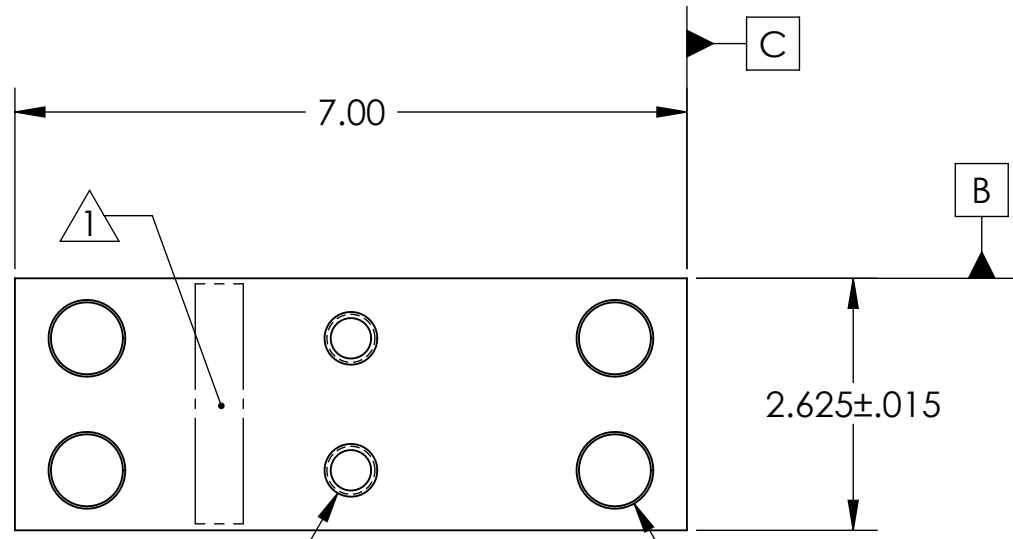
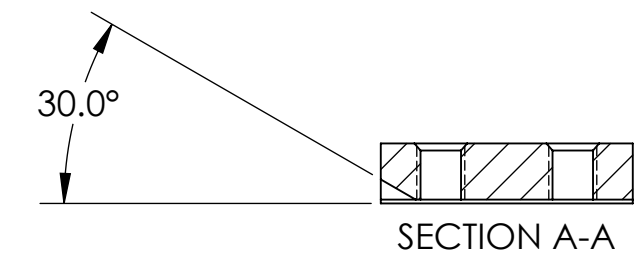
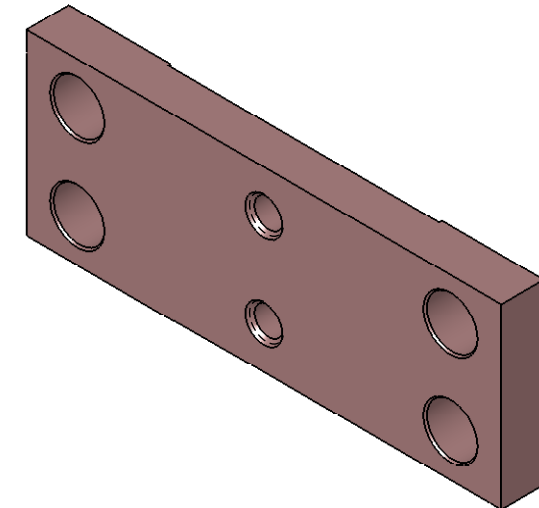
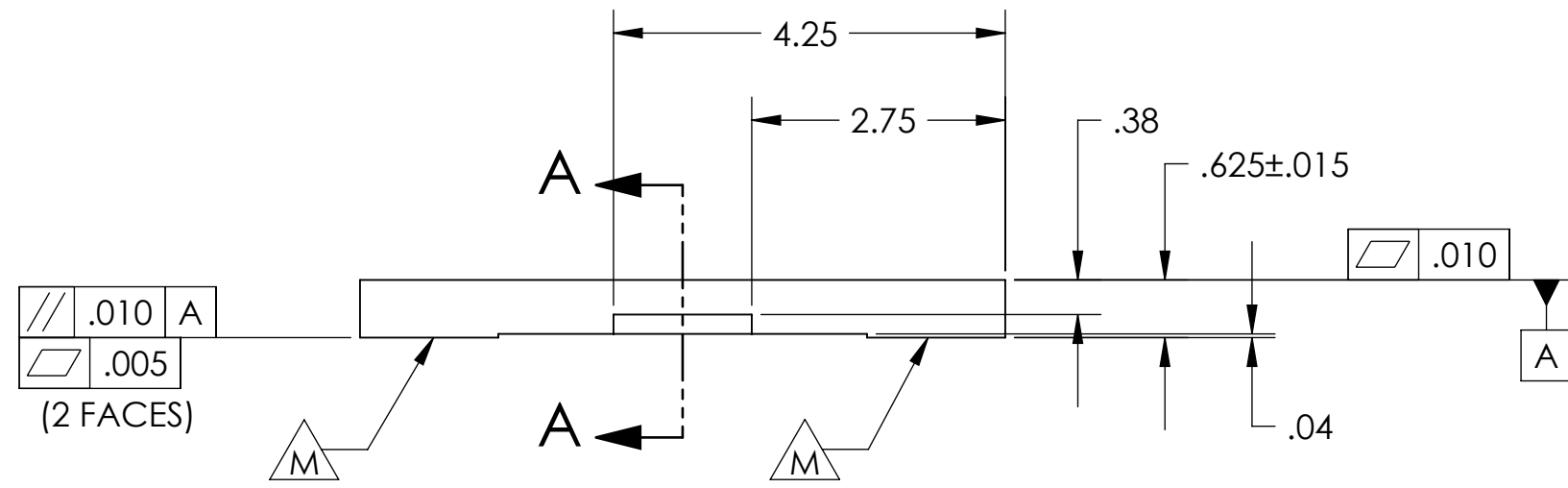


REV	DATE	APPROVAL	DESCRIPTION
00	08/27/2008	A. STEIN	PRE-RELEASE, FOR RFQ.
01	09/05/2008	A. STEIN	PROTOTYPE RELEASE. SPECIFIED LOCATION FOR P/N ENGRAVING.
02	09/24/2008	A. STEIN	ADDED GROOVE FOR EXTRA CLEARANCE IN HEPI ASSEMBLY.
A	10/17/2008	DCN # E080509-00	RELEASE FOR PRODUCTION. SPECIFIED MAT'L AS 1018 CRS. CHANGED SIZE OF P/N ENGRAVING.



2X ϕ .422 THRU
 1/2-13 UNC THRU
 \sphericalangle ϕ .55 X 82°, NEAR SIDE
 \oplus ϕ .010 A B C

4X ϕ .750 THRU
 \sphericalangle ϕ .80 X 82°, BOTH SIDES
 \oplus ϕ .010 (M) A B C



- NOTES:
- WHERE INDICATED, MECHANICALLY SCRIBE, STAMP, OR ENGRAVE THE FOLLOWING INFORMATION AS SHOWN BELOW: PART NUMBER-REVISION, FOLLOWED ON THE NEXT LINE WITH A UNIQUE 3-DIGIT SERIAL NUMBER STARTING AT 001 FOR THE FIRST PART AND INCREMENTING THEREAFTER. USE 0.24" TALL CHARACTERS UNLESS PART SIZE DICTATES SMALLER. LETTERING MUST BE VISIBLE AFTER PAINTING, IF APPLICABLE.
 D080493-A
 S/N - ###
 - PLUG ALL SCREW HOLES, BOTH TAPPED AND THRU.
 - PAINT ALL SURFACES, EXCEPT WHERE INDICATED BY $\triangle M$. USE MEDIUM BLUE SHERWIN WILLIAMS (POLANE (R) T-PLUS POLYURETHANE ENAMEL). PRIME WITH SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER P60G2.
 - APPLY "OXISOLV RUST INHIBITOR" TO ALL UNPAINTED SURFACES, PER MFG INSTRUCTIONS. REMOVE PLUGS FROM ALL HOLES.

NOTES: (UNLESS OTHERWISE SPECIFIED)

1. DO NOT SCALE FROM DRAWING.		DIMENSIONS ARE IN INCHES	
2. REMOVE ALL SHARP EDGES. LEAVE .005 X 45° MIN CHAMFER, OR .005 MIN RADIUS.		TOLERANCES:	SURFACE ROUGHNESS:
3. ALL MACHINING FLUIDS MUST BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE. E.G., MILACRON CIMTECH 410.		.XX ± 0.015	63
4. CLEAN THOROUGHLY TO REMOVE ALL OIL, DIRT, AND CHIPS.		.XXX ± 0.005	
THIS PRINT & THE EMBEDDED CAD MODEL ARE THE DOCUMENTATION OF RECORD. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS IN THE MODEL ARE BASIC, WITH TOLERANCES GIVEN BY:		ANGULAR ± 0.5°	

MATERIAL		1018 CRS	
FINISH		SEE NOTES	
DRAWN	A. STEIN	DATE	08/27/2008
CHECKED	-	-	-
APPROVED	-	-	-

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP	
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	SEI
NEXT ASSY	D080496
PART NAME	HAM HEPI CAGING REAR PLATE
SIZE	DWG. NO. D080493
REV	A
SCALE:	1:2
PROJECTION:	
SHEET 1 OF 1	

\oplus ϕ .015 A B C