

D0901525_Hex_Wall-Lower-Small-BSC_ISI, PART PDM REV: X-026, DRAWING PDM REV: X-008

8 7 6 5 4 3 2 1

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. APPROXIMATE WEIGHT = 5.6 LB.
- 7. A TRUE POSITION TOLERANCE OF $\phi .010$ IS ~ THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.
- 8. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 9. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES.
- 10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

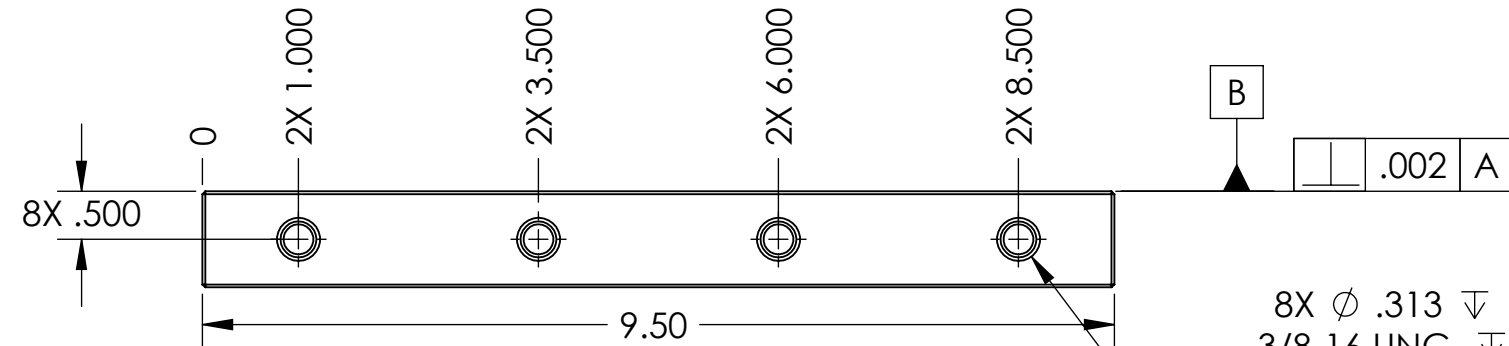
| REV. | DATE | DCN # | DRAWING TREE # |
|------|--------------|----------|----------------|
| v1 | 12 Mar. 2010 | E1000020 | E1000025 |

D

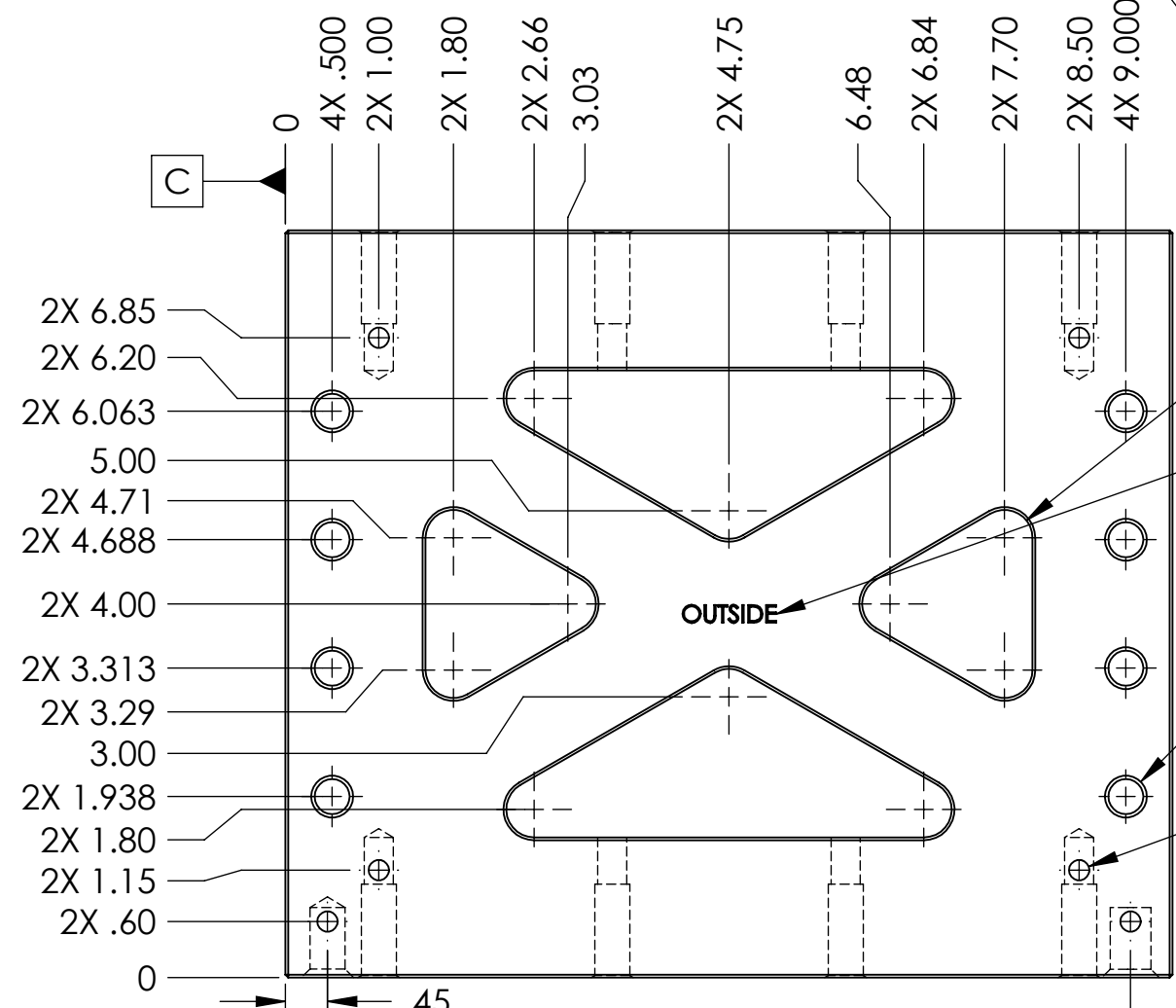
C

B

A



8X $\phi .313 \nabla 1.50$
 3/8-16 UNC $\nabla 1.00$
 $\phi .45 \times 120^\circ$, NEAR SIDE
 4 NEAR SIDE
 4 FAR SIDE



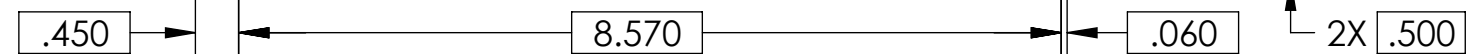
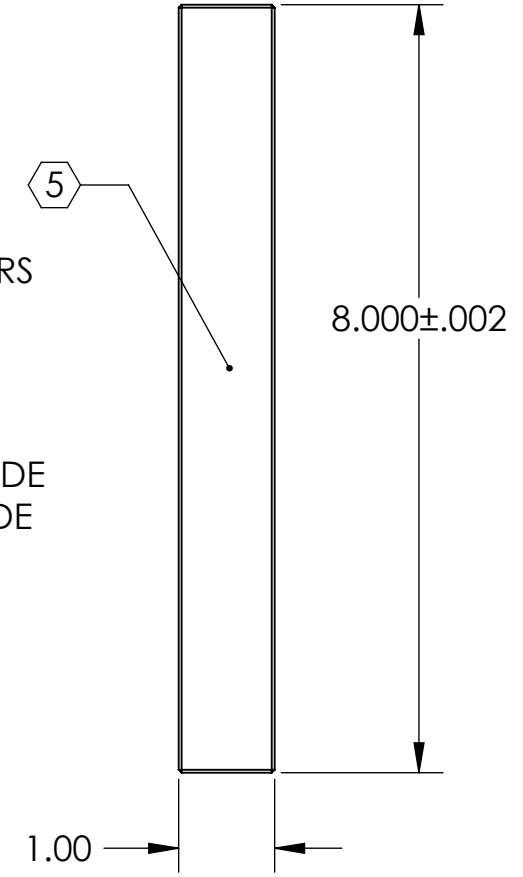
R.30 TYP.
 ALL POCKETS
 ENGRAVE "OUTSIDE"
 USING .19 HIGH CHARACTERS

8X $\phi .313$ THRU ALL
 3/8-16 UNC THRU ALL
 $\phi .45 \times 120^\circ$, NEAR SIDE
 $\phi .45 \times 120^\circ$, FAR SIDE

6X $\phi .22$ THRU ALL

$\phi .3757^{+.0008} \nabla .75$
 $\phi .56 \times 90^\circ$, NEAR SIDE
 $\phi .002 (M) A B C$

$\phi .3757^{+.0008} \nabla .75$ SLOT
 BREAK EDGE .09 X 45°
 $\phi .002 (M) A B C$



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX $\pm .015$
 .XXX $\pm .005$
 ANGULAR $\pm 0.5^\circ$

| | |
|--|---------------|
| 1. INTERPRET DRAWING PER ASME Y14.5-1994. | |
| 2. BREAK 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 μ inch |

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|---|---------------|
| LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY | |
| SYSTEM | ADVANCED LIGO |
| SUB-SYSTEM | SEI |
| NEXT ASSY | D0901181 |

| | | | |
|---------------------------------------|-------------|--------------|---------------|
| PART NAME | | | |
| Hex Wall, Lower, Small, aLIGO BSC ISI | | | |
| DESIGNER | A.STEIN | 11 Jan. 2010 | SIZE DWG. NO. |
| DRAFTER | M.HILLARD | 11 Jan. 2010 | B |
| CHECKER | F.MATICHARD | 11 Jan. 2010 | D0901525 |
| APPROVAL | K.MASON | 11 Jan. 2010 | REV. v1 |
| SCALE: 1:2 | | PROJECTION: | |
| SHEET 1 OF 1 | | | |

8 7 6 5 4 3 2 1