



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: 000100-001 - A VIBRATOR TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X XX ±0.3 (11)
ANGULAR ±0.25°

MATERIAL: AL ALLOY S803 OR SIMILAR
FINISH: CLEAN AND DEGREASED
Ra: 1.6
√Ra (µm)

DRAWN	J. O'BELL	29/OCT/09
CHECKED	J. O'BELL	29/OCT/09
APPROVED	JOD	29/OCT/09

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RUTHERFORD APPLTON LABORATORIES

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: QUAD N-TYPE TOOLING
PART NAME: TOP PLATE LARGE (LOWER STRUCTURE TOOLING)
DRG. NO.: D060300
SCALE: 1:21 PROJECTION: 4 SHEET 1 OF 1