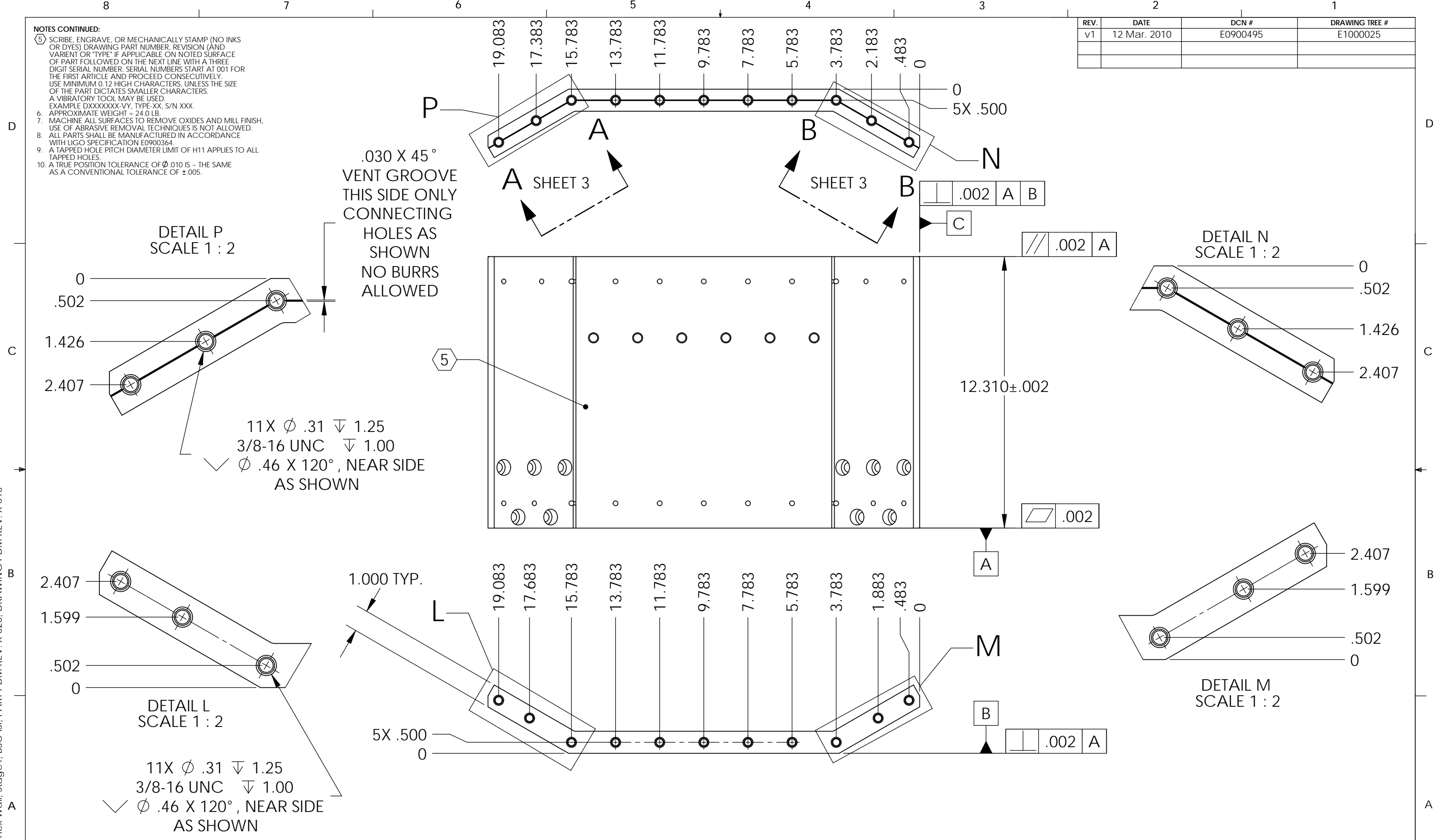


D0902271 Angled Hex Wall, Stage1, BSC-ISI, PART PDM REV: X-026, DRAWING PDM REV: X-010

**NOTES CONTINUED:**  
 (5) SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12 HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.  
 EXAMPLE DXXXXXX-VY, TYPE-XX, S/N XXX.  
 6. APPROXIMATE WEIGHT = 24.0 LB.  
 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.  
 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.  
 9. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES TO ALL TAPPED HOLES.  
 10. A TRUE POSITION TOLERANCE OF  $\phi .010$  IS - THE SAME AS A CONVENTIONAL TOLERANCE OF  $\pm .005$ .

REV.	DATE	DCN #	DRAWING TREE #
v1	12 Mar. 2010	E0900495	E1000025



DETAIL P  
SCALE 1 : 2

DETAIL N  
SCALE 1 : 2

DETAIL L  
SCALE 1 : 2

DETAIL M  
SCALE 1 : 2

11X  $\phi .31 \nabla 1.25$   
 3/8-16 UNC  $\nabla 1.00$   
 $\surd \phi .46 \times 120^\circ$ , NEAR SIDE  
 AS SHOWN

11X  $\phi .31 \nabla 1.25$   
 3/8-16 UNC  $\nabla 1.00$   
 $\surd \phi .46 \times 120^\circ$ , NEAR SIDE  
 AS SHOWN

.030 X 45°  
 VENT GROOVE  
 THIS SIDE ONLY  
 CONNECTING  
 HOLES AS  
 SHOWN  
 NO BURRS  
 ALLOWED

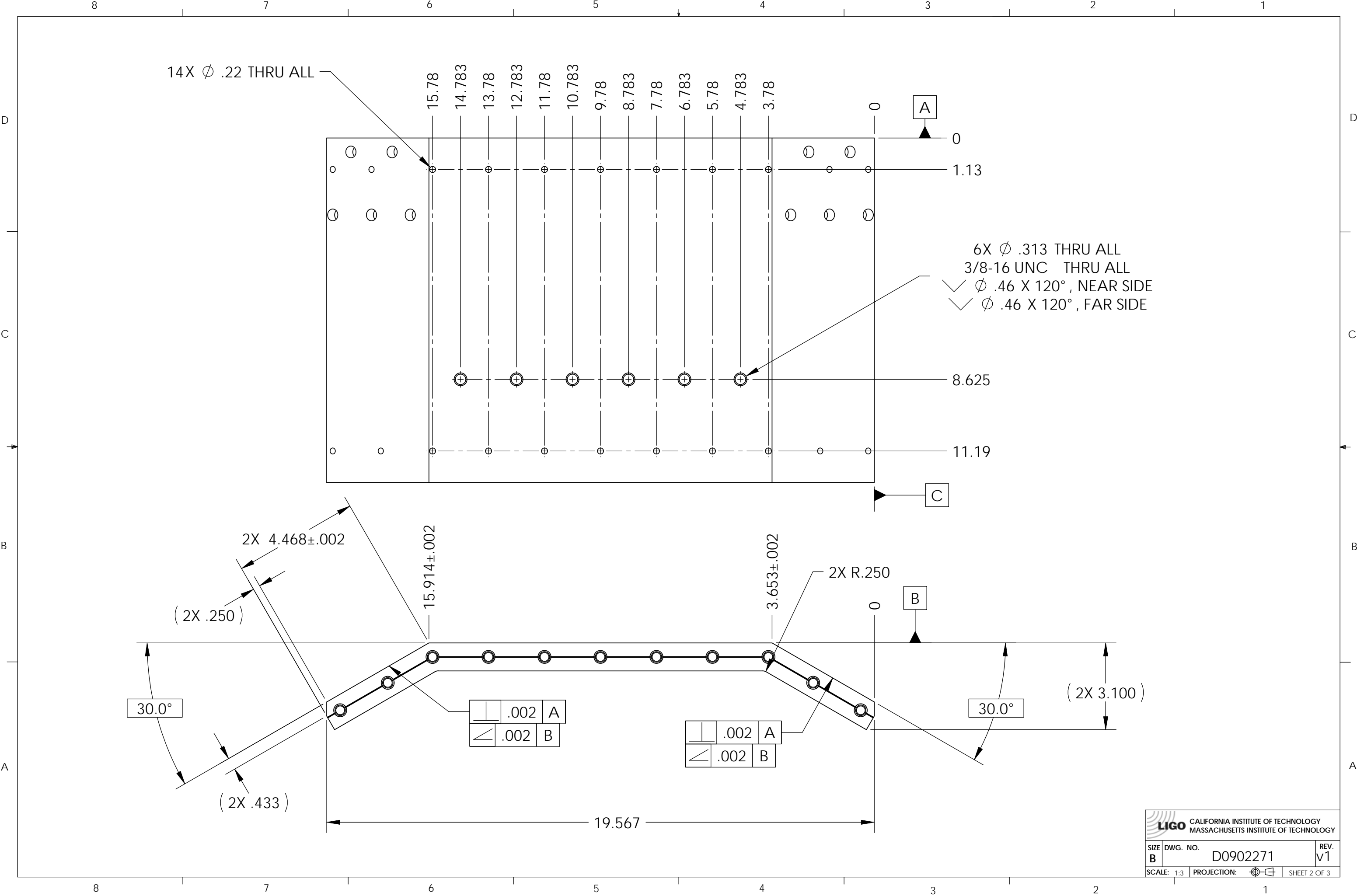
**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .015 .XXX ± .005	
ANGULAR ± 0.5°	
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 $\mu$ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	SEI
NEXT ASSY	D0901180

PART NAME ANGLED HEX WALL, STAGE 1, aLIGO BSC ISI			
DESIGNER	F.MATICHARD	15 Jan. 2010	SIZE
DRAFTER	M.HILLARD	15 Jan. 2010	DWG. NO.
CHECKER	A.STEIN	15 Jan. 2010	<b>B</b>
APPROVAL	K.MASON	15 Jan. 2010	D0902271
SCALE: 1:4		PROJECTION:	SHEET 1 OF 3
REV.	v1		

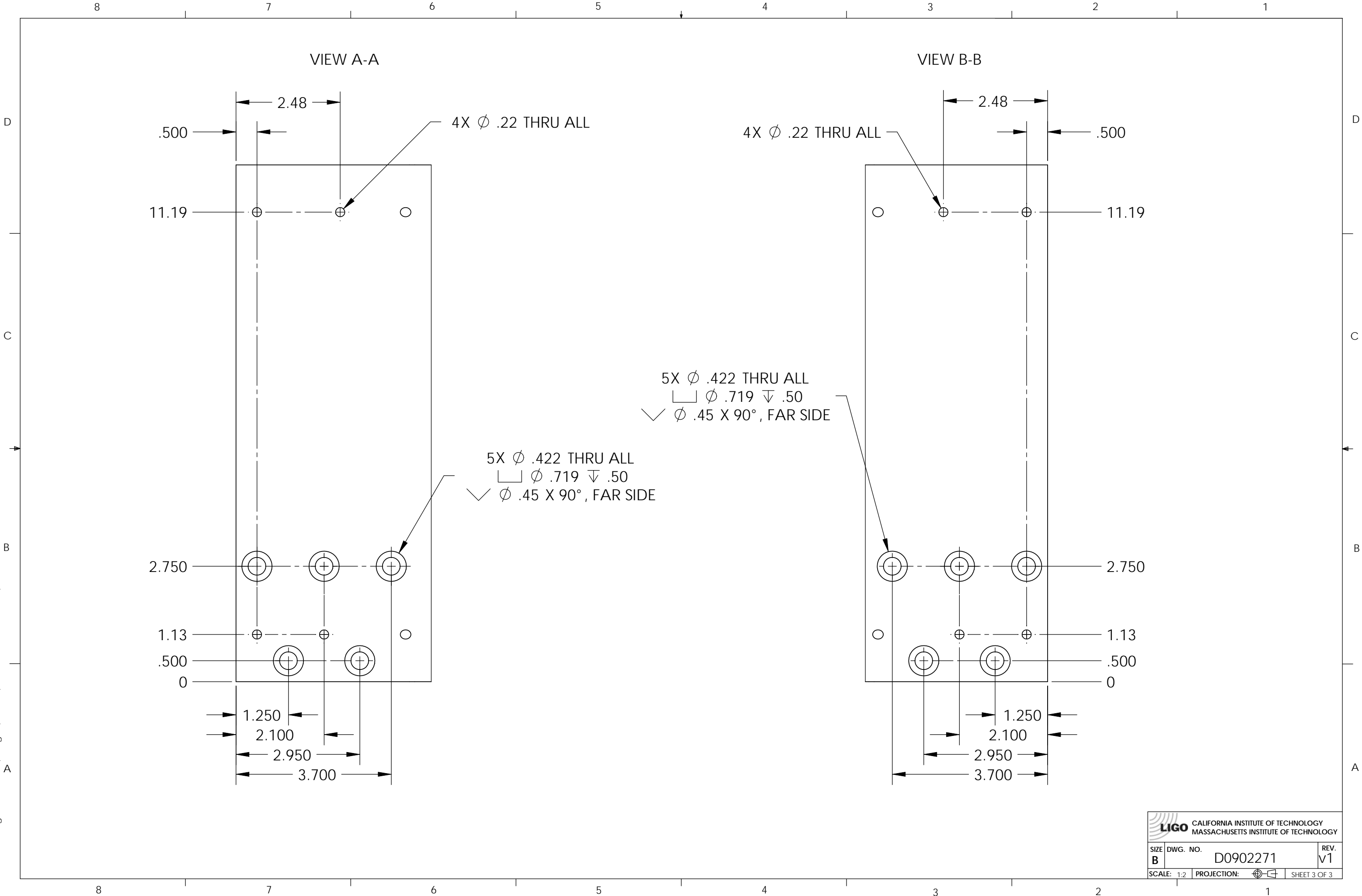
D0902271 Angled Hex Wall, Stage1, BSC-ISI, PART PDM REV: X-026, DRAWING PDM REV: X-010



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SIZE	DWG. NO.	REV.
B	D0902271	V1
SCALE: 1:3	PROJECTION:	SHEET 2 OF 3

D0902271 Angled Hex Wall, Stage1, BSC-ISI, PART PDM REV: X-026, DRAWING PDM REV: X-010



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SIZE <b>B</b>	DWG. NO. D0902271	REV. V1
SCALE: 1:2	PROJECTION:	SHEET 3 OF 3