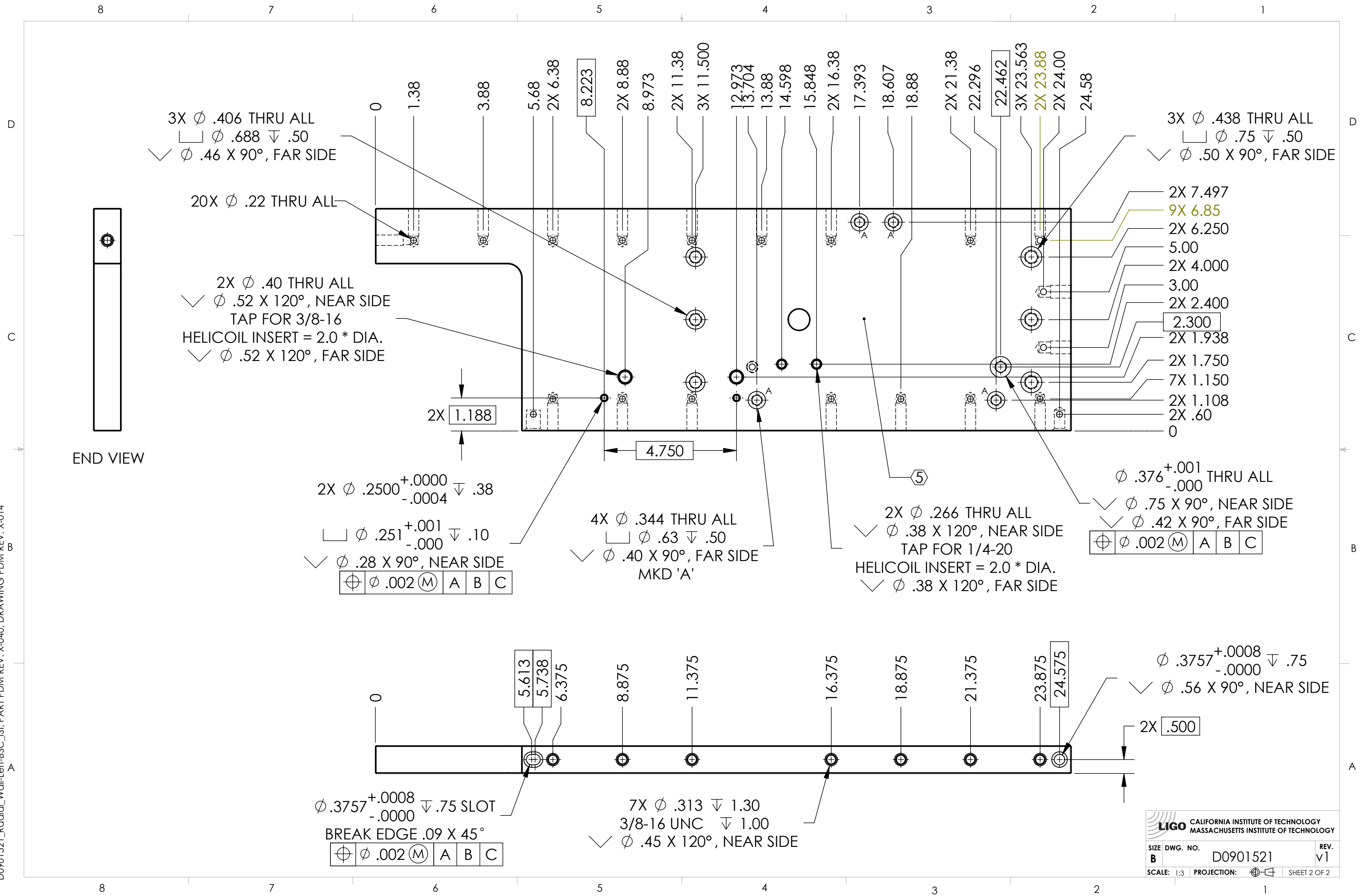
NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07 HIGH CHARACTERS. EXAMPLE DXXXXXX-VY, S/N 001.
 A VIBRATORY TOOL MAY BE USED.
 6. APPROXIMATE WEIGHT = 15.7 LB.
 7. A TRUE POSITION TOLERANCE OF $\phi .010$ IS - THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.
 8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
 9. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS.
 10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 11. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES, BUT DOES NOT APPLY TO THREADED INSERTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	12 Mar. 2010	E1000020	E1000025



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				1. INTERPRET DRAWING PER ASME Y14.5-1994.		Radial Wall, Left, aLIGO BSC ISI	
TOLERANCES: .XX ± .015 .XXX ± .005				2. BREAK ALL EDGES AND CORNERS .03 X 45°.		DESIGNER A.STEIN 11 Jan. 2010	
ANGULAR ± 0.5°				3. DO NOT SCALE FROM DRAWING.		DRAFTER M.HILLARD 11 Jan. 2010	
MATERIAL 6061-T6 Al				4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		CHECKER F.MATICHARD 11 Jan. 2010	
FINISH 63 μinch				NEXT ASSY D0901181		APPROVAL K.MASON 11 Jan. 2010	
SYSTEM ADVANCED LIGO				SUB-SYSTEM SEI		SIZE DWG. NO. B D0901521	
SCALE: 1:3				PROJECTION:		REV. v1	
SHEET 1 OF 2							

D0901521_Rodical_Wall-Left-BSC_ISI, PART PDM REV: X-040, DRAWING PDM REV: X-014



3X Ø .406 THRU ALL
┌───┐ Ø .688 ▽ .50
✓ Ø .46 X 90°, FAR SIDE

20X Ø .22 THRU ALL

2X Ø .40 THRU ALL
✓ Ø .52 X 120°, NEAR SIDE
TAP FOR 3/8-16
HELICOIL INSERT = 2.0 * DIA.
✓ Ø .52 X 120°, FAR SIDE

3X Ø .438 THRU ALL
┌───┐ Ø .75 ▽ .50
✓ Ø .50 X 90°, FAR SIDE

- 2X 7.497
- 9X 6.85
- 2X 6.250
- 5.00
- 2X 4.000
- 3.00
- 2X 2.400
- 2.300
- 2X 1.938
- 2X 1.750
- 7X 1.150
- 2X 1.108
- 2X .60
- 0

2X Ø .2500^{+0.0000} ▽ .38
-0.0004

┌───┐ Ø .251^{+0.001} ▽ .10
-0.000
✓ Ø .28 X 90°, NEAR SIDE
⊕ ⊖ Ø .002 (M) A B C

4X Ø .344 THRU ALL
┌───┐ Ø .63 ▽ .50
✓ Ø .40 X 90°, FAR SIDE
MKD 'A'

2X Ø .266 THRU ALL
✓ Ø .38 X 120°, NEAR SIDE
TAP FOR 1/4-20
HELICOIL INSERT = 2.0 * DIA.
✓ Ø .38 X 120°, FAR SIDE

Ø .376^{+0.001} THRU ALL
-0.000
✓ Ø .75 X 90°, NEAR SIDE
✓ Ø .42 X 90°, FAR SIDE
⊕ ⊖ Ø .002 (M) A B C

Ø .3757^{+0.0008} ▽ .75 SLOT
-0.0000
BREAK EDGE .09 X 45°
⊕ ⊖ Ø .002 (M) A B C

7X Ø .313 ▽ 1.30
3/8-16 UNC ▽ 1.00
✓ Ø .45 X 120°, NEAR SIDE

Ø .3757^{+0.0008} ▽ .75
-0.0000
✓ Ø .56 X 90°, NEAR SIDE
2X .500

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MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D0901521	v1
SCALE: 1:3	PROJECTION:	SHEET 2 OF 2