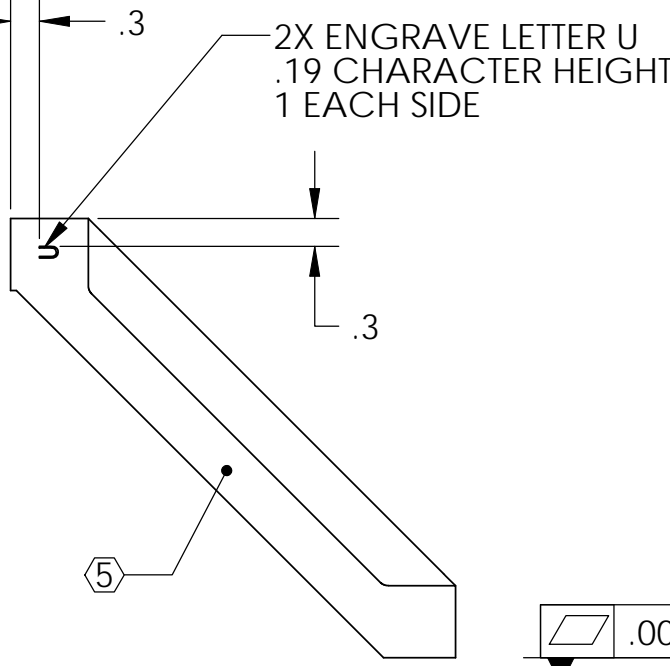
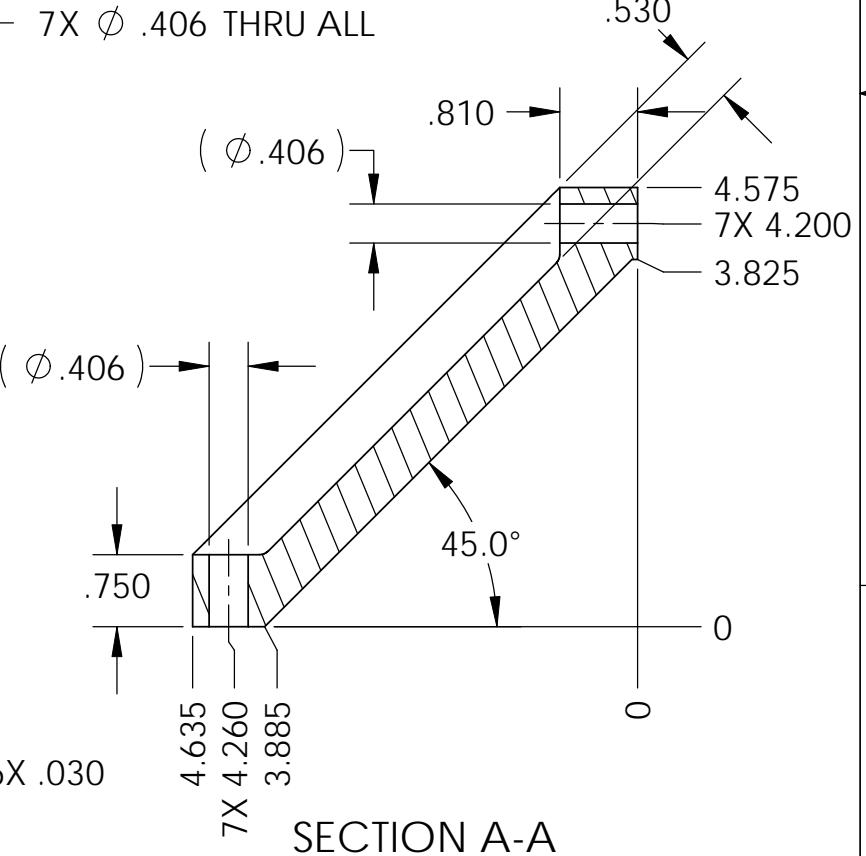
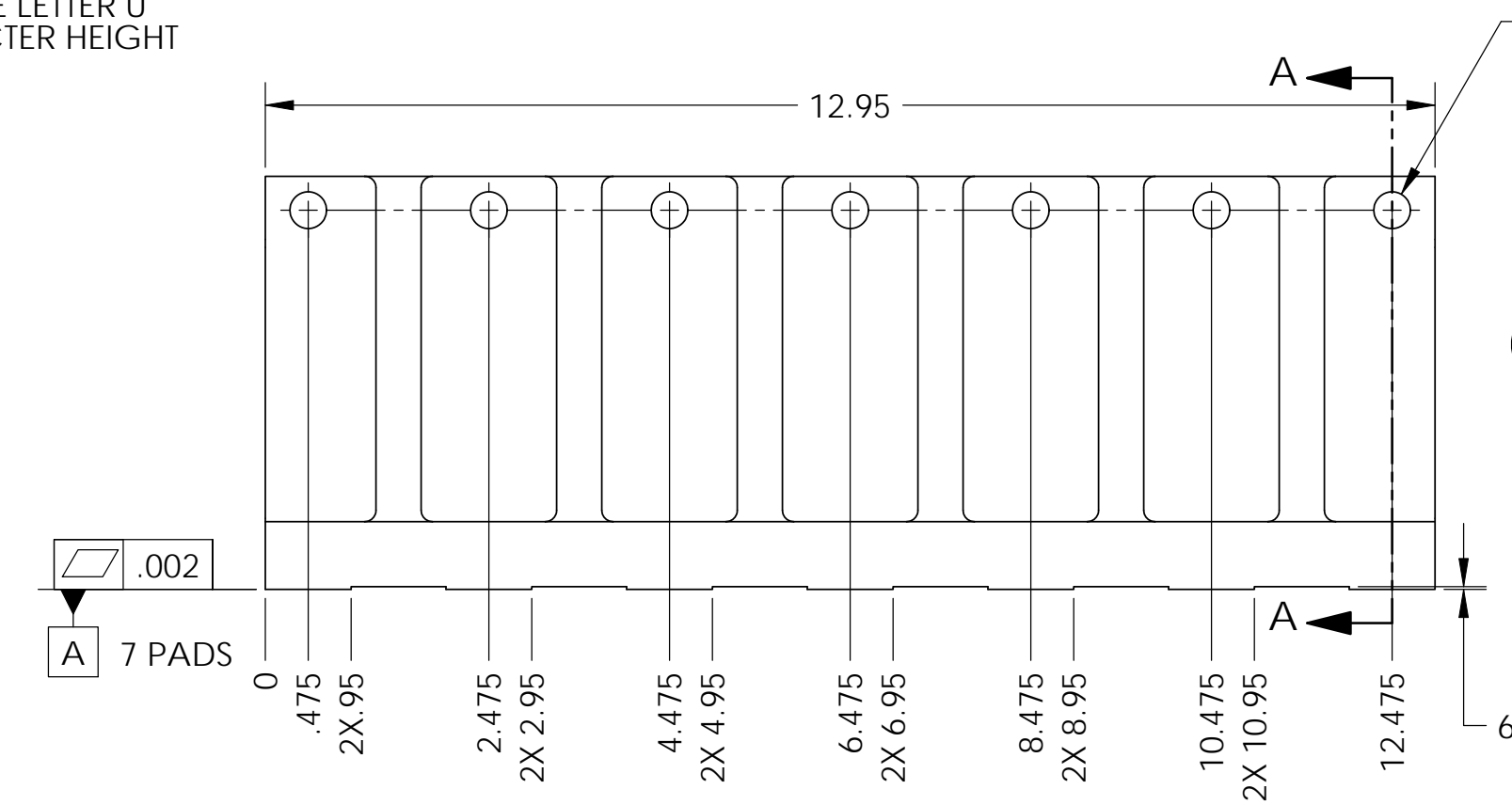
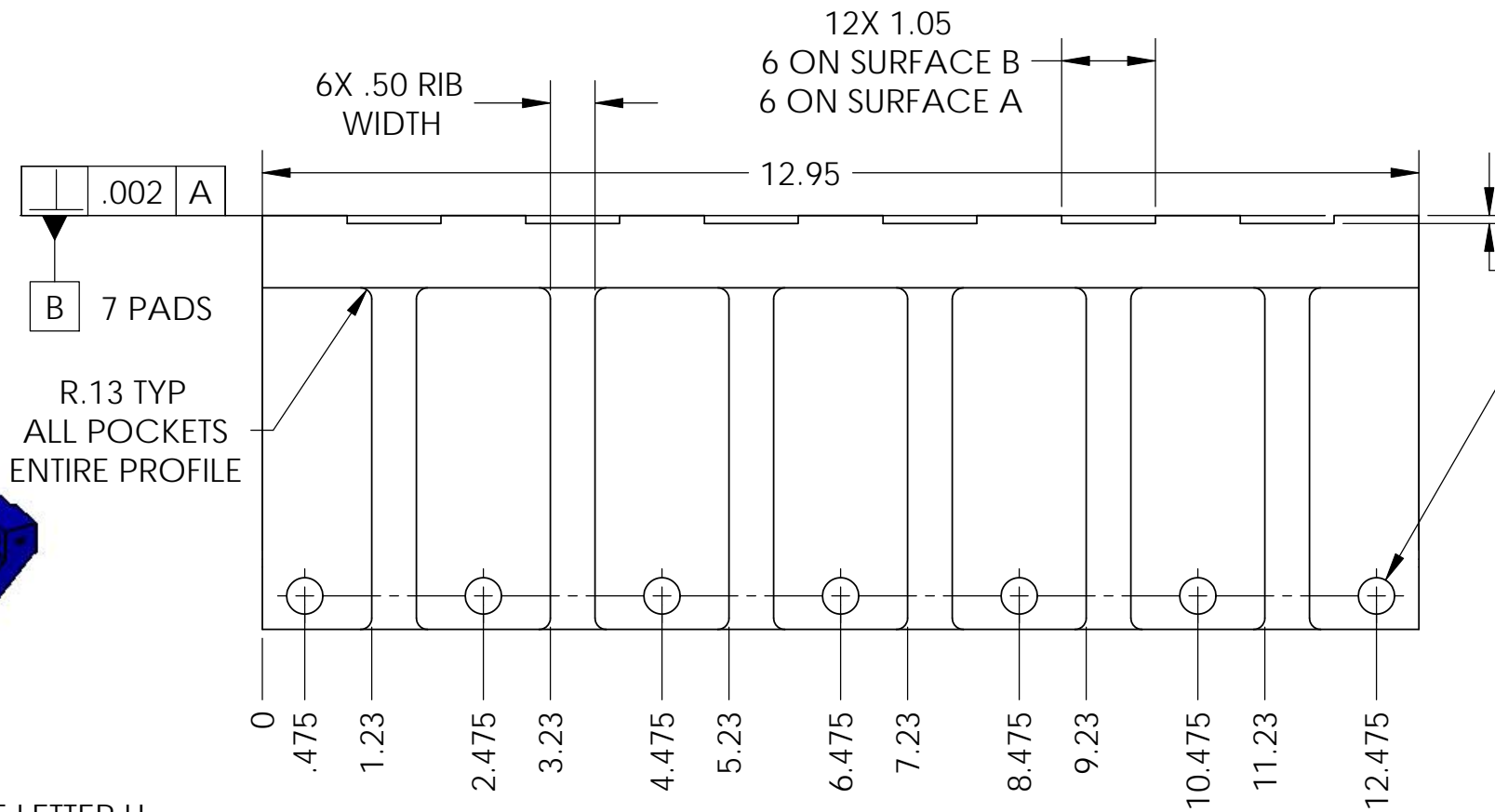
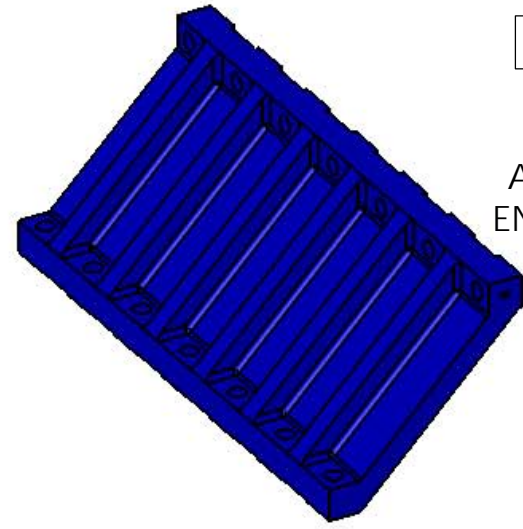


D0902441, Side Ribs, Stage 1, BSC ISI, PART PDM REV: X-011, DRAWING PDM REV: X-011

**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 = 5.3 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.

REV.	DATE	DCN #	DRAWING TREE #
v1	12 Mar. 2010	E0900495	E1000025



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± 0.5°				CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		SIDE RIBS, 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 ADVANCED LIGO		SUB-SYSTEM SEI	
MATERIAL 6061-T6 Al				FINISH 63 μinch		NEXT ASSY D0901180	
DESIGNER F.MATICHARD		DATE 15 Jan. 2010		SIZE B		DWG. NO. D0902441	
DRAFTER M.HILLARD		DATE 15 Jan. 2010		SCALE 1:2		REV. v1	
CHECKER A.STEIN		DATE 15 Jan. 2010		PROJECTION 1st Angle		SHEET 1 OF 1	
APPROVAL K.MASON		DATE 15 Jan. 2010		SCALE: 1:2 PROJECTION: 1st Angle SHEET 1 OF 1			