

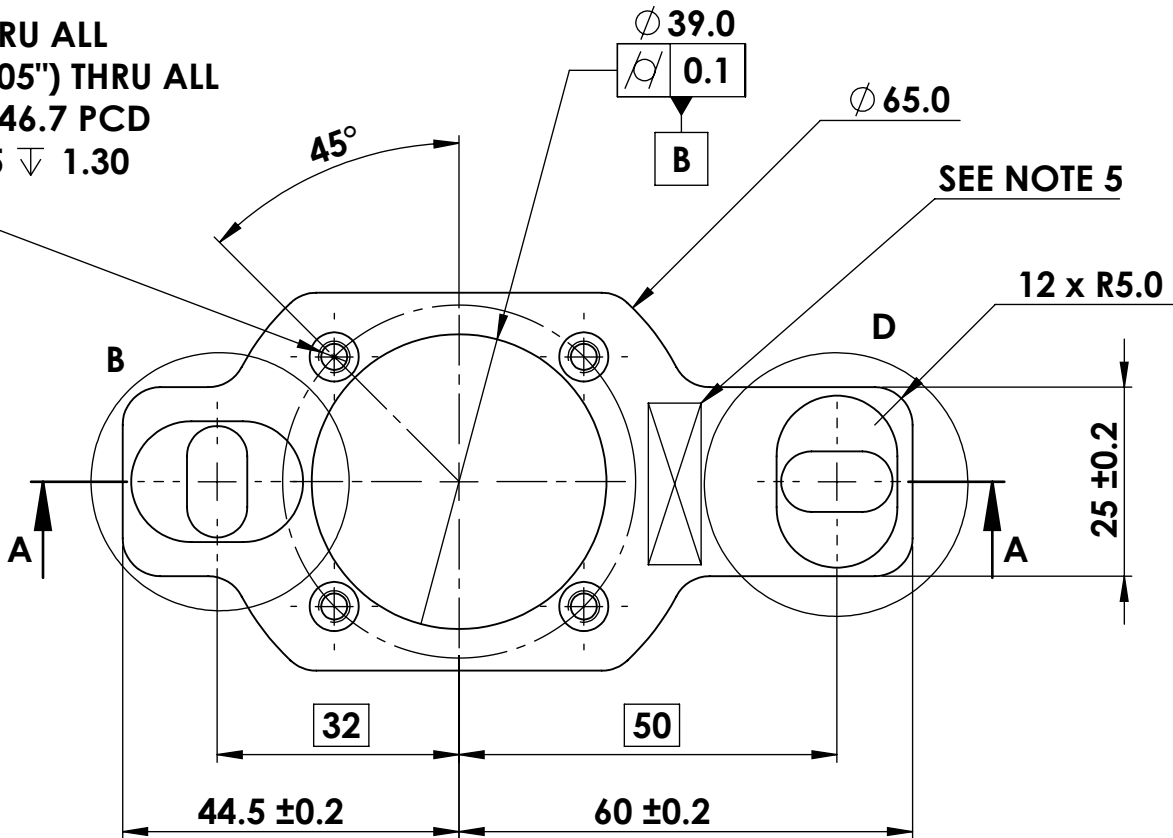
NOTES CONTINUED:
⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

- D
6. APPROXIMATE WEIGHT = 29.59 g
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO MANUFACTURING SPECIFICATION E2200225
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH MANUFACTURING SPECIFICATION E2200225
9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO MANUFACTURING SPECIFICATION E2200225
10. DUAL DIMENSIONED CALLOUTS IN THE FORMAT x.xxx" [x.x] ARE TO BE MACHINED USING IMPERIAL TOOLING

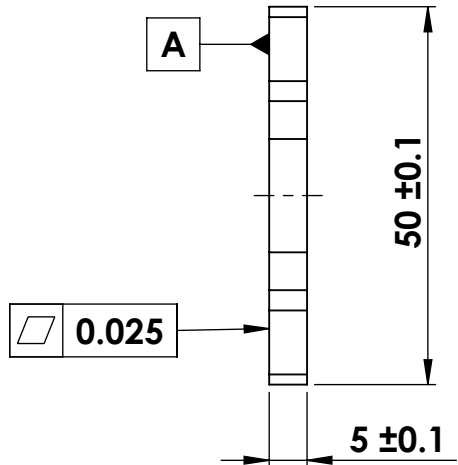
4 x ϕ 3.45 THRU ALL
8-32 UNC H11(+0.005") THRU ALL
EQUISPACED ϕ 46.7 PCD

ϕ 6.5 \pm 0.05 ∇ 1.30

ϕ 0.1 A B

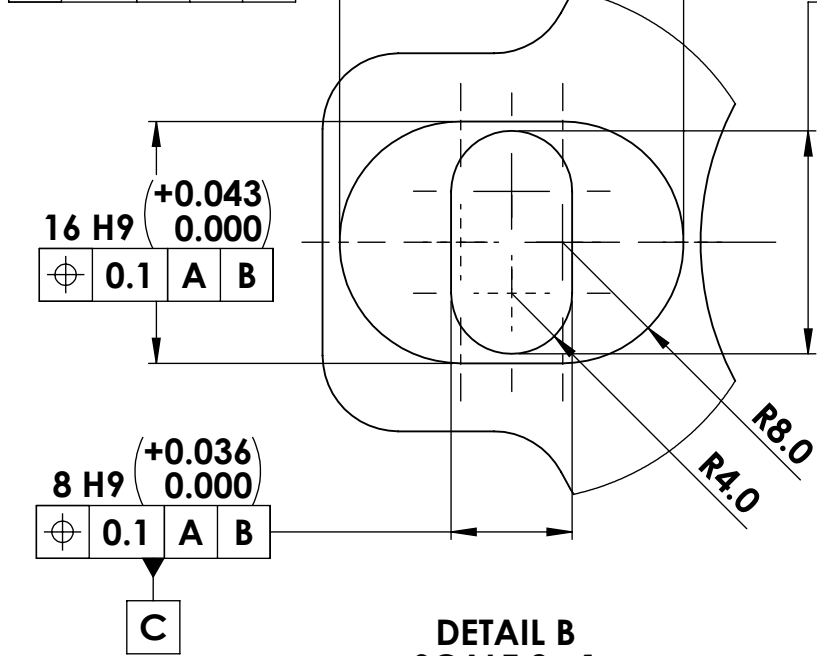


REV.	DATE	DCN #	DRAWING TREE #
v1	09 JUN 2020	E2000291	
v2	21 JUL 2020	E2000390	
v6	10 JUNE 2022	E2200259	



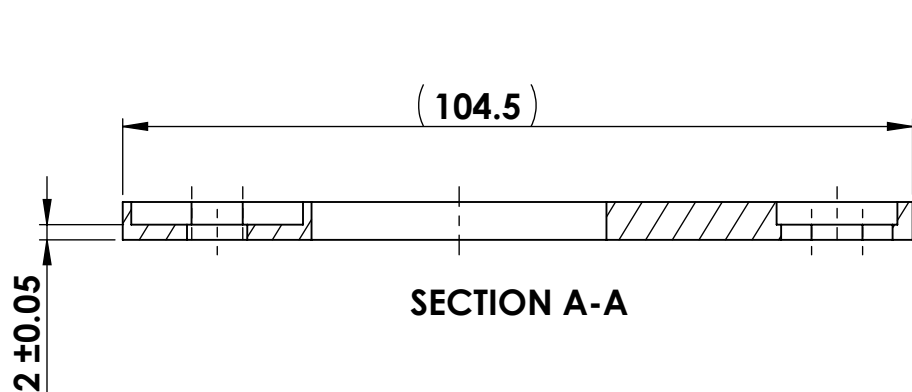
+0.1
22.75 0.0

ϕ 0.1 A B C



+0.1
14.75 0.0

ϕ 0.1 A B C



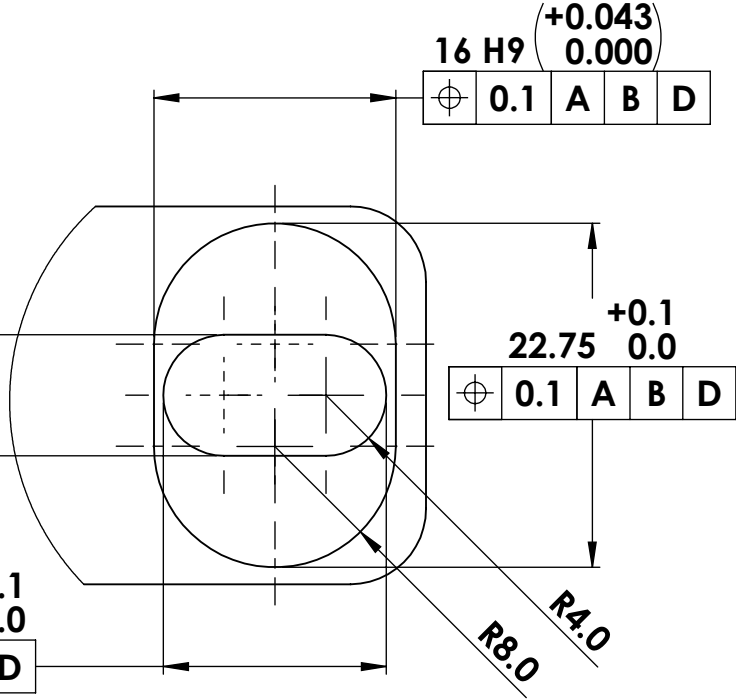
8 H9 (+0.036) 0.000

ϕ 0.1 A B

D

+0.1
14.75 0.0

ϕ 0.1 A B D



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN MILLIMETERS

TOLERANCES:
.X \pm .10
.XX \pm .05
ANGULAR \pm 0.2°

1. INTERPRET DRAWING PER BS 8888.
2. REMOVE ALL SHARP EDGES, 0.1-0.3 FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R0.5 FOR SHEET METAL PARTS.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL 6061-T6 Al FINISH 1.6 μ m

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM A+ SUB-SYSTEM SUS

NEXT ASSY MULTIPLE ASSY

PART NAME
A+, SUS, BOSEM ADJUSTER BASE PLATE

DESIGNER A. HUDDART 04 SEPT 2019 SIZE DWG. NO. B D1900349 REV. v6

DRAFTER A. HUDDART 10 JUNE 2022

CHECKER J.ODELL 12 JULY 2022

APPROVAL J.ODELL 12 JULY 2022 SCALE: 1:1 PROJECTION: SHEET 1 OF 1