

TAP 2 HOLES
1/4-20 UNC THRO
0.005" OVERSIZE

TAP 12 HOLES 1/4-20 UNC THRO
EQ SP ON 148 PCD
0.005" OVERSIZE

$\varnothing 10.1^{+0.1}$
4 PLACES

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

DRILL AND TAP 4 HOLES
FOR 8-32-UNC X 20 DP HELICOILS
2 POSITIONS
HELICOILS NOT TO BE FITTED

$38^{+0.2}$
 $19^{+0.1}$

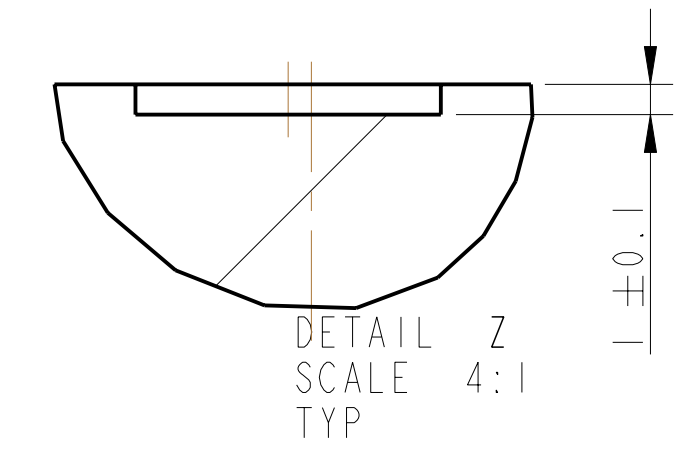
8.55

40

15
30

$1.55^{-0.1}$

$54^{+0.2}$



NOTES: (UNLESS OTHERWISE SPECIFIED)

- REMOVE ALL SHARP EDGES. R10 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: 000100-001 - A VIBRATOR TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES) TOLERANCES:

X XX ± 0.2 ANGLAR ±0.25 °

MATERIAL: AL ALLOY 6061-T6

FINISH: CLEAN Ra: 1.6

NAME	DATE	STY
DRAWN J O'BELL	SEP108	
CHECKED AJB	OCT 08	
APPROVED JOD	OCT 08	

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: THIS
PART NAME: BS ROUND MASS BODY
BEAMSPLITTER ROUND MASS
DRG. NO.: D080369
SCALE: 1:1 PROJECTION: 1ST ANGLE SHEET 1 OF 1