

8

7

6

5

4

3

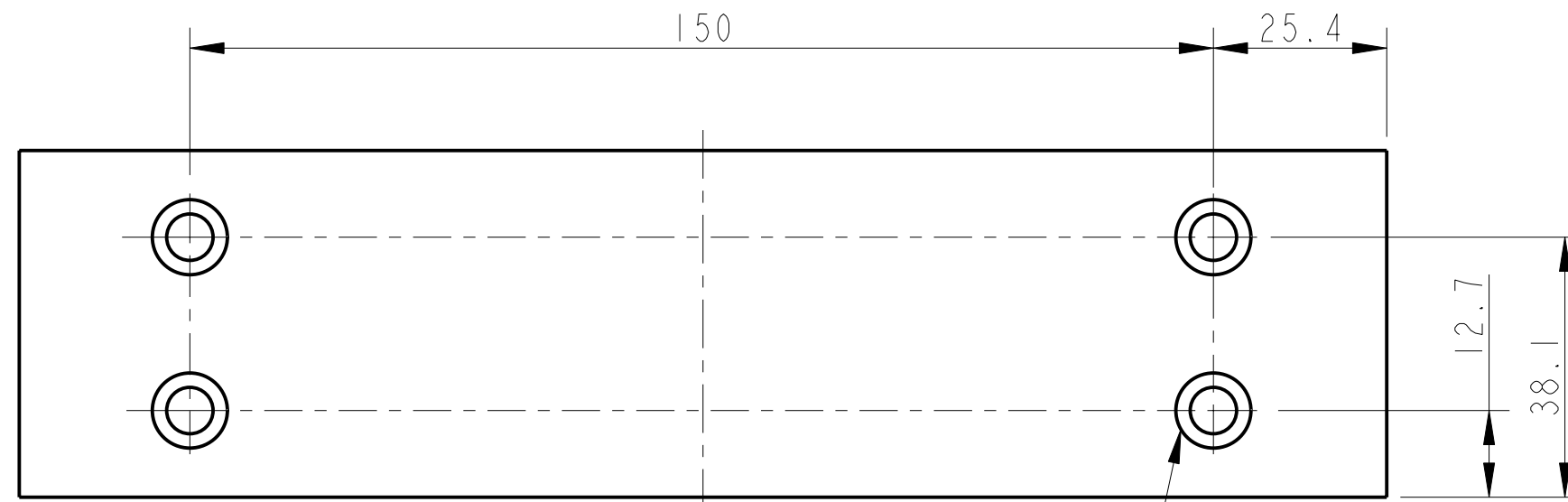
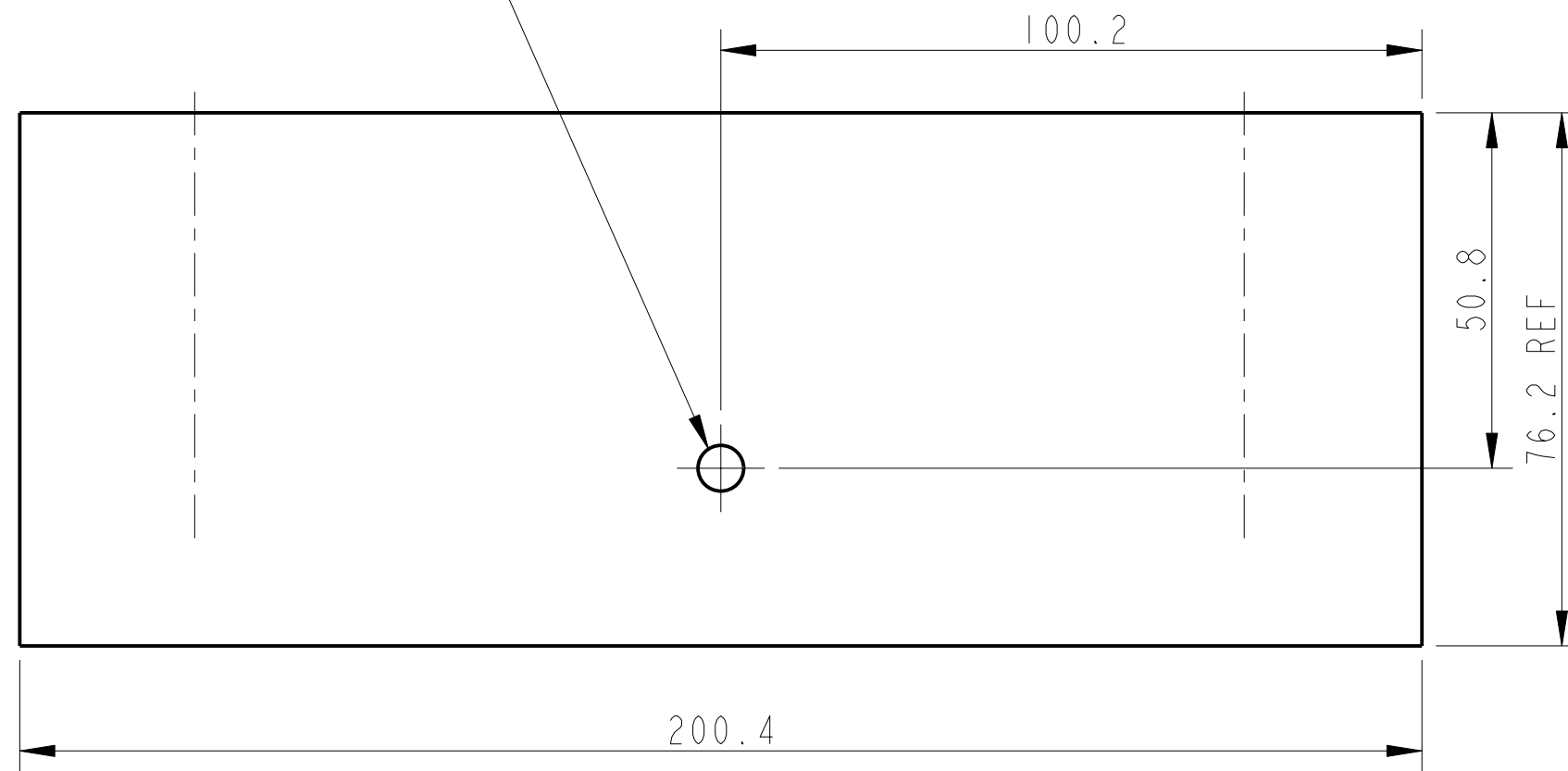
2

1

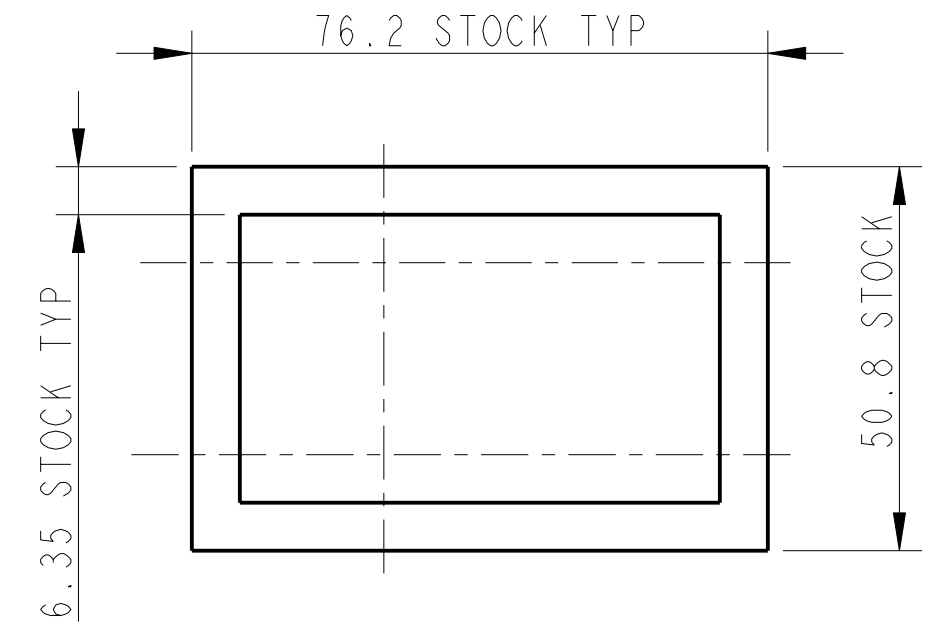
INTRALINK NAME: D060304

REV.	DATE	DCN #	DRAWING TREE #

DRILL  $\varnothing 6.5$  THRU BOTH WALLS



DRILL  $\varnothing 11$  THRO FIRST WALL  
DRILL  $\varnothing 6.8$  THRO SECONUD WALL



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: D020188-001. A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES)  
TOLERANCES:  
X.XX  $\pm 0.2$  mm (INCHES)  
ANGULAR  $\pm 0.25^\circ$

MATERIAL: AL ALLOY 5083

FINISH: CLEAN AND DEGREASE  
 $\sqrt{\mu m}$  (MIN) Ra = 1.6 OR STOCK

NAME	DATE
DRAWN I WILMUT	22/SEP/06
CHECKED J'OD	21/FEB/07
APPROVED IW	22/FEB/07

SCALE 1:1 PROJECTION

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

SYSTEM **alIGO**  
SUB-SYSTEM **SUS**  
NEXT ASSY **QUAD TOOLING**  
PART NAME **LIFTING SECTION (SHORT)**  
**(LOWER STRUCTURE TOOLING)**

DRG. NO. **D060304** REV. **D**  
SCALE 1:1 PROJECTION SHEET 1 OF 1