

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 0.25" HIGH CHARACTERS, UNLESS SIZE OF PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXX-VY, TYPE-XX, S/N XXX.
- 6. THIS DRAWING IS MINIMALLY DIMENSIONED. USE CAD MODEL TO EVALUATE FULL DIMENSIONAL DETAIL. UNLESS OTHERWISE SPECIFIED, THE MODEL TAKES PRECEDENCE OVER THE DRAWING WHEREVER THERE ARE DISCREPANCIES.
- 7. UNLESS OTHERWISE SPECIFIED, ALL SURFACES MUST SATISFY .025 PROFILE TOLERANCE WITH RESPECT TO DATUMS A, B, AND C.
- 8. APPROXIMATE WEIGHT = 573 LB.
- 9. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES (INCLUDING SANDING OR SCOURING FOR MATTE FINISH) IS NOT ALLOWED.
- 10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPEC. E0900364.
- 11. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES TO ALL TAPPED HOLES, EXCLUDING THREADED INSERTS AND HOLES LABELED "FOR LIFTING HARDWARE."
- 12. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS. USE ONLY NITRONIC 60 INSERTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	25 JAN 2010	E1000013	E1000025
v2	09 JUN 2010	E1000207	E1000025

142X ϕ .547 THRU ALL
 ϕ .938 ∇ 4.00
 \checkmark ϕ 1.00 X 90°, NEAR SIDE
 \checkmark ϕ .62 X 90°, FAR SIDE
 \oplus ϕ .010 (M) A B C

∇ .025 A B C
 (FOR ALL BASIC DIMENSIONS, UNLESS OTHERWISE SPECIFIED)

.06 X 45° CHAMFER
 ALL EDGES, BOTH SIDES
 UNLESS OTHERWISE SPECIFIED

12X ϕ .422 ∇ 1.25 (BREAK THRU)
 1/2-13 UNC -2B ∇ 1.00
 \checkmark ϕ .60 X 120°, NEAR SIDE
 2 EACH SIDE, 60° APART
 (FOR LIFTING HARDWARE)
 \oplus ϕ .030 A B C

12X ϕ .266 ∇ 1.50 (BREAK THRU)
 \checkmark ϕ .36 X 120°, NEAR SIDE
 TAP FOR 1/4-20
 HELICOIL INSERT = 2.0 * DIA.
 4 EACH SIDE, 120° APART
 (FOR LIFTING HARDWARE)
 \oplus ϕ .030 A B C

A
 ∇ .005
 ∇ .001 (1"X1")
 6.00
 ∇ .005 A
 ∇ .001 (1"X1")

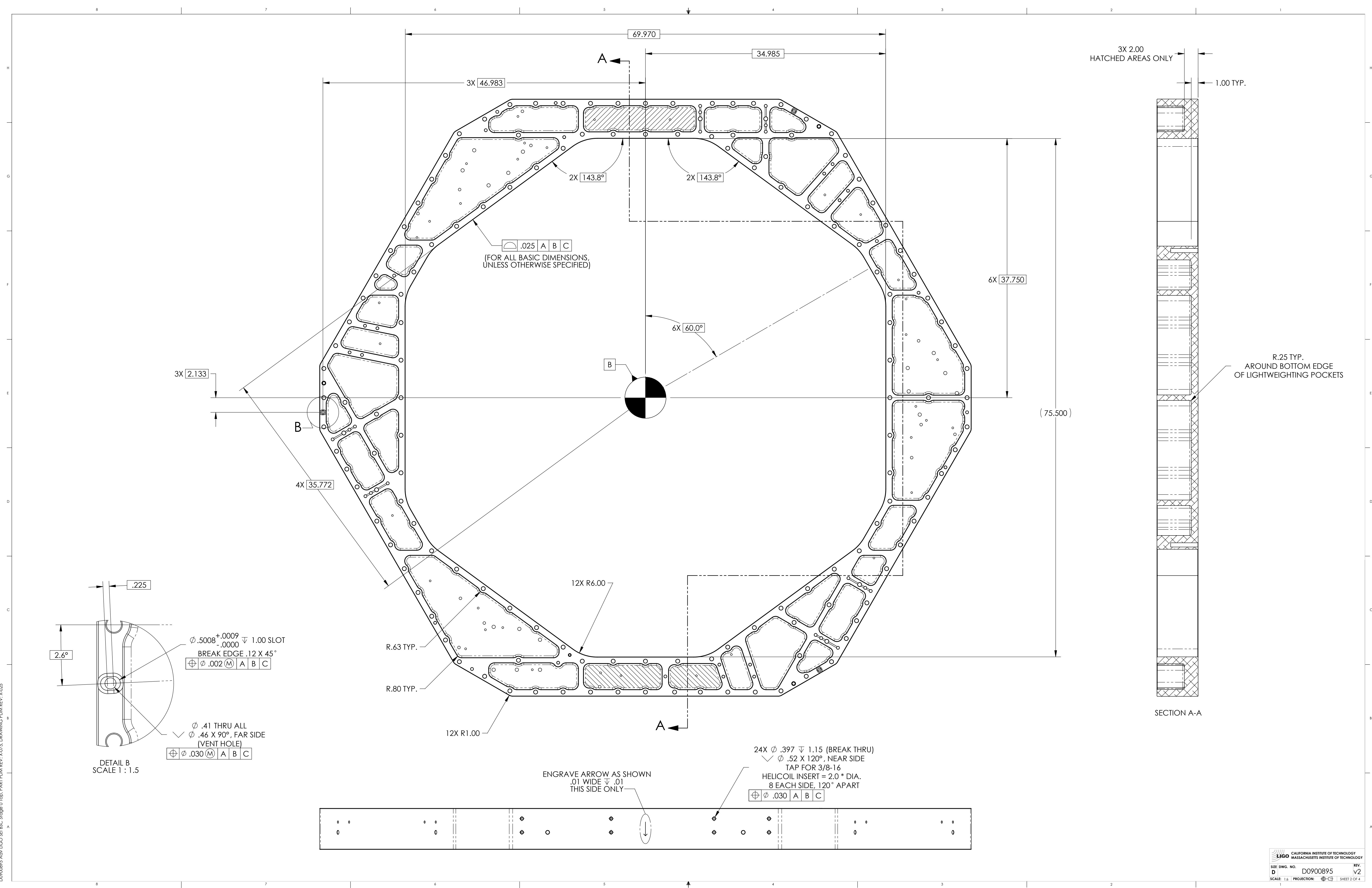
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .015 .XXX ± .005	
ANGULAR ± 0.5°	
MATERIAL	FINISH
6061-T6 Al	63 μ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	SEI
NEXT ASSY	
D0900896	

PART NAME				Stage 0 Top, aLIGO BSC ISI			
DESIGNER	C.RAMET	05 JAN 2010	SIZE	DWG. NO.		REV.	
DRAFTER	M.HILLARD	05 JAN 2010	D	D0900895		v2	
CHECKER	F.MATCHARD	05 JAN 2010	SCALE: 1:6	PROJECTION:		SHEET 1 OF 4	
APPROVAL	K.MASON	05 JAN 2010					

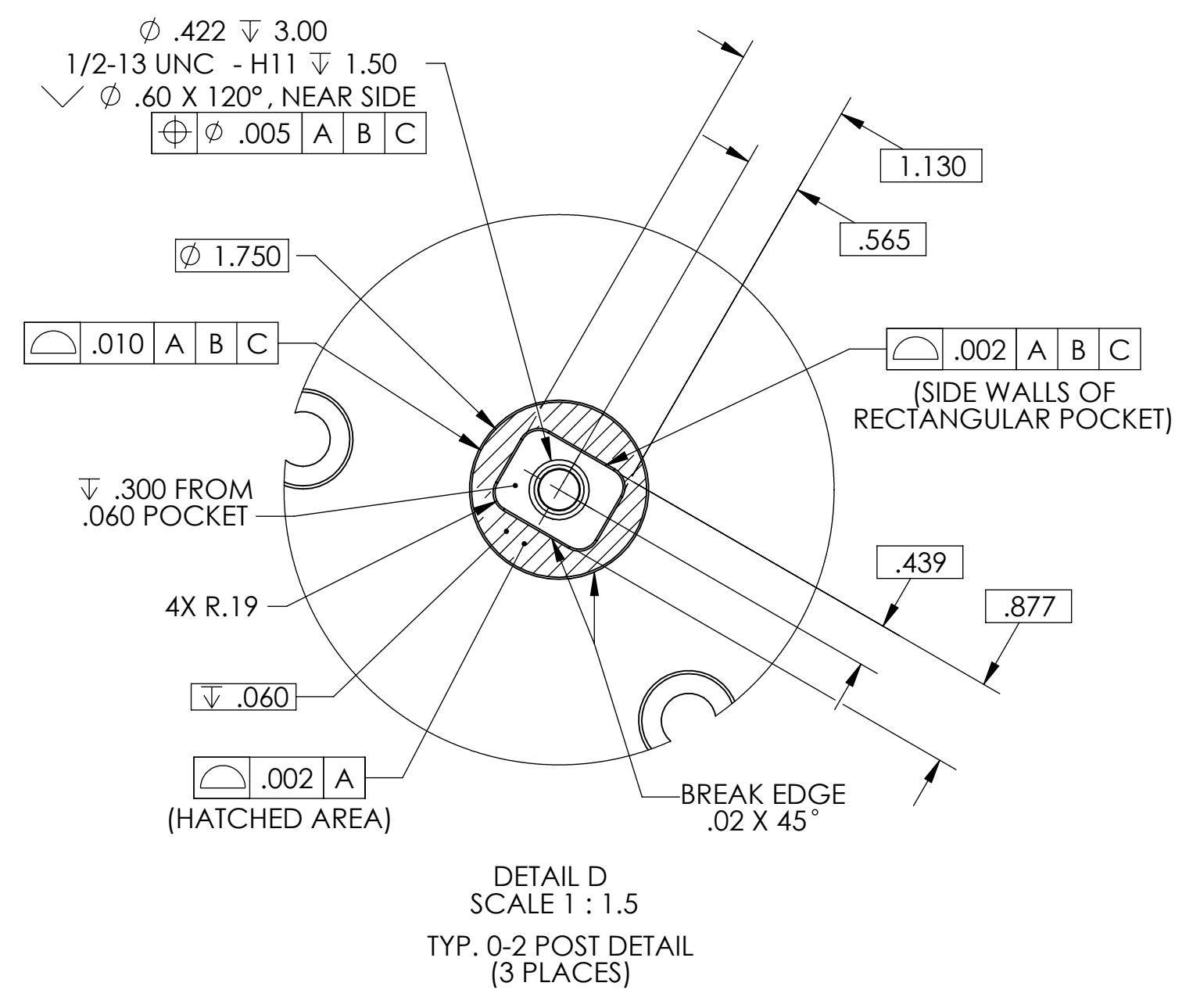
C VIEW C INDICATES THE BASE HOLE PATTERN, ARRAYED 3X. SEE VIEW C ON SHEET 3. NOT ALL FEATURES INCLUDED IN PATTERN.

D0900895 Adv LIGO BSC Stage 0 Top Part PDM REV: X-073 DRAWING PDM REV: X-025



D0900895 Adv LIGO SEI BSC Stage 0 Top PART PDM REV. X-073 DRAWING PDM REV. X-025

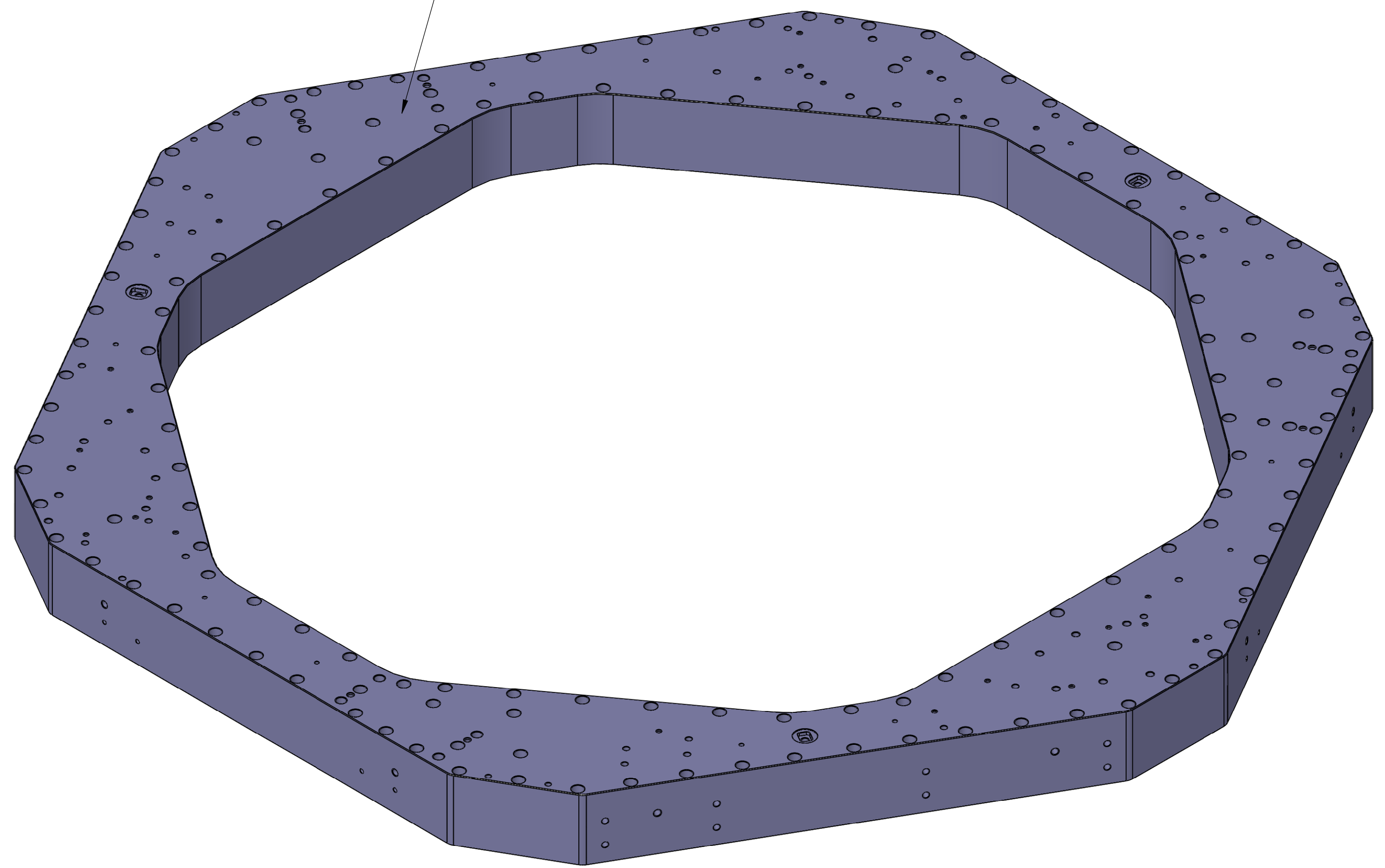
VIEW C
VIEW SHOWN INDICATES
BASE HOLE PATTERN, ARRAYED 3X
(SCALE 1:4)



TAG	SIZE	QUANTITY	TOLERANCE
A	$\phi .656 \pm 3.00$ $\checkmark \phi .85 \times 120^\circ$, NEAR SIDE TAP FOR 5/8-11 HELICOIL INSERT = 2.0 * DIA.	4	$\oplus \phi .010$ A B C
B	$\phi .500^{+.0000} \pm .75$ $\perp \phi .502^{+.001} \pm .15$ $\checkmark \phi .55 \times 90^\circ$, NEAR SIDE $\phi .41 \pm 3.00$ (VENT)	2	$\oplus \phi .002$ (M) A B C
C	$\phi .397 \pm 3.00$ $\checkmark \phi .52 \times 120^\circ$, NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA.	10	$\oplus \phi .010$ A B C
D	$\phi .3750^{+.0000} \pm .60$ $\perp \phi .377^{+.001} \pm .13$ $\checkmark \phi .42 \times 90^\circ$, NEAR SIDE $\phi .28 \pm 3.00$ (VENT)	8	$\oplus \phi .002$ (M) A B C
E	$\phi .266 \pm 2.00$ (BREAK THRU) $\checkmark \phi .34 \times 120^\circ$, NEAR SIDE TAP FOR 1/4-20 HELICOIL INSERT = 2.0 * DIA.	4	$\oplus \phi .010$ A B C
F	$\phi .422 \pm 3.00$ 1/2-13 UNC - H11 ± 1.50 $\checkmark \phi .60 \times 120^\circ$, NEAR SIDE	6	$\oplus \phi .010$ A B C NOTE 11
G	$\phi .422 \pm 3.00$ 1/2-13 UNC - 2B ± 1.50 $\checkmark \phi .60 \times 120^\circ$, NEAR SIDE	1	$\oplus \phi .030$ A B C FOR LIFTING HARDWARE
H	$\phi .41 \pm 3.00$ $\checkmark \phi .46 \times 90^\circ$, NEAR SIDE	1	$\oplus \phi .030$ (M) A B C VENT HOLE

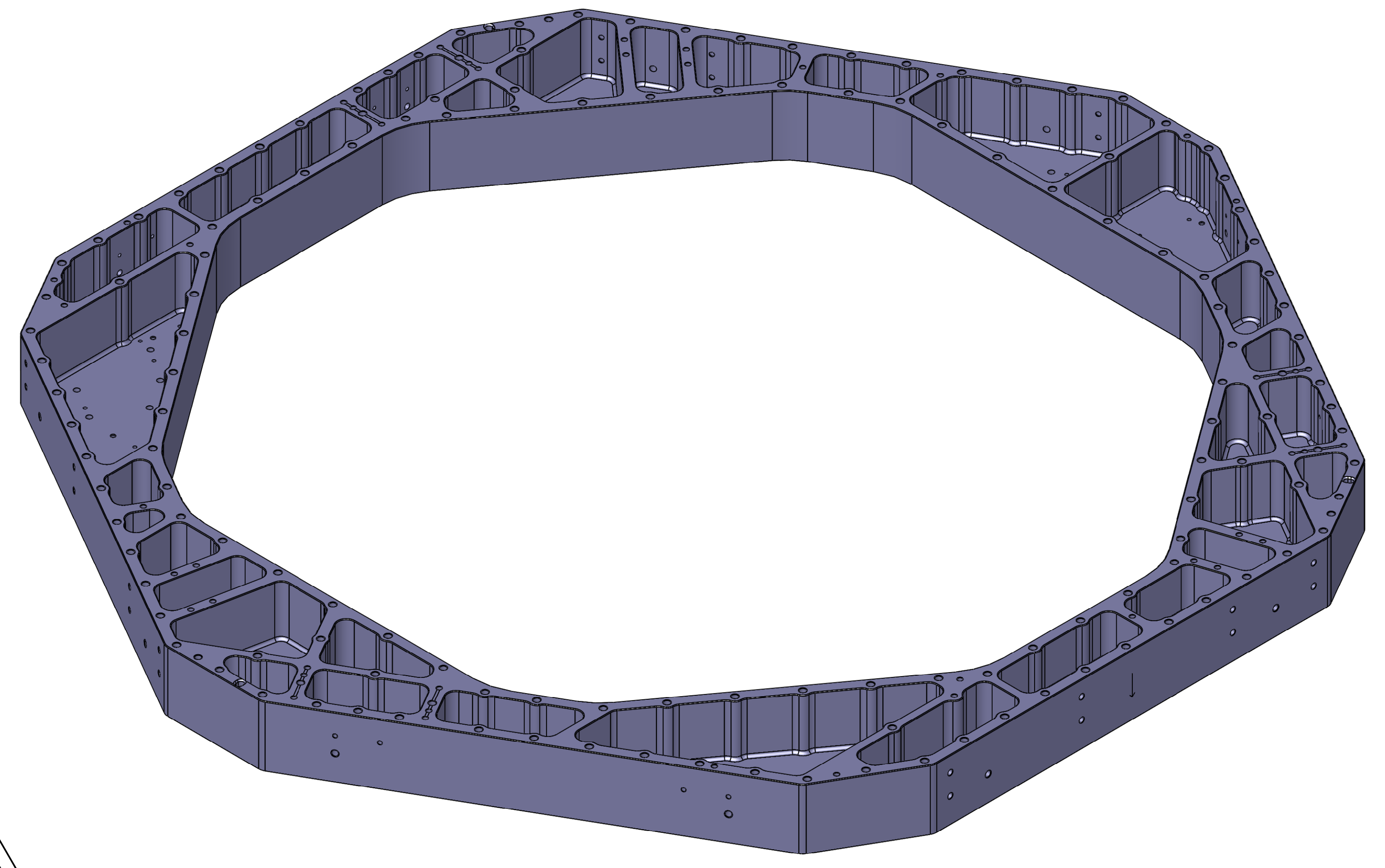
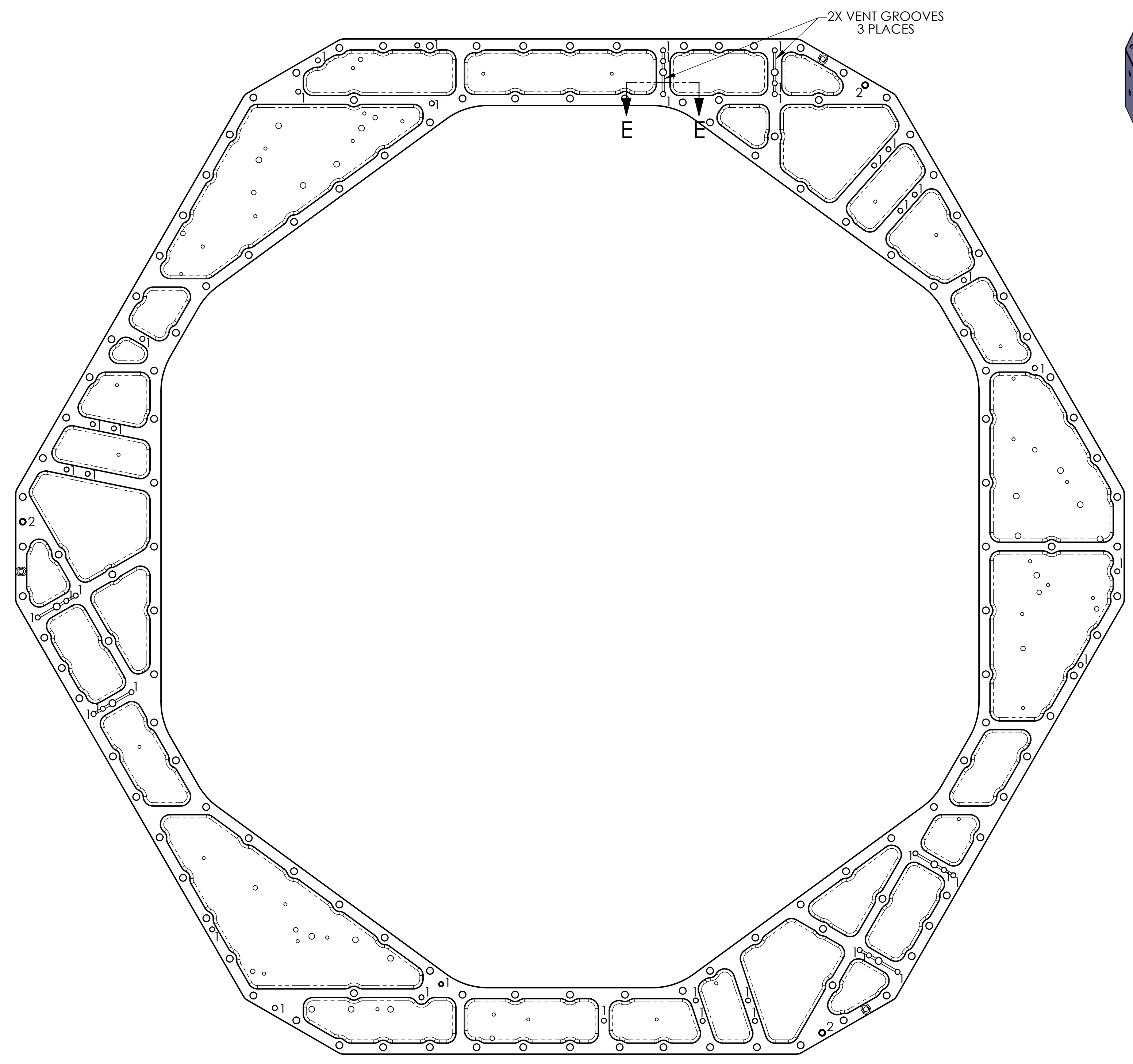
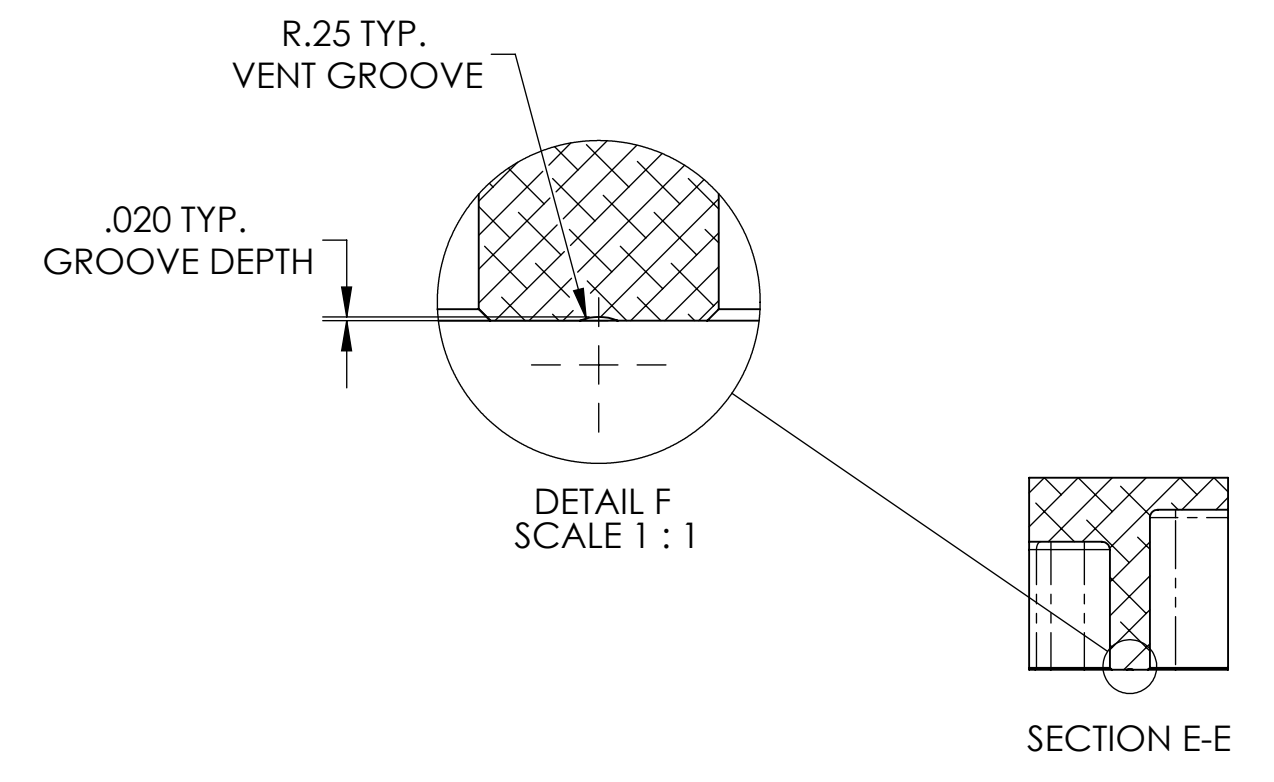
HOLE PATTERN ARRAYED 3X

FOR SHIPPING:
PLACE INTO CRATE WITH THIS SIDE FACING UP.



DDP00895-Adv-LIGO-SEI-BSC-Stage 0 Top PART PDM REV. X-073 DRAWING PDM REV. X-025

TAG	SIZE	QUANTITY	TOLERANCE
1	$\phi .41 \sqrt{3.00}$ $\phi .46 \times 90^\circ$, NEAR SIDE	44	$\oplus \phi .030 \text{ (M) A B C}$ VENT HOLE
2	$\phi .422 \sqrt{3.00}$ $1/2-13 \text{ UNC} - 2B \sqrt{1.50}$ $\phi .60 \times 120^\circ$, NEAR SIDE	3	$\oplus \phi .030 \text{ A B C}$ FOR LIFTING HARDWARE



D:\090895_Ash\UGO_S&E_BSC_Stage 0 Top_PART PDM_REV: X-073_DRAWING PDM_REV: X-025