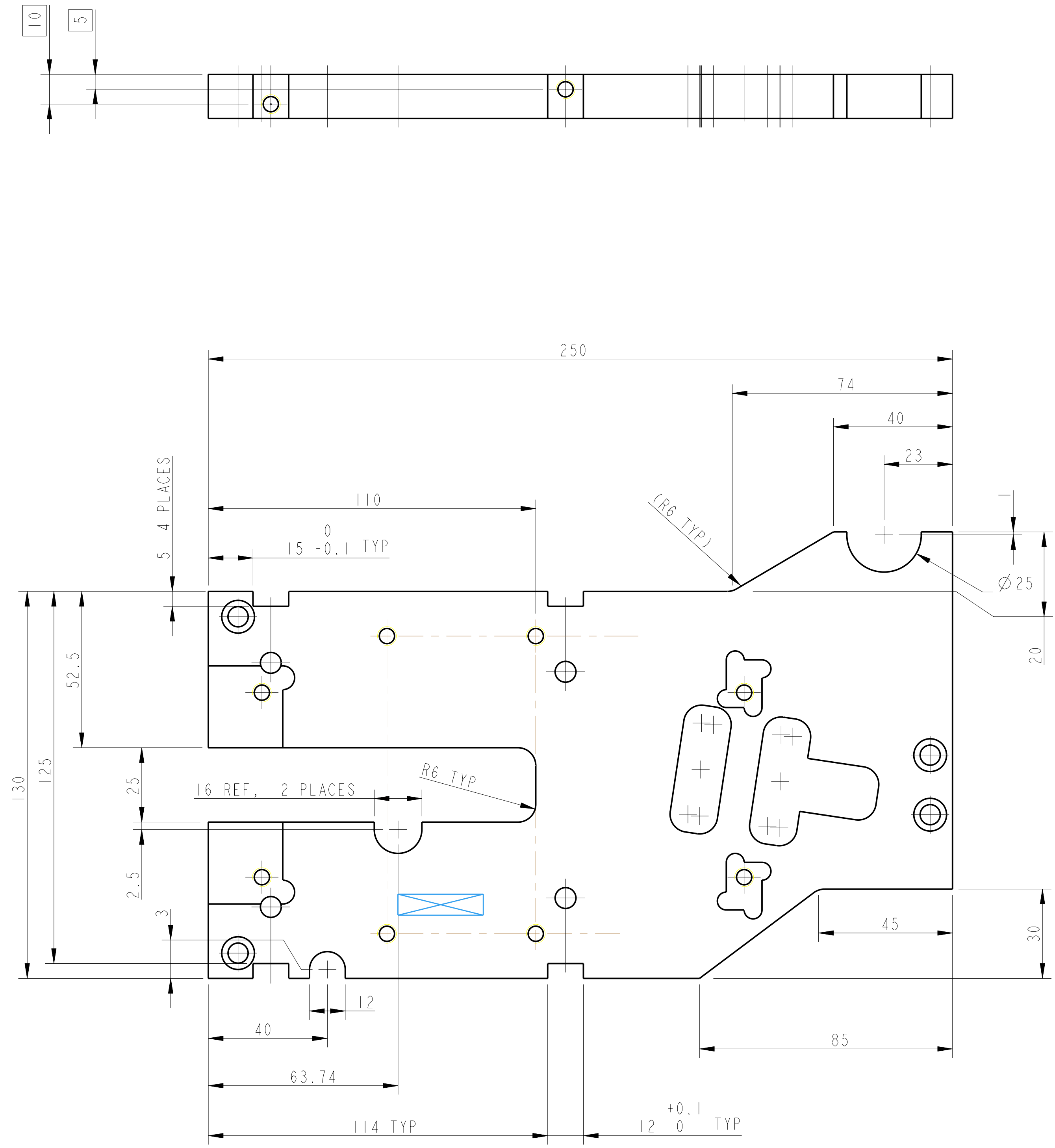
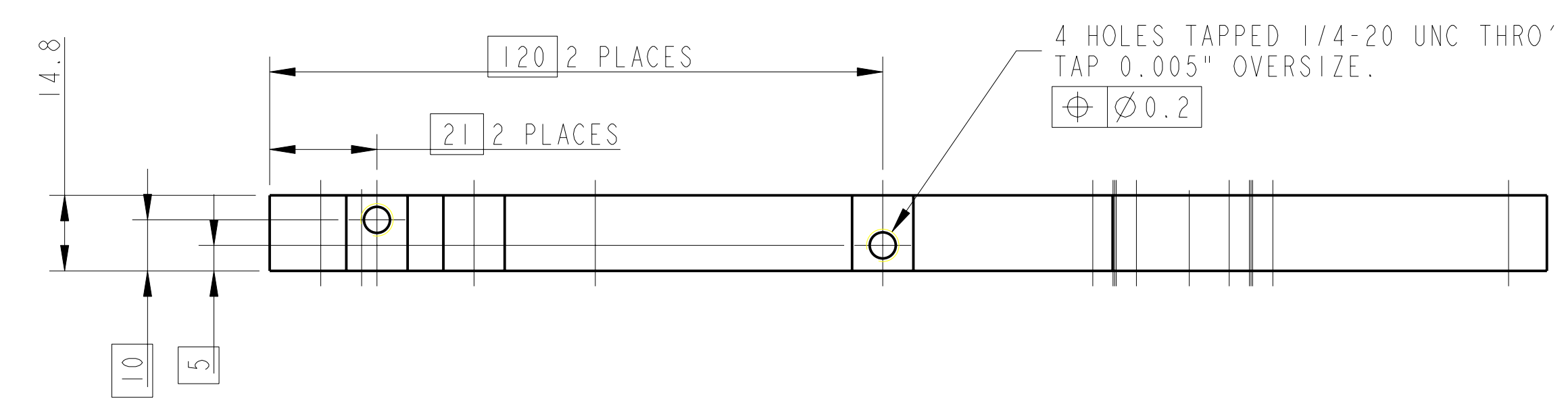
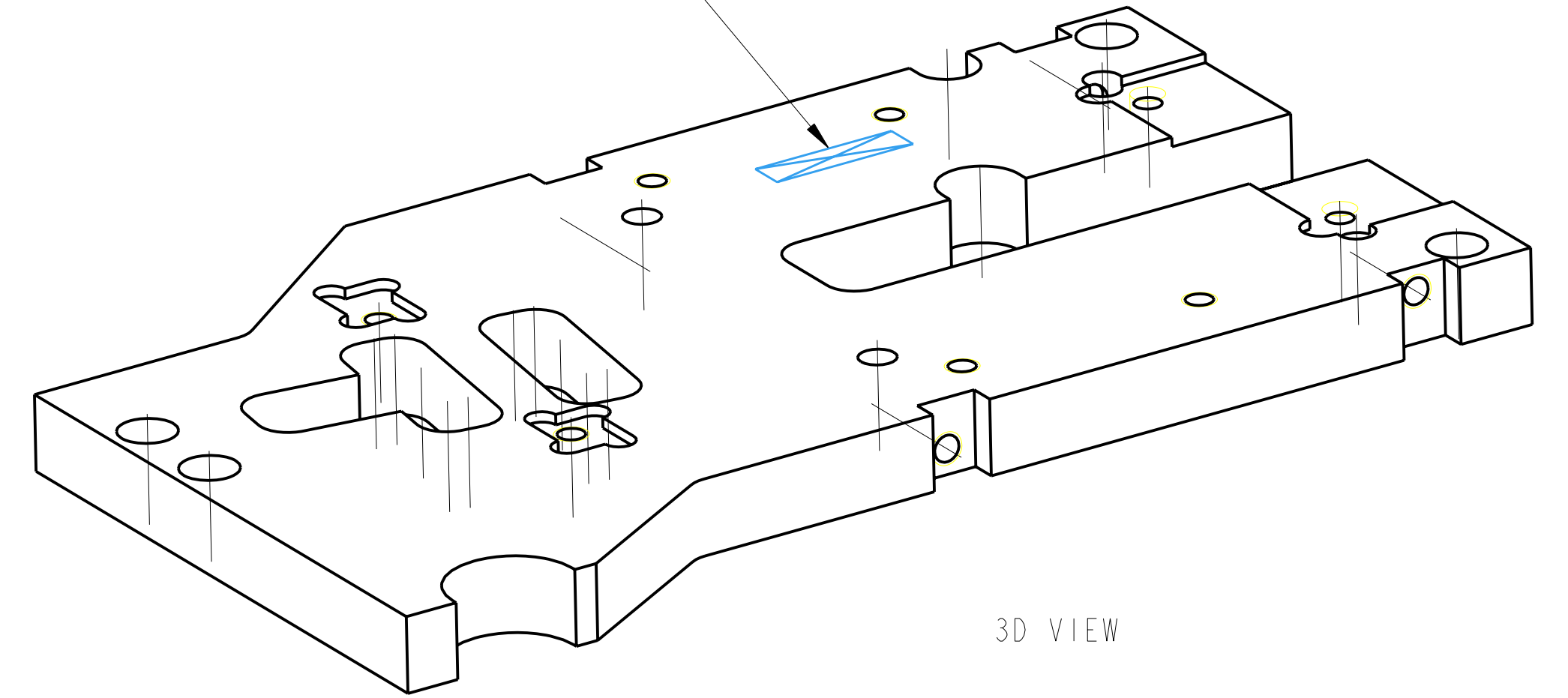


REV.	DATE	DCN #	DRAWING TREE #
A	19/OCT/06	E060248	
B	17/DEC/07	E060248-B	
H	15/JULY/08	E060368	



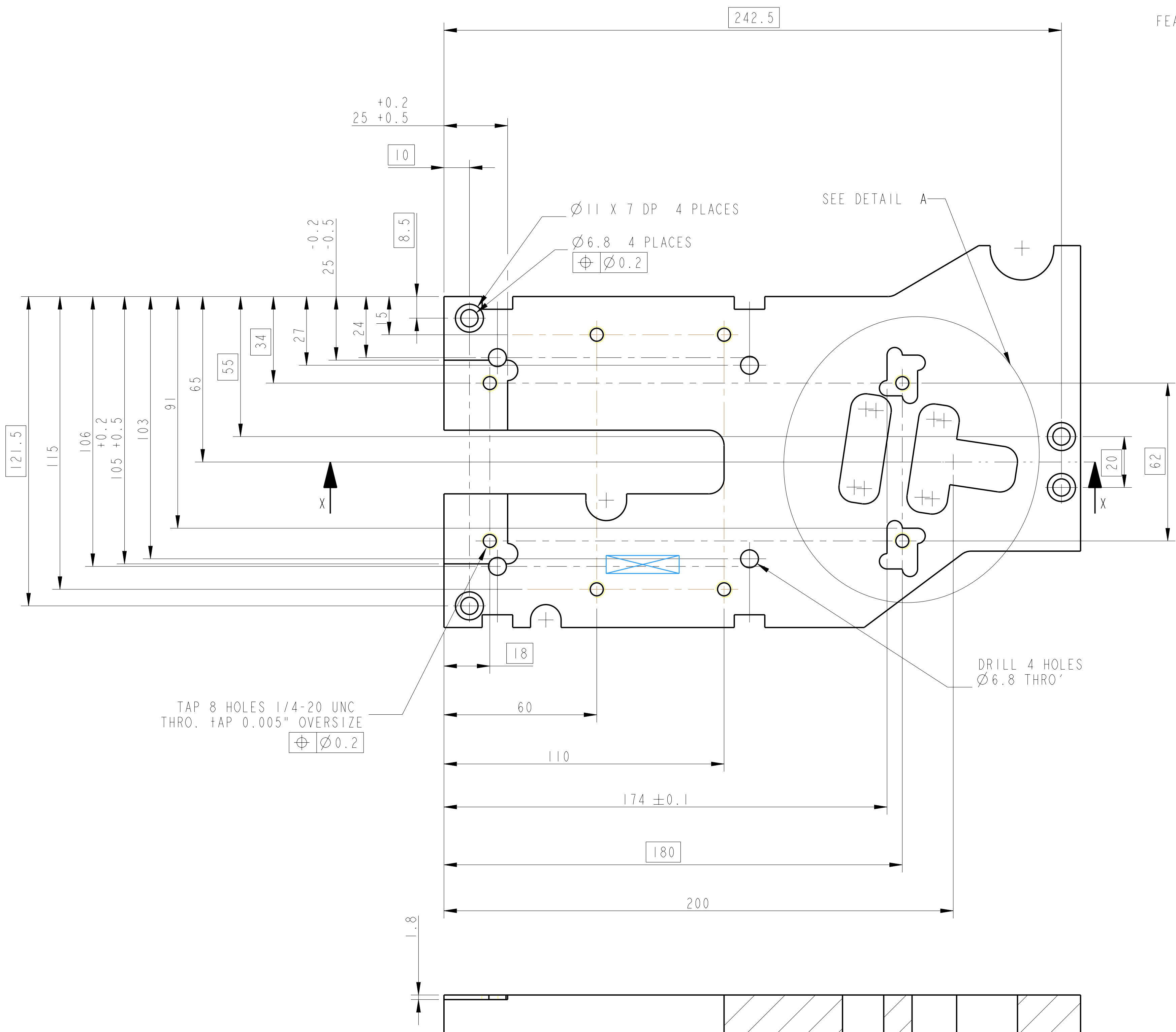
PART NO. (SEE NOTE 4) TO BE ETCHED OR STAMPED IN APPROX POSITION SHOWN.



ADDITIONAL NOTES:  
5. ALL FEATURES ARE MACHINED THROUGH THE PLATE UNLESS OTHERWISE STATED

NOTES: (UNLESS OTHERWISE SPECIFIED)		DIMENSIONS ARE IN mm (INCHES)		TOLERANCES:	
1. REMOVE ALL SHARP EDGES. R.02 MIN.		mm	±0.2	mm	±0.1
2. DO NOT SCALE FROM DRAWING.		mm	±0.2	mm	±0.1
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SODIUM, CHLORINE AND SILICONE. SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).		MATERIAL:	ST. STEEL	FINISH:	CLEAN, GREASE FREE
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: 000100-001 - A VIBRATOR TOOL MAY BE USED.		APPROVED:	JOD	DATE:	15/MAR/10
		SCALE:	1:1	PROJECTION:	1st Angle

CALIFORNIA INSTITUTE OF TECHNOLOGY		GLASGOW UNIVERSITY GEC ROU GROUP		RUTHERFORD APPLION LABORATORIES	
SYSTEM:	aLIGO	SUB-SYSTEM:	SUS	NEXT ASSY:	TOP MASS QUAD
PART NAME:	TOP PLATE	DRG. NO.:	D060411	SHEET:	1 OF 2



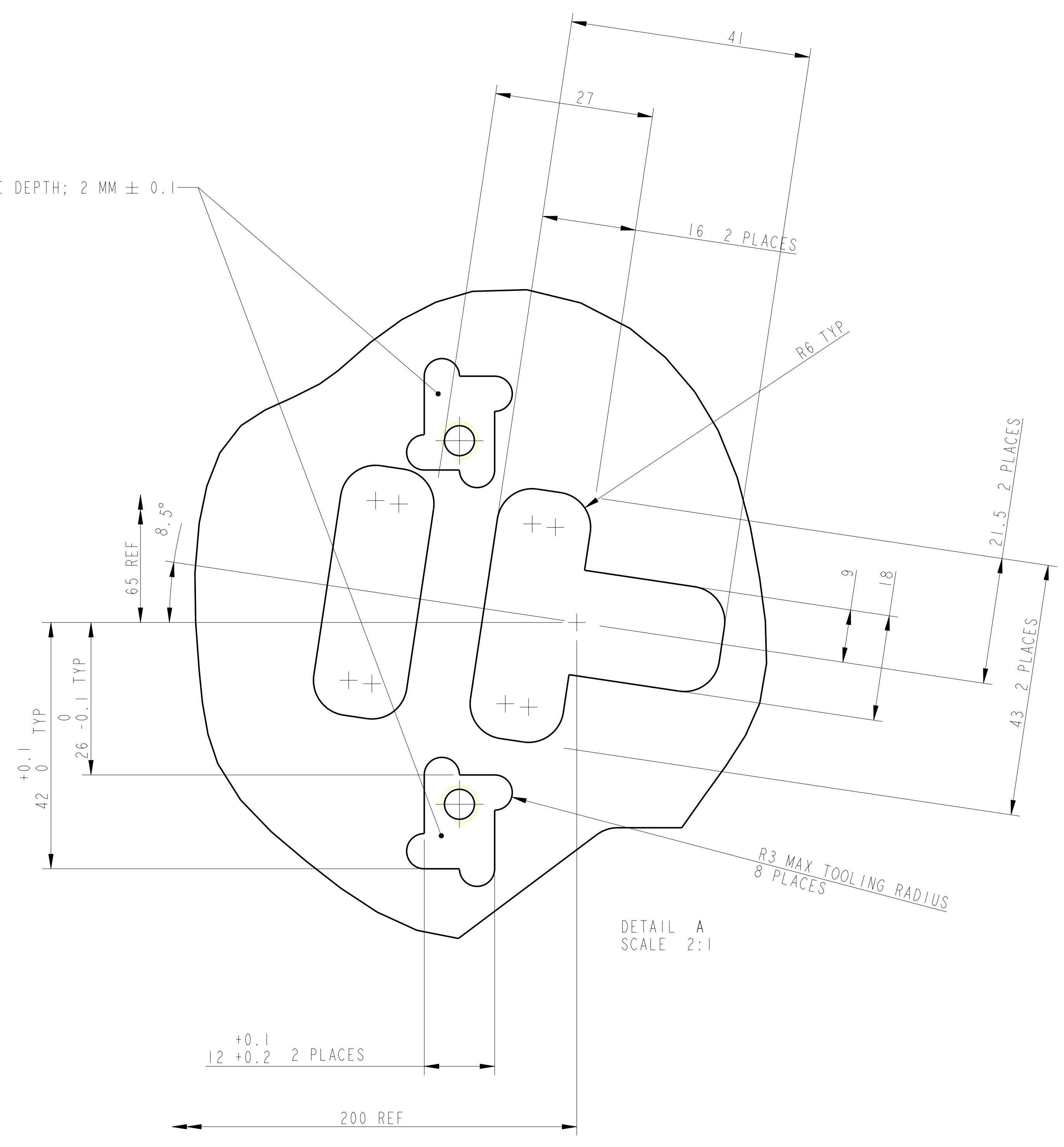
TAP 8 HOLES 1/4-20 UNC THRO. TAP 0.005" OVERSIZE  
 $\pm 0.2$

$\text{Ø}11 \times 7$  DP 4 PLACES  
 $\text{Ø}6.8$  4 PLACES  
 $\pm 0.2$

DRILL 4 HOLES Ø 6.8 THRO'

SECTION X-X

FEATURE DEPTH;  $2 \text{ mm} \pm 0.1$



DETAIL A  
 SCALE 2:1

ADDITIONAL NOTES:

5. ALL FEATURES ARE MACHINED THROUGH THE PLATE UNLESS OTHERWISE STATED

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).
- SCORE, 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: D060411-001 - A VIBRATOR TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES)		CALIFORNIA INSTITUTE OF TECHNOLOGY RUTHERFORD APPLIION LABORATORIES
X, XX ± 0.2 mm	ANGULAR ± 0.1 °	
MATERIAL:	ST. STEEL 316	SYSTEM: aLIGO SUB-SYSTEM: SUS NEXT ASSY: TOP MASS QUAD PART NAME: TOP PLATE
FINISH:	CLEAN, GREASE FREE $\sqrt{Ra}$ (μm) Ra: 1.6	
DRAWN:	J. O'BELL 02/NOV/05	SCALE: 1:1 PROJECTION:
CHECKED:	MB 15/MAR/10	
APPROVED:	JOD 15/MAR/10	DRG. NO.: D060411 SHEET: 2 OF 2