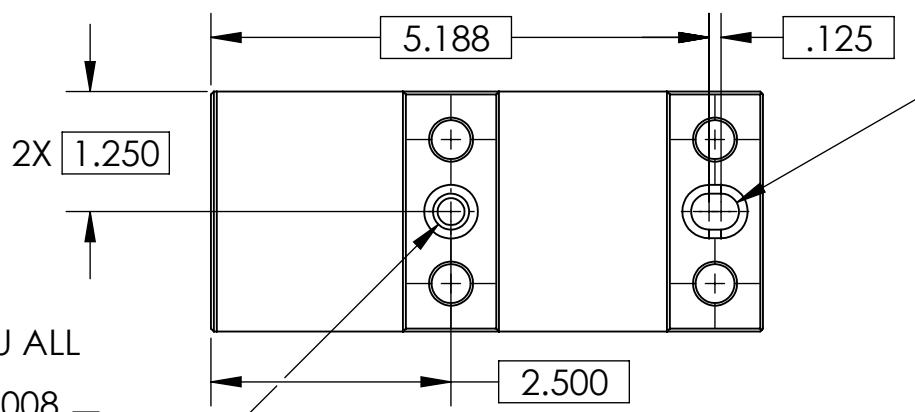
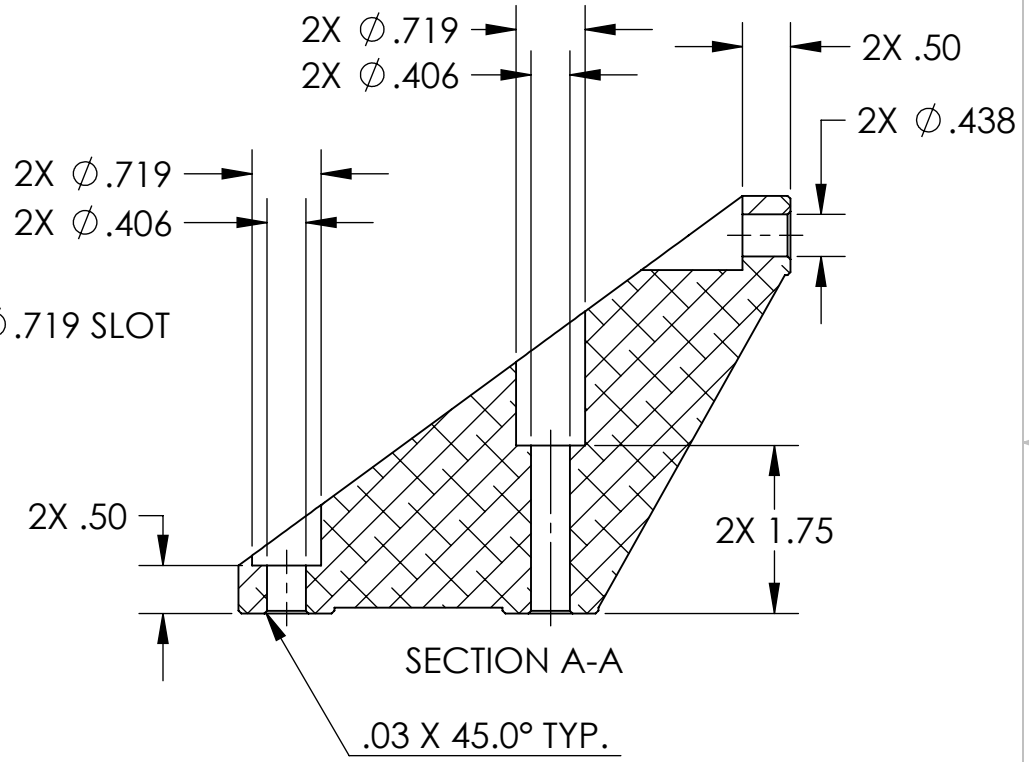
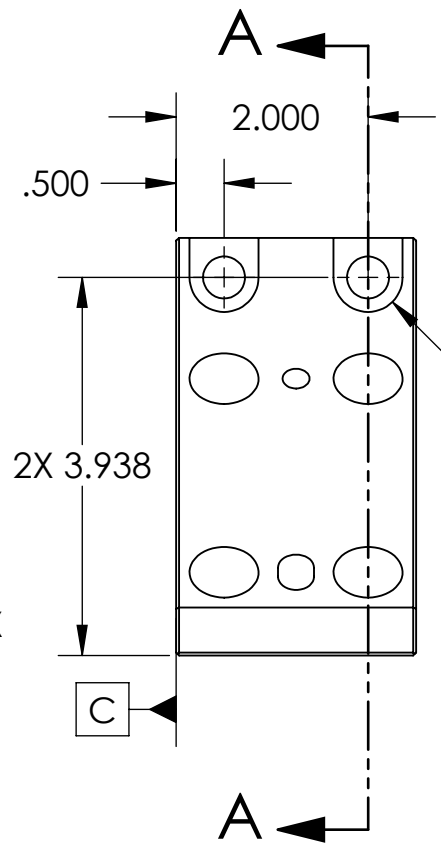
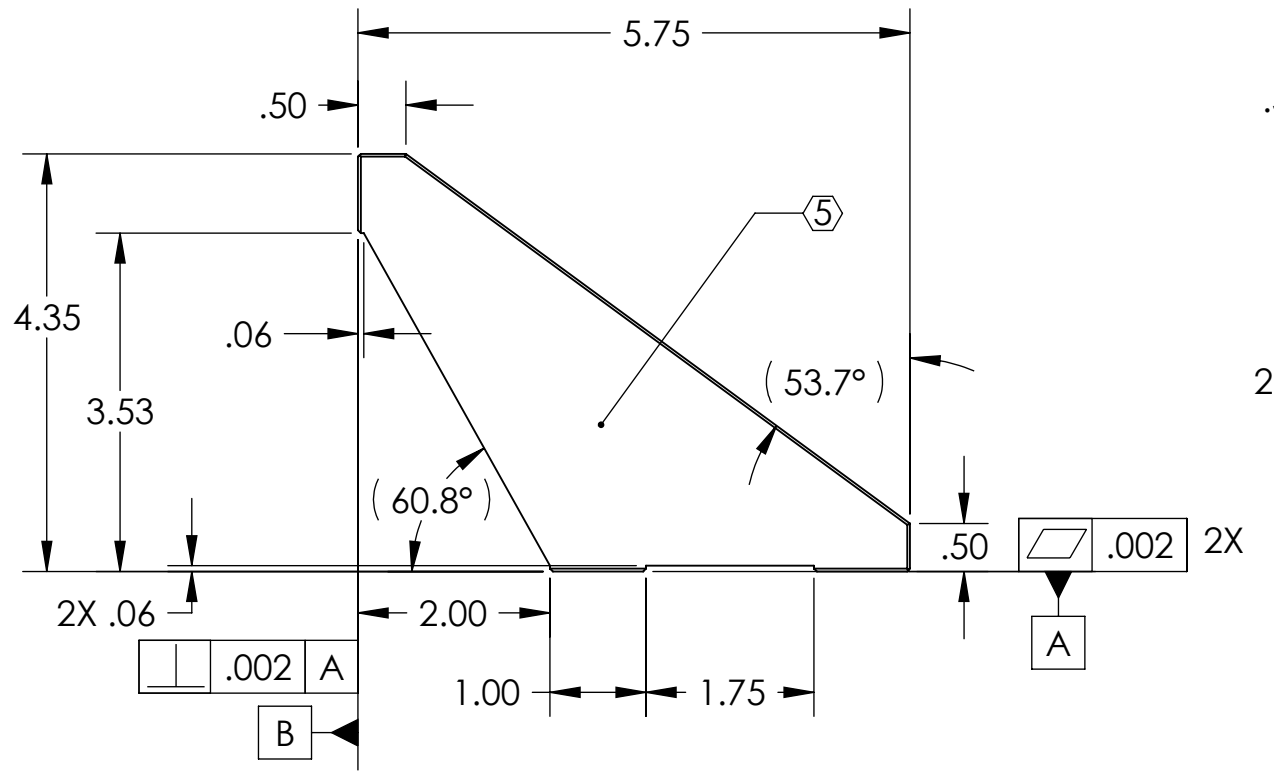
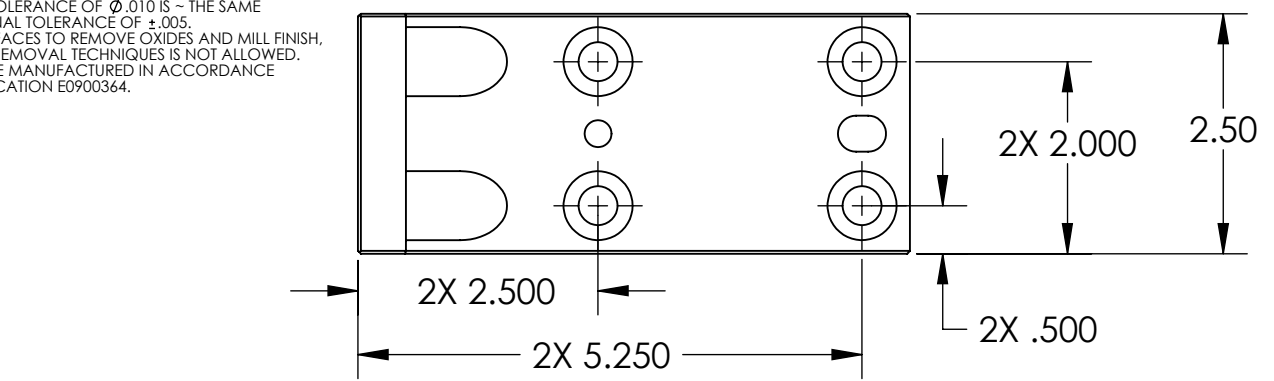
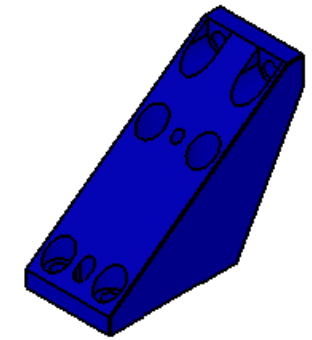


NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07 HIGH CHARACTERS. EXAMPLE DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.
 6. APPROXIMATE WEIGHT = 2.4 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 PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

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



$\phi .3757^{+.0008}_{-.0000}$ THRU SLOT
 BREAK EDGE .09 X 45°
 $\phi .002 (M) A B C$



$\phi .28$ THRU ALL
 $\phi .3757^{+.0008}_{-.0000} \downarrow .75$
 $\phi .56 \times 90^\circ$, NEAR SIDE
 $\phi .002 (M) A B C$

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- INTERPRET DRAWING PER ASME Y14.5-1994.
- BREAK ALL EDGES AND CORNERS .03 X 45°.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX $\pm .015$
 .XXX $\pm .005$
 ANGULAR $\pm 0.5^\circ$

MATERIAL	6061-T6 Al	FINISH	63 μ inch
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM ADVANCED LIGO		SUB-SYSTEM SEI	
NEXT ASSY		D0901181	
DESIGNER	A.STEIN	11 Jan. 2010	SIZE DWG. NO.
DRAFTER	M.HILLARD	11 Jan. 2010	B
CHECKER	F.MATICHARD	11 Jan. 2010	D0902133
APPROVAL	K.MASON	11 Jan. 2010	REV. v1
SCALE: 1:2		PROJECTION:	
SHEET 1 OF 1			

D0902133_Gusset-Hex_Wall-BSC_ISI, PART PDM REV: X-012, DRAWING PDM REV: X-009