

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

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 = 0.9 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. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS. USE ONLY NITRONIC 60 INSERTS.

10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

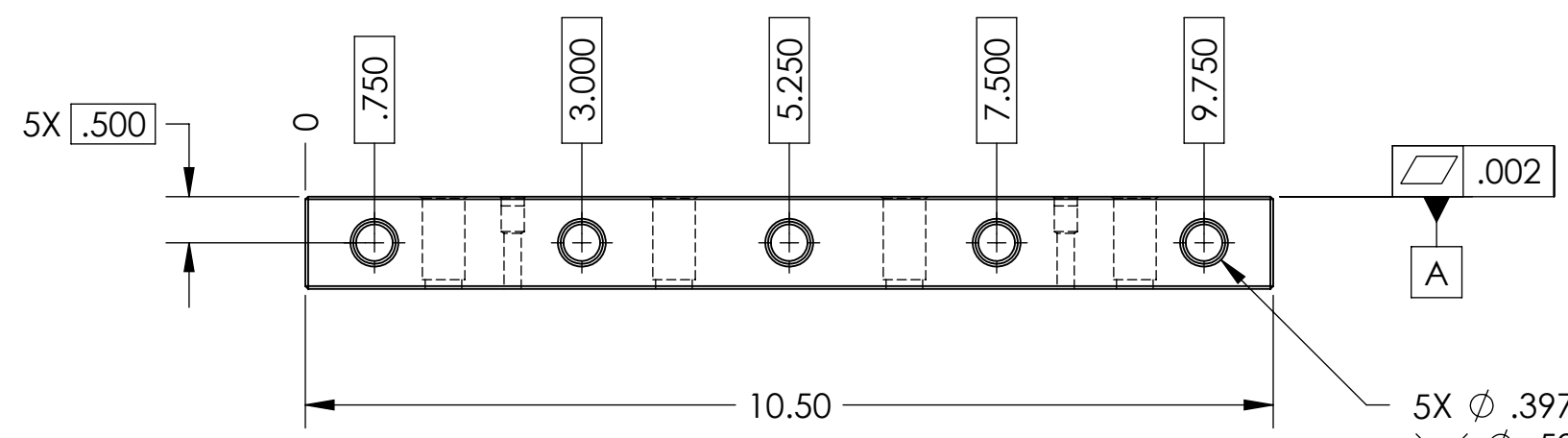
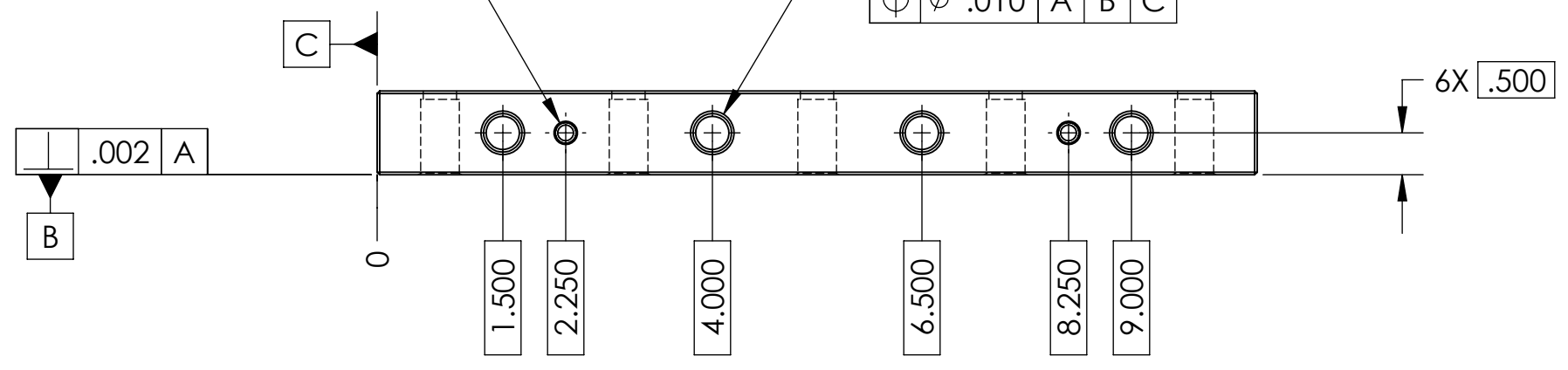
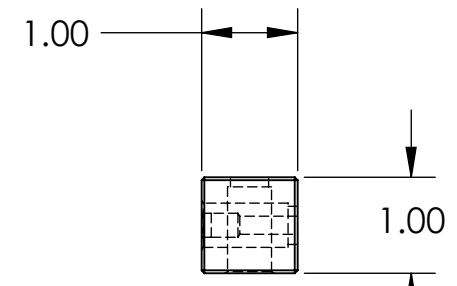
D
C
B
A

D
C
B
A

2X $\phi .19$ THRU
 $\phi .2500^{+.0000}_{-.0004}$ $\nabla .38$

$\nabla \phi .251^{+.001}_{-.000}$ $\nabla .10$
 $\nabla \phi .28 \times 90^\circ$, NEAR SIDE
 $\phi .002$ (M) A B C

4X $\phi .397$ THRU ALL
 $\nabla \phi .52 \times 120^\circ$, NEAR SIDE
 TAP FOR 3/8-16
 HELICOIL INSERT = 2.0 * DIA.
 $\phi .010$ A B C



5X $\phi .397$ THRU ALL
 $\nabla \phi .52 \times 120^\circ$, NEAR SIDE
 TAP FOR 3/8-16
 HELICOIL INSERT = 2.0 * DIA.
 $\phi .010$ B A C

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. BREAK ALL EDGES AND CORNERS $.03 \times 45^\circ$.
 3. DO NOT SCALE FROM DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX $\pm .015$
 .XXX $\pm .005$
 ANGULAR $\pm 0.5^\circ$

MATERIAL: 6061-T6 Al FINISH: 63 μ inch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME Bracket, Lower Outer Wall, Top, aLIGO BSC ISI	
SYSTEM ADVANCED LIGO	SUB-SYSTEM SEI	DESIGNER A.STEIN 11 Jan. 2010	SIZE DWG. NO. B D0901536
DRAFTER M.HILLARD 11 Jan. 2010	CHECKER F.MATICHARD 11 Jan. 2010	APPROVAL K.MASON 11 Jan. 2010	REV. v1
NEXT ASSY D0901181	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1

D0901536_Bracket-Lower_Outer_Wall-Top-BSC_ISI, PART PDM REV: X-013, DRAWING PDM REV: X-008

8 7 6 5 4 3 2 1