

D1100375 Unified Plate Flipper Tooling Double End, BSC-ISI, PART PDM REV: X-000, DRAWING PDM REV:

NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

6. ENGRAVE IN LOCATION INDICATED, 3/8" HIGH CHARACTERS:

D0902279 = 2A 9X 3/8"- 16 x 3" & Nuts
 D0902273 = C 3X 3/8"- 16 x 1.5" & 6X 3/8"- 16 x 4.5" & Nuts
 D0901520 = 1A 10X 3/8"- 16 x 1.5"
 D0901518 = B 10X 1/4"- 20 x 4.5" & Nut
 D0901519 = B 10X 1/4"- 20 x 4.5" & Nut

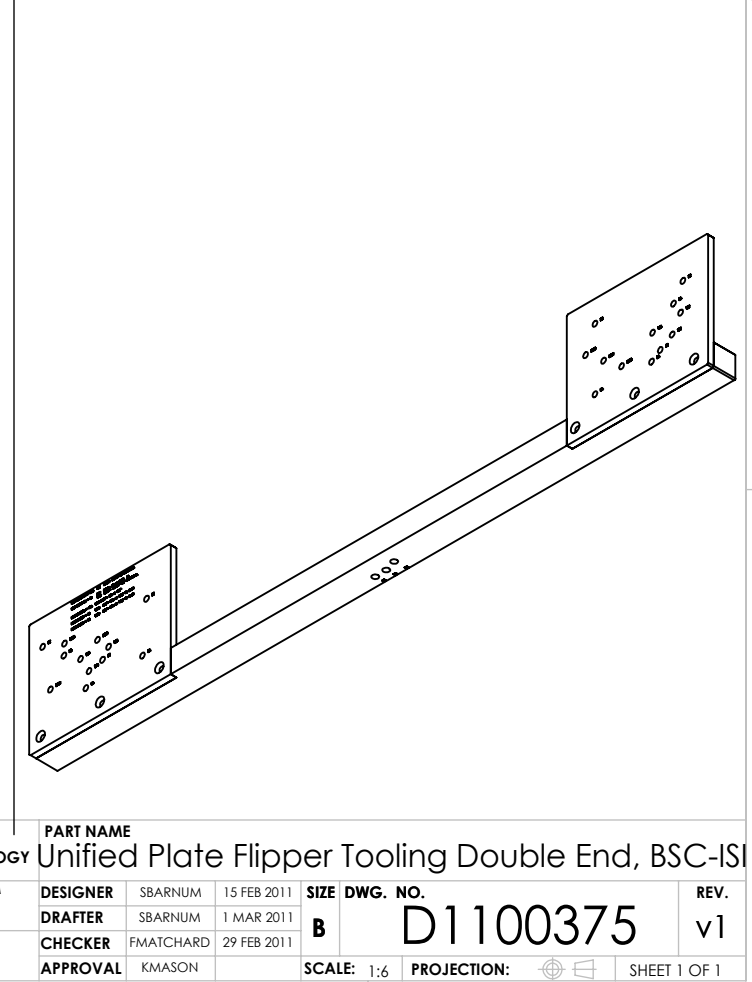
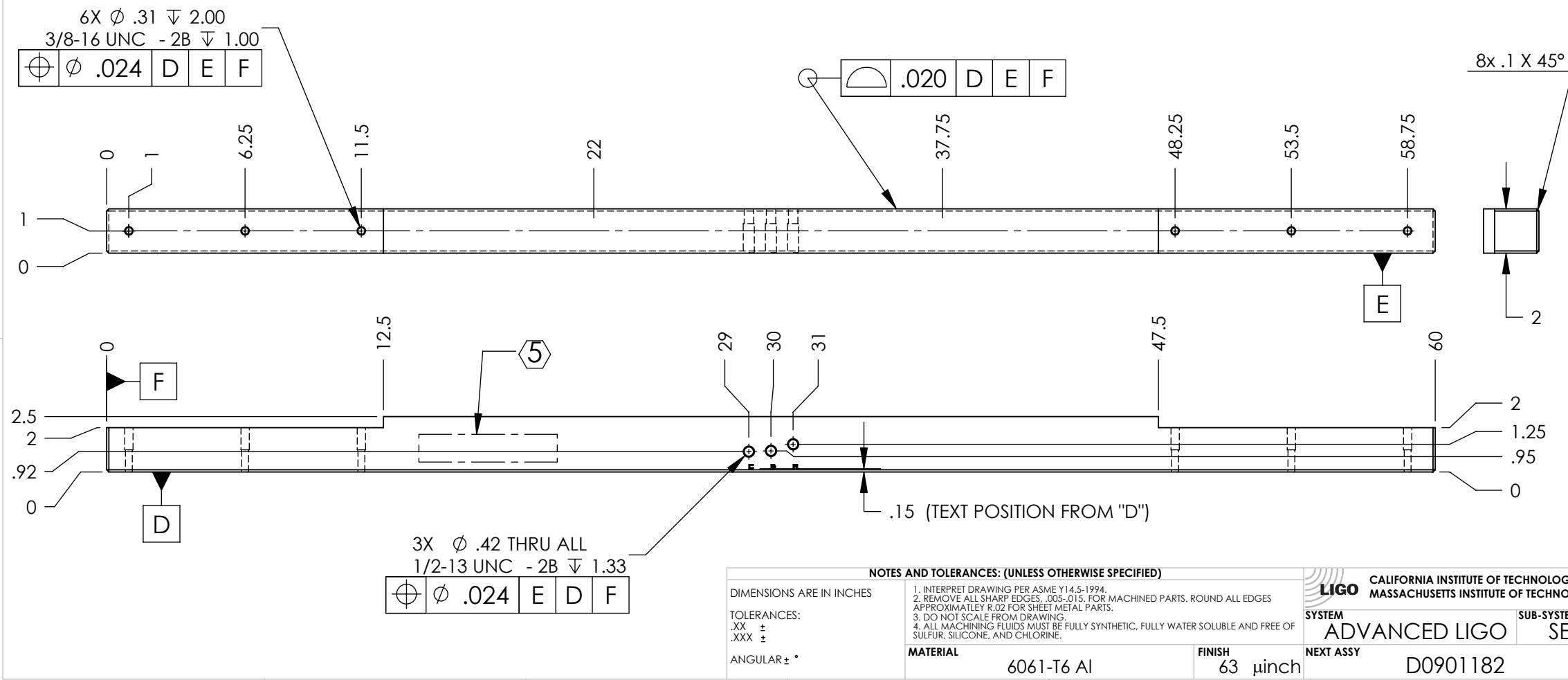
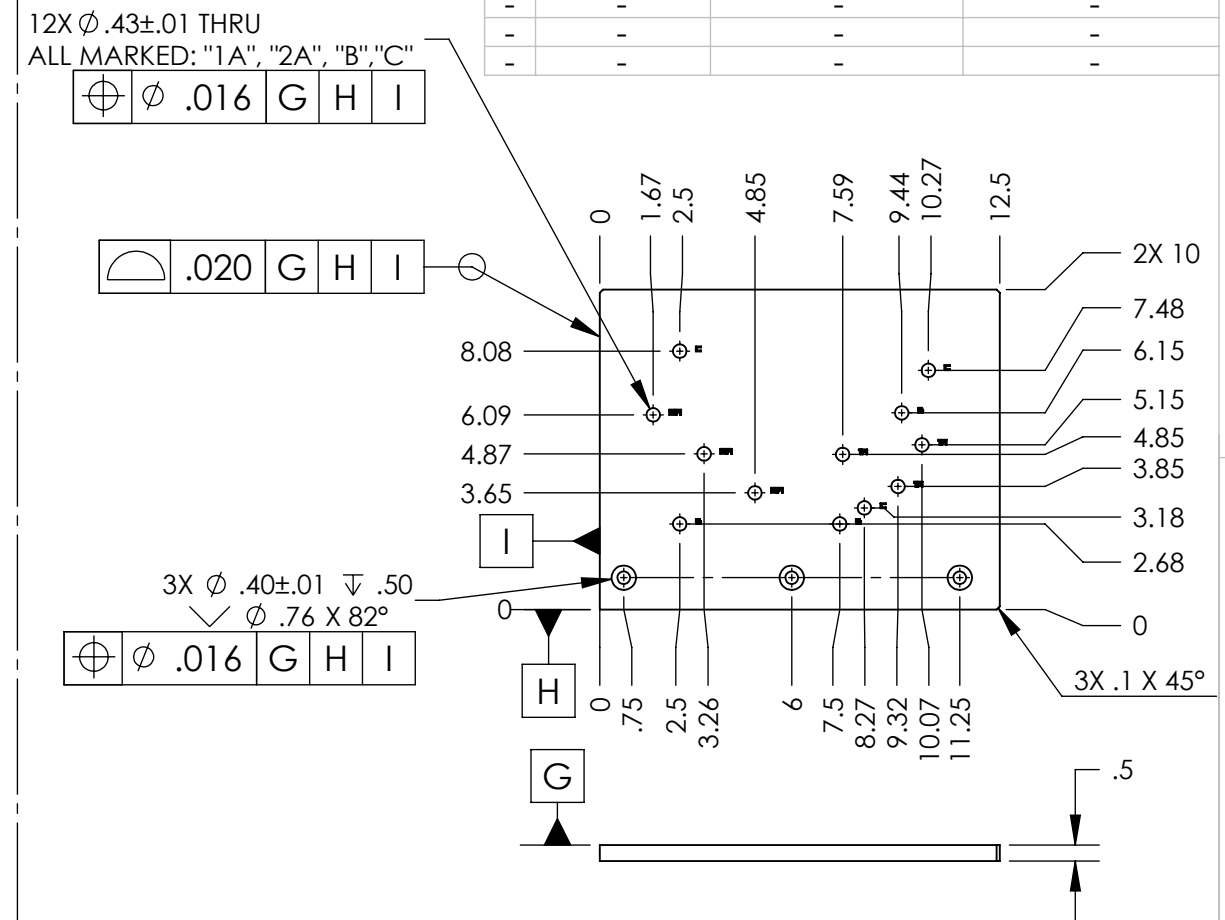
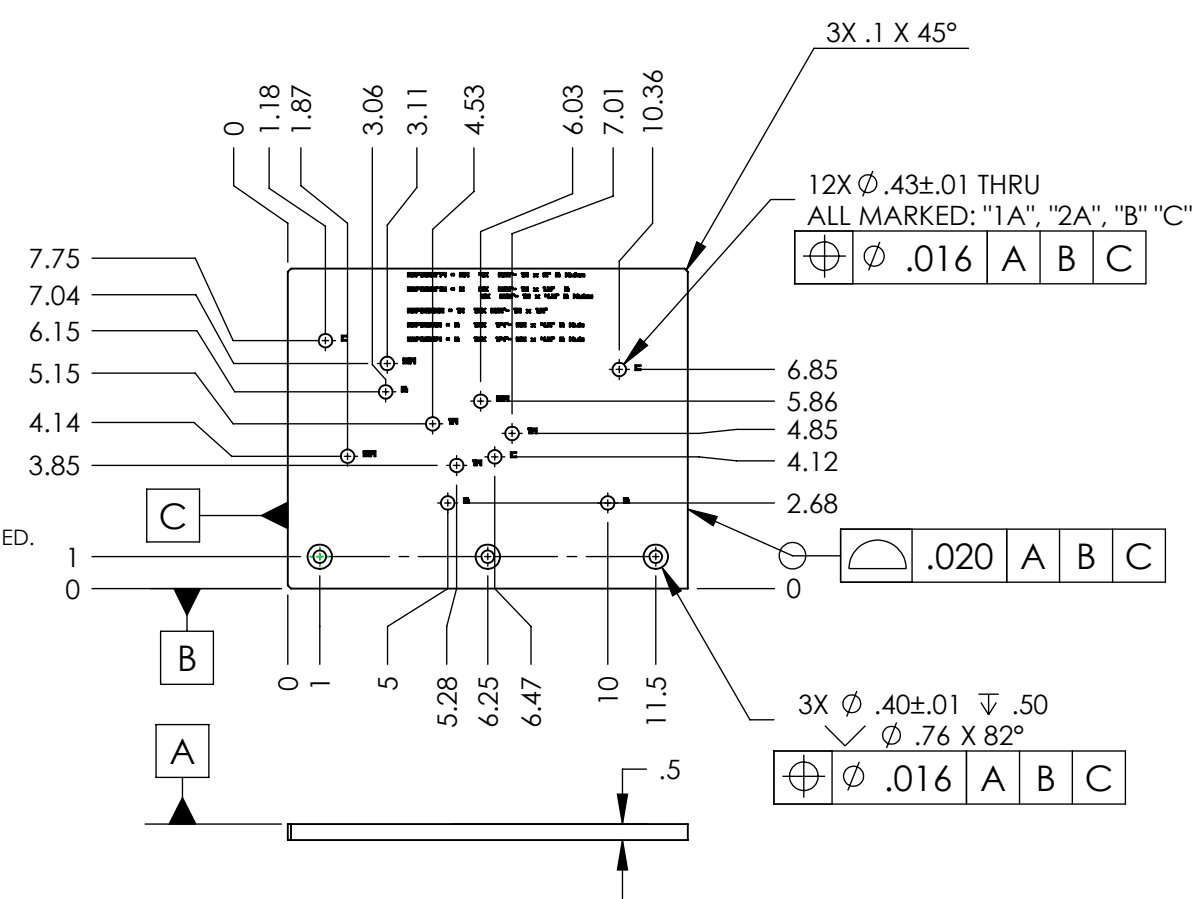
7. ENGRAVE IN LOCATIONS INDICATED, 3/8" HIGH CHARACTERS:

1A, 2A, B, C (3/8" FROM EDGE OF ASSOCIATED HOLE)

8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH.

9. ALL DIMENSIONS ARE BASIC UNLESS OTHERWISE SPECIFIED.

REV.	DATE	DCN #	DRAWING TREE #
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-	-	-	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .XXX ± ANGULAR ± °				Unified Plate Flipper Tooling Double End, BSC-ISI	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.				ADVANCED LIGO SEI	
MATERIAL: 6061-T6 Al FINISH: 63 µinch				DESIGNER: SBARNUM 15 FEB 2011 DRAFTER: SBARNUM 1 MAR 2011 CHECKER: FMATCHARD 29 FEB 2011 APPROVAL: KMASON	
SYSTEM: ADVANCED LIGO SUB-SYSTEM: SEI NEXT ASSY: D0901182				SIZE DWG. NO.: B D1100375 SCALE: 1:6 PROJECTION:	
				SHEET 1 OF 1	