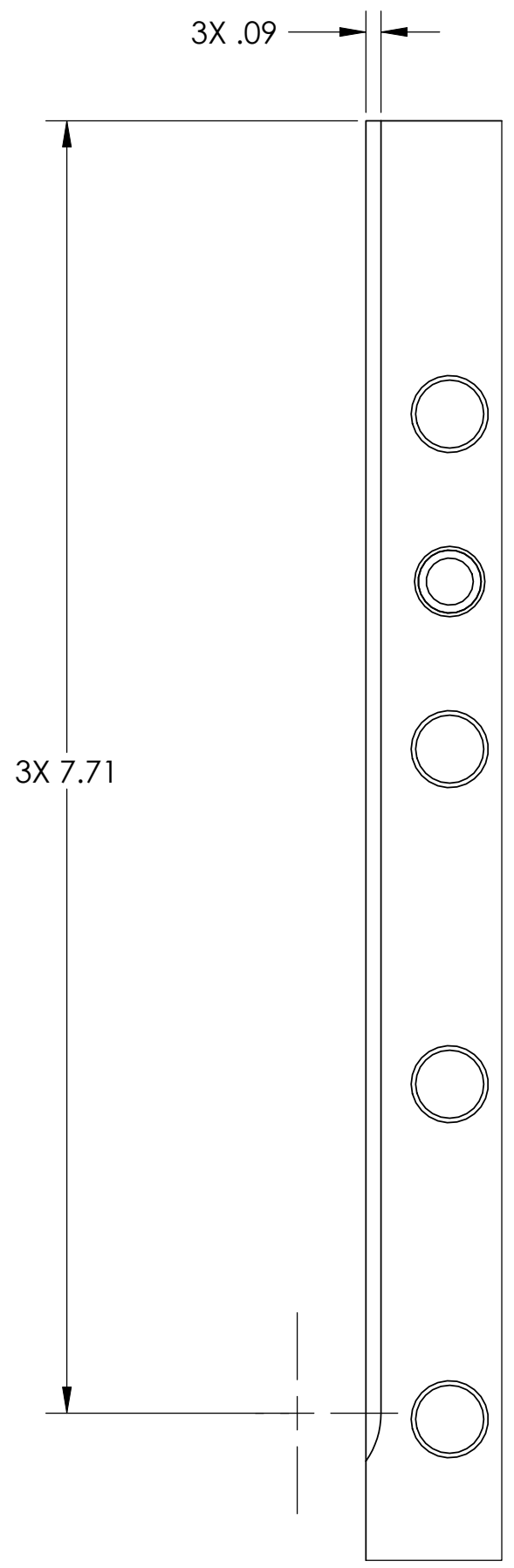
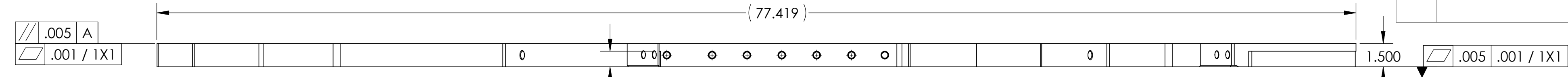
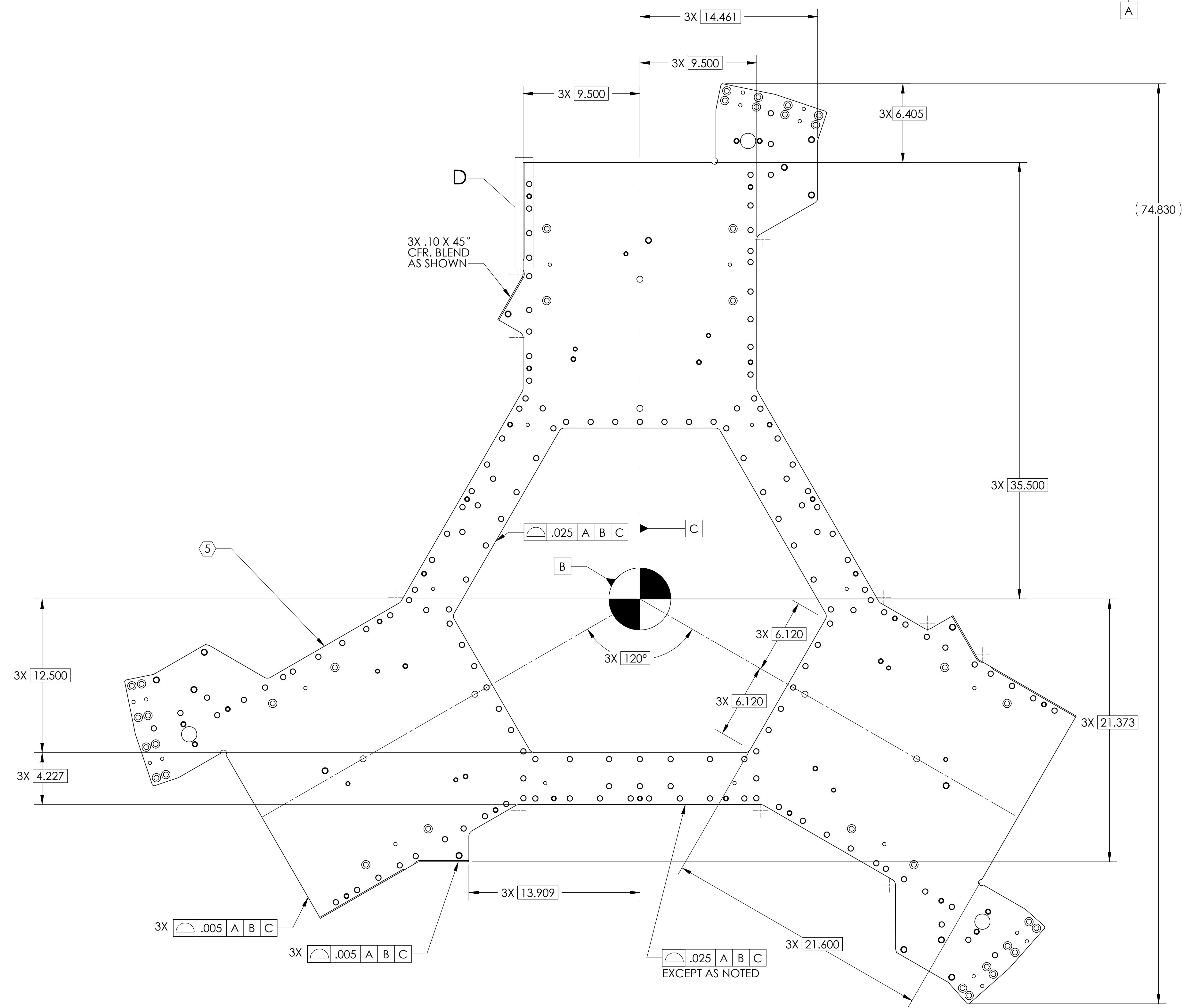


REV.	DATE	DCN #	DRAWING TREE #
v1	25 Jan 2010	E0900487	T0900600

- 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: DXXXXX-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 = 233LB.
  10. A TRUE POSITION TOLERANCE OF  $\phi .010$  IS - THE SAME AS A CONVENTIONAL TOLERANCE OF  $\pm .005$ .
  11. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.
  12. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONEL, AFTER DELIVERY OF FINISHED PARTS.



DETAIL D  
SCALE 1 : 1



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .015 .XXX ± .005	
ANGULAR ± .5°	
MATERIAL	FINISH
6061-T6 Al	63 μinch

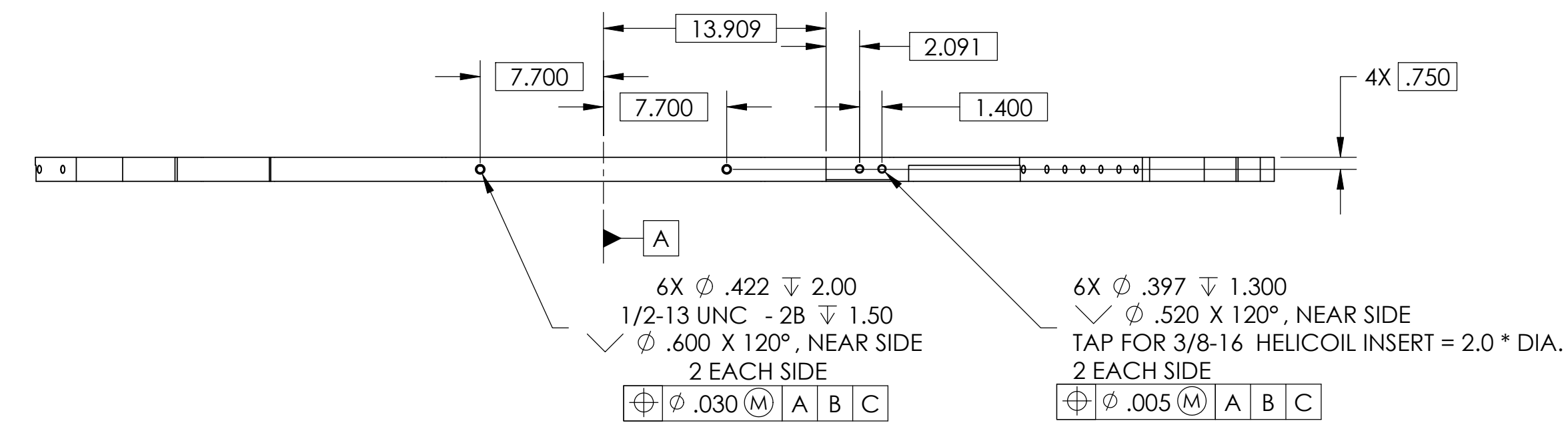
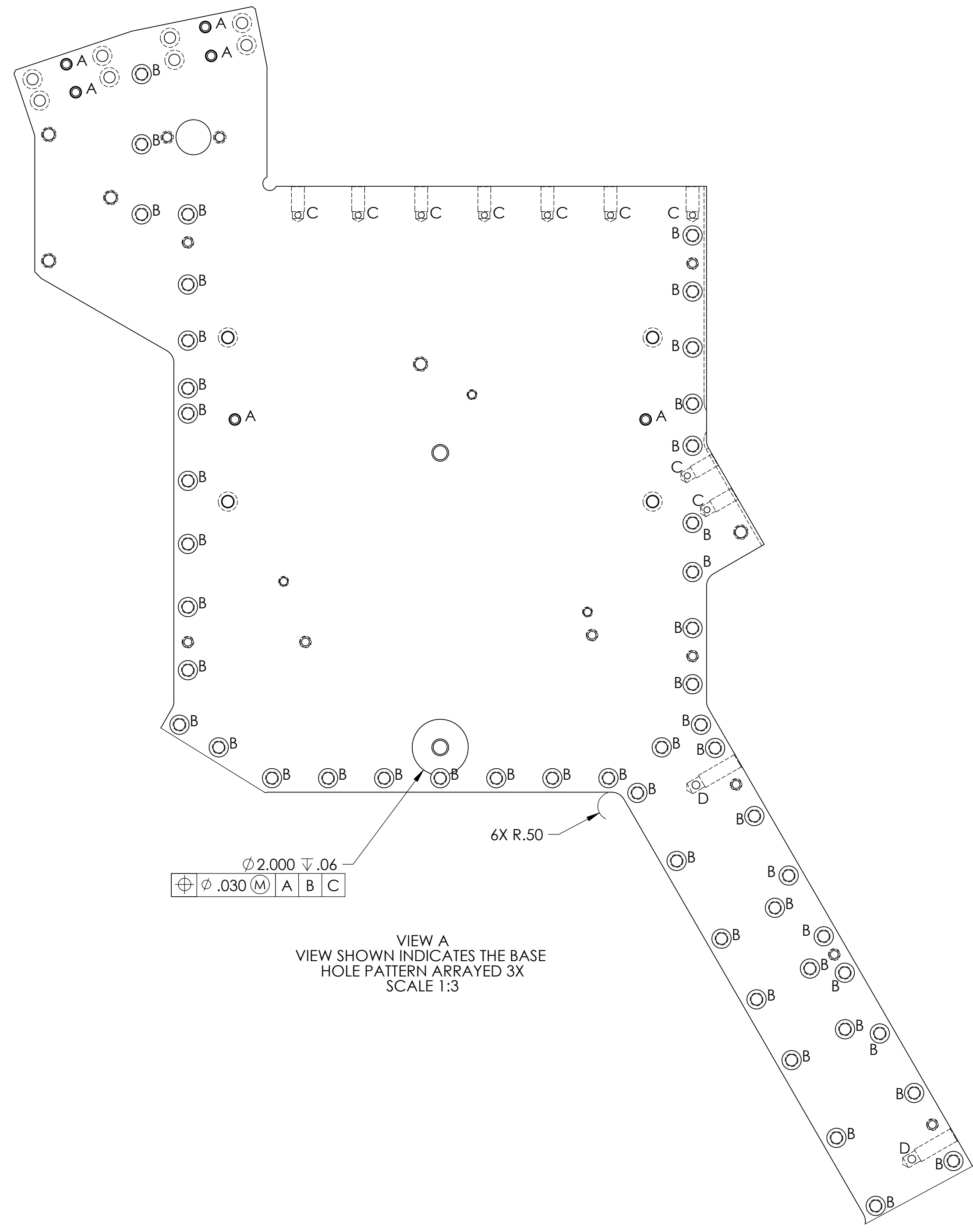
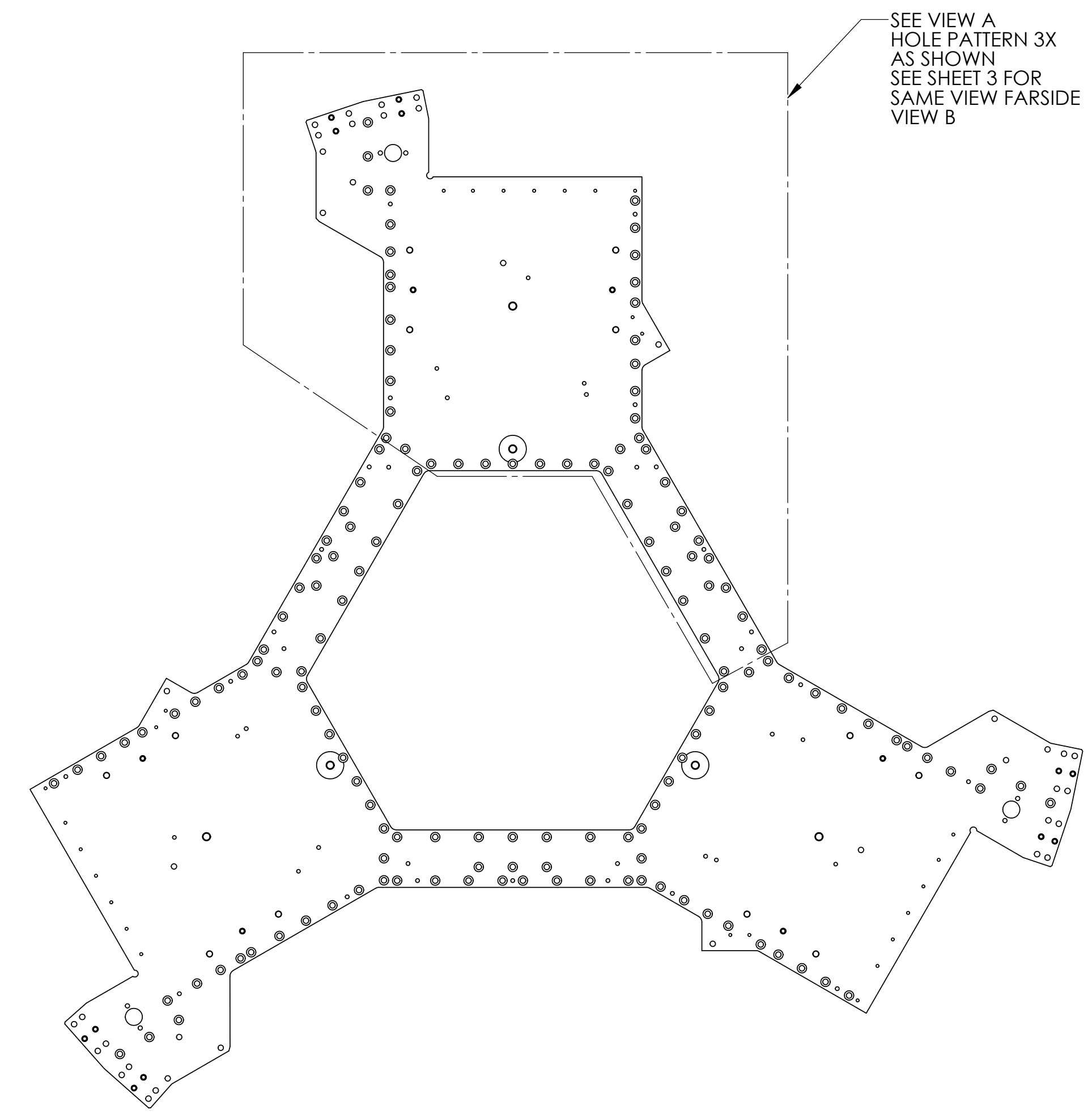
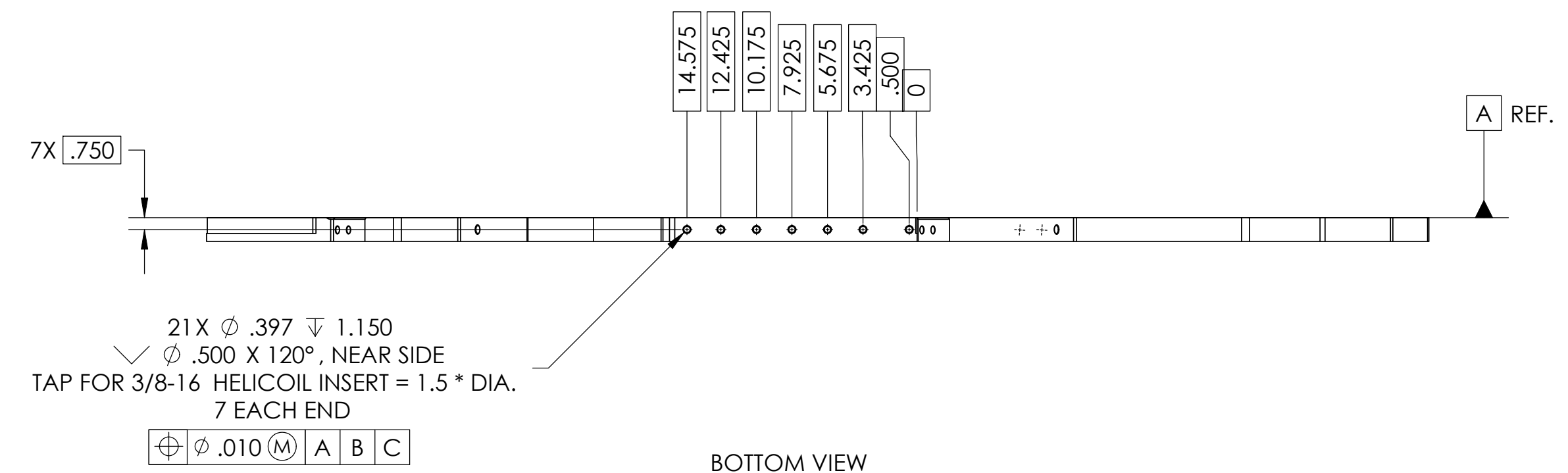
CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	SEI
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D0901180	

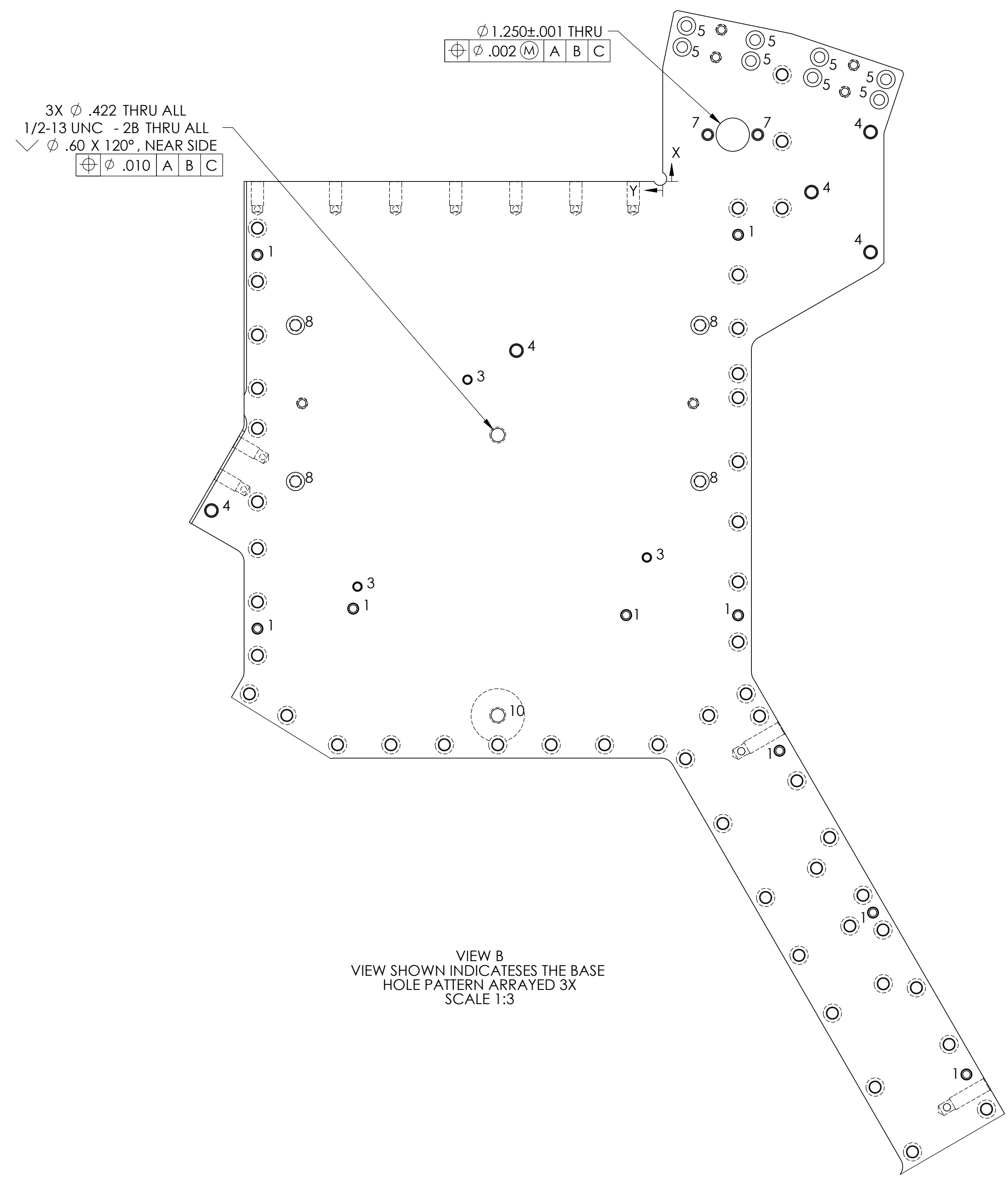
PART NAME				Base Plate, Stage 1, aLIGO BSC-ISI			
DESIGNER	F.MATCHARD	28 Dec. 2009	SIZE	DWG. NO.		REV.	
DRAFTER	M.HILLARD	25 Jan 2010	D	D0902279		v1	
CHECKER	A.STEIN	25 Jan 2010	SCALE: 1:5	PROJECTION:	SHEET 1 OF 3		
APPROVAL	K.Mason	25 Jan 2010					

D0902279 Base Plate Stage 1.dwg (1 of 3) PART PDM REV: X-080 DRAWING PDM REV: X-017

TAG	SIZE	QUANTITY	GD&T
A	$\phi .3750^{+.0000}_{-.0004}$ $\square \phi .377^{+.001}_{-.000} \downarrow .13$ $\checkmark \phi .42 \times 90^\circ$ , NEAR SIDE $\phi .22$ THRU	6	$\oplus \phi .002$ (M) A B C
B	$\phi .406$ THRU $\square \phi .688 \downarrow 1.00$ $\checkmark \phi .46 \times 90^\circ$ , FAR SIDE	50	$\oplus \phi .010$ (M) A B C
C	$\phi .22 \downarrow .75$	9	$\oplus \phi .010$ (M) A B C
D	$\phi .28$ THRU ALL	2	$\oplus \phi .010$ (M) A B C

HOLE QTY 3X





TAG	SIZE	QUANTITY	GD&T
1	$\phi .3750^{+.0000}_{-.0004} \nabla .60$ $\square \phi .377^{+.001}_{-.000} \nabla .13$ $\checkmark \phi .42 \times 90^\circ$ , NEAR SIDE $\phi .22$ THRU	9	⊕ Ø .002 (M) A B C
3	$\phi .266$ THRU ALL $\checkmark \phi .36 \times 120^\circ$ , NEAR SIDE TAP FOR 1/4-20 HELICOIL INSERT = 2.0 * DIA.	3	⊕ Ø .010 (M) A B C
4	$\phi .397$ THRU ALL $\checkmark \phi .52 \times 120^\circ$ , NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA.	5	⊕ Ø .010 (M) A B C
5	$\phi .406$ THRU $\square \phi .688 \nabla .780$	8	⊕ Ø .010 (M) A B C
7	$\phi .313$ THRU ALL $3/8-16$ UNC $\nabla 1.13$ $\checkmark \phi .45 \times 120^\circ$ , NEAR SIDE	2	⊕ Ø .010 (M) A B C H11 PITCH DIA LIMIT APPLIES
8	$\phi .406$ THRU ALL $\square \phi .688 \nabla 1.00$ $\checkmark \phi .46 \times 90^\circ$ , FAR SIDE	4	⊕ Ø .010 (M) A B C
10	$\phi .422$ THRU ALL $1/2-13$ UNC THRU ALL $\checkmark \phi .60 \times 120^\circ$ , NEAR SIDE	1	⊕ Ø .030 (M) A B C

HOLE QTY 3X

D0902279 Base Plate\_Stage1.dwg BSC-SI PART PDM REV: X-080 DRAWING PDM REV: X-017