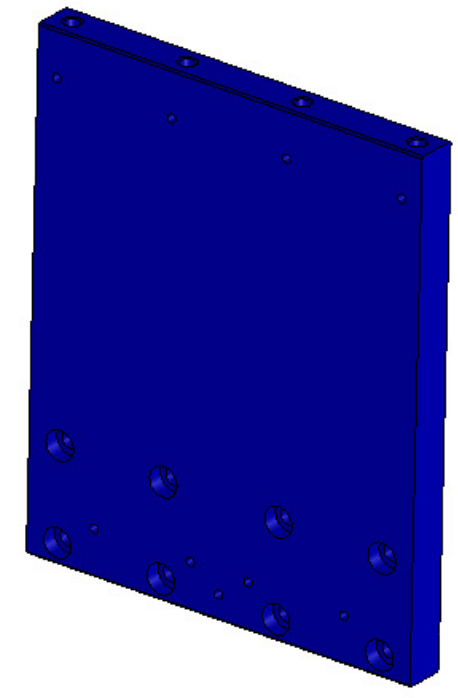
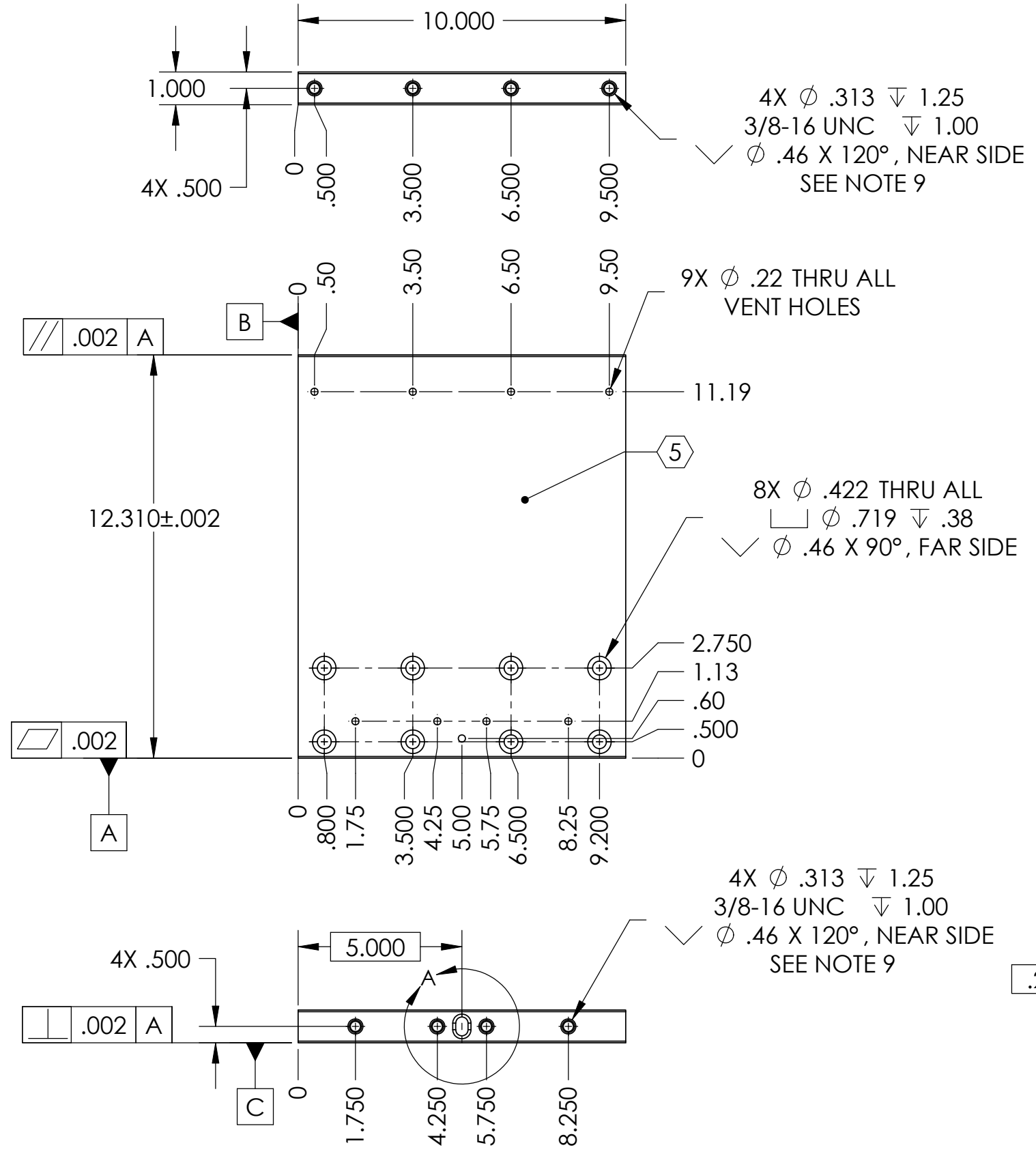


D0902282 Hex Inner Wall, Stage 1, BSC-ISI, PART PDM REV: X-019, DRAWING PDM REV: X-008

**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 = 11.67 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. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES TO ALL TAPPED HOLES.  
 10. 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



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		HEX INNER WALL, STAGE 1, aLIGO BSC ISI	
TOLERANCES: .XX ± .015 .XXX ± .005				SUB-SYSTEM SEI		DESIGNER	F.MATICHARD 15 Jan. 2010
ANGULAR ± 0.5°				NEXT ASSY D0901180		DRAFTER	M.HILLARD 15 Jan. 2010
MATERIAL 6061-T6 Al				FINISH 63 μinch		CHECKER	A.STEIN 15 Jan. 2010
						APPROVAL	K.MASON 15 Jan. 2010
						SIZE	DWG. NO.
						B	D0902282
						REV.	v1
						SCALE: 1:4	PROJECTION:
						SHEET 1 OF 1	