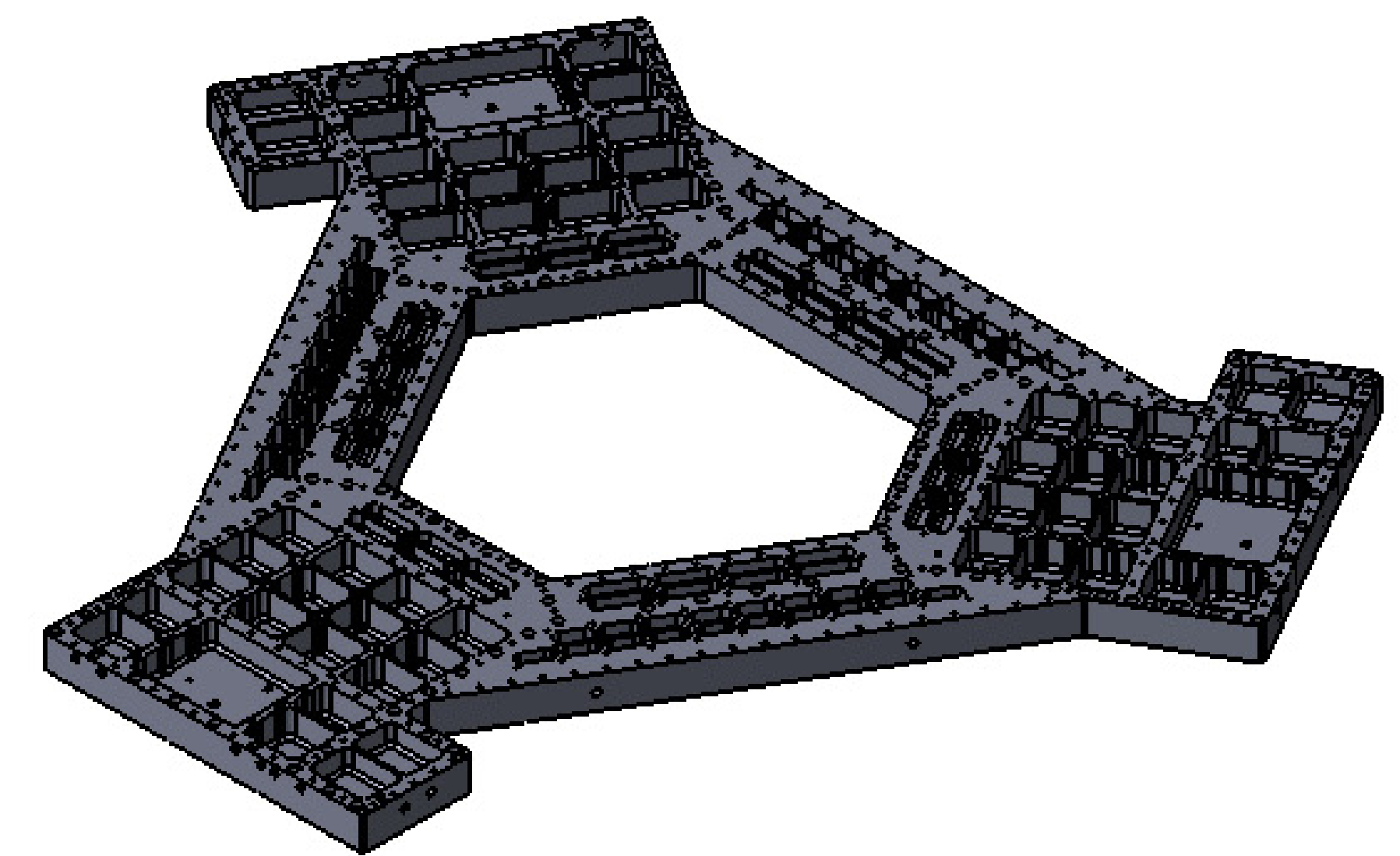
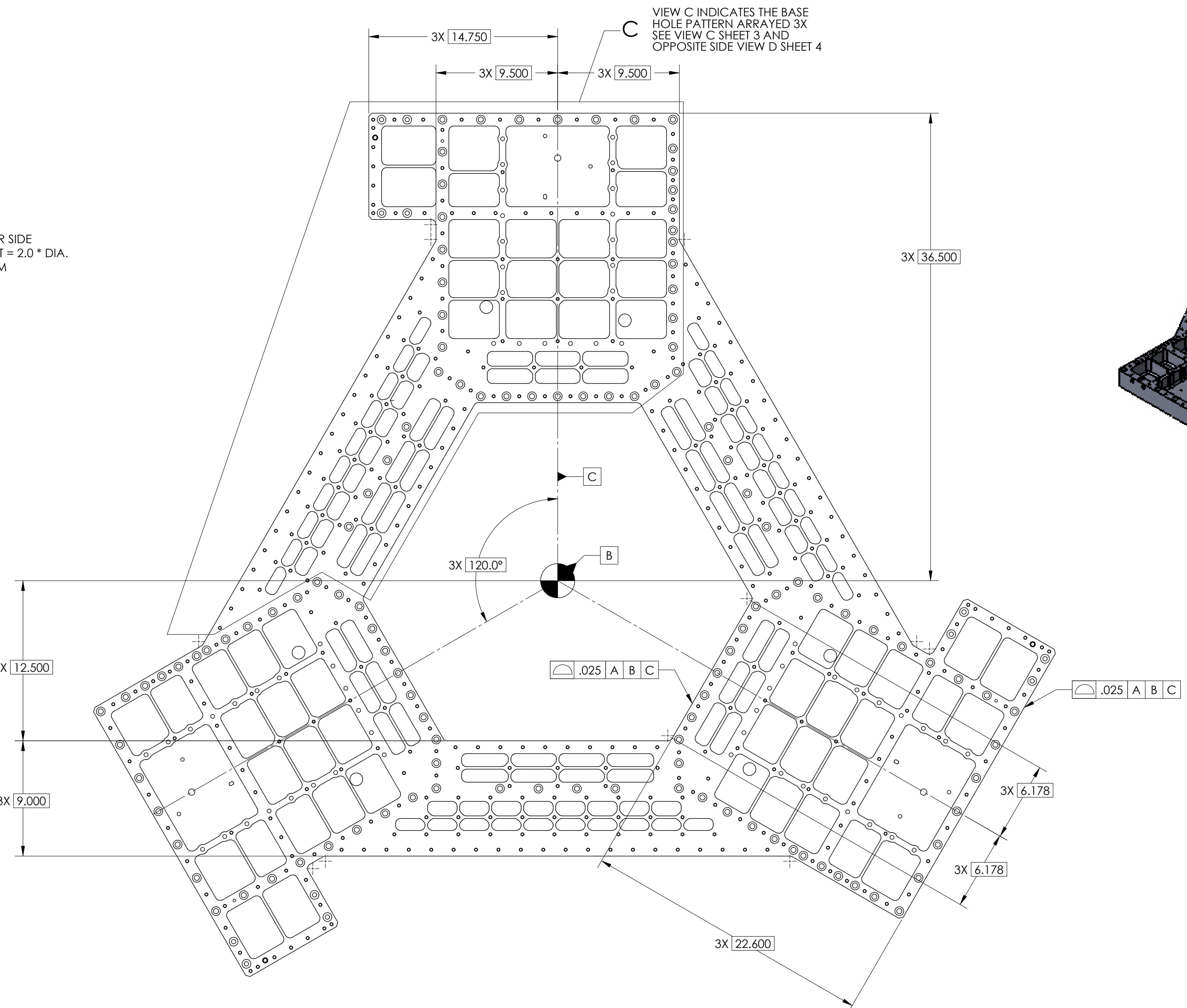
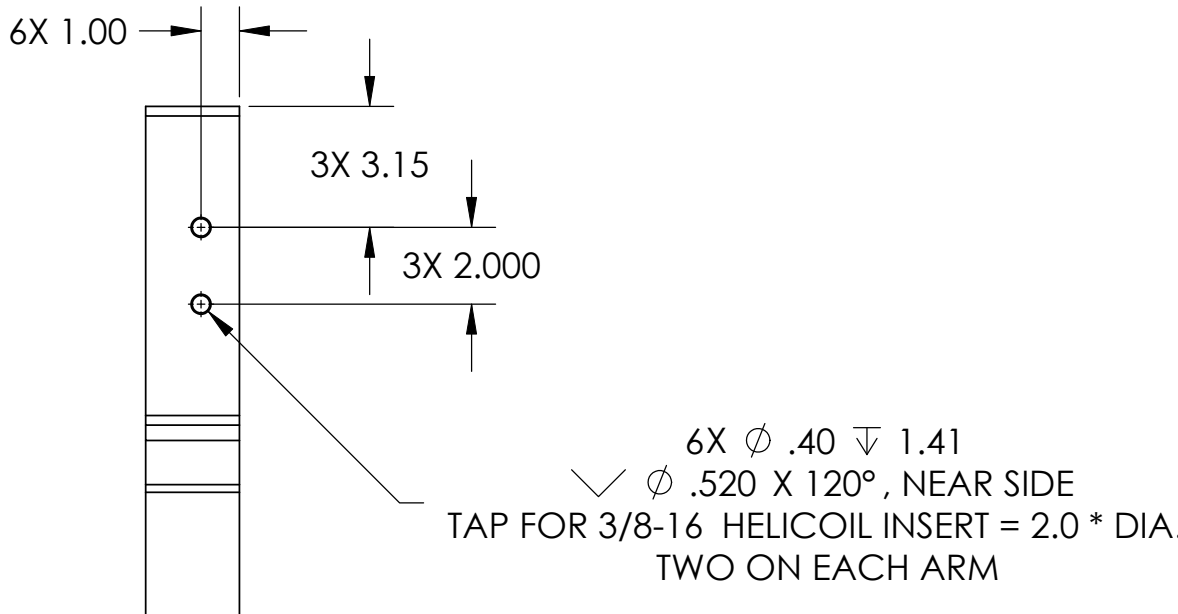
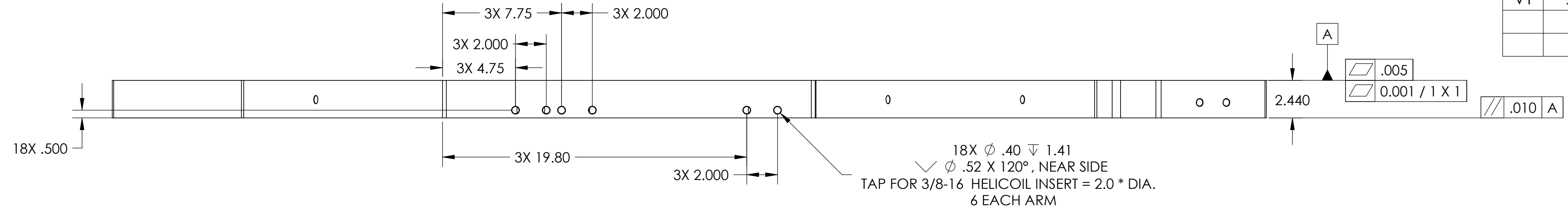


REV.	DATE	DCN #	DRAWING TREE #
v1	25 Jan 2010	E0900487	T0900600

- 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.
 - 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.
 - 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.
 - ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E048225.
 - APPROXIMATE WEIGHT = 287LB.
 - A TRUE POSITION TOLERANCE OF $\phi .010$ IS - THE SAME AS A CONVENTIONAL TOLERANCE OF $\pm .005$.
 - MULTIPLE SHEET DRAWING; SHEETS MAY HAVE DIFFERENT SCALES.
 - MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. ABRASIVE REMOVAL TECHNIQUES ARE NOT ACCEPTABLE.
 - ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONEL, AFTER DELIVERY OF FINISHED PARTS.



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

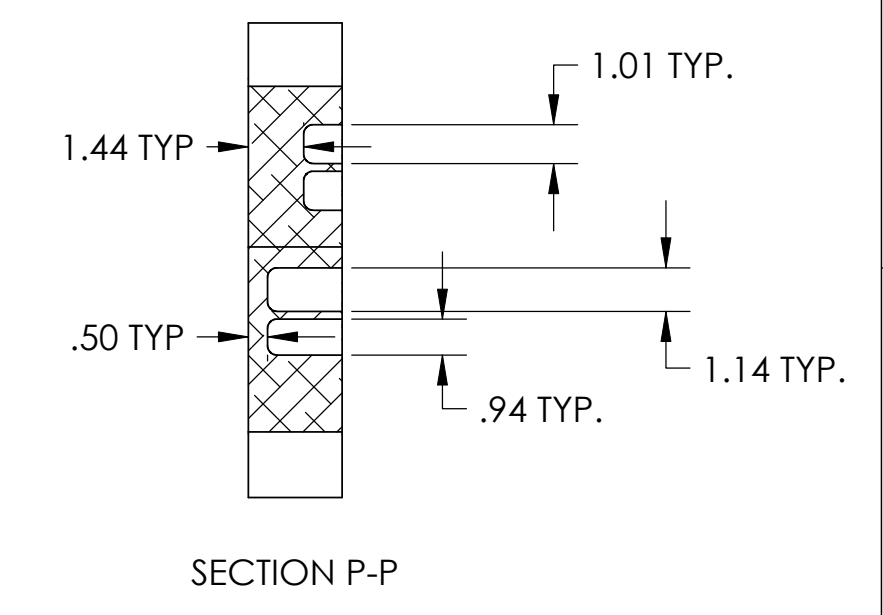
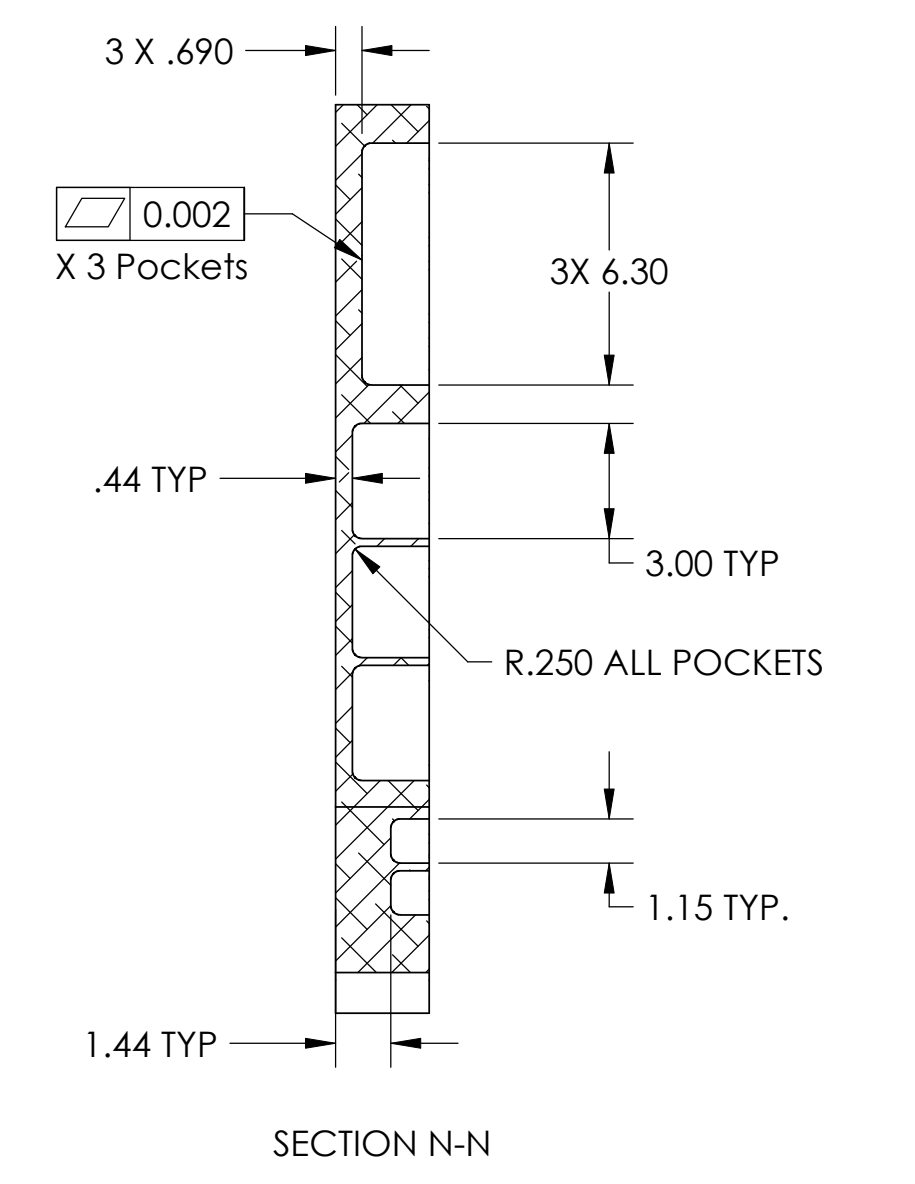
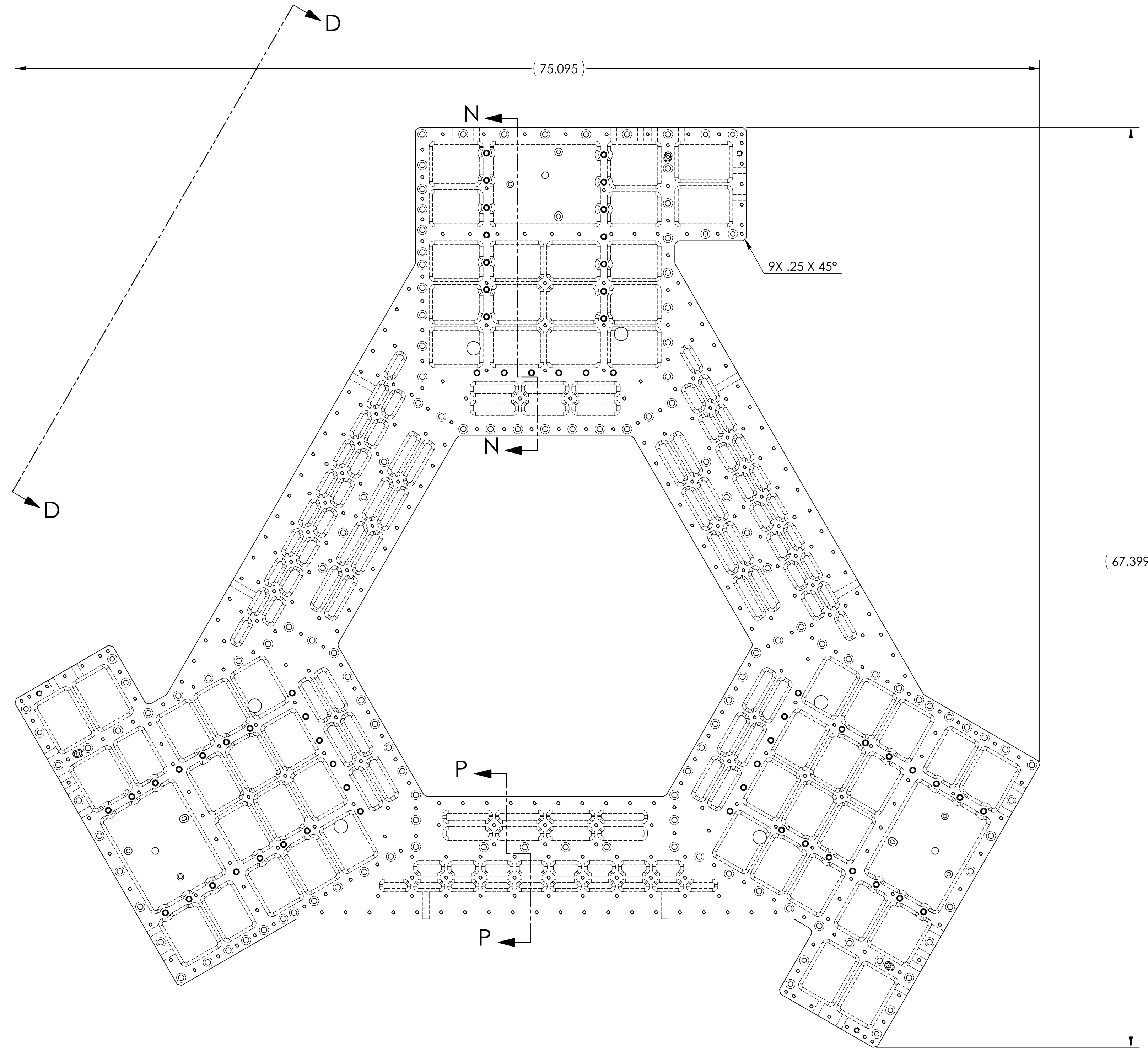
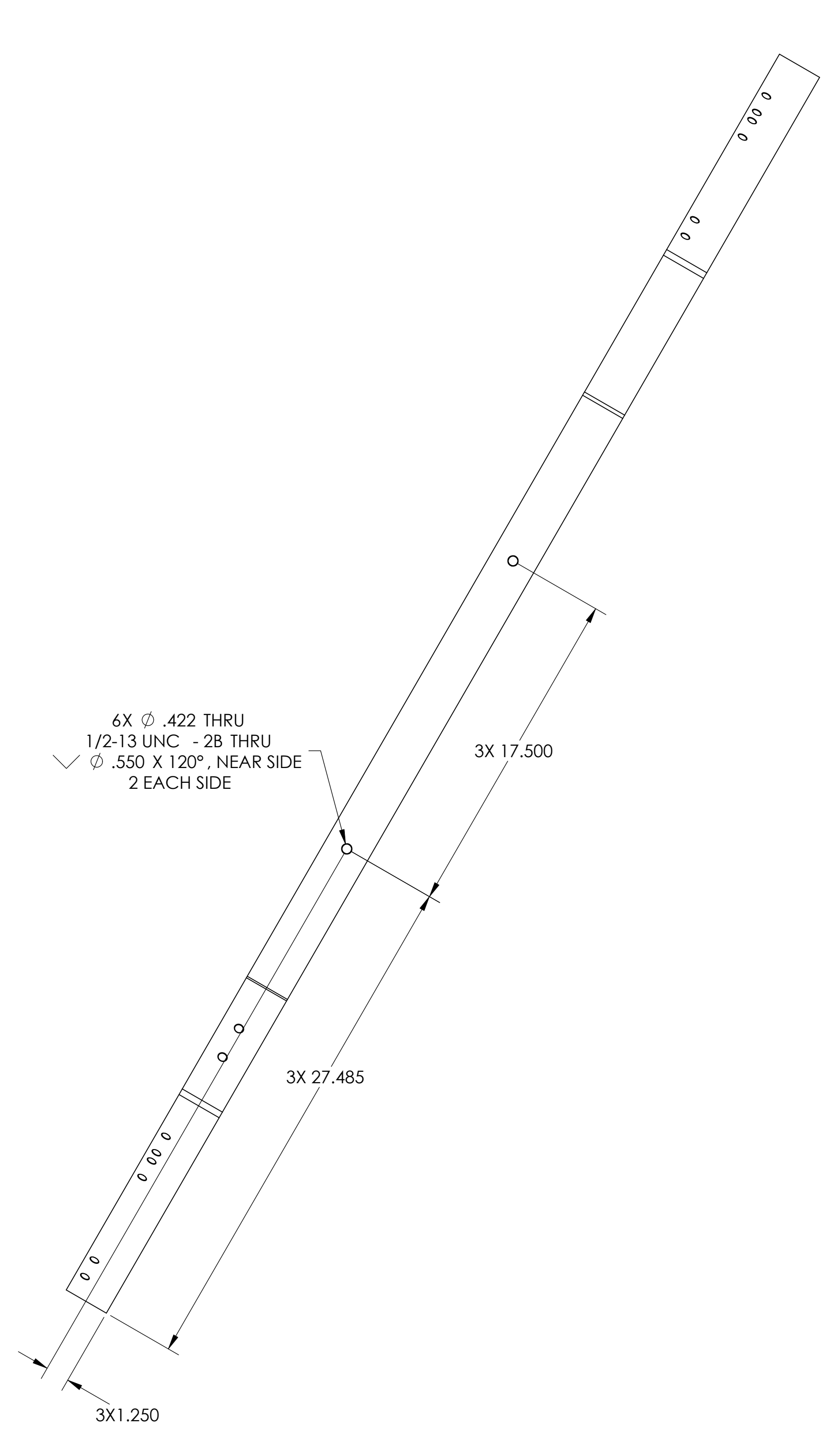
- INTERPRET DRAWING PER ASME Y14.5-1994.
- BREAK ALL EDGES AND SHARP CORNERS .03 X 45°.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

DIMENSIONS ARE IN INCHES	TOLERANCES: .XX ± .015 .XXX ± .005	ANGULAR ± .5°
MATERIAL	FINISH	NEXT ASSY
6061-T6 Al	63 μinch	D0901180

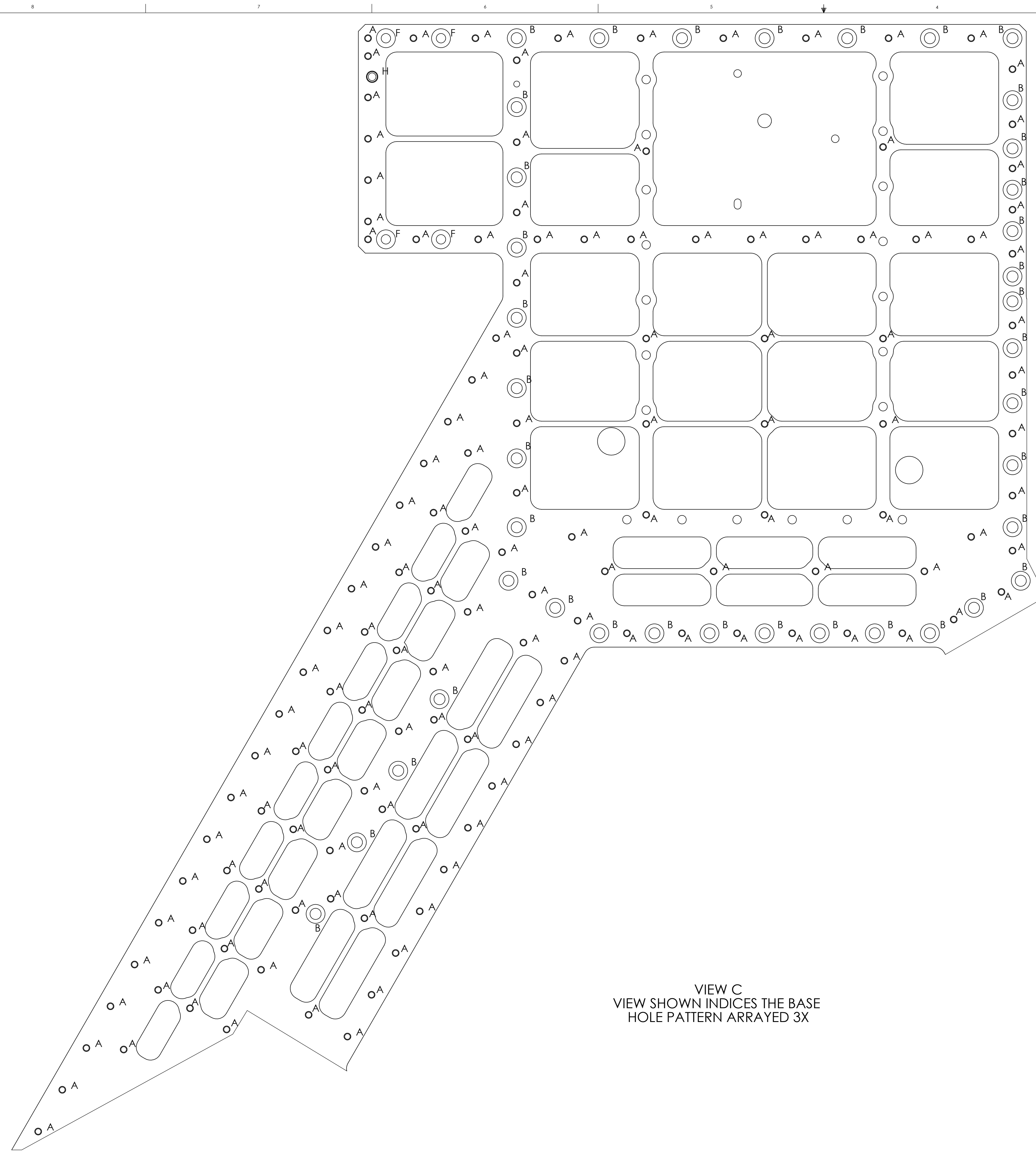
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	SEI

PART NAME		Close Out Plate, Stage 1 aLIGO BSC-ISI	
DESIGNER	F.Motichard	17 Dec. 2009	SIZE DWG. NO.
DRAFTER	M.Hillard	25 Jan 2010	D D0902273
CHECKER	A.Stein	25 Jan 2010	
APPROVAL	K.Mason	25 Jan 2010	SCALE: 1:5
PROJECTION:		SHEET 1 OF 4	

D0902273 Close Out Plate, Stage 1 BSC-ISI PART PDM REV: X.064 DRAWING PDM REV: X.004



D0902273 Close-Out Plots Stage 1 BSC:SI PART FDM REV: X-064 DRAWING FDM REV: X-004

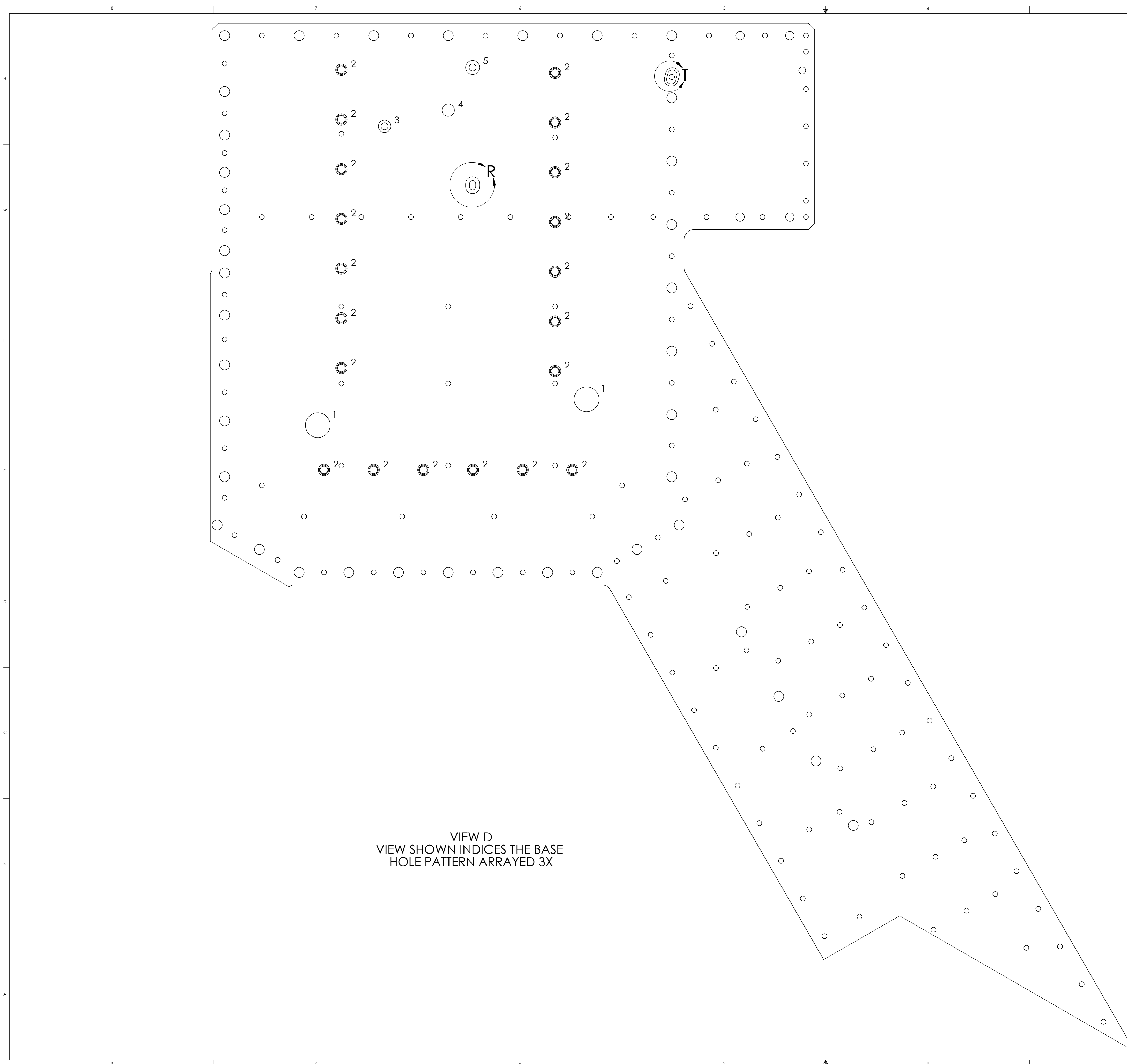


VIEW C
 VIEW SHOWN INDICES THE BASE
 HOLE PATTERN ARRAYED 3X

TAG	SIZE	QUANTITY	GD&T
A	$\phi .20$ THRU ALL $1/4-20$ UNC - 2B $\nabla .75$ $\nabla \phi .25$ X 90°, NEAR SIDE	137	$\oplus \phi .010$ A B C H11 oversize tapped hole
B	$\phi .406$ THRU ALL $\nabla \phi .688$ $\nabla 1.94$	39	$\oplus \phi .010$ (M) A B C
F	$\phi .344$ THRU ALL $\nabla \phi .688$ $\nabla 1.94$	4	$\oplus \phi .010$ (M) A B C
H	$\phi .3750$ $\nabla .60$ $.3746$ $\nabla \phi .377^{+.001}$ $\nabla .13$ $-.000$ $\nabla \phi .42$ X 90°, NEAR SIDE $\phi .22$ THRU	1	$\oplus \phi .002$ (M) A B C

HOLE PATTERN ARRAYED 3X

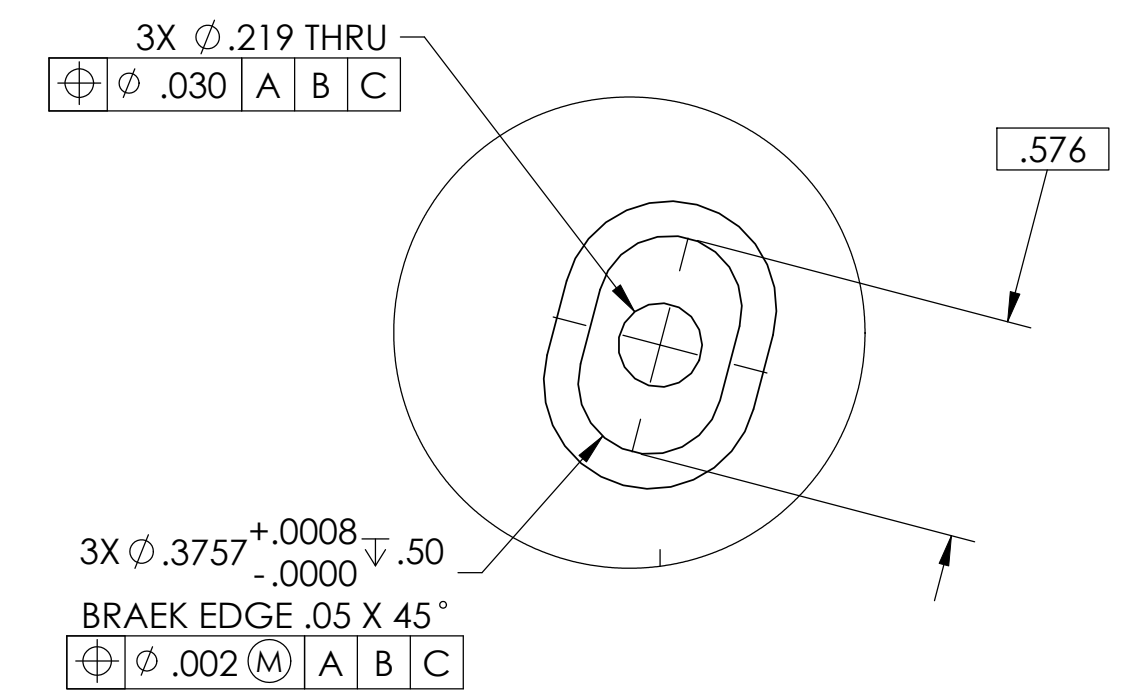
D0902273 Close-Out Plots, Stage 1, BSC:SI, PART PDM REV: X-064, DRAWING PDM REV: X-004



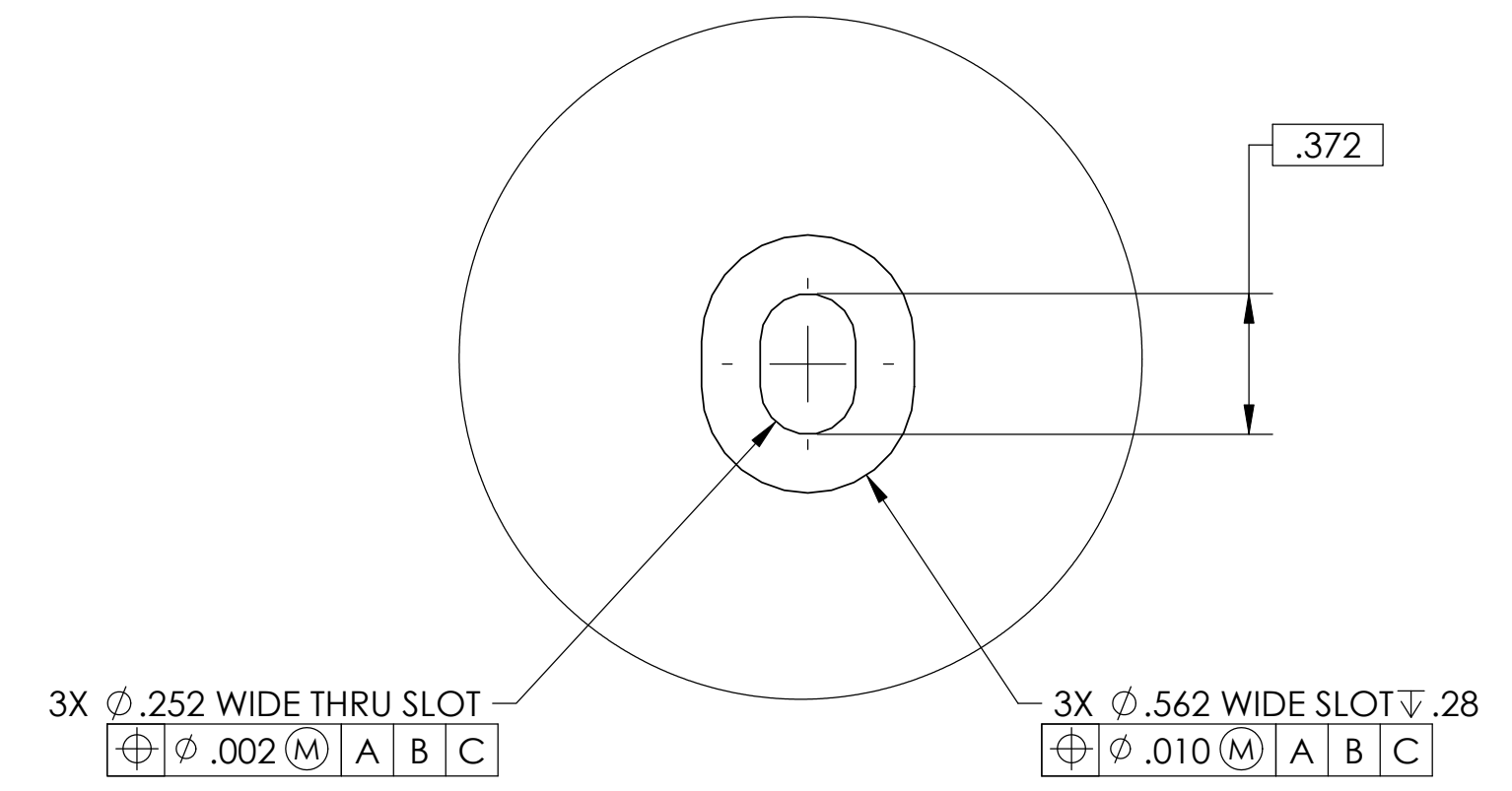
VIEW D
VIEW SHOWN INDICES THE BASE
HOLE PATTERN ARRAYED 3X

TAG	SIZE	QUANTITY	
1	ϕ 1.000 THRU ALL	2	$\oplus \phi .030 (M) A B C$
2	ϕ .313 THRU ALL 3/8-16 UNC - 2B ∇ 1.00 $\checkmark \phi$.46 X 120°, NEAR SIDE	20	$\oplus \phi .010 A B C$
3	ϕ .281 THRU ALL $\square \phi$.500 ∇ .28	1	$\oplus \phi .010 (M) A B C$
4	ϕ .422 THRU ALL 1/2-13 UNC - 1B THRU ALL	1	$\oplus \phi .010 A B C$
5	ϕ .281 THRU ALL $\square \phi$.563 ∇ .28	1	$\oplus \phi .010 (M) A B C$

HOLE PATTERN ARRAYED 3X



DETAIL T
SCALE 2 : 1



DETAIL R
SCALE 2 : 1

D0902273 Close-Out Plots Stage 1 BSC:SI PART PDM REV: X364 DRAWING PDM REV: X004