



DETAIL Z  
SCALE 5:1  
TYP 2 PLACES

DRILL AND TAP THRO' FOR  
1/4-20 UNC HELICOIL,  
HELICOIL NOT TO BE FITTED

4 HOLES DRILL AND TAP FOR  
1/4-20 UNC HELICOILS,  
HELICOILS NOT TO BE FITTED

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

NOTES: (UNLESS OTHERWISE SPECIFIED)

- REMOVE ALL SHARP EDGES, R.02 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: D080085-001 - A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN MM (INCHES)

FINISH: CLEAN, GREASE FREE

MATERIAL: ST-STEEL 304-316

SCALE: 1:1 PROJECTION: 1st Angle

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|----------|------|----|
| NAME     | DATE | BY |
|          |      |    |
| CHECKED  |      |    |
|          |      |    |
| APPROVED |      |    |
|          |      |    |

CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY  
OP. GLASGOW UNIVERSITY GEC ROX GROUP  
RUTHERFORD APPLTON LABORATORIES

SYSTEM: ADVANCED LIGO  
SUB-SYSTEM: SUS  
NEXT ASSY: D080082  
PART NAME: BLADE CLAMP BASE  
BS TOP STAGE

DRG. NO.: D080085  
SHEET 1 OF 1