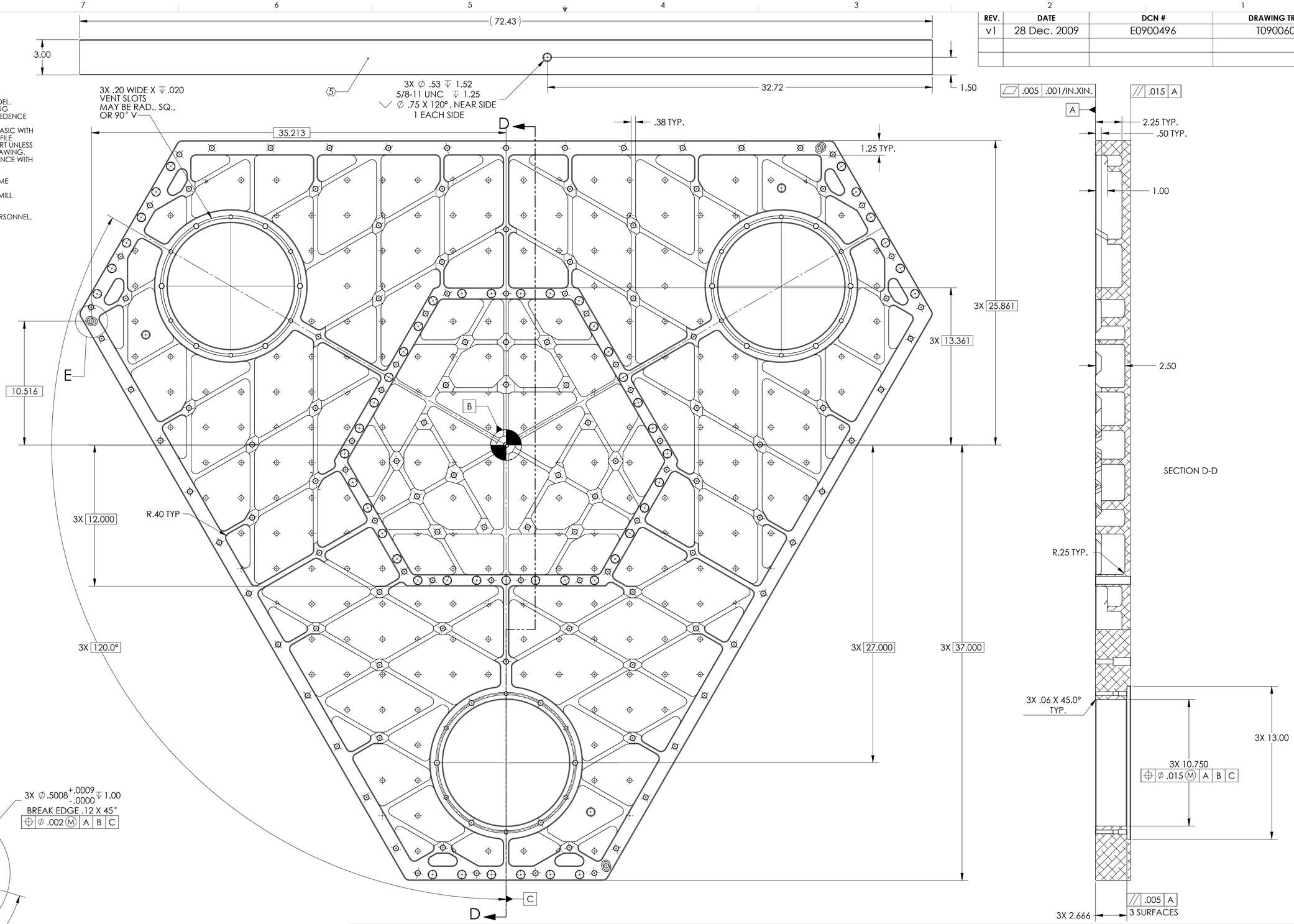
NOTES CONTINUED:

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 = 350 LB.
10. A TRUE POSITION TOLERANCE OF ⌀.010 IS ~ THE SAME AS A CONVENTIONAL TOLERENCE OF ±.005.
11. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. ABRASIVE REMOVAL 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



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. BREAL ALL EDGES AND CORNERS .03 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.	MATERIAL: 6061-T6 Al	FINISH: 63 µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM	SUB-SYSTEM	NEXT ASSY
ADVANCED LIGO	SEI	D0901181

PART NAME: Keel Plate, Up-Facing, aLIGO BSC ISI

DESIGNER	A.STEIN	28 Dec. 2009	SIZE: D
DRAFTER	M.HILLARD	28 Dec. 2009	DWG. NO.: D0901519
CHECKER	F.MATICHARD	28 Dec. 2009	REV.: v1
APPROVAL	K.MASON	28 Dec. 2009	SCALE: 1:4

PROJECTION: SHEET 1 OF 2

D0901519_Keel_Plate-Up-Facing-BSC_ISI, PART PDM, REV= X-V31, DRAWING_PDM, REV= X-V07

TAG	SIZE	QUANTITY	GD&T
A	∅ .406 THRU ALL ⌴ ∅ .688 ↧ 1.50 ⌵ ∅ .75 X 90°, NEAR SIDE ⌵ ∅ .46 X 90°, FAR SIDE	127	⌖ ∅ .010 Ⓜ A B C
B	∅ .69 THRU ALL ⌵ ∅ .75 X 90°, BOTH SIDES	51	⌖ ∅ .030 A B C
D	∅ .397 ↧ .88 ⌵ ∅ .52 X 120°, NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT = 1.0 * DIA.	239	⌖ ∅ .030 A B C
F	∅ .53 THRU .5/8-11 UNC THRU ⌵ ∅ .75 X 120°, BOTH SIDES	3	⌖ ∅ .030 A B C

M

18X ∅ .406 THRU ALL
⌴ ∅ .688 ↧ 1.17
⌵ ∅ .75 X 90°, NEAR SIDE
⌵ ∅ .46 X 90°, FAR SIDE
(6 EACH HOLE)
⌖ ∅ .010 Ⓜ A C D

18X ∅ .33 ↧ 1.17
⌵ ∅ .44 X 120°, NEAR SIDE
TAP FOR 5/16-24
HELICOIL INSERT = 2.0 * DIA.
(6 EACH HOLE)
⌖ ∅ .010 A C D

12X 30.0°

D

∅ 11.750 BC

DETAIL M
SCALE 1 : 2

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
D	D0901519	v1

SCALE: 1:3.1 | PROJECTION: | SHEET 2 OF 2

D0901519_Keel_Plate-Up-Facing-BSC_ISI. PART FDM REV: X-031. DRAWING FDM REV: X-007