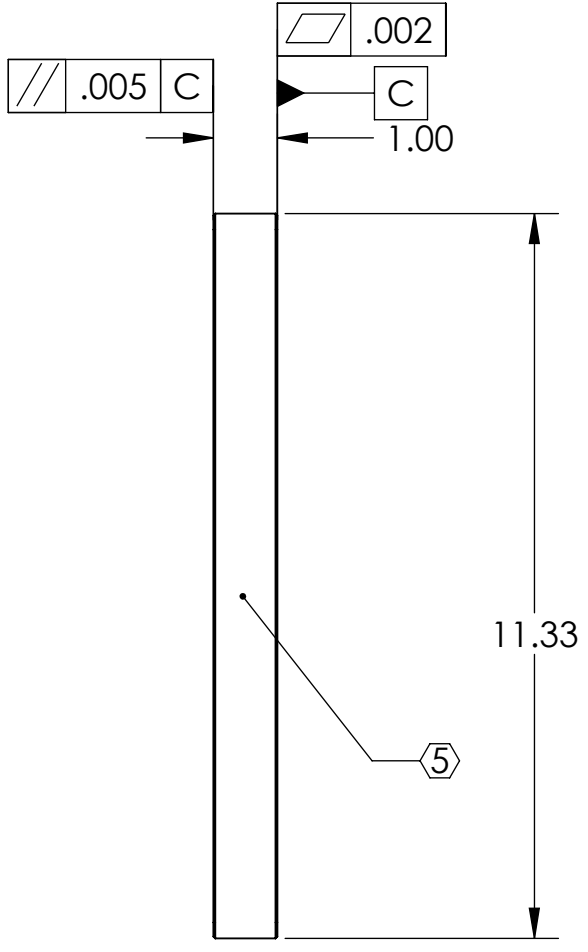
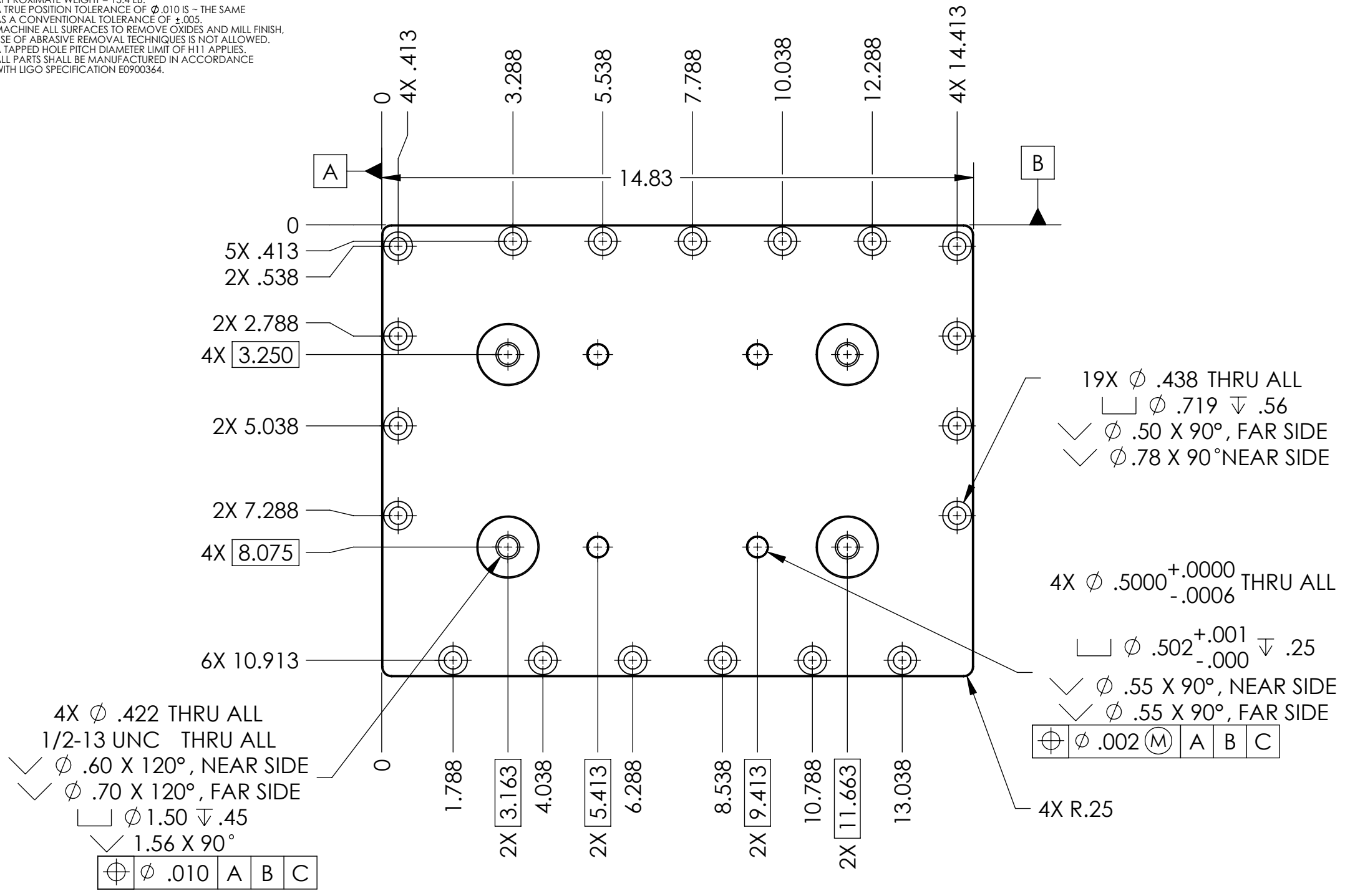


NOTES CONTINUED:

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 = 13.4 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

D0901532\_Outer\_Wall-Lower-BSC\_ISI, PART PDM REV: X-027, DRAWING PDM REV: X-007



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		Outer Wall, Lower, aLIGO BSC ISI	
TOLERANCES: .XX $\pm .015$ .XXX $\pm .005$				SEI		DESIGNER	A.STEIN 14 Jan. 2010
ANGULAR $\pm 0.5^\circ$				MATERIAL 6061-T6 Al		DRAFTER	M.HILLARD 14 Jan. 2010
FINISH 63 $\mu$ inch				NEXT ASSY D1000052		CHECKER	F.MATICHARD 14 Jan. 2010
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.				SCALE: 1:3		APPROVAL	K.MASON 14 Jan. 2010
						SIZE DWG. NO.	B D0901532
						REV.	v1
						SHEET 1 OF 1	