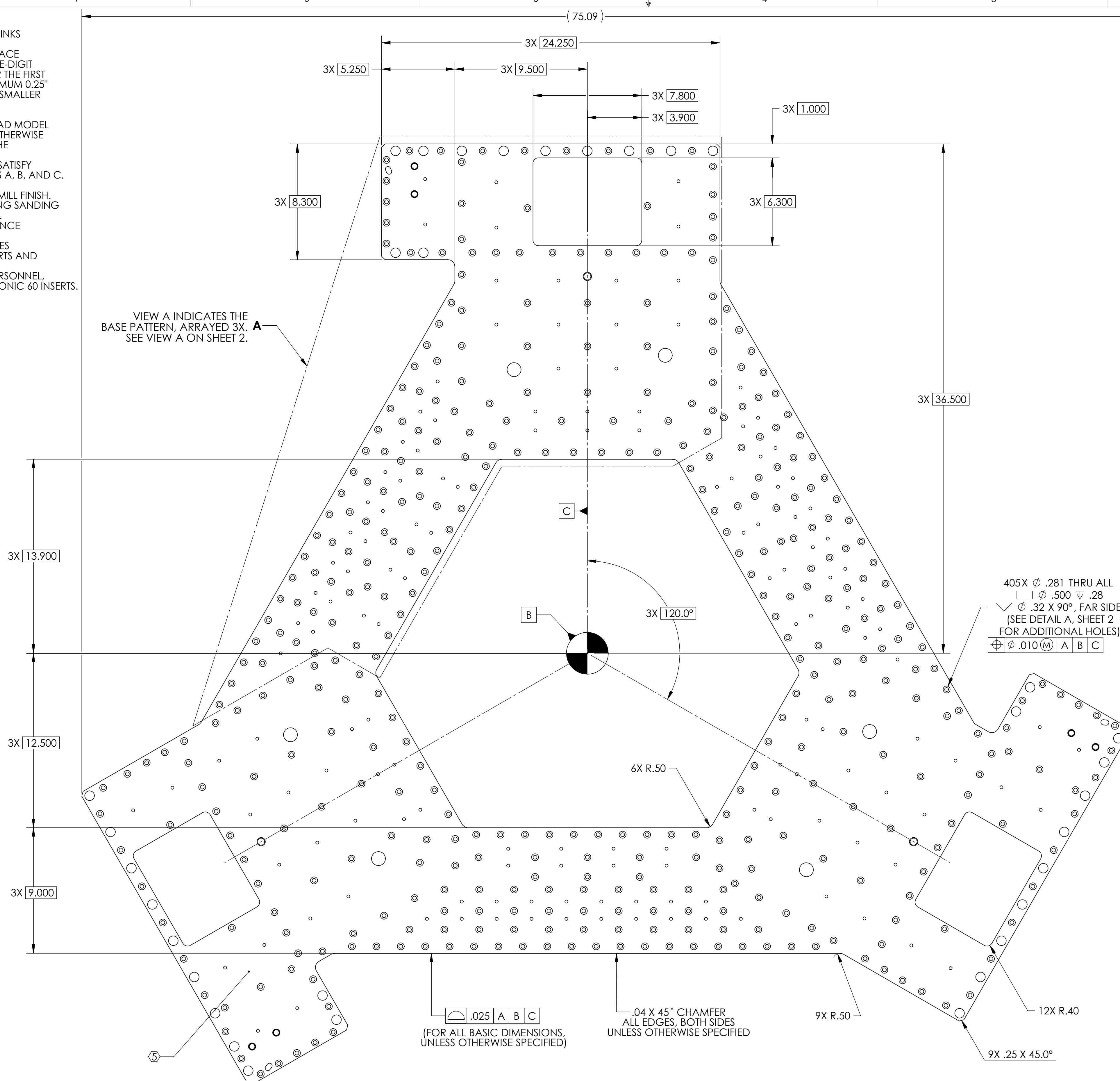


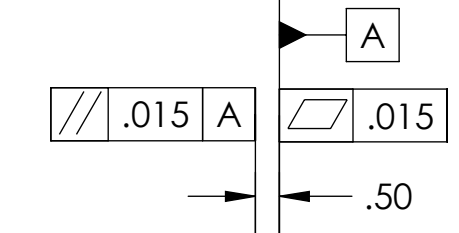
DD902503 BSC-01 Stage 1 Close out plate cover PART PDM REV. X-029 DRAWING PDM REV. X-011

- 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 0.25" HIGH CHARACTERS, UNLESS SIZE OF PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXX-VY, TYPE-XX, S/N XXX.
  6. THIS DRAWING IS MINIMALLY DIMENSIONED. USE CAD MODEL TO EVALUATE FULL DIMENSIONAL DETAIL. UNLESS OTHERWISE SPECIFIED, THE MODEL TAKES PRECEDENCE OVER THE DRAWING WHEREVER THERE ARE DISCREPANCIES.
  7. UNLESS OTHERWISE SPECIFIED, ALL SURFACES MUST SATISFY .025 PROFILE TOLERANCE WITH RESPECT TO DATUMS A, B, AND C.
  8. APPROXIMATE WEIGHT = 88 LB.
  9. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES (INCLUDING SANDING OR SCOURING FOR MATTE FINISH) IS NOT ALLOWED.
  10. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPEC. E0900364.
  11. A TAPPED HOLE PITCH DIAMETER LIMIT OF H11 APPLIES TO ALL TAPPED HOLES, EXCLUDING THREADED INSERTS AND HOLES LABELED "FOR LIFTING HARDWARE."
  12. ALL THREADED INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS. USE ONLY NITRONIC 60 INSERTS.



VIEW A INDICATES THE BASE PATTERN, ARRAYED 3X. SEE VIEW A ON SHEET 2.

REV.	DATE	DCN #	DRAWING TREE #
v1	25 JAN 2010	E0900487	E1000025
v2	05 MAY 2010	E1000151	E1000025

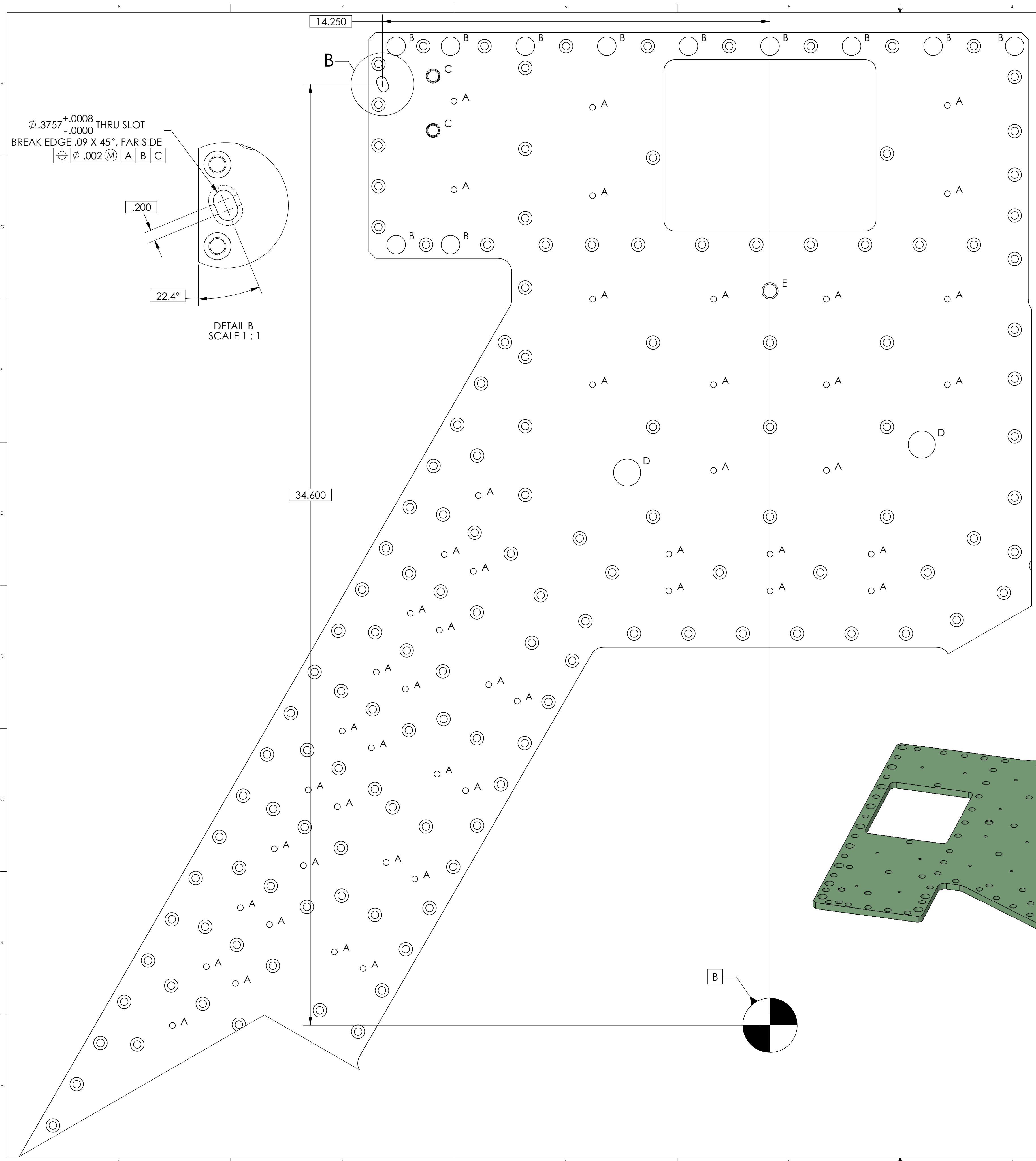


(67.40)

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .015 .XXX ± .005	
ANGULAR ± .5°	
MATERIAL	FINISH
6061-T6 Al	63 μinch

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

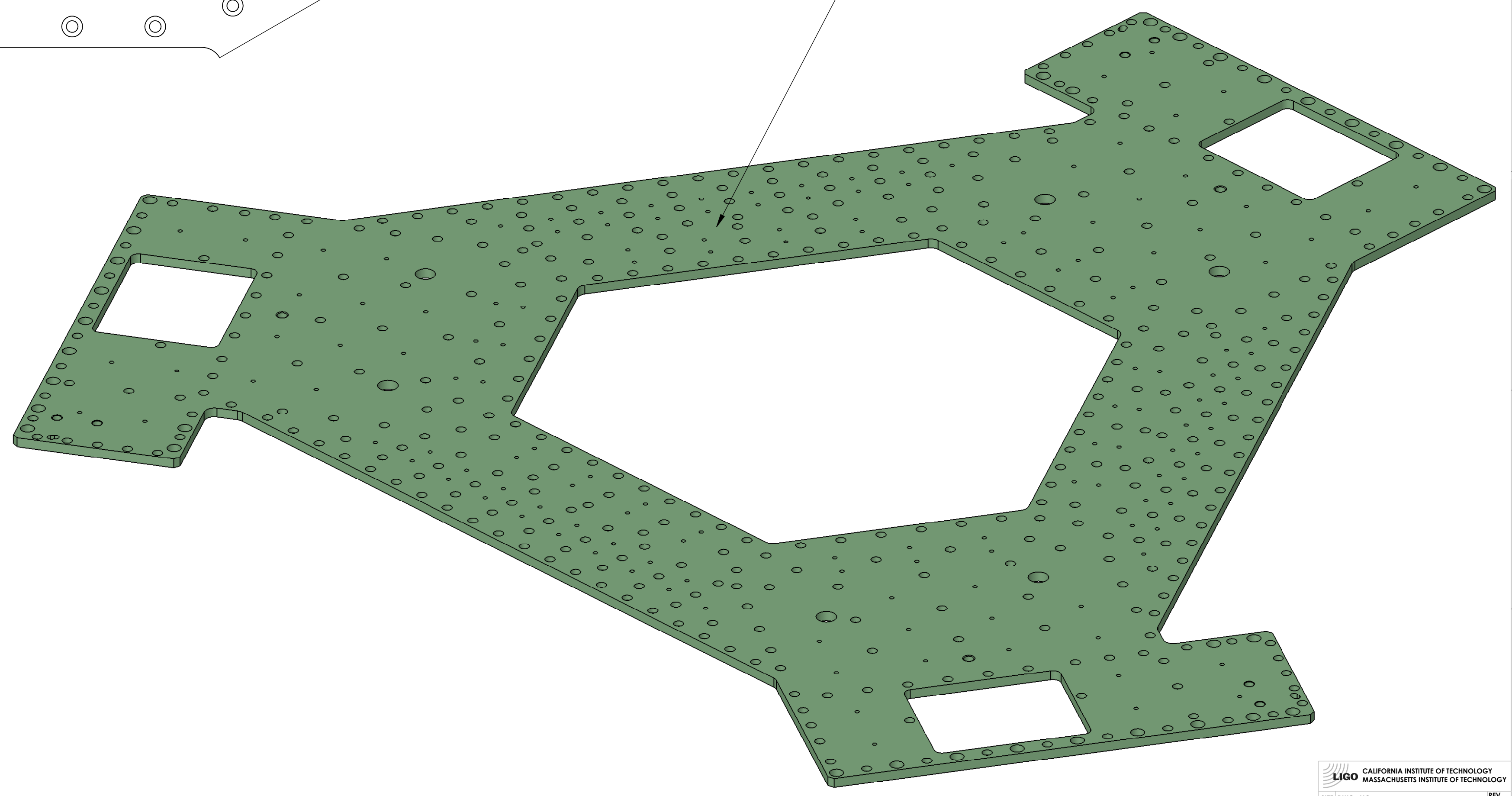
PART NAME			
BSC-ISI, Stage 1, Close Out Plate Cover			
DESIGNER	F.MATCHARD	17 DEC 2009	SIZE DWG. NO.
DRAFTER	M.HILLARD	17 DEC 2009	D D0902503
CHECKER	A.STEIN	17 DEC 2009	REV. v2
APPROVAL	K.MASON	17 DEC 2009	SCALE: 1:4
PROJECTION:		SHEET 1 OF 2	



TAG	SIZE	QUANTITY	TOLERANCE
A	$\phi .22$ THRU ALL	48	$\phi .030$ (M) A B C VENT HOLE
B	$\phi .688$ THRU ALL $\phi .75$ X 90°, FAR SIDE	11	$\phi .030$ (M) A B C
C	$\phi .397$ THRU ALL $\phi .52$ X 120°, NEAR SIDE TAP FOR 3/8-16 HELICOIL INSERT = 1.0 * DIA.	2	$\phi .010$ A B C
D	$\phi 1.00$ THRU ALL	2	$\phi .030$ (M) A B C
E	$\phi .422$ THRU ALL 1/2-13 UNC - 2B THRU ALL $\phi .60$ X 120°, NEAR SIDE $\phi .60$ X 120°, FAR SIDE	1	$\phi .030$ A B C FOR LIFTING HARDWARE

HOLE PATTERN ARRAYED 3X

FOR SHIPPING:  
PLACE INTO CRATE WITH THIS SIDE FACING UP.



D0902503.BSC-BI\_Stage 1\_Close out plate cover\_ PART PDM REV.X-029\_DRAWING PDM REV.X-011