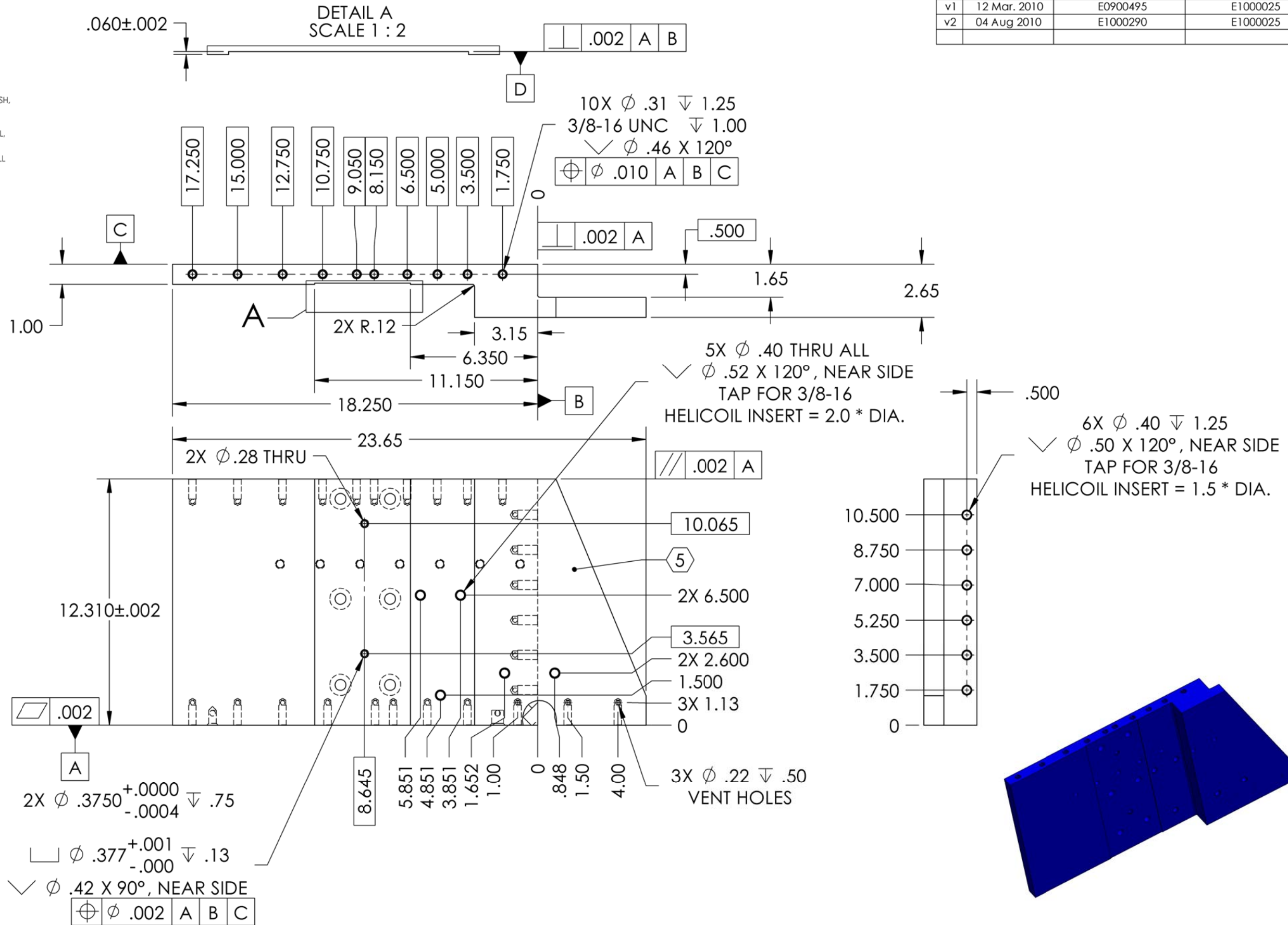


D0902274 Flexure Wall, Stage 1, BSC ISI, PART PDM REV: X-044, DRAWING PDM REV: X-018

- 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 = 14.0 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. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.
 10. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES TO ALL TAPPED HOLES EXCLUDING THREADED INSERTS.
 11. 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
v2	04 Aug 2010	E1000290	E1000025



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .015
 .XXX ± .005

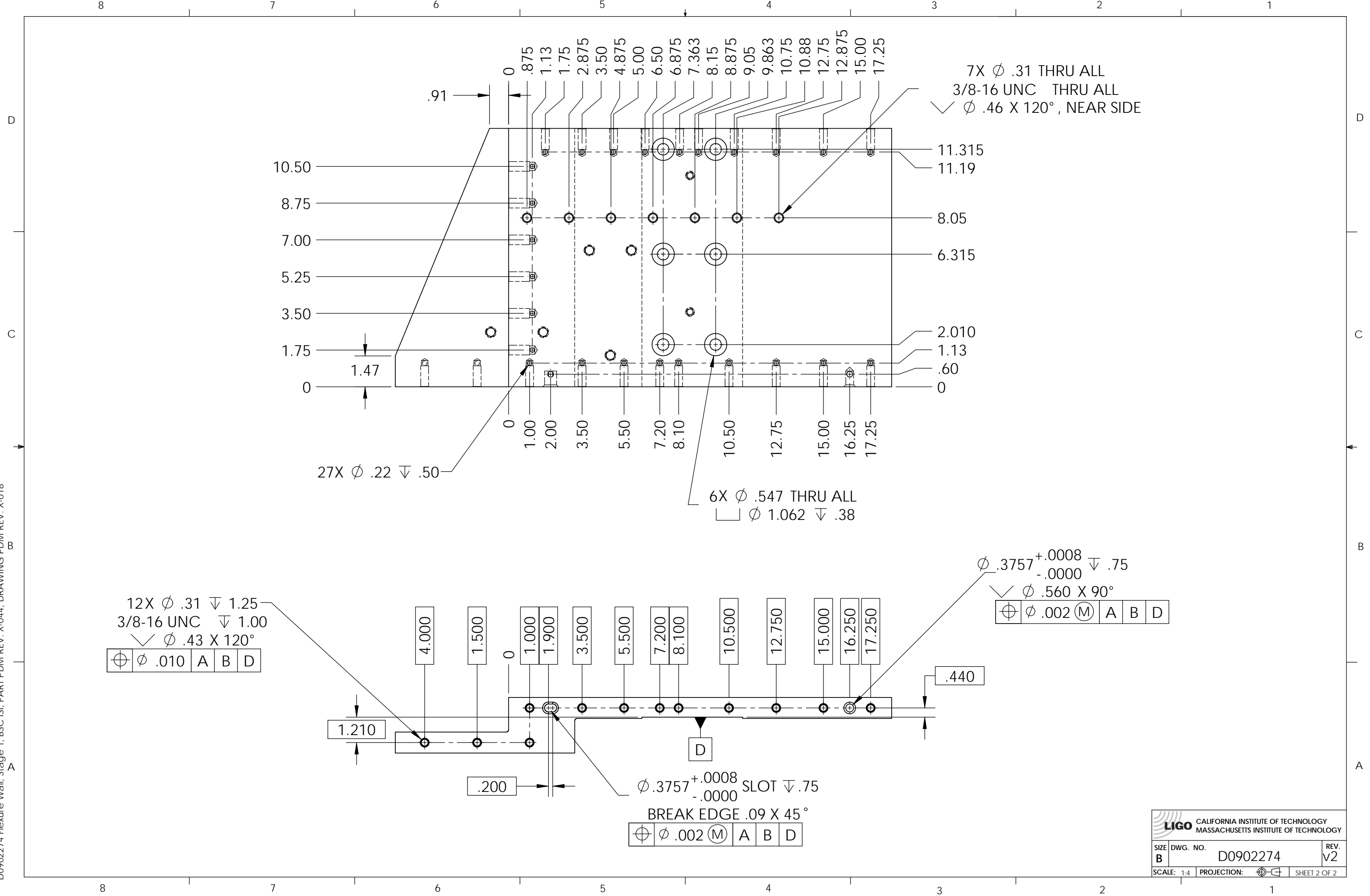
ANGULAR ± .5°

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 μinch
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME FLEXURE WALL, STAGE 1, αLIGO BSC ISI	
SYSTEM ADVANCED LIGO	SUB-SYSTEM SEI	DESIGNER F.MATICHARD 15 Jan. 2010	SIZE
DRAFTER M.HILLARD 15 Jan. 2010	CHECKER A.STEIN 15 Jan. 2010	APPROVAL K.MASON 15 Jan. 2010	DWG. NO. B D0902274
NEXT ASSY D0901180	SCALE: 1:5	PROJECTION:	REV. v2
			SHEET 1 OF 2

D0902274 Flexure Wall, Stage 1, BSC ISI, PART PDM REV: X-044, DRAWING PDM REV: X-018



7X ϕ .31 THRU ALL
3/8-16 UNC THRU ALL
 \checkmark ϕ .46 X 120°, NEAR SIDE

27X ϕ .22 ∇ .50

6X ϕ .547 THRU ALL
 \square ϕ 1.062 ∇ .38

12X ϕ .31 ∇ 1.25
3/8-16 UNC ∇ 1.00
 \checkmark ϕ .43 X 120°
 \oplus ϕ .010 A B D

ϕ .3757^{+0.0008}_{-.0000} ∇ .75
 \checkmark ϕ .560 X 90°
 \oplus ϕ .002 (M) A B D

ϕ .3757^{+0.0008}_{-.0000} SLOT ∇ .75
BREAK EDGE .09 X 45°
 \oplus ϕ .002 (M) A B D

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D0902274	V2
SCALE: 1:4	PROJECTION:	SHEET 2 OF 2