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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 = 2.7 LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY OF FINISHED PARTS. USE ONLY NITRONIC 60 INSERTS.
- 9. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

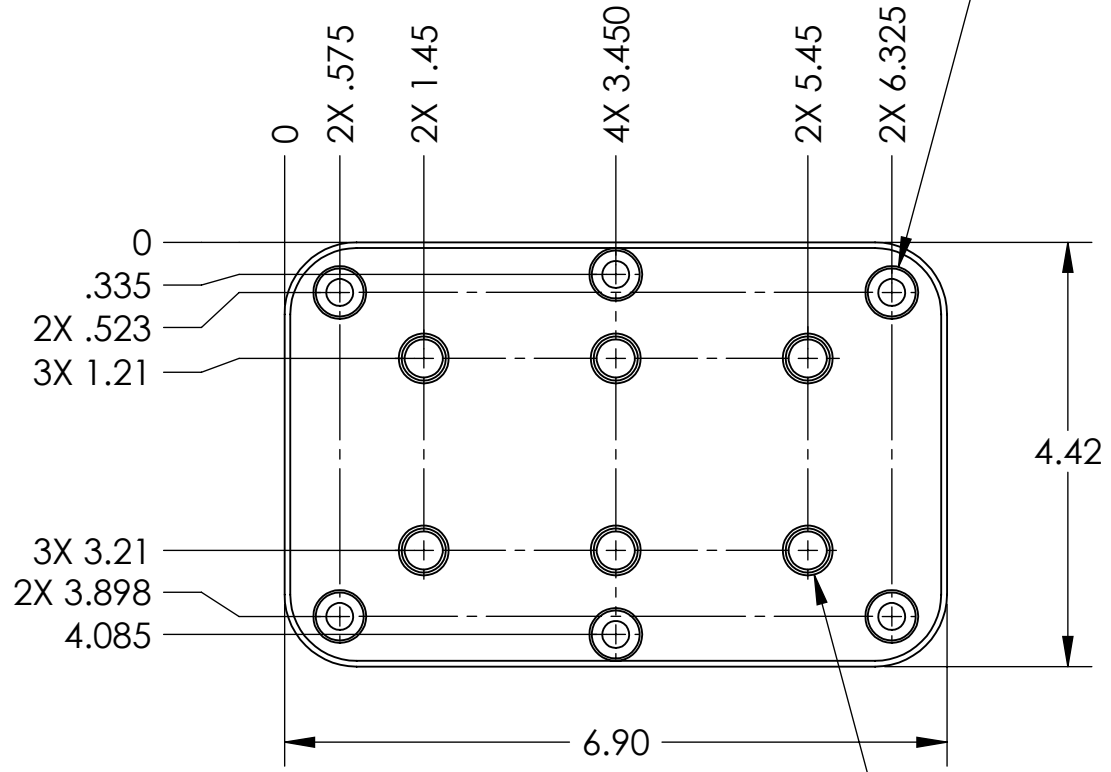
REV.	DATE	DCN #	DRAWING TREE #
v1	12 Mar. 2010	E1000020	E1000025

6X  $\phi$  .281 THRU ALL

$\square$   $\phi$  .500  $\nabla$  .50

$\checkmark$   $\phi$  .55 X 90°, NEAR SIDE

$\checkmark$   $\phi$  .32 X 90°, FAR SIDE



$\square$  .002

A

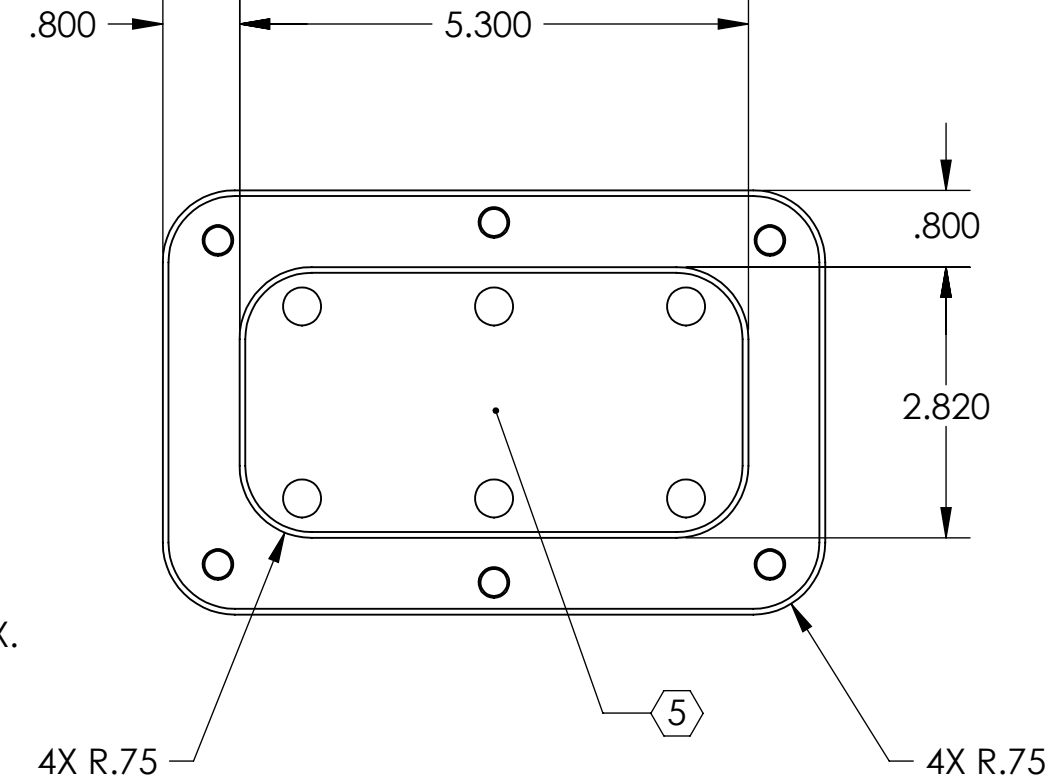
1.13

.850

$\parallel$  .002 A

3X .06 X 45.0° TYP.

R.015 MAX.



6X  $\phi$  .397 THRU ALL

$\checkmark$   $\phi$  .52 X 120°, NEAR SIDE

TAP FOR 3/8-16

HELICOIL INSERT = 2.0 \* DIA.

D0902487\_Spring\_Hatch-BSC\_ISI, PART PDM REV: X-008, DRAWING PDM REV: X-004

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

<p>CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY</p>	PART NAME	
	Spring Hatch, aLIGO BSC ISI	
	DESIGNER	A.STEIN 11 Jan. 2010
	DRAFTER	M.HILLARD 11 Jan. 2010
SYSTEM	SUB-SYSTEM	CHECKER
ADVANCED LIGO	SEI	F.MATICHARD 11 Jan. 2010
NEXT ASSY	D0901181	APPROVAL
		K.MASON 11 Jan. 2010

SIZE	DWG. NO.	REV.
B	D0902487	v1
SCALE:	1:2	PROJECTION:
		SHEET 1 OF 1

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