

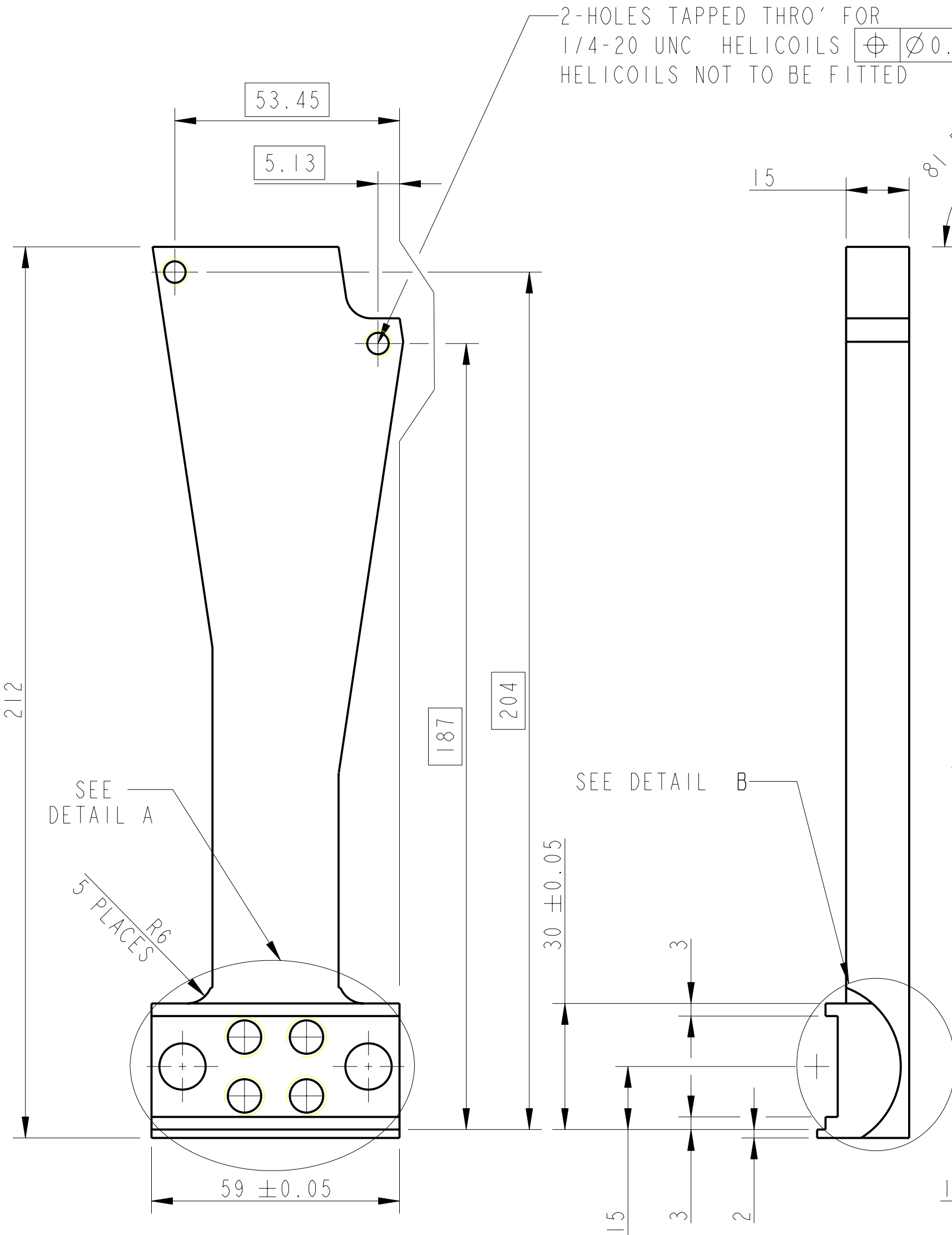
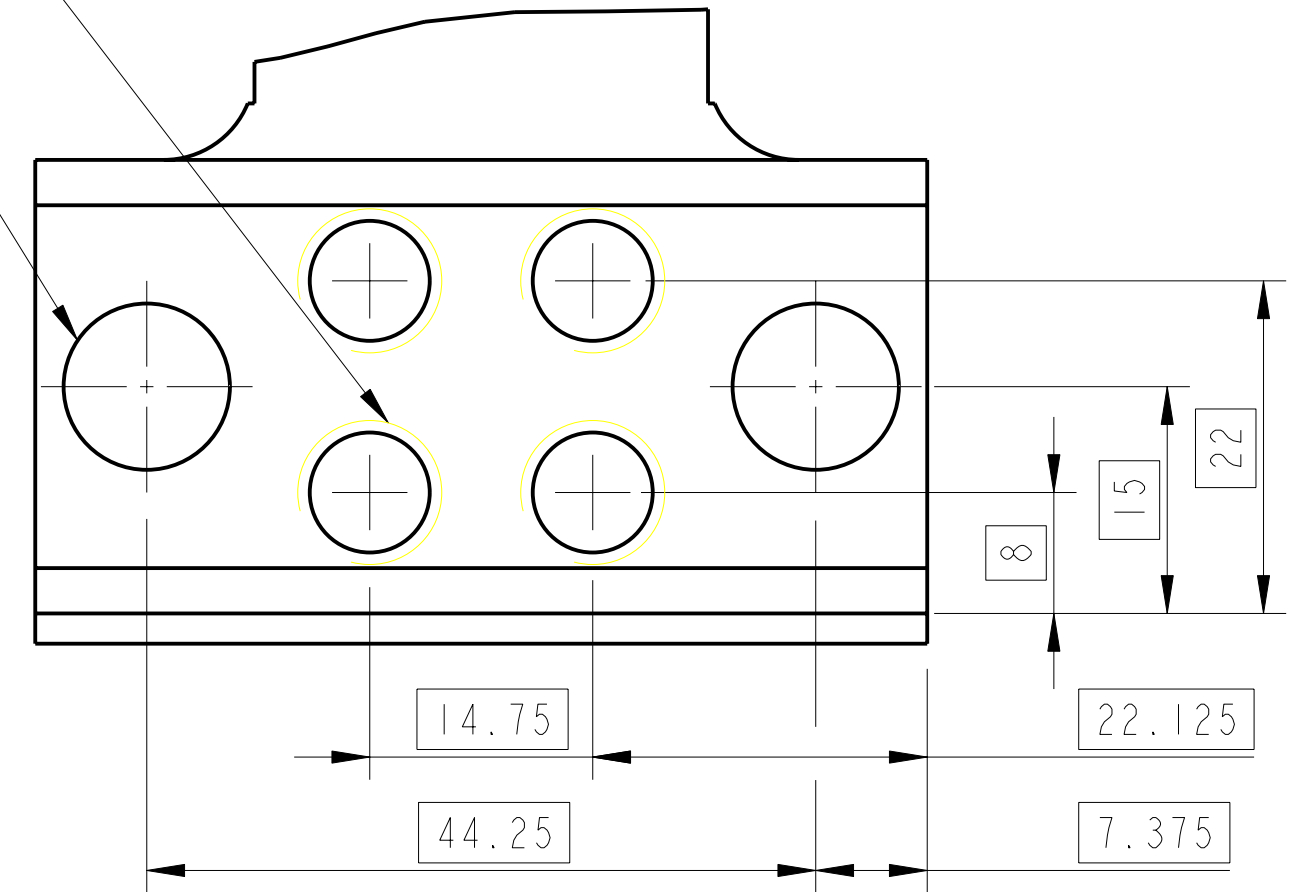
REV.	DATE	DCN #	DRAWING TREE #
A	19/OCT/06.	E060248	
B	17/DEC/07	E060248-B	
H	15/JULY/08	E080368	

4 HOLES TAPPED THRO' FOR
3/8-16 UNC HELICOILS $\text{H} \begin{matrix} \oplus \\ \ominus \end{matrix} \text{ } \phi 0.1$
HELICOILS NOT TO BE FITTED

DETAIL A
SCALE 2:1

DRILL 2 HOLES $\phi 11$
THRO $\text{H} \begin{matrix} \oplus \\ \ominus \end{matrix} \text{ } \phi 0.2$

2-HOLES TAPPED THRO' FOR
1/4-20 UNC HELICOILS $\text{H} \begin{matrix} \oplus \\ \ominus \end{matrix} \text{ } \phi 0.3$
HELICOILS NOT TO BE FITTED



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

DETAIL B
SCALE 2:1

R20 $\begin{matrix} +0.25 \\ 0 \end{matrix}$

NOTES: (UNLESS OTHERWISE SPECIFIED)		DIMENSIONS ARE IN MM TOLERANCES:	
1. REMOVE ALL SHARP EDGES, R. 0.2 MIN.	± 0.2 mm	MATERIAL:	ST STEEL 304/316
2. DO NOT SCALE FROM DRAWING.	± 0.25 °	FINISH:	CLEAN, GREASE FREE
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)		APPROVED:	JOD 15/MAR/10
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: D020188-001. A VIBRATORY TOOL MAY BE USED.		SCALE:	1:1
		SYSTEM:	aLIGO
		SUB-SYSTEM:	SUS - QUAD
		NEXT ASSY:	TOP MASS QUAD
		PART NAME:	BLADE TIP Z POSITION ADJ (BTM HALF)
		DRG. NO.:	D060415
		REV.:	J.