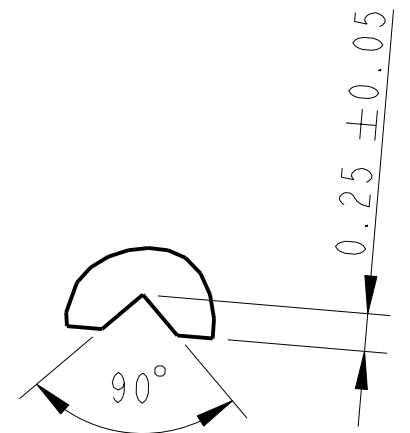


1 HOLE DR. THRU AND TAP FOR 8-32 UNC HELICOIL, HELICOIL NOT TO BE FITTED

$\text{H}\text{OLES } \varnothing 0.2$



DETAIL B
SCALE 20:1

$10_{-0.1}^0$

SEE DETAIL A

2 ± 0.1

90°

9

0.5

DETAIL A
SCALE 5:1

14.5

19.8

4

(0.9)

3.4

7.2

14

$94.85^\circ \pm 0.2^\circ$

24.07

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

3.4

15

7.2

DRILL 2 VENT HOLES $\varnothing 2$ TO BREAK INTO 8-32 UNC HOLES

2 HOLES DR. AND TAP 10.5 DP FOR 8-32 UNC HELICOILS, HELICOILS NOT TO BE FITTED

$\text{H}\text{OLES } \varnothing 0.2$

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 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.

DIMENSIONS ARE IN mm [INCHES]
TOLERANCES:

X.XX ± 0.2 mm
ANGULAR $\pm 0.25^\circ$

MATERIAL: ST. STEEL
304/316

FINISH: CLEAN, GREASE FREE
 $\sqrt{\mu\text{m}}$ [μin]
Ra = 1.6

NAME	DATE
DRAWN REV/FEL	21/12/07
CHECKED J'OD	DEC/07
APPROVED IW	DEC/07

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

SYSTEM	ADVANCED LIGO
SUB-SYSTEM	SUS
NEXT ASSY	D080080
PART NAME	BLADE WIRE CLAMP BS TOP STAGE
SIZE	B
DRG. NO.	D080088
SCALE	2:1
PROJECTION	1st Angle
SHEET	1 OF 1