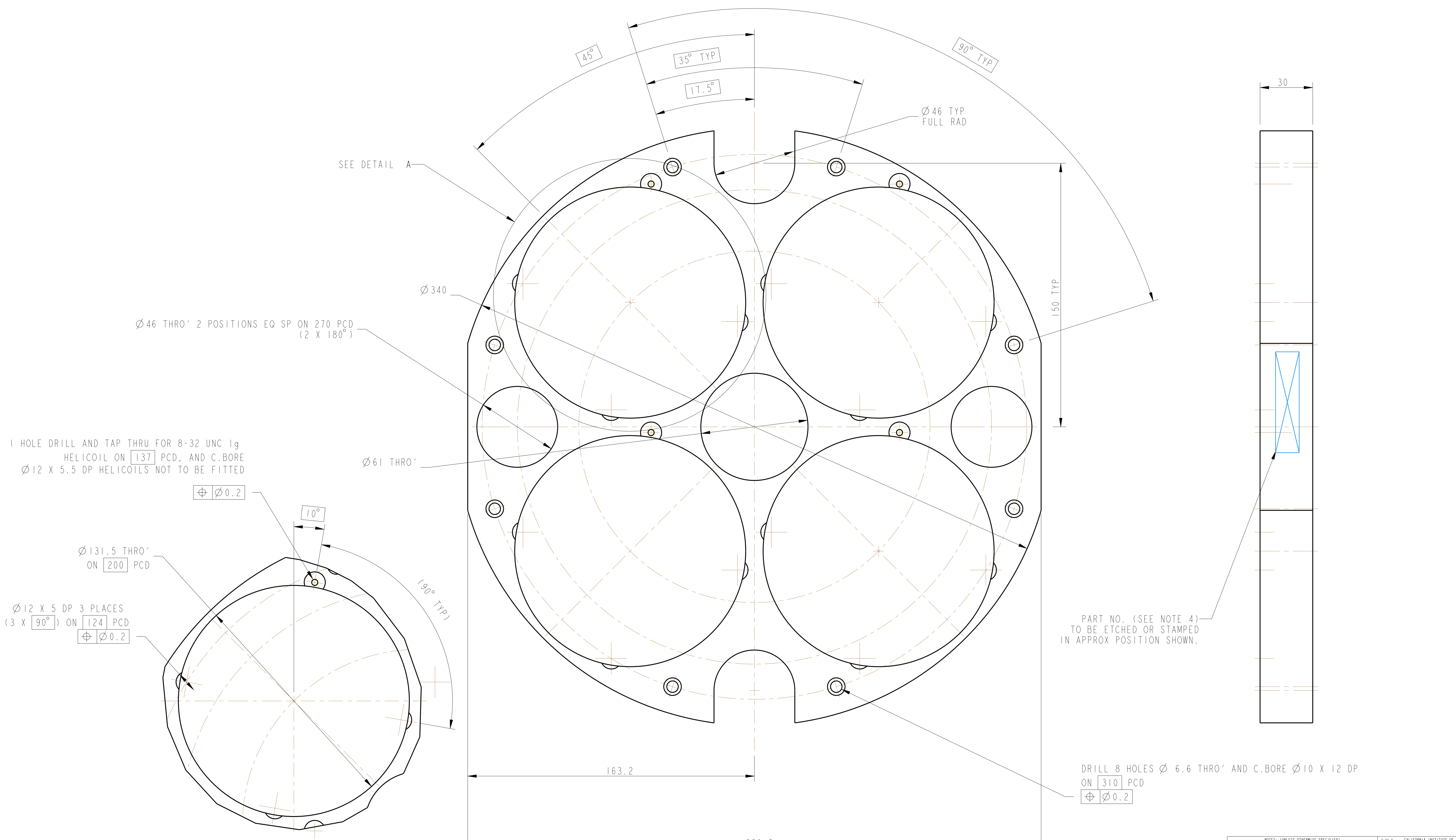


REV.	DATE	DCN #	DRAWING TREE #
A	15/OCT/06	E060240	
B	20/DEC/07	E060240-B	
G	21/JULY/08	E080370	



1 HOLE DRILL AND TAP THRU FOR 8-32 UNC 1g
HELICOIL ON 137 PCD, AND C.BORE
Ø12 X 5.5 DP HELICOILS NOT TO BE FITTED

Ø46 THRO' 2 POSITIONS EQ SP ON 270 PCD
(2 X 180°)

Ø131.5 THRO'
ON 200 PCD

Ø12 X 5 DP 3 PLACES
(3 X 90°) ON 124 PCD

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

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

DRILL 8 HOLES Ø 6.6 THRO' AND C.BORE Ø10 X 12 DP
ON 310 PCD

NOTES: (UNLESS OTHERWISE SPECIFIED)

- REMOVE ALL SHARP EDGES. R.02 MIN.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).
- 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.

DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X XX ± 0.2
ANGULAR ±0.25 °

MATERIAL: ST STEEL 304/316
FINISH: CLEAN, GREASE FREE
Ra = 1.6
√µm (µin)

NAME	DATE	SIZE
DRAWN	J O'BELL	05/JAN/06
CHECKED	MB	15/MAR/10
APPROVED	JOD	15/MAR/10

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
GLASGOW UNIVERSITY TECH RES GROUP
RUTHERFORD APPLETON LABORATORIES

SYSTEM: aLIGO
SUB-SYSTEM: SUS
NEXT ASSY: PENRE ETM QUAD
PART NAME: BACK PLATE

DRG. NO.: D060344
SCALE: 1:1 PROJECTION: 4th ANGLE SHEET 1 OF 1