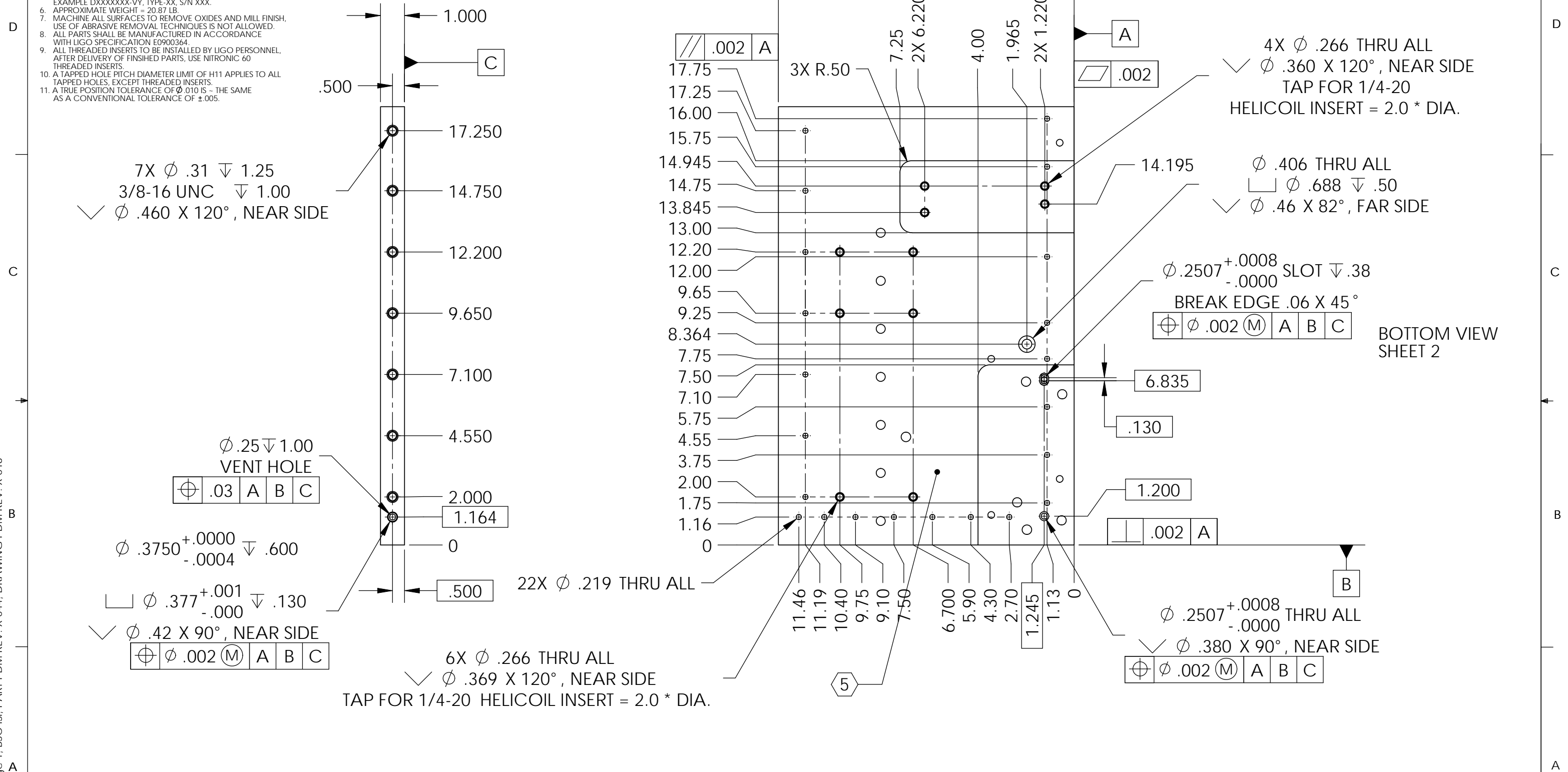


D0902278 L4C Wall, Stage 1, BSC-ISI, PART PDM REV: X-044, DRAWING PDM REV: X-016

- NOTES CONTINUED:**
- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS 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 DXXXXXX-VY, TYPE-XX, S/N XXX.
  - 6. APPROXIMATE WEIGHT = 20.87 LB.
  - 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
  - 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
  - 9. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
  - 10. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES TO ALL TAPPED HOLES, EXCEPT THREADED INSERTS.
  - 11. A TRUE POSITION TOLERANCE OF  $\phi$  .010 IS - THE SAME AS A CONVENTIONAL TOLERANCE OF  $\pm$  .005.

REV.	DATE	DCN #	DRAWING TREE #
v1	12 Mar. 2010	E0900495	E1000025
v2	05 Aug. 2010	E1000290	E1000025

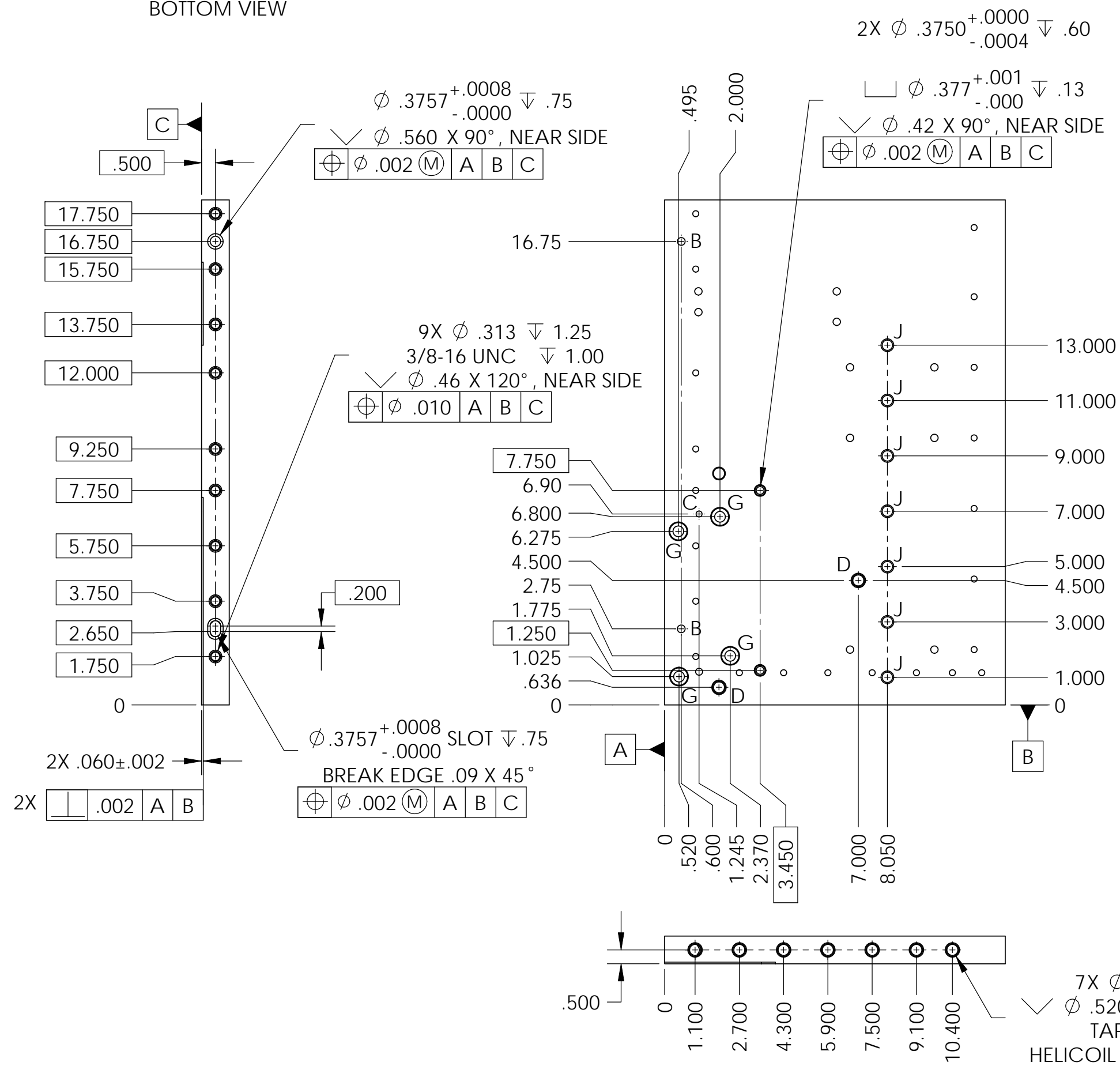


BOTTOM VIEW SHEET 2

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX $\pm$ .015 .XXX $\pm$ .005 ANGULAR $\pm$ .5°				CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		L4C WALL, STAGE 1, aLIGO BSC ISI	
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.				SYSTEM <b>ADVANCED LIGO</b>		SUB-SYSTEM <b>SEI</b>	
MATERIAL 6061-T6 Al				FINISH 63 $\mu$ inch		NEXT ASSY D0901180	
		DESIGNER F.MATICHARD 15 Jan. 2010		SIZE <b>B</b>		DWG. NO. <b>D0902278</b>	
		DRAFTER M.HILLARD 15 Jan. 2010		CHECKER A.STEIN 15 Jan. 2010		REV. <b>v2</b>	
		APPROVAL K.MASON 15 Jan. 2010		SCALE: 1:4		PROJECTION:  SHEET 1 OF 2	

D0902278 L4C Wall, Stage 1, BSC-ISI, PART PDM REV: X-044, DRAWING PDM REV: X-016

BOTTOM VIEW



TAG	SIZE	QUANTITY
B	Ø .28 THRU ALL	2
C	Ø .22 THRU TO SLOT	1
D	Ø .397 THRU ALL ∇ Ø .52 X 120°, NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA.	2
G	Ø .386 THRU ALL ∇ Ø .625 ∇ .375 ∇ Ø .68 X 90°, NEAR SIDE	4
J	Ø .31 THRU ALL 3/8-16 UNC THRU ALL ∇ Ø .46 X 120°, NEAR SIDE	7

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D0902278	V2
SCALE: 1:4	PROJECTION:	SHEET 2 OF 2