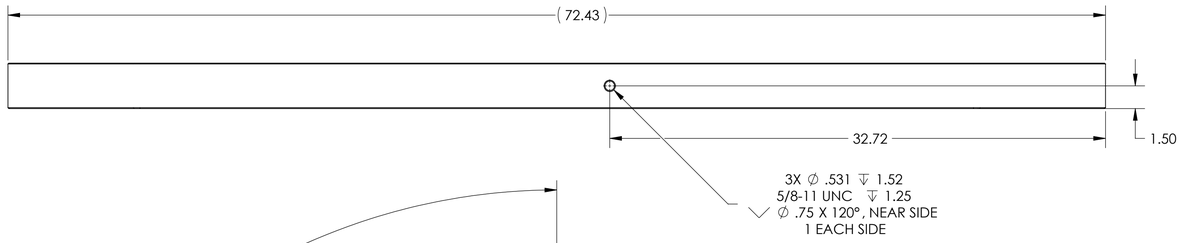
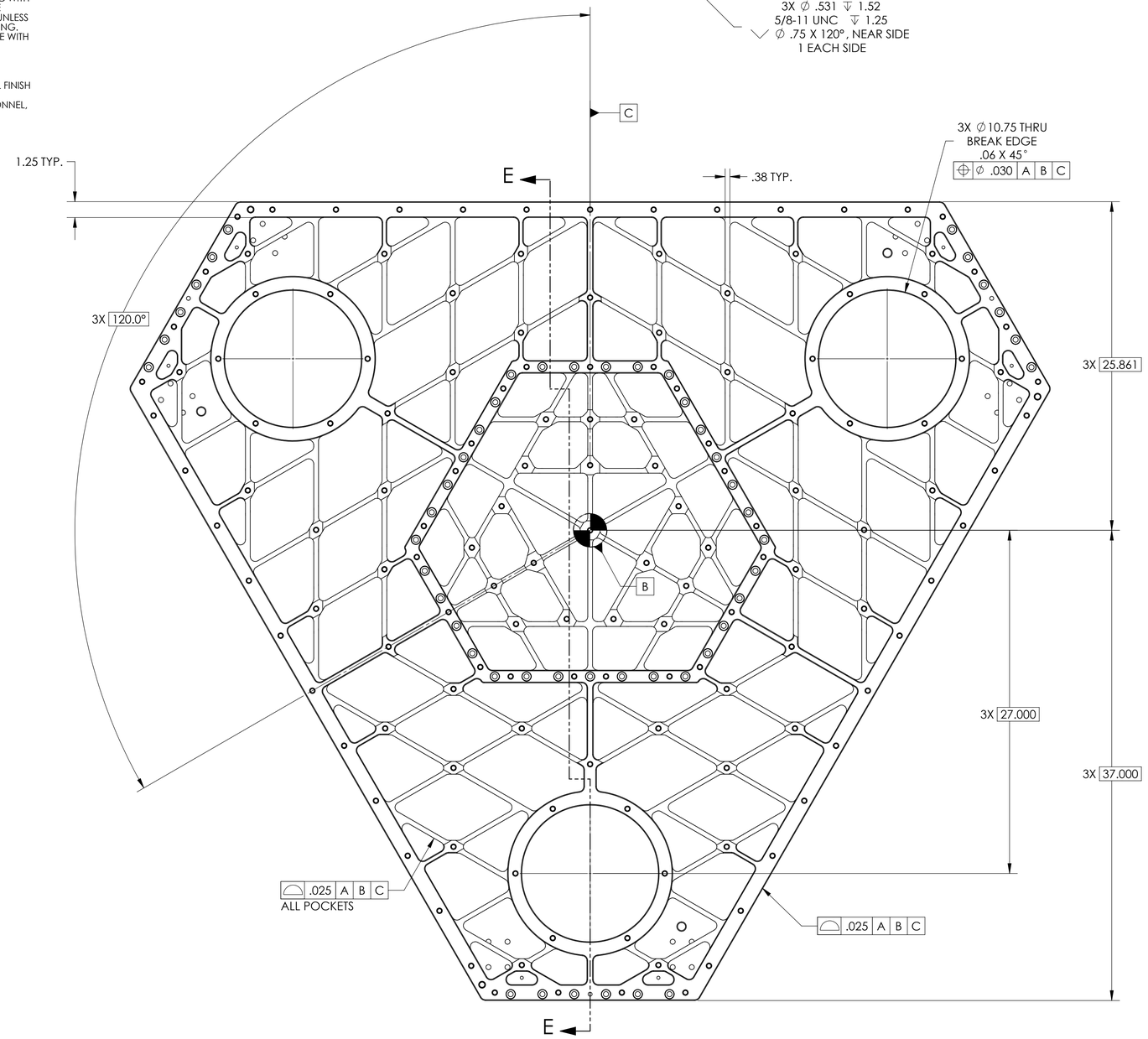
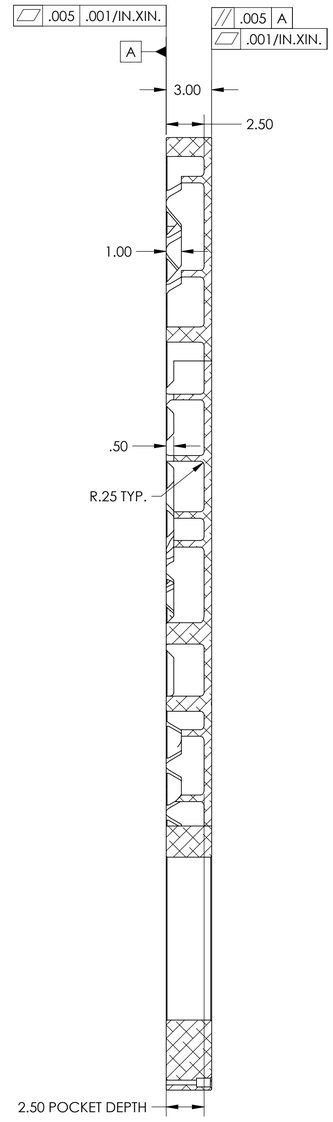
NOTES CONTINUED:

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: DXXXXXXX-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 UNLESS OTHERWISE SPECIFIED.
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 = 333 LBS.
10. A TRUE POSITION TOLERANCE OF Ø.010 IS ~ THE SAME AS A CONVENTIONAL TOLERENCE OF ±.005
11. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH ABRASIVE TECHNIQUES ARE NOT ACCEPTABLE.
12. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	28 Dec. 2009	E0900496	T0900600





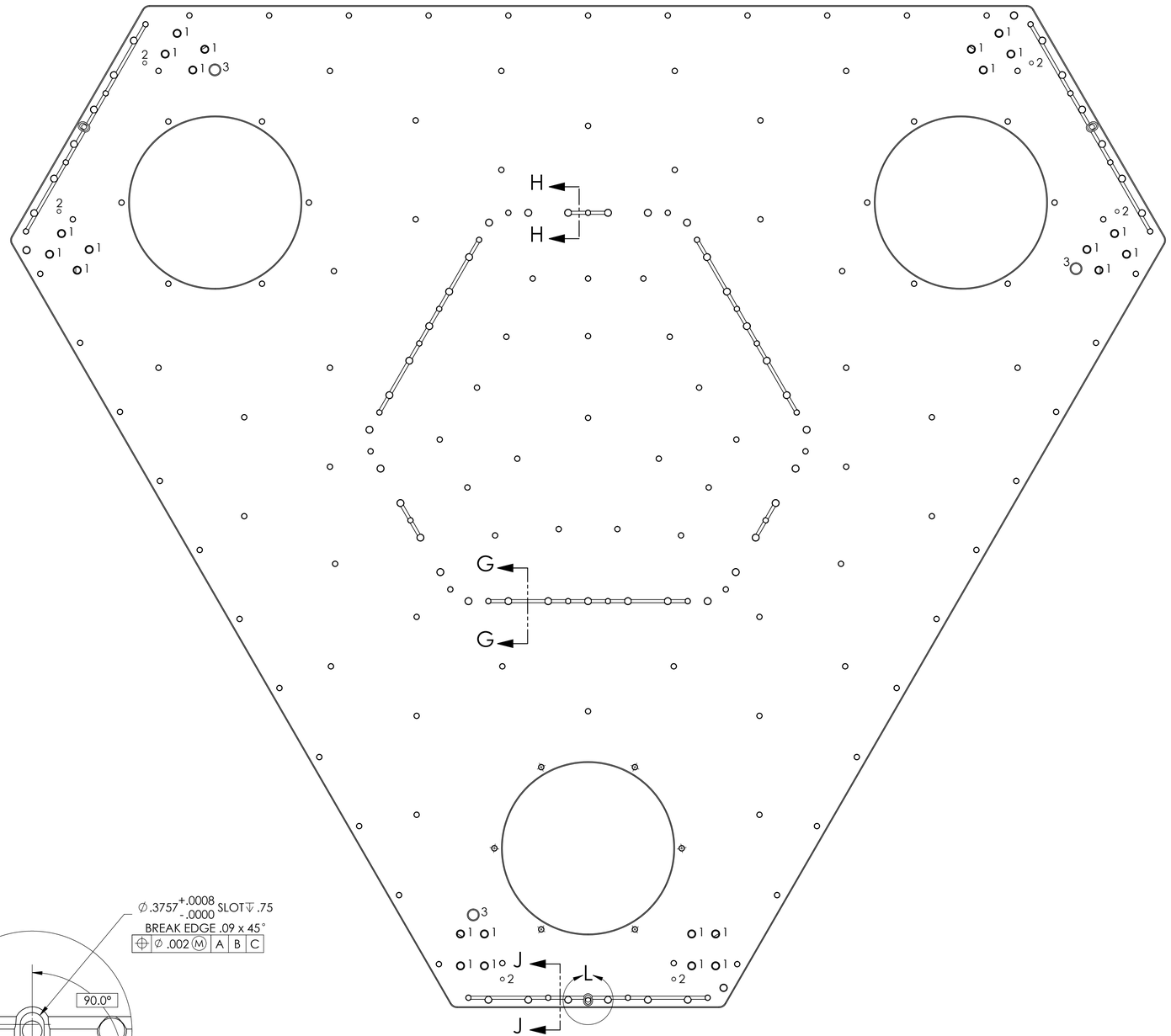


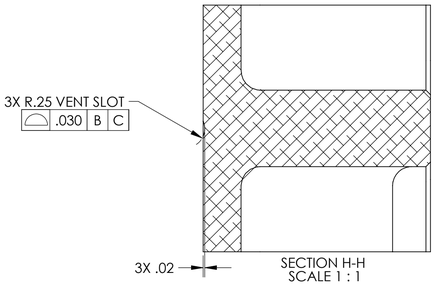
SECTION E-E

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)										
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± .5°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. BREAK ALL EDGES AND CORNERS .030 X 45°. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.			LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY			PART NAME: Keel Plate, Down-Facing, aLIGO BSC ISI			
	MATERIAL: 6061-T6 Al	FINISH: 63 µinch		SYSTEM: ADVANCED LIGO	SUB-SYSTEM: SEI		DESIGNER: A.STEIN 28 Dec. 2009	SIZE: D	DWG. NO.: D0901518	REV.: v1
				NEXT ASSY: D0901181			DRAFTER: M.HILLARD 28 Dec. 2009			
							CHECKER: F.MATICHARD 28 Dec. 2009			
							APPROVAL: K.MASON 28 Dec. 2009	SCALE: 1:5	PROJECTION:	SHEET 1 OF 3

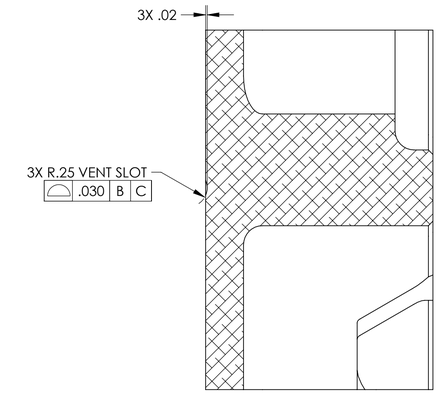
D0901518_Keel_Plate-Down-Facing-BSC_ISI, PART PDM REV: X-033, DRAWING PDM REV: X-009

TAG	SIZE	QUANTITY	GD&T
1	∅ .397 ↧ 1.30 ⌵ ∅ .52 X 120°, NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT = 2.0 * DIA.	24	⌖ ∅ .010 A B C
2	∅ .25 THRU ALL	6	⌖ ∅ .030 A B C
3	∅ .531 THRU 5/8-11 UNC THRU ⌵ ∅ .75 X 120°, NEAR SIDE ⌵ ∅ .75 X 120°, FAR SIDE	3	⌖ ∅ .010 A B C

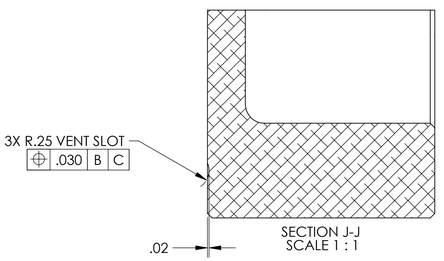




SECTION H-H
SCALE 1 : 1



SECTION G-G
SCALE 1 : 1



SECTION J-J
SCALE 1 : 1

DETAIL L
SCALE 1 : 1

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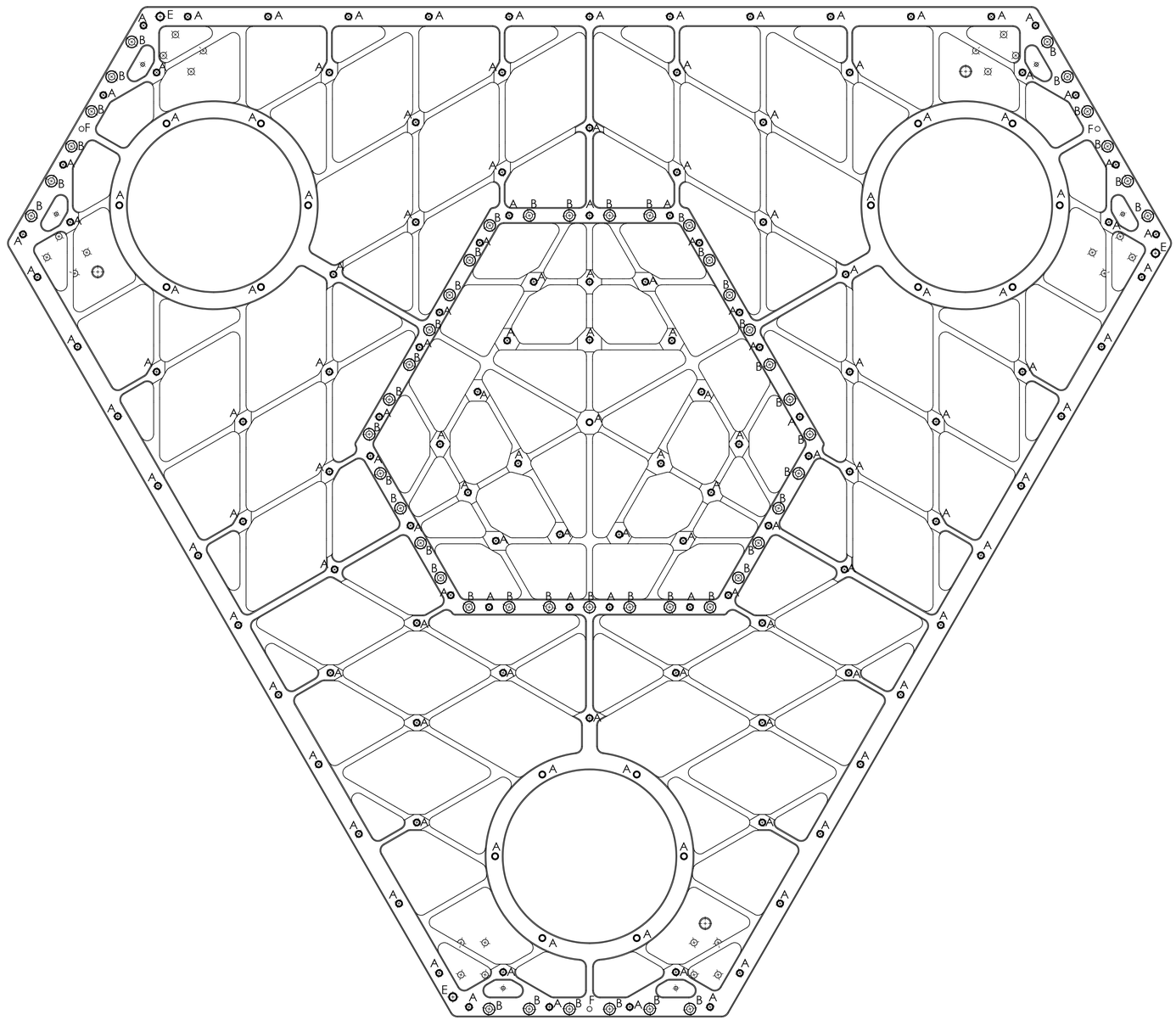
SIZE	DWG. NO.	REV.
D	D0901518	V1
SCALE: 1:4	PROJECTION:	SHEET 2 OF 3



TAG	SIZE	QUANTITY	GD&T
A	∅ .31 ↧ THRU 3/8-16 UNC ↧ 1.13 ⌵ ∅ .45 X 120° NEARSIDE	144	⌖ ∅ .010 A B C A THREAD PITCH DIAMETER LIMIT OF H11 APPLIES.
B	∅ .406 THRU ALL ⌴ ∅ .688 ↧ 1.50 ⌵ ∅ .75 X 90°, NEAR SIDE ⌵ ∅ .46 X 90°, FAR SIDE	51	⌖ ∅ .010 A B C
E	$\varnothing\ .5000^{+.0000}_{-.0006}$ ↧ .75 ⌴ $\varnothing\ .502^{+.001}_{-.000}$ ↧ .15 ⌵ ∅ .55 X 90°, NEAR SIDE ∅ .41 THRU	3	⌖ ∅ .002 A B C
F	∅ .31 THRU ALL	3	⌖ ∅ .030 A B C

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SIZE	DWG. NO.	REV.
D	D0901518	v1
SCALE: 1:4	PROJECTION:	SHEET 3 OF 3