

2 HOLES DR FROM OPP SIDE
20 DEEP & TAP 1/4-20 UNC
0.005" OVERSIZE

2 HOLES 1/4-20 UNC THRU
X 0.005" OVERSIZE
2 PLACES
⊕ ⌀0.3

3 HOLES ⌀5 THRO' BOTH WALLS

2 HOLES DR THRU &
TAP FOR 1/4"UNC HELICOILS,
2 PLACES
HELICOILS NOT TO BE FITTED

2 HOLES DR ⌀2 TO BREAK
INTO #8UNC CORE HOLE

2 HOLES 8-32 UNC X 15 DP
0.005" OVERSIZE
MIRROR ON OPPOSITE FACE

2 HOLES ⌀6.8
THRU
TYP 4 PLACES

DETAIL Z
SCALE 1:1
TYP 4 PLACES
FROM SECTION A-A

6 HOLES DR THRU & TAP
1/4"-20 UNC 0.005" OVERSIZE
⊕ ⌀0.3

NOTES: (UNLESS OTHERWISE SPECIFIED)

- REMOVE ALL SHARP EDGES. R0.2 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 UNFINISHED 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 ± 0.2
ANGULAR ±0.25 °

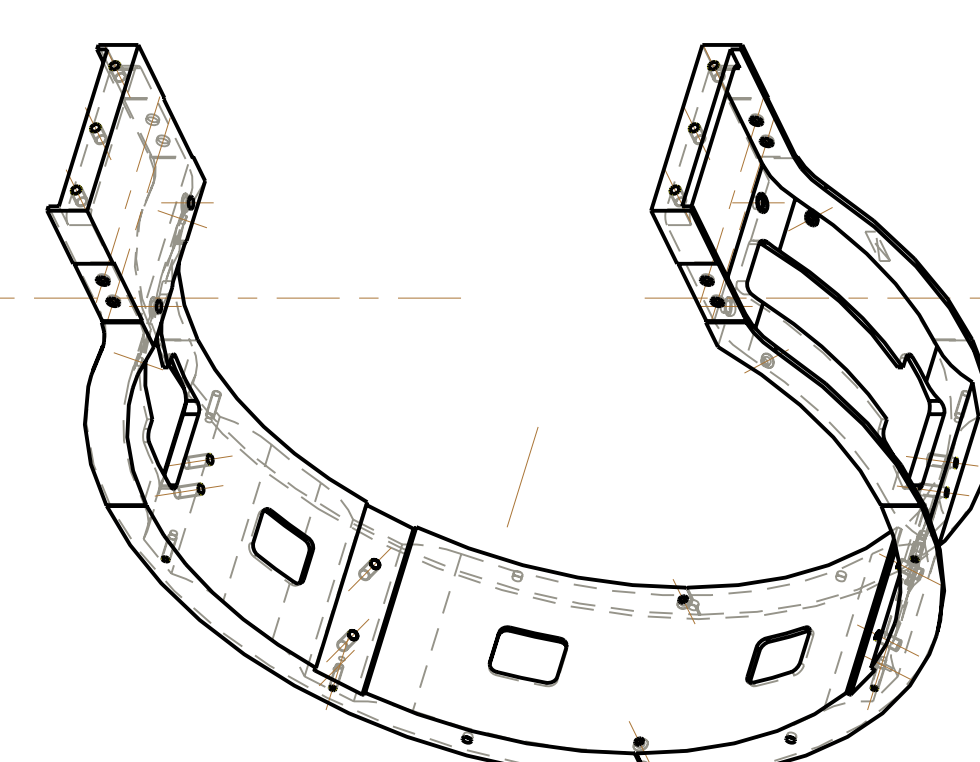
MATERIAL: AL ALLOY 6061 OR SIMILAR

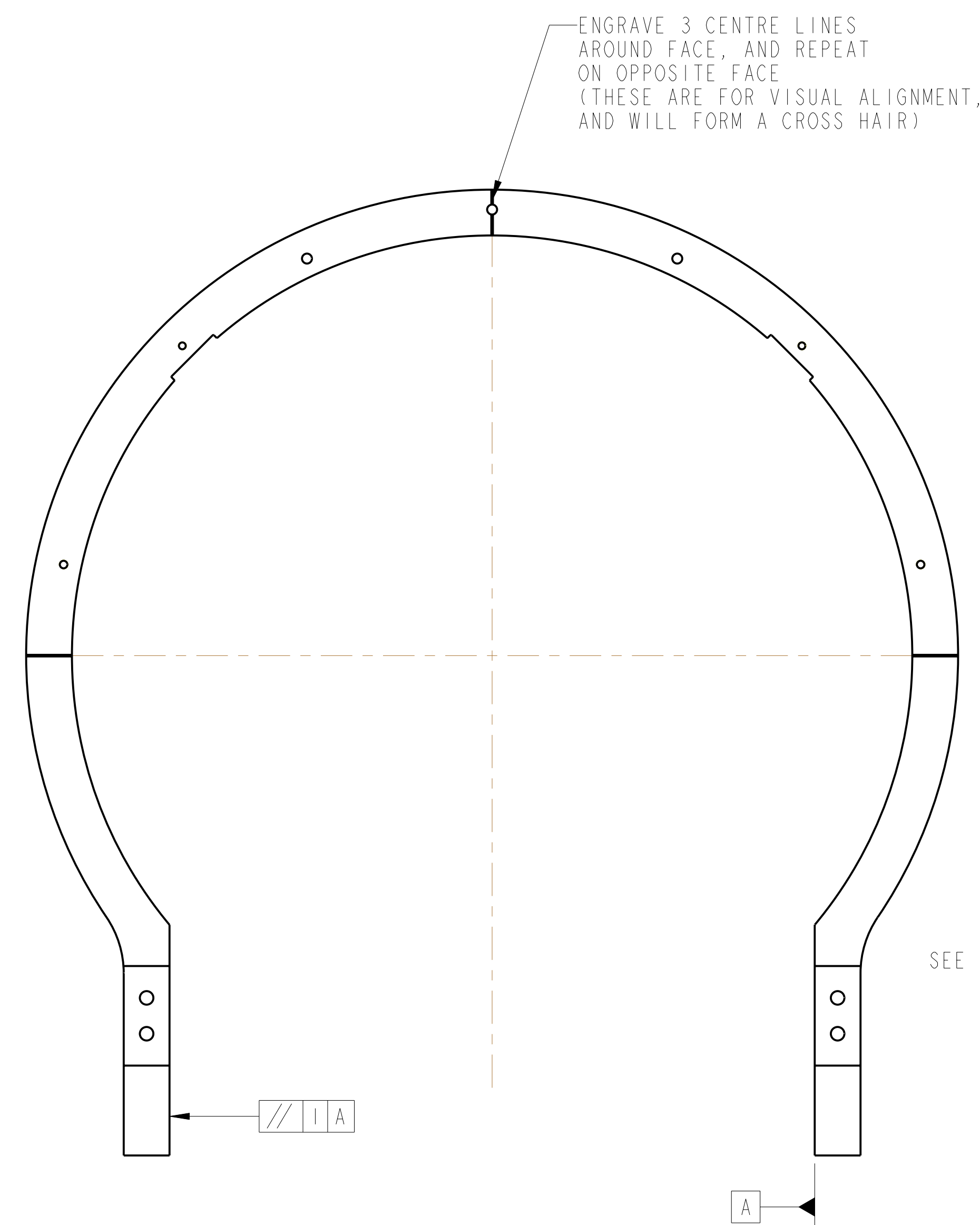
FINISH: CLEAN, GREASE FREE
√Ra (μm) Ra = 1.6

NAME	DATE	BY
CHECKED	J'00	JAN 2008
APPROVED	TW	JAN 2008

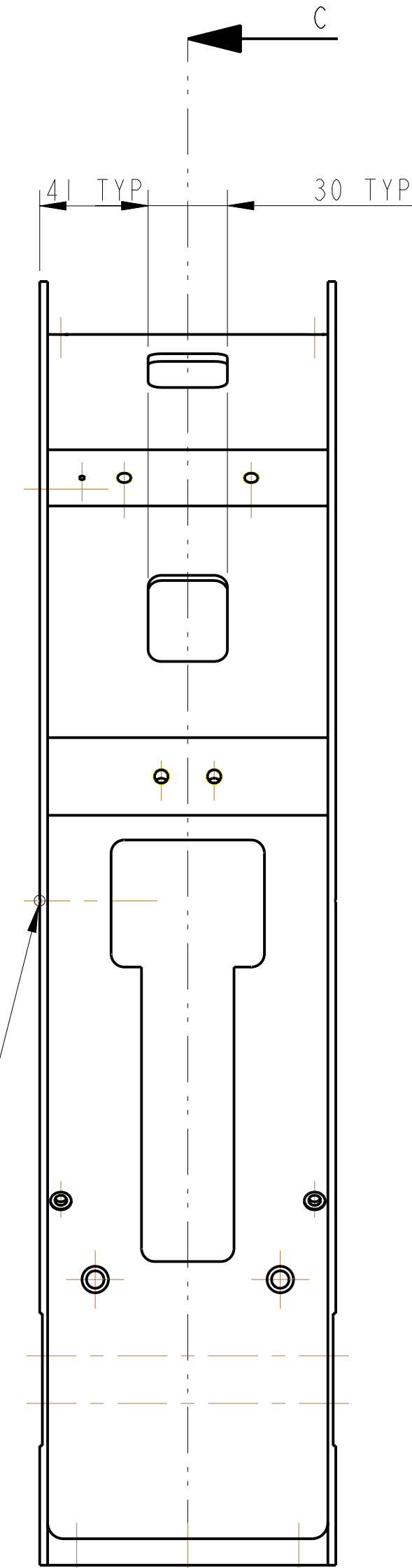
CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
OPR. - GLASSBORO UNIVERSITY GEG RES GROUP
RUTHERFORD APPLTON LABORATORIES

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: DOB0005
PART NAME: BS LOWER STRUCTURE
BS LS BOTTOM HALF
DRG. NO.: DOB0006
SCALE: 1:1 PROJECTION: 1 OF 2

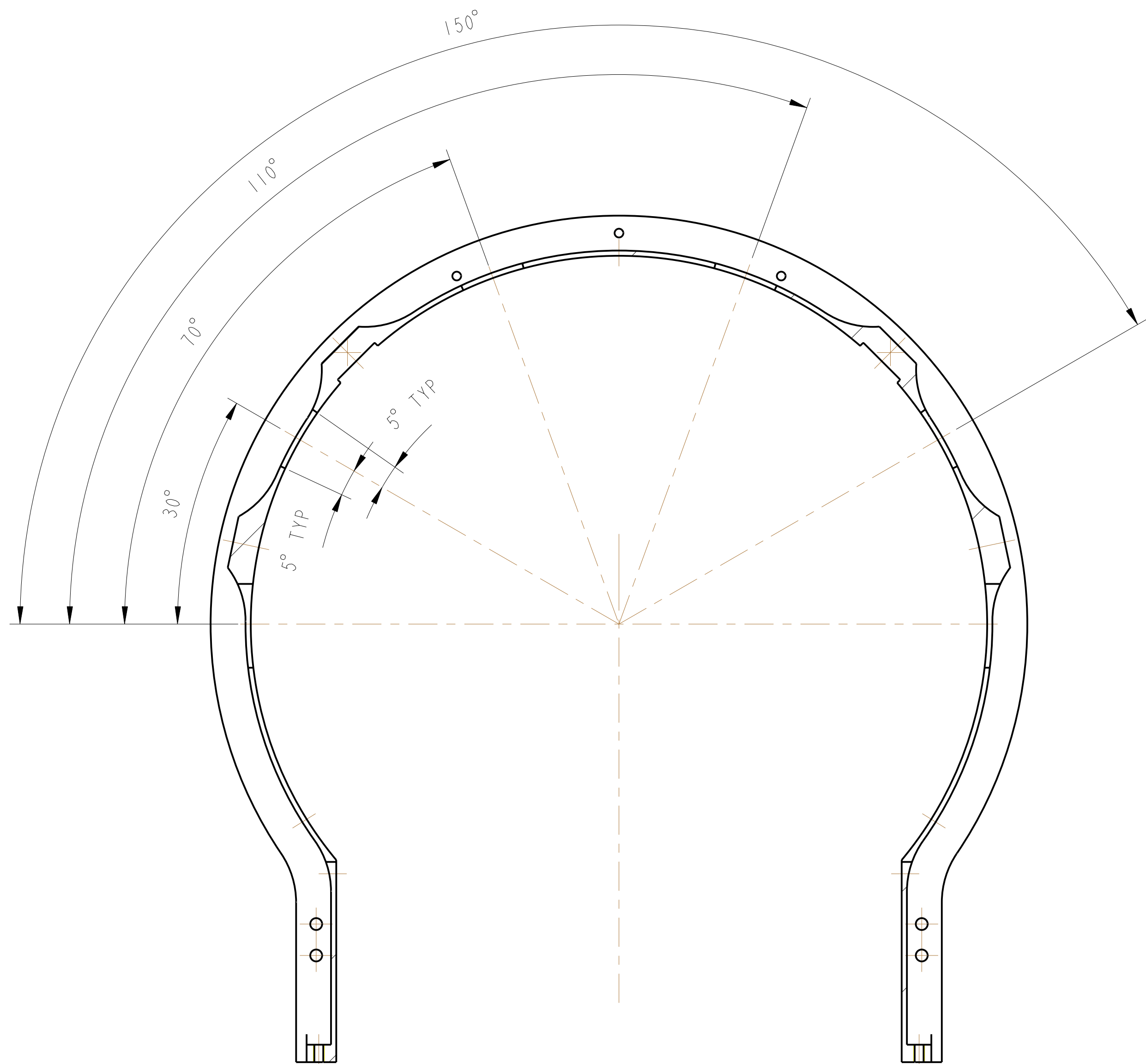




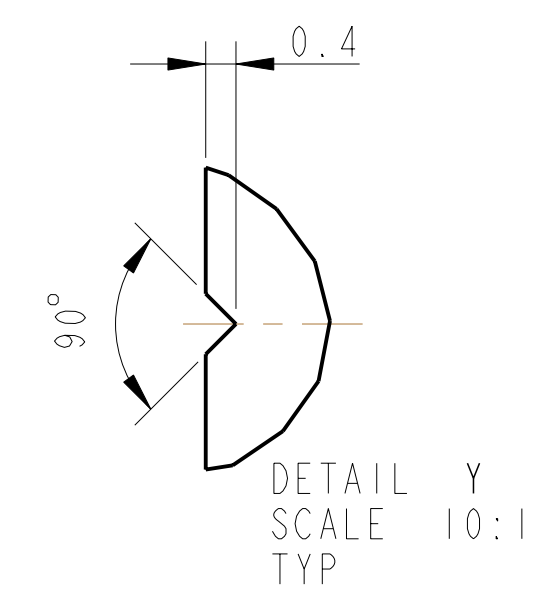
ENGRAVE 3 CENTRE LINES AROUND FACE, AND REPEAT ON OPPOSITE FACE (THESE ARE FOR VISUAL ALIGNMENT, AND WILL FORM A CROSS HAIR)



SEE DETAIL Y



SECTION C-C



NOTES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY	
1. REMOVE ALL SHARP EDGES. R.02 MIN.		MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
2. DO NOT SCALE FROM DRAWING.		DEPT. OF GLASGOW UNIVERSITY TECH RES GROUP	
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SODIUM, CHLORINE AND SILICONE. SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).		RUTHERFORD APPLINGTON LABORATORIES	
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: D080006-001 - A VIBRATORY TOOL MAY BE USED.		ADVANCED LIGO	
	DIMENSIONS ARE IN mm (INCHES) TOLERANCES:	SUB-SYSTEM SUS	
	X .XX ± .13	NEXT ASSY THIS	
	ANGULAR ±0.25 °	PART NAME BS LOWER STRUCTURE	
	MATERIAL: AL ALLOY 6061 OR SIMILAR	BS LS BOTTOM HALF	
	FINISH: CLEAN, GREASE FREE	DRG. NO. D080006	
	√Ra (μm) Ra = 1.6	SCALE 1:21 PROJECTION	
	DRAWN: J'00	SHEET 2 OF 2	
	REVISED: 30/09/08	BY	
	CHECKED: J'00	E	
	APPROVED: TW	JAN 2008	