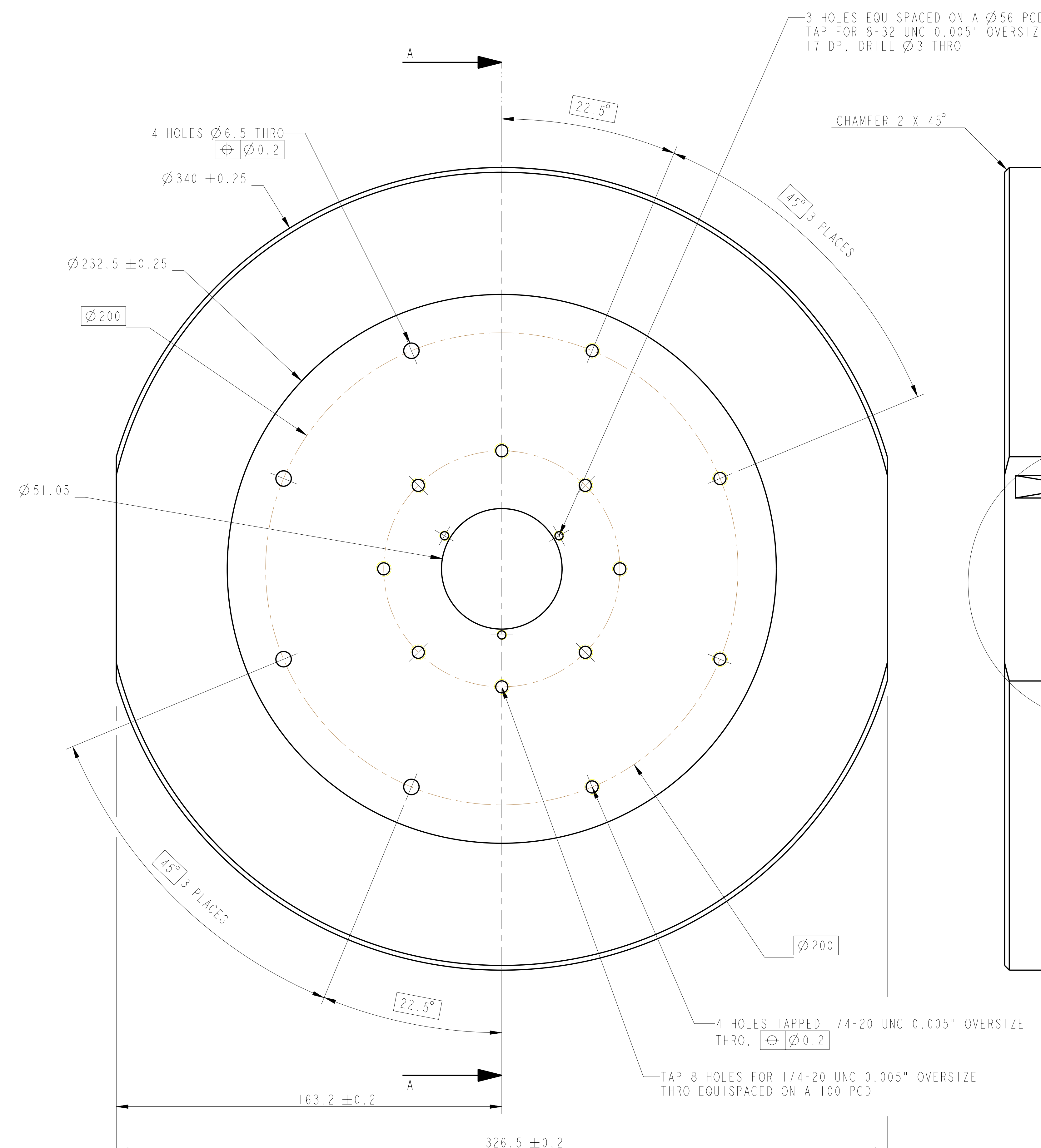
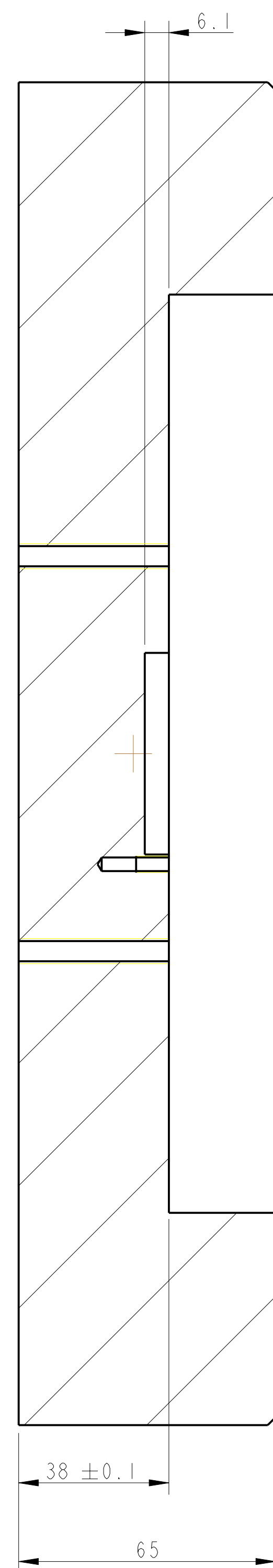


REV.	DATE	DCN #	DRAWING TREE #
A	15/OCT/06	E060240	
B	20/DEC/07	E060240-B	
F	21/JULY/08	E080370	

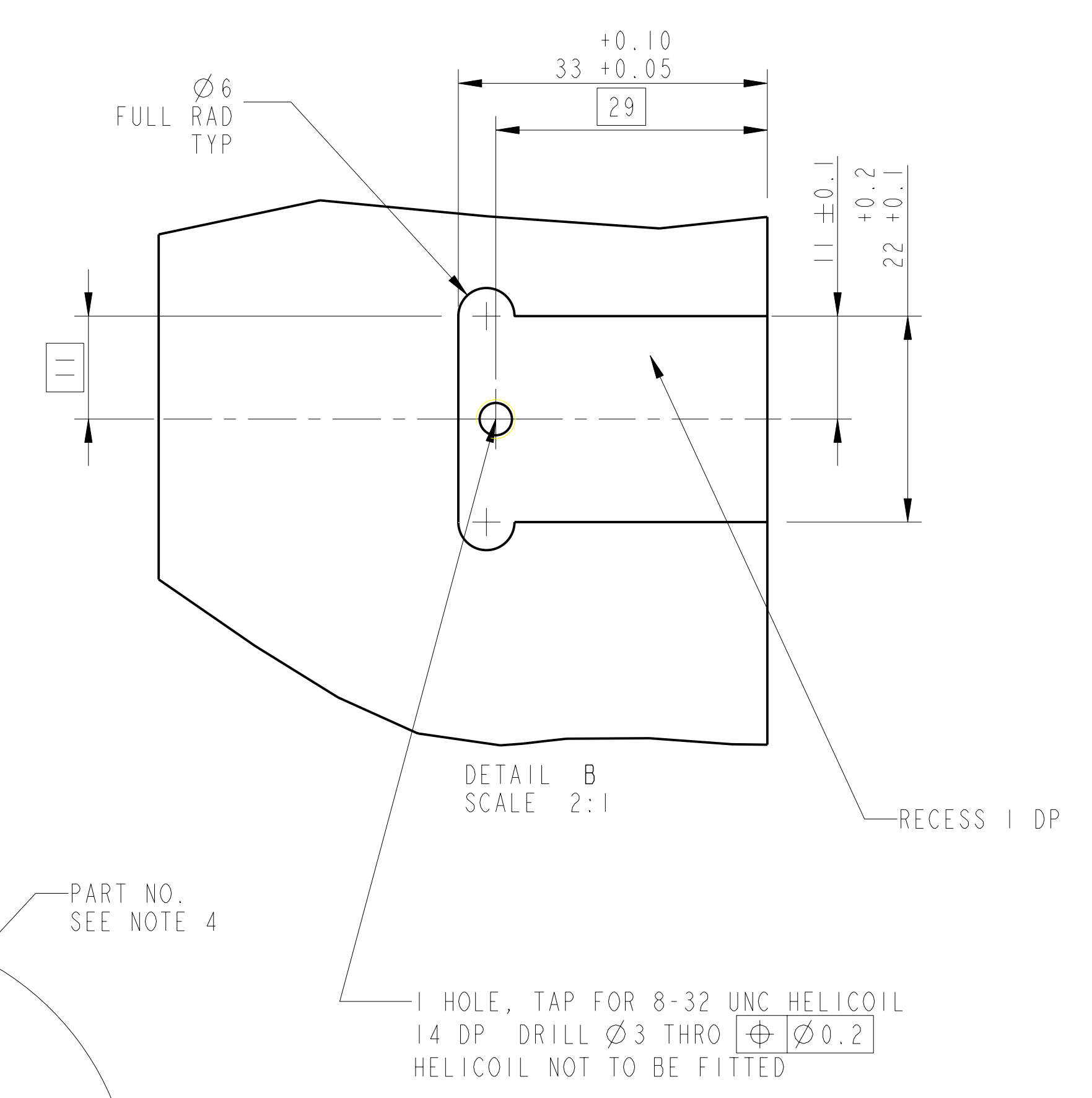


3 HOLES EQUISPACED ON A $\varnothing 56$ PCD
TAP FOR 8-32 UNC 0.005" OVERSIZE
17 DP, DRILL $\varnothing 3$ THRO

CHAMFER 2 X 45°

4 HOLES TAPPED 1/4-20 UNC 0.005" OVERSIZE
THRO, $\varnothing 0.2$

TAP 8 HOLES FOR 1/4-20 UNC 0.005" OVERSIZE
THRO EQUISPACED ON A 100 PCD



PART NO.
SEE NOTE 4

SEE DETAIL B

DETAIL B
SCALE 2:1

RECESS 1 DP

SECTION A-A

NOTES: (UNLESS OTHERWISE SPECIFIED)

- REMOVE ALL SHARP EDGES. R 0.2 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: 000100-001 - A VIBRATOR TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X XX ± 0.2MM (1)
ANGULAR ± 0.25°

MATERIAL: AL ALLOY 5052

FINISH: CLEAN AND DECREASED \sqrt{Ra} (1.6)

DRAWN	WILMOT	29/SEP/06
CHECKED	MB	15/MAR/10
APPROVED	JOD	15/MAR/10

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
GLASGOW UNIVERSITY GEC ROU GROUP
RUTHERFORD APPLETON LABORATORIES

SYSTEM: aLIGO
SUB-SYSTEM: SUS
NEXT ASSY: ASSEMBLY MASSES QUAD
PART NAME: HALF MASS
(DUMMY HALF REACTION MASS)
DRG. NO.: D060357
SCALE: 1:1 PROJECTION: 1ST
SHEET 1 OF 1