



Ø 46 THRO' 2 POSITIONS EQ SP ON 270 PCD
(2 X 180°)

1 HOLE DRILL 15 DP FOR 8-32 UNC X 1.5 D 1g
HELICOILS ON 137 PCD, AND C.BORE
Ø 12 X 5.5 DP HELICOILS NOT TO BE FITTED

⊕ Ø 0.2

Ø 131.5 THRO'
ON 200 PCD

Ø 12 X 5 DP 3 PLACES
(3 X 90°) ON 124 PCD
⊕ Ø 0.2

DETAIL A
SCALE 1:1
4 PLACES EQ SP (4 X 90°)
⊕ Ø 0.2

PART NO. (SEE NOTE 4)
TO BE ETCHED OR STAMPED
IN APPROX POSITION SHOWN.

DRILL 8 HOLES Ø 6.6 THRO' AND C.BORE Ø 10 X 5 DP
ON 310 PCD
⊕ Ø 0.2

NOTES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY GLASGOW UNIVERSITY TECH RES GROUP RUTHERFORD APPLETON LABORATORIES	
1. REMOVE ALL SHARP EDGES. R 0.2 MIN.	2. DO NOT SCALE FROM DRAWING.	DIMENSIONS ARE IN mm (INCHES) TOLERANCES:	
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE. SUCH AS CINCINNATI MILACRON'S CMTTECH 410 (STAINLESS STEEL)	4. SCRIBE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART AND A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE 07" HIGH CHARACTERS. EXAMPLE: D060344-001. A VIBRATORY TOOL MAY BE USED.	MATERIAL: ST STEEL 303/304/316	FINISH: CLEAN, GREASE FREE Ra: 1.6
		NAME: J. O'BELL	DATE: 05/JAN/06
		CHECKED: TW	28/SEP/06
		APPROVED: TW	28/SEP/06
		SYSTEM: ADVANCED LIGO	
		SUB-SYSTEM: SUS	
		NEXT ASSY: PENRE ETM QUAD N4TYPE	
		PART NAME: BACK PLATE	
		DRG. NO.: D060344	BY: D
		SCALE: 1:1 PROJECTION: 4	