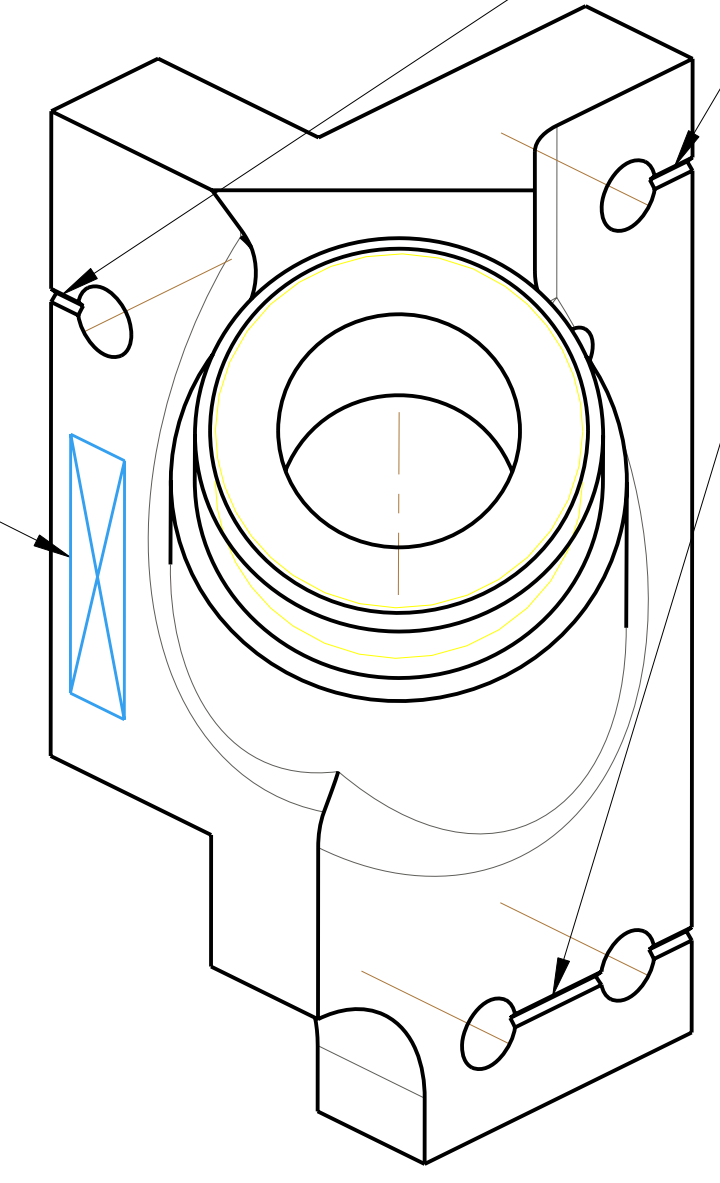
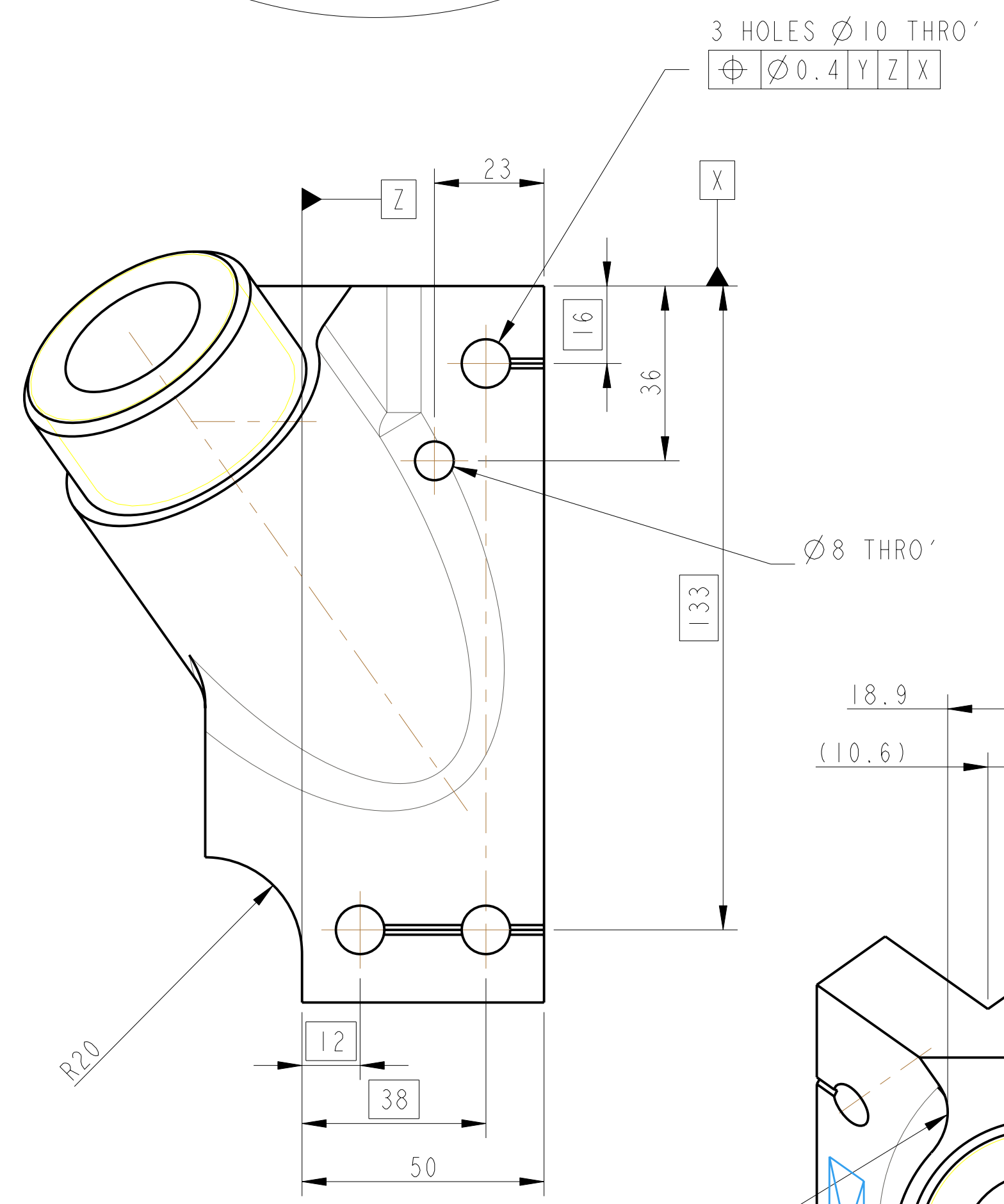
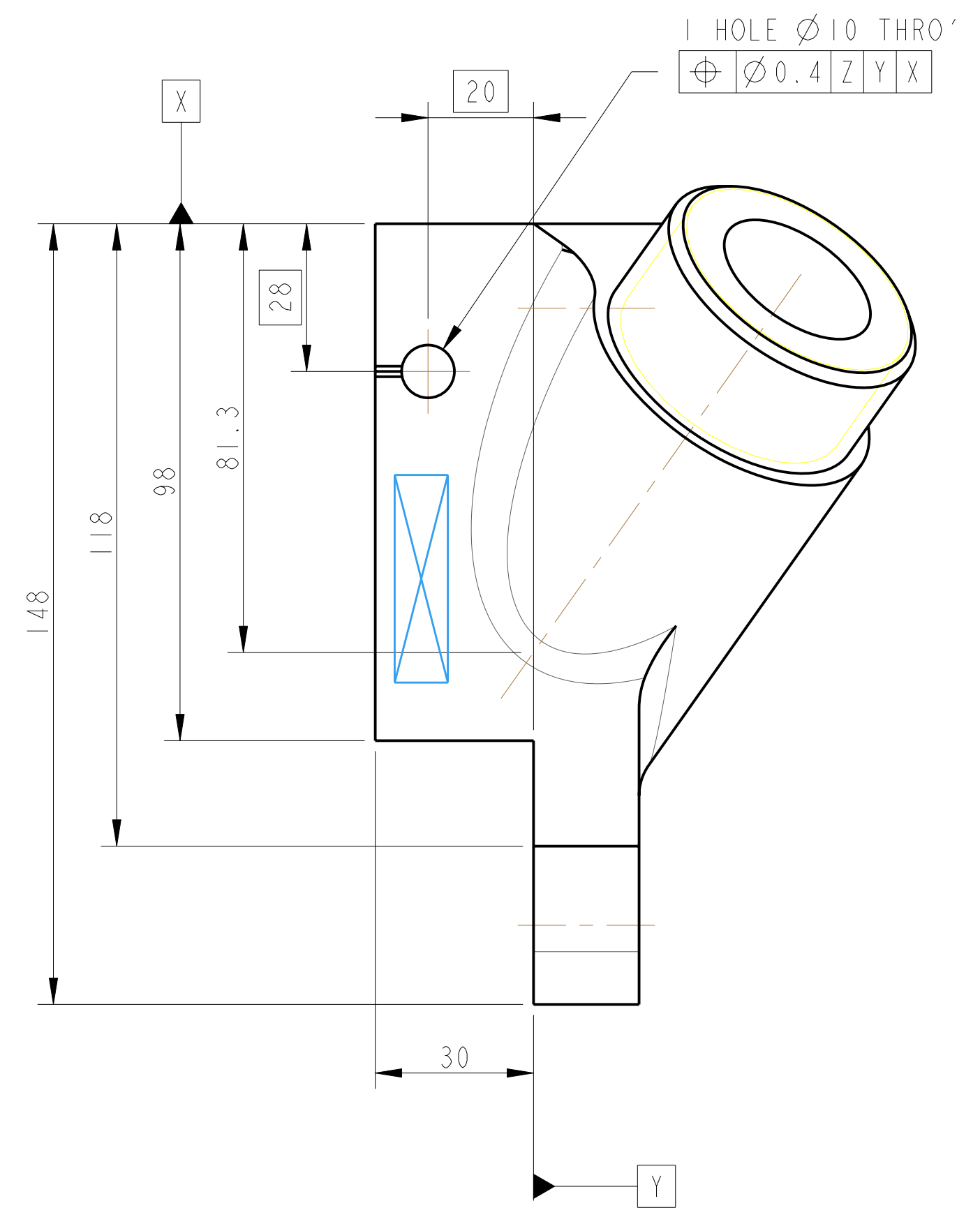


PART# (SEE NOTE4) TO BE ETCHED OR STAMPED IN APPROX. POSITION SHOWN



ENGRAVE 90° VEE GROOVE (LEAK PATH) X 1 DP 3 PLACES

3D VIEW

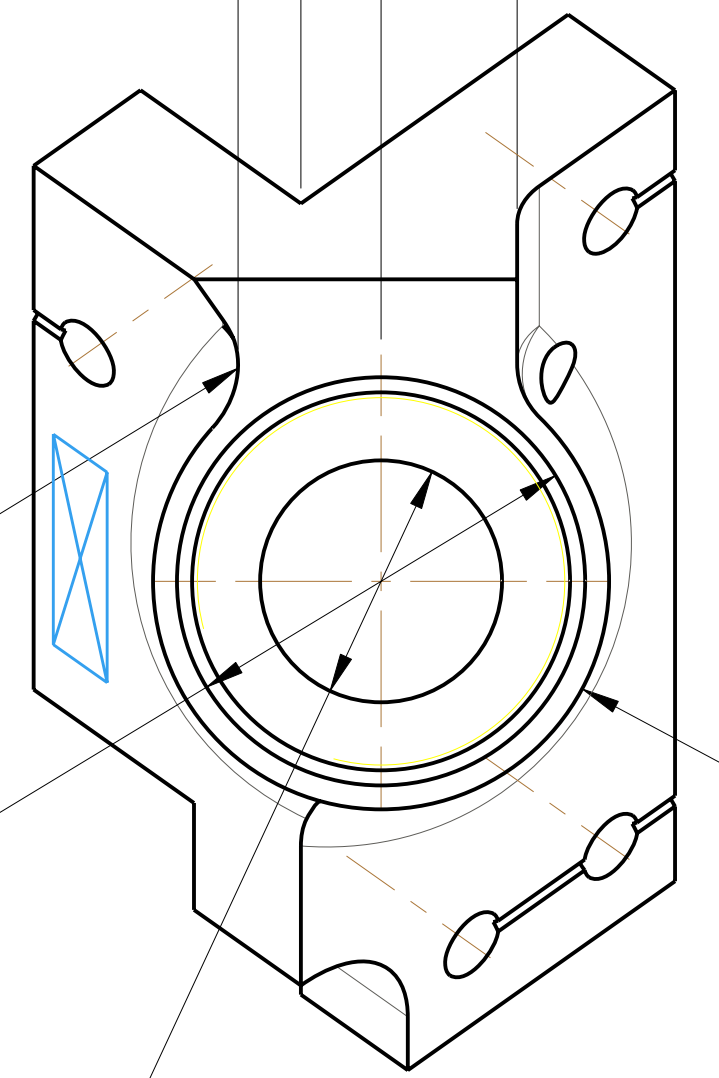


18.9 (10.6) 18

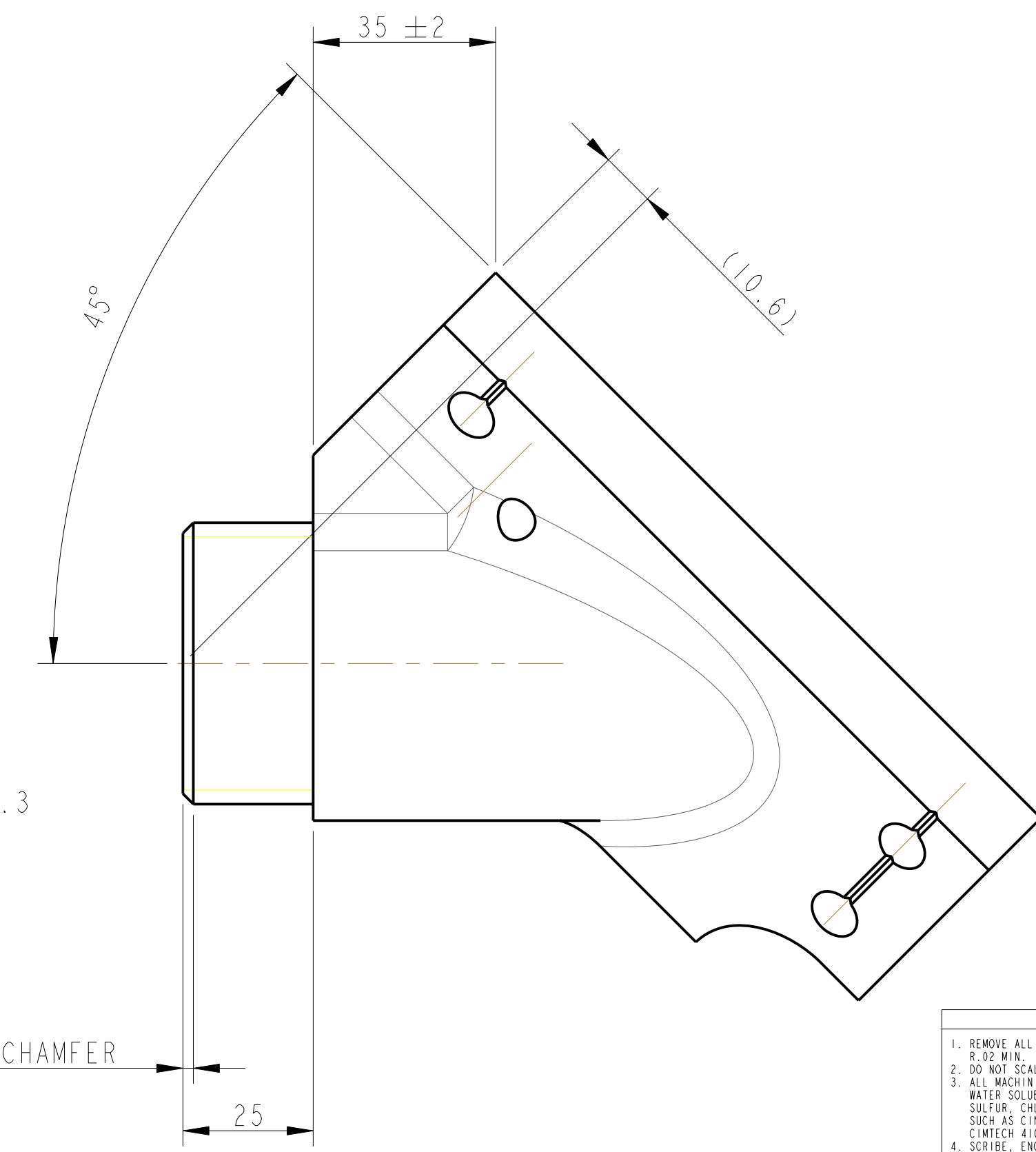
R10 ± 10 TYP TOOLING RAD

M54 X 1.5 (F7) FULL THREAD UP TO SHOULDER. UNDERCUT IF NECESSARY

DRILL Ø32 ± 1 X 45 DP TO DRILL POINT THIS HOLE MAY BE DRILLED THROUGH FOR MANUFACTURING PURPOSES, BUT MUST IN THIS CASE BE REDUCED TO Ø20



2 X 45° CHAMFER



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: D080507-001 - A VIBRATOR TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES) TOLERANCES:

X XX ± .13 ANGULAR ±0.25 °

MATERIAL: AL ALLOY SUBS OR SIMILAR

FINISH: CLEAN, GREASE FREE √µm (1µin) Ra = 1.6

NAME	DATE	SIZE
DRAWN J O'BELL	07/01/09	32
CHECKED AJB
APPROVED JOD

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY RUTHERFORD APPLTON LABORATORIES

SYSTEM: ADVANCED LIGO

SUB-SYSTEM: SUS

NEXT ASSY: BS/FM UPPER STRUCTURE

PART NAME: BS UPPER STRUCTURE STAY BRACKET *2

DRG. NO.: D080507

SCALE: 1:1 PROJECTION: G

SHEET 1 OF 1