

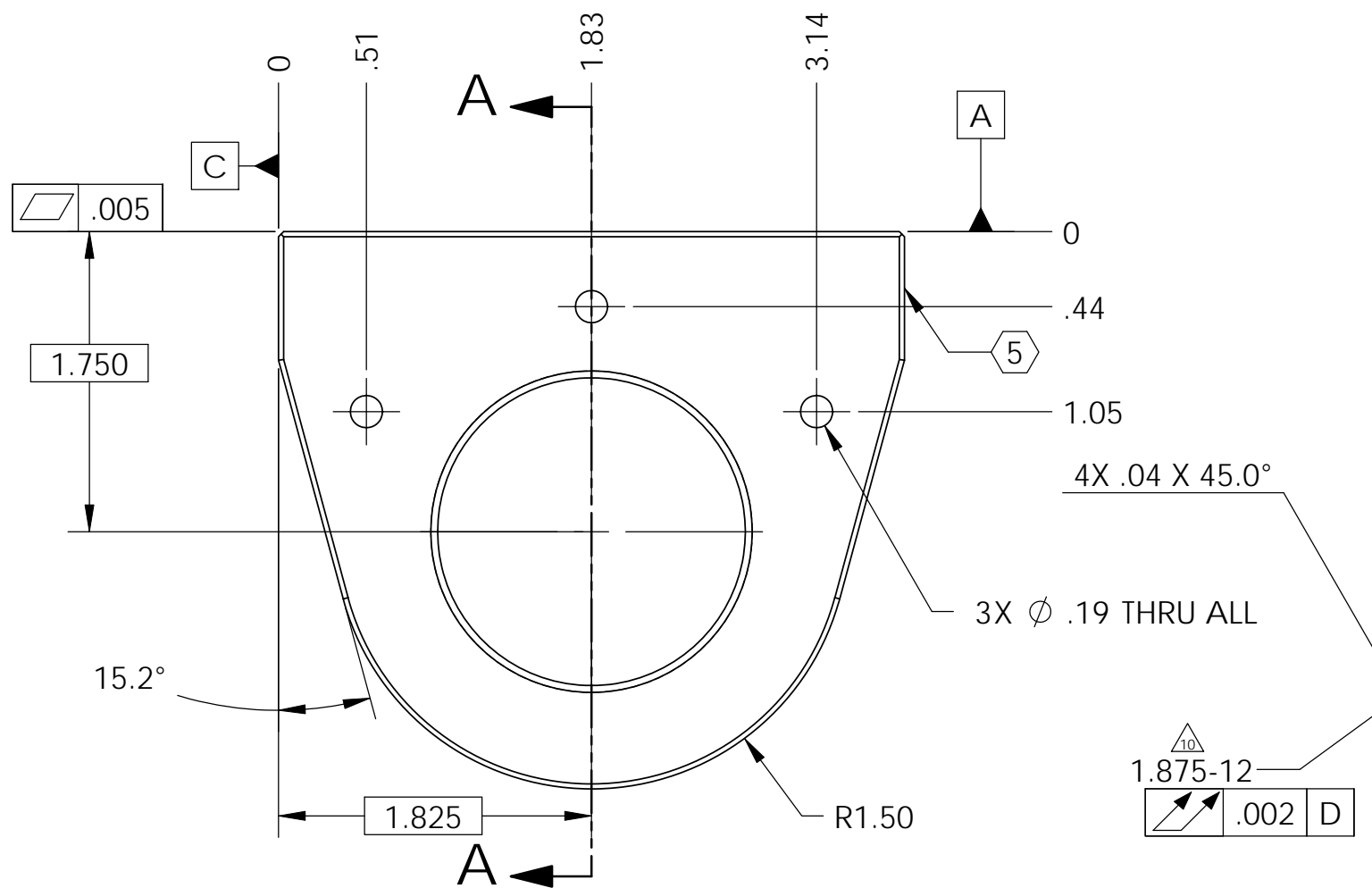
D1000908 HOUSING LOCKER SLEEVE, aLIGO BSC ISI, PART PDM REV: X-005, DRAWING PDM REV: X-007

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 = 1.1 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.
 11. A TRUE POSITION TOLERANCE OF $\phi .010$ IS - THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.

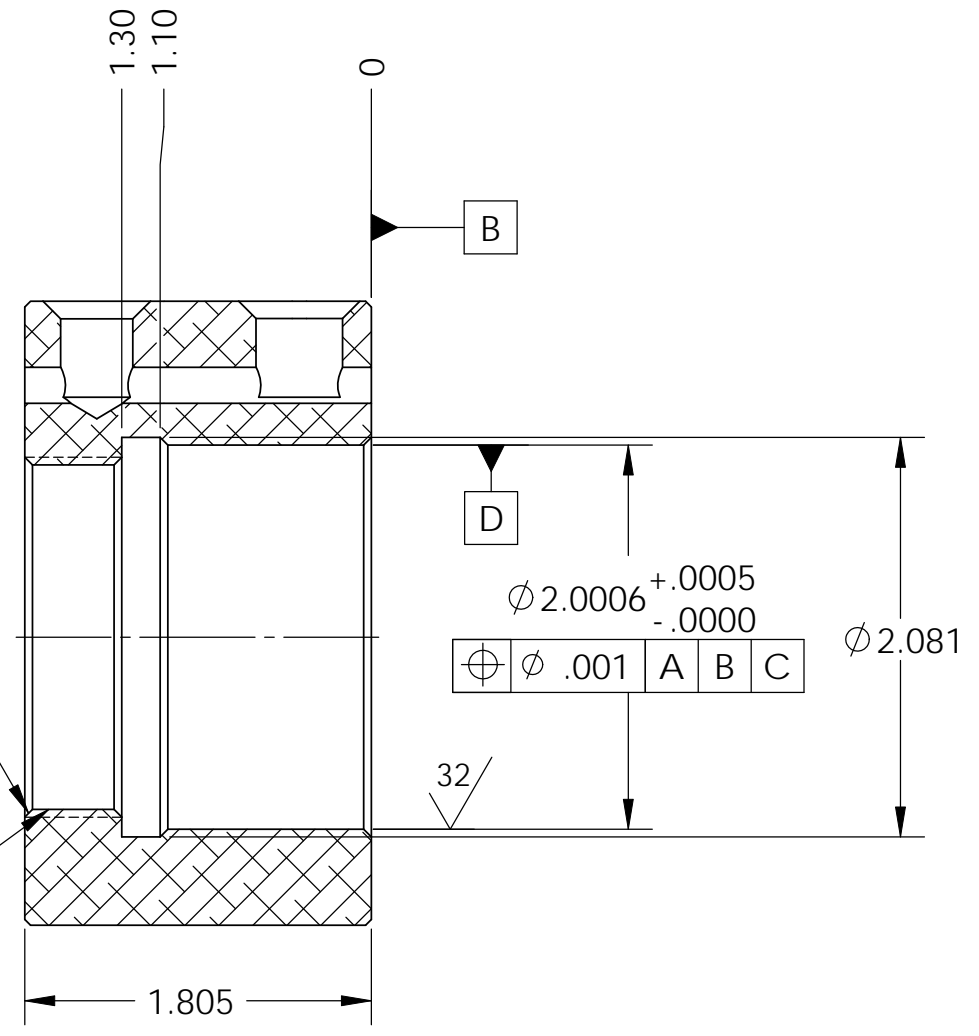
REV.	DATE	DCN #	DRAWING TREE #
v1	01 Mar. 2010	E1000115	E1000025

4X $\phi .40 \nabla 1.15$
 $\nabla \phi .52 \times 120^\circ$, NEAR SIDE
 TAP FOR 3/8-16
 HELICOIL INSERT = 2.0 * DIA.

$\phi .3757^{+.0008}_{-.0000}$ SLOT $\nabla .75$
 BREAK EDGE .09 X 45°
 $\phi .3757^{+.0008}_{-.0000}$ $\nabla .50$
 $\nabla \phi .56 \times 90^\circ$, NEAR SIDE



SECTION A-A



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		HOUSING LOCKER SLEEVE, aLIGO BSC ISI					
TOLERANCES: .XX ± .015 .XXX ± .005				SEI		DESIGNER	A.STEIN	01 Mar. 2010	SIZE	DWG. NO.	REV.
ANGULAR ± .5°				MATERIAL		DRAFTER	M.HILLARD	01 Mar. 2010	B	D1000908	
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.				FINISH		CHECKER	F.MATICHARD	01 Mar. 2010	SCALE	PROJECTION:	SHEET 1 OF 1
2024-T351 Al				63 μinch		APPROVAL	K.MASON	01 Mar. 2010	1:1		
NEXT ASSY				D1000854, D1000855							