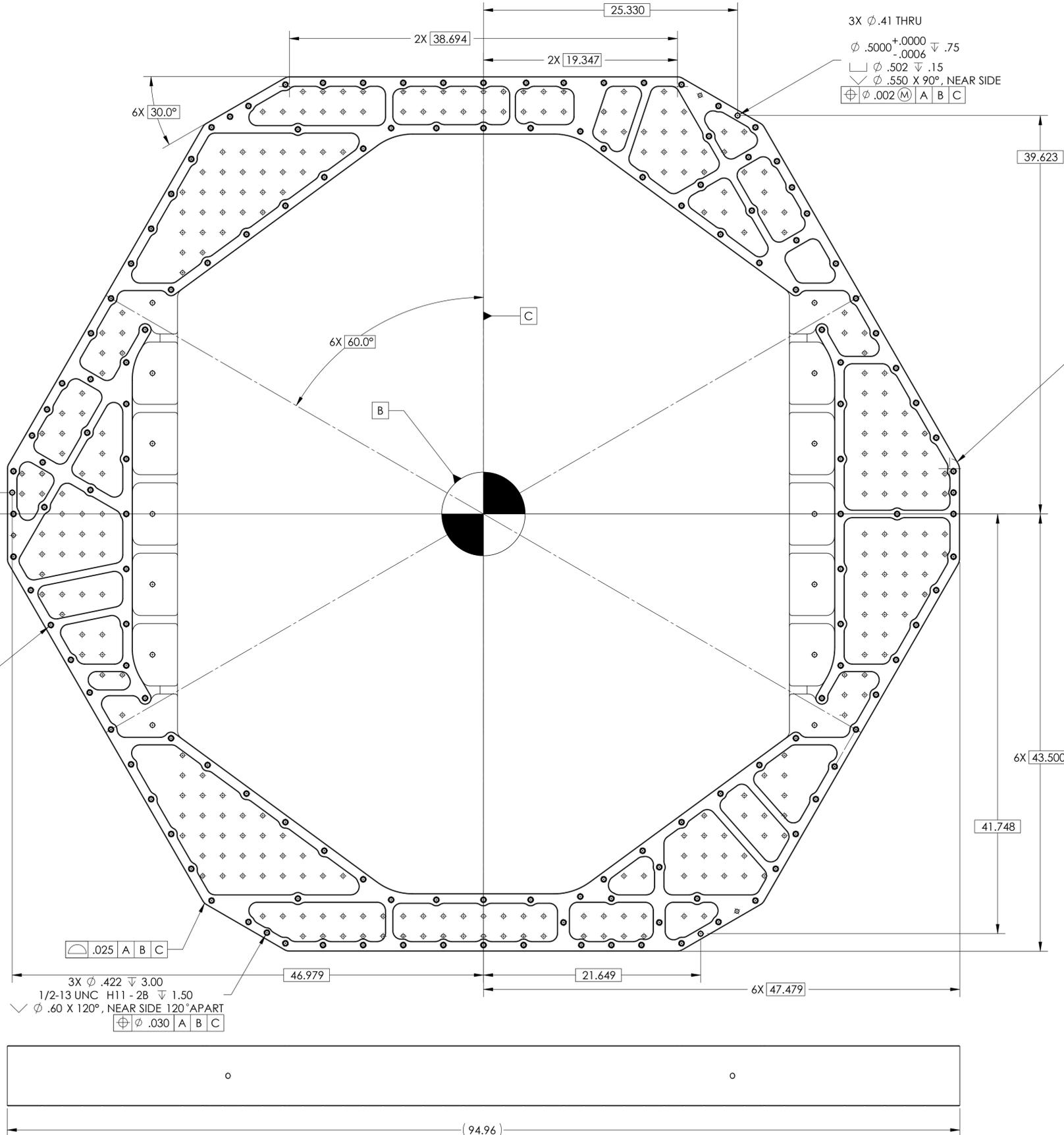


- NOTES CONTINUED:**
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.
  6. THIS PART IS TO BE PRODUCED USING THE CAD MODEL. IF THERE ARE DISCREPANCIES BETWEEN THIS DRAWING AND THE CAD MODEL, THE MODEL WILL TAKE PRECEDENCE.
  7. SURFACES WITH PROFILE CONTROL ARE LOCATED BASIC WITH RESPECT TO REFERENCED DATUMS. A SURFACE PROFILE TOLERANCE OF .025 SHALL APPLY TO THE ENTIRE PART UNLESS SPECIFICALLY TOLERANCED ELSEWHERE ON THE DRAWING.
  8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E048225.
  9. APPROXIMATE WEIGHT = 233LB.
  10. A TRUE POSITION TOLERANCE OF  $\phi .010$  IS ~ THE SAME AS A CONVENTIONAL TOLERANCE OF  $\pm .005$ .
  11. MULTIPLE SHEET DRAWING: SHEETS MAY HAVE DIFFERENT SCALES.
  12. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.
  13. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONEL, AFTER DELIVERY OF FINISHED PARTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	25 Jan 2010	E1000013	T0900600



142X  $\phi .38$  THRU  
 $\phi .422 \nabla 3.00$   
 1/2-13 UNC H11  $\nabla 1.50$   
 $\phi .60 \times 120^\circ$ , NEAR SIDE  
 $\phi .43 \times 90^\circ$  FAR SIDE  
 $\phi \phi .010$  A B C

3X  $\phi .422 \nabla 3.00$   
 1/2-13 UNC H11 - 2B  $\nabla 1.50$   
 $\phi \phi .60 \times 120^\circ$ , NEAR SIDE 120° APART  
 $\phi \phi .030$  A B C

3X  $\phi .41$  THRU  
 $\phi .5000^{+.0000} \nabla .75$   
 $\phi .502 \nabla .15$   
 $\phi .550 \times 90^\circ$ , NEAR SIDE  
 $\phi \phi .002$  (M) A B C

6X  $\phi .42 \nabla 4.00$   
 1/2-13 UNC H11 - 2B  $\nabla 1.50$   
 $\phi \phi .55 \times 120^\circ$ , NEAR SIDE  
 $\phi \phi .030$  A B C

$\phi \phi .005$  A  
 $\phi \phi .001 / 1X1$

$\phi \phi .005$  .001 / 1X1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. BREAK ALL EDGES AND CORNERS  $.030 \times 45^\circ$ .
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.

DIMENSIONS ARE IN INCHES

TOLERANCES:  
 .XX  $\pm .015$   
 .XXX  $\pm .005$

ANGULAR  $\pm 0.5^\circ$

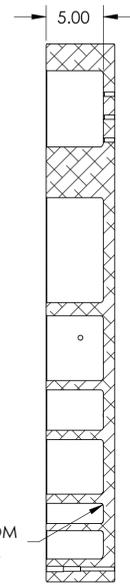
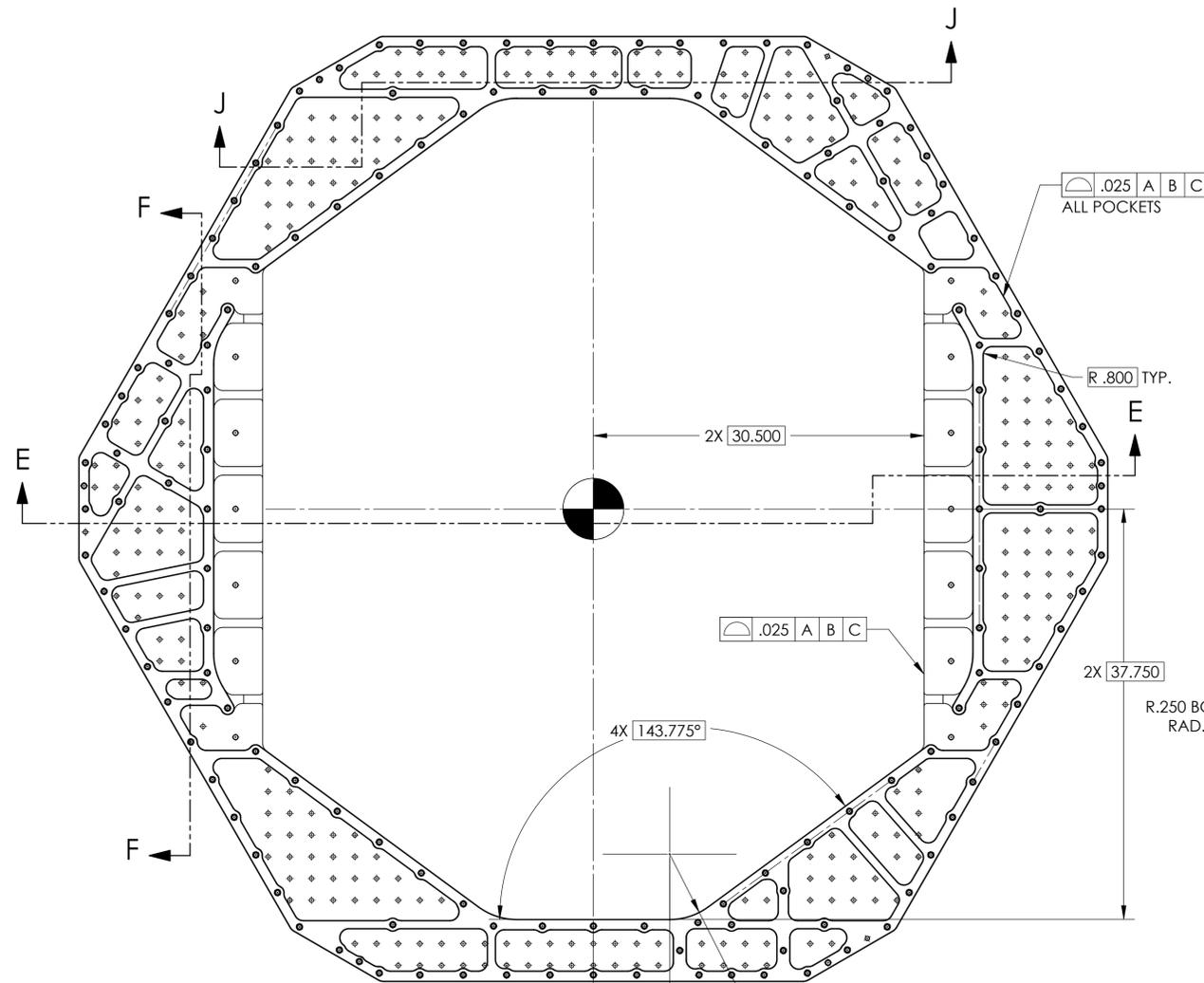
MATERIAL	6061-T6 Al	FINISH	63 $\mu$ inch
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 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

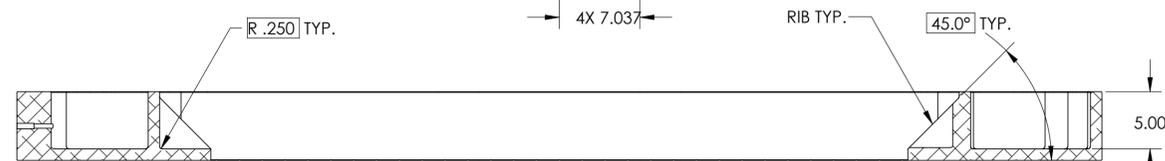
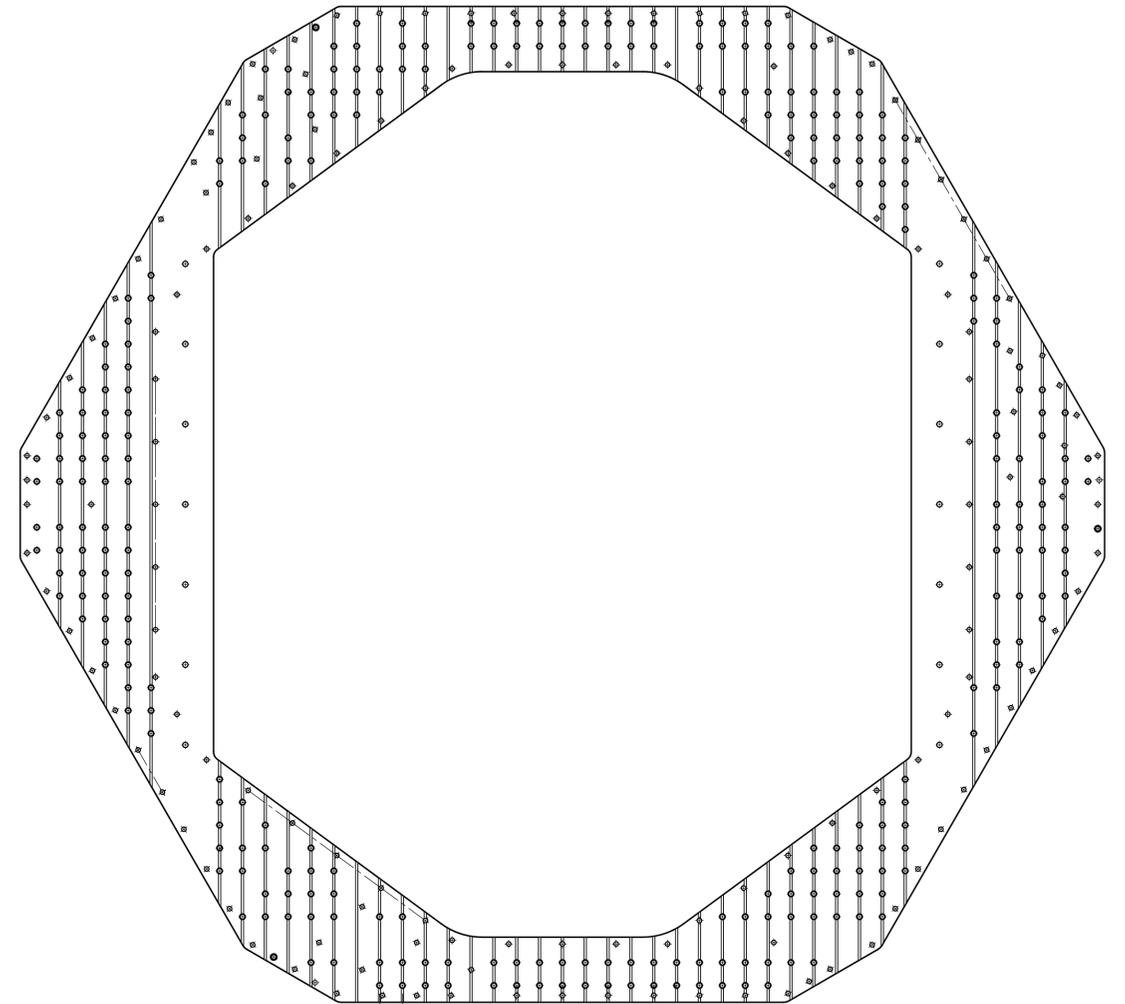
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	SEI
NEXT ASSY	D0900896		

PART NAME				STAGE 0 BOTTOM, dLIGO BSC-ISI			
DESIGNER	C.RAMET	05 Jan. 2010	SIZE	D	DWG. NO.	D0900894	REV.
DRAFTER	M.HILLARD	25 Jan 2010	SCALE	1:6	PROJECTION		v1
CHECKER	F.MATCHARD	25 Jan 2010	SHEET	1 OF 3			
APPROVAL	K.MASON	25 Jan 2010					

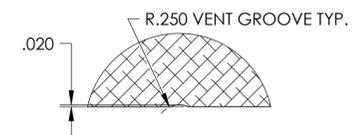
D0900894 Adv LIGO SEI BSC Stage 0 Bottom PART PDM REV: X-048 DRAWING PDM REV: X-019



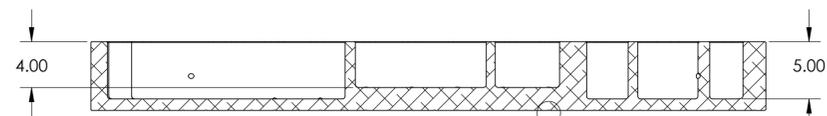
SECTION F-F



SECTION E-E



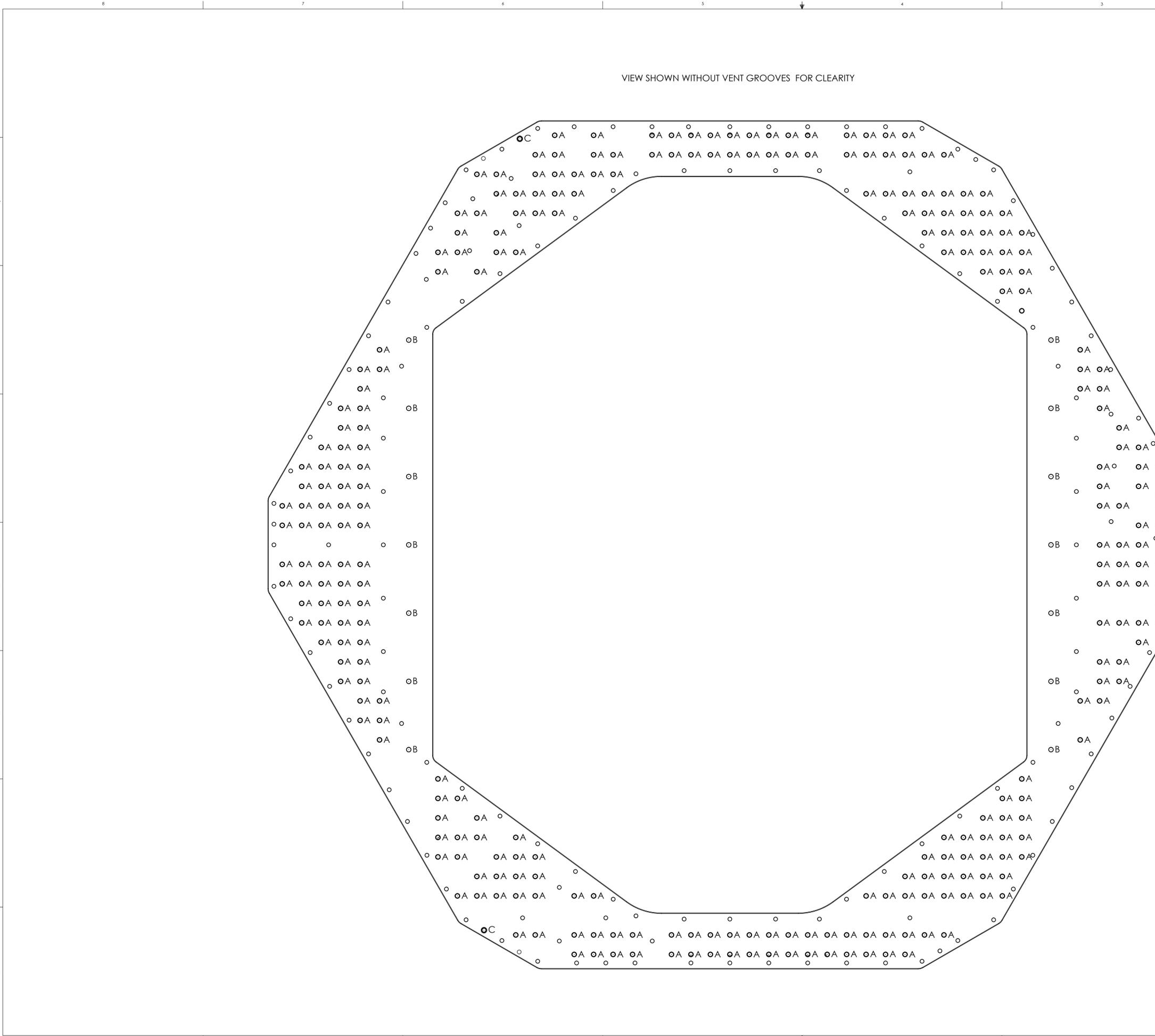
DETAIL K  
SCALE 1 : 1



SECTION J-J

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE	DWG. NO.	v1
D	D0900894	
SCALE: 1:8	PROJECTION:	SHEET 2 OF 3

D:\0900894 Adv LIGO SEI REC Stage 0 Bottom PART PDM REV: X-048 DRAWING PDM REV: X-019



TAG	SIZE	QUANTITY	GD&T
A	$\checkmark \phi .40 \downarrow 2.00$ $\checkmark \phi .52 \times 120^\circ$ , NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA.	286	$\oplus \phi .010$   A   B   C
B	$\checkmark \phi .438$ THRU $\checkmark \phi .50 \times 90^\circ$ , BOTH SIDES	14	$\oplus \phi .010$   A   B   C
C	$\phi .38$ THRU $\phi .42 \downarrow 3.00$ $\checkmark 1/2-13$ UNC $\downarrow 1.50$ $\checkmark \phi .60 \times 120^\circ$ , NEAR SIDE	3	$\oplus \phi .030$   A   B   C

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SIZE	DWG. NO.	REV.
D	D0900894	v1
SCALE: 1:5	PROJECTION:	SHEET 3 OF 3

D:\090894\_Ash\UGS\_S&E\BSC Stage 0\Bottom\_P\PART PDM REV: X-048\_DRAWING PDM REV: X-019