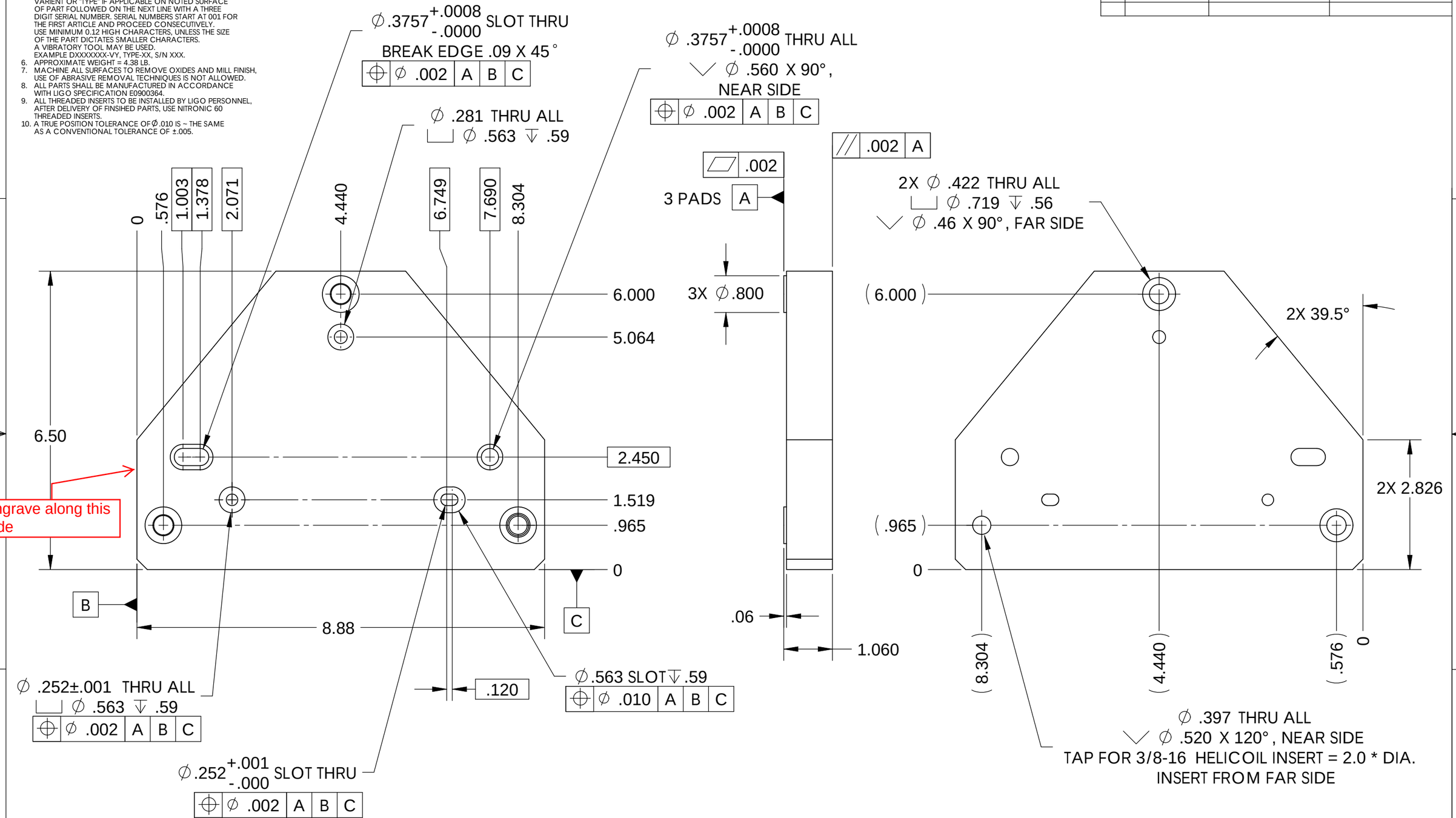
REV.	DATE	DCN #	DRAWING TREE #
v1	12 Mar. 2010	E0900495	E1000025

NOTES CONTINUED:

(5) SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIENT 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 DXXXXXXX-VY, TYPE-XX, S/N XXX.

6. APPROXIMATE WEIGHT = 4.38 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 FINSIHED PARTS, USE NITRONIC 60 THREADED INSERTS.
10. A TRUE POSITION TOLERANCE OF ∅.010 IS ~ THE SAME AS A CONVENTIONAL TOLERANCE OF ±.005.



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. REMOVE ALL SHARP EDGES, R.02 MIN.
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

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO

SUB-SYSTEM: SEI

NEXT ASSY: D1000525

PART NAME: L4C INTERPOSER, STAGE 1, aLIGO BSC ISI

DESIGNER	F.MATICHARD	12 Mar. 2010
DRAFTER	M.HILLARD	12 Mar. 2010
CHECKER	A.STEIN	12 Mar. 2010
APPROVAL	K.MASON	12 Mar. 2010

SIZE: B

DWG. NO.: D0902283

REV.: v1

SCALE: 1:2

PROJECTION:

SHEET 1 OF 1

D0902283 L4C Interposer, Stage 1, BSC-ISI, PART PDM REV: X-010, DRAWING PDM REV: X-005