DRILL AND TAP 4-40 UNC X 6 DP
0.005" OVERSIZE

(1/4-20 UNC THREAD)

4 ±0.1

(25.4)
[1"]
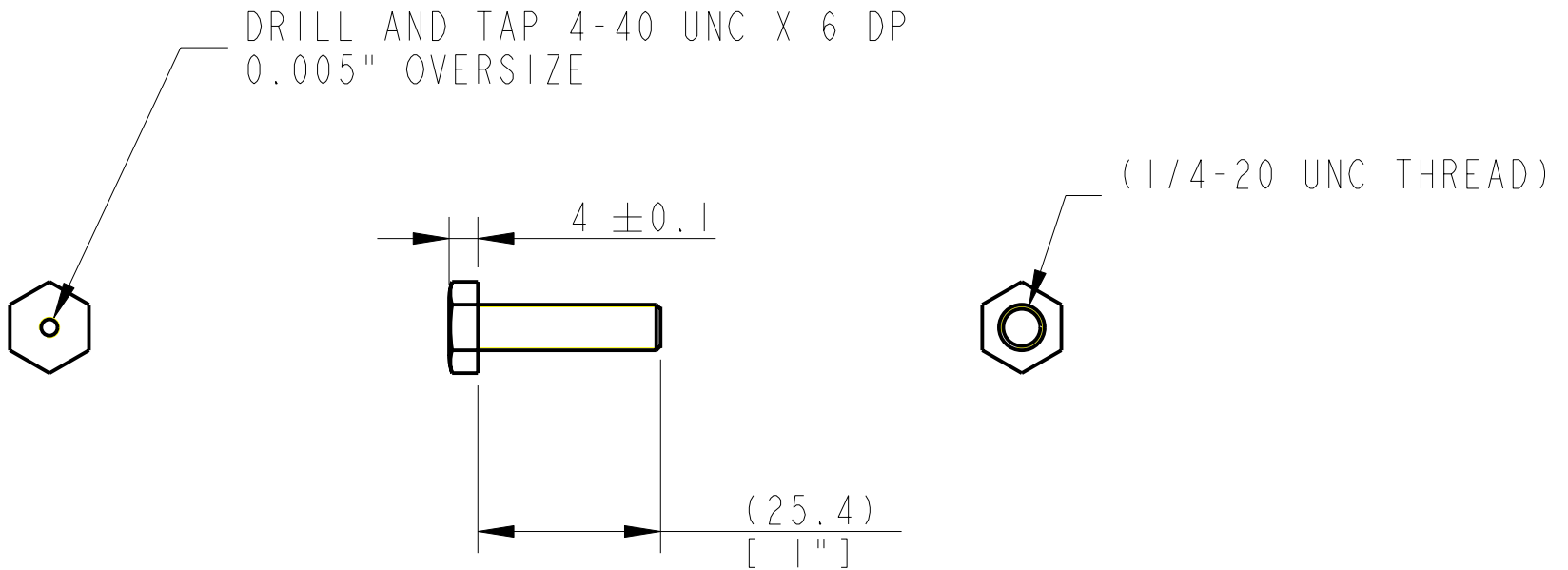
NOTE:

USE A STANDARD HEX HEAD 1/4-20 UNC
BOLT, AND MAKE SPECIFIED MODIFICATIONS

DRAWING UNCHECKED AND FOR REFERENCE ONLY

NOTES: (UNLESS OTHERWISE SPECIFIED)

1. REMOVE ALL SHARP EDGES, R.02 MIN.
2. DO NOT SCALE FROM DRAWING.
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL)
4. SCRIBE, ENGRAVE OR STAMP DRAWING PARTNUMBER 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.

DIMENSIONS ARE IN mm [INCHES]
TOLERANCES:

X.XX ±0.2 mm
ANGULAR ±0.25 °

MATERIAL: ST. STEEL
                  304 OR 316

FINISH: CLEAN, GREASE FREE
∇µm [µin]   Ra = 1.6

	NAME	DATE
DRAWN	J O'DELL	24/APR/08
CHECKED	MB	15/MAR/10
APPROVED	JOD	15/MAR/10

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
IGR, GLASGOW UNIVERSITY GEO 600 GROUP
RUTHERFORD APPLETON LABORATORIES

SYSTEM   aLIGO

SUB-SYSTEM   SUS

NEXT ASSY   QUAD

PART NAME   MODIFIED 1/4-20 UNC X 1" HEX HEAD
             PEN RE MASS BUMP STOPS

SIZE A

DRG. NO.   D080242

REV F.

SCALE 1:1 | PROJECTION: ⊖⊕ | SHEET 1 OF 1