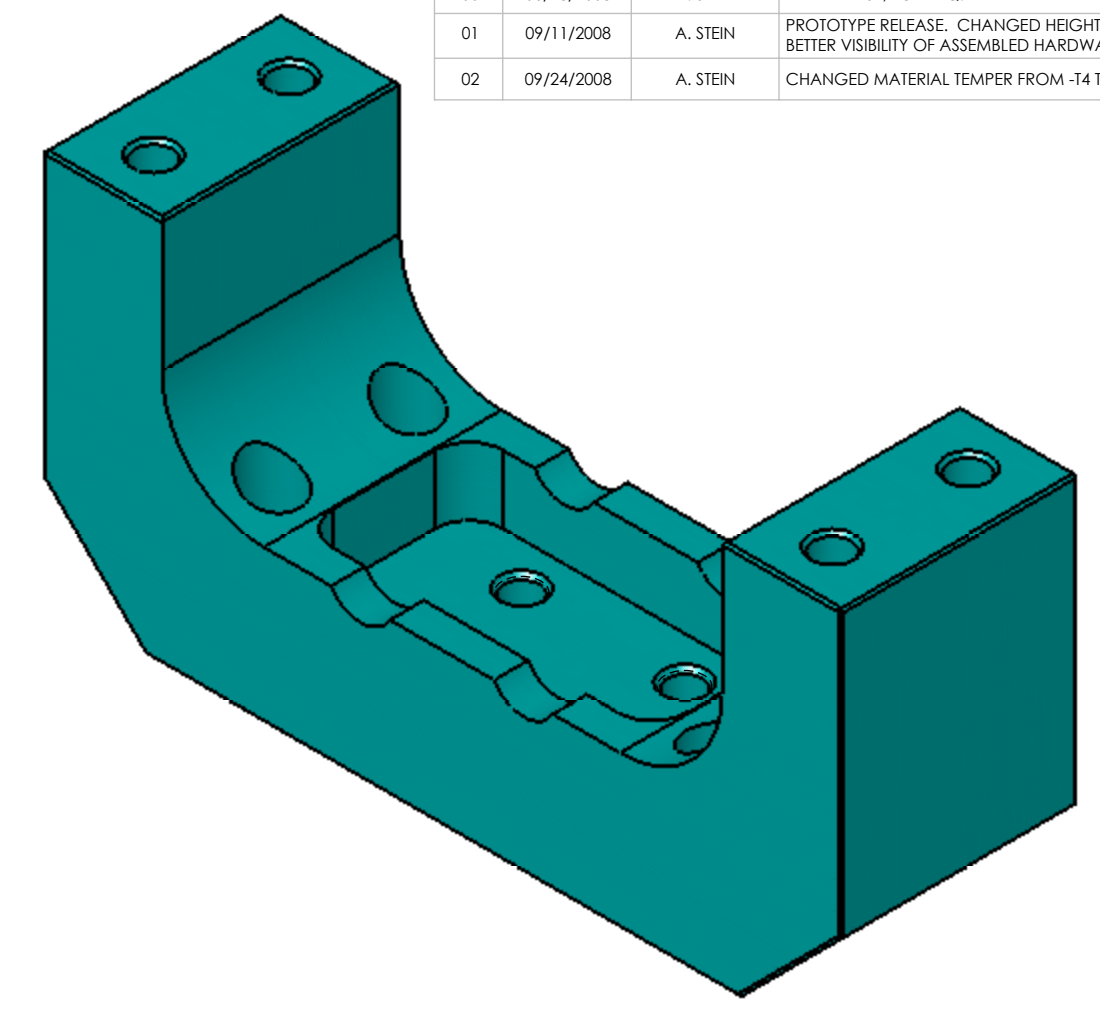


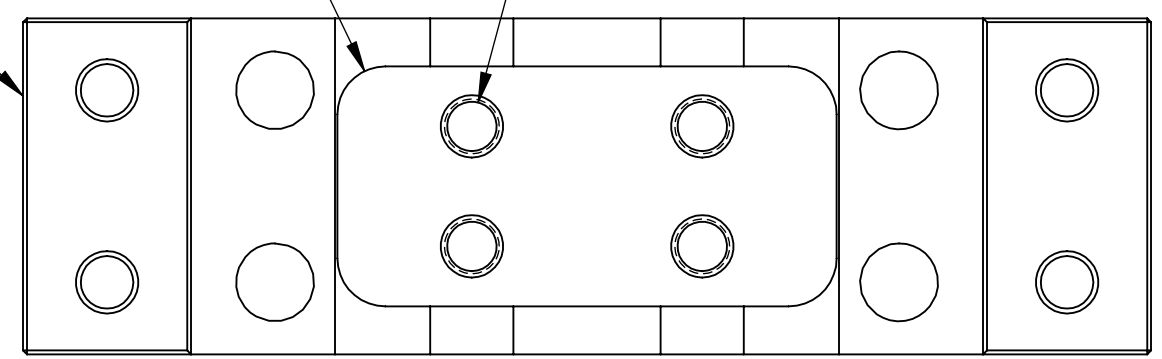
REV	DATE	APPROVAL	DESCRIPTION
00	06/18/2008	A. STEIN	PRE-RELEASE, FOR RFQ.
01	09/11/2008	A. STEIN	PROTOTYPE RELEASE. CHANGED HEIGHT. ADDED 4X NOTCHES, FOR BETTER VISIBILITY OF ASSEMBLED HARDWARE. CHANGED MATL TO 2024-T4.
02	09/24/2008	A. STEIN	CHANGED MATERIAL TEMPER FROM -T4 TO -T351. ADDED P/N NOTE.



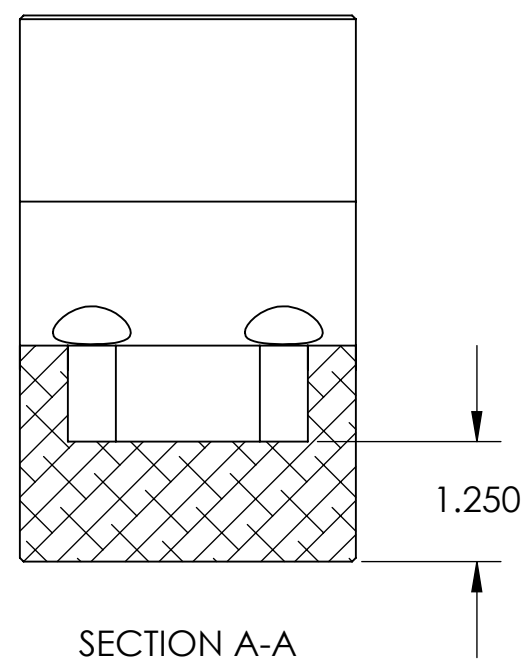
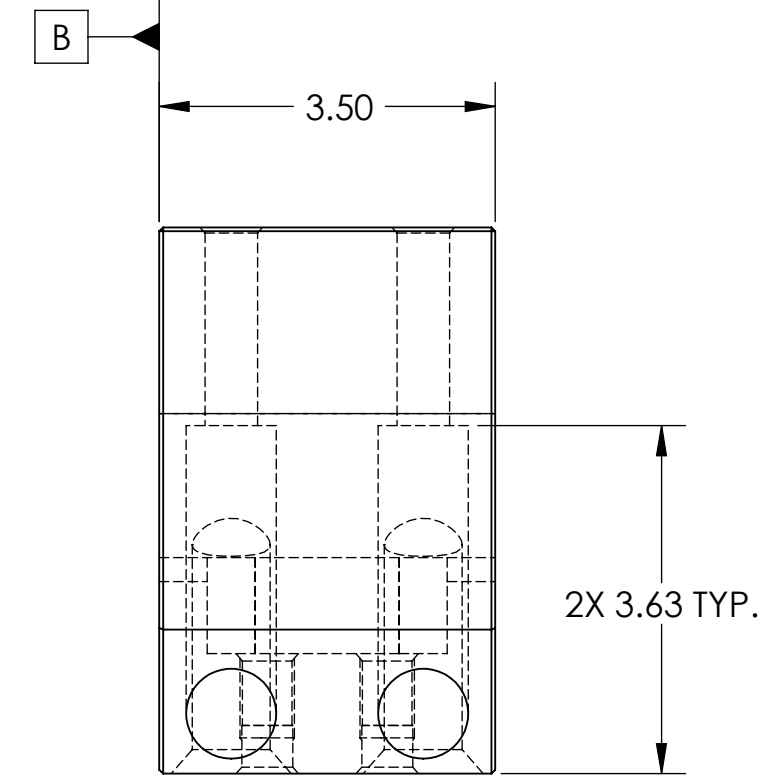
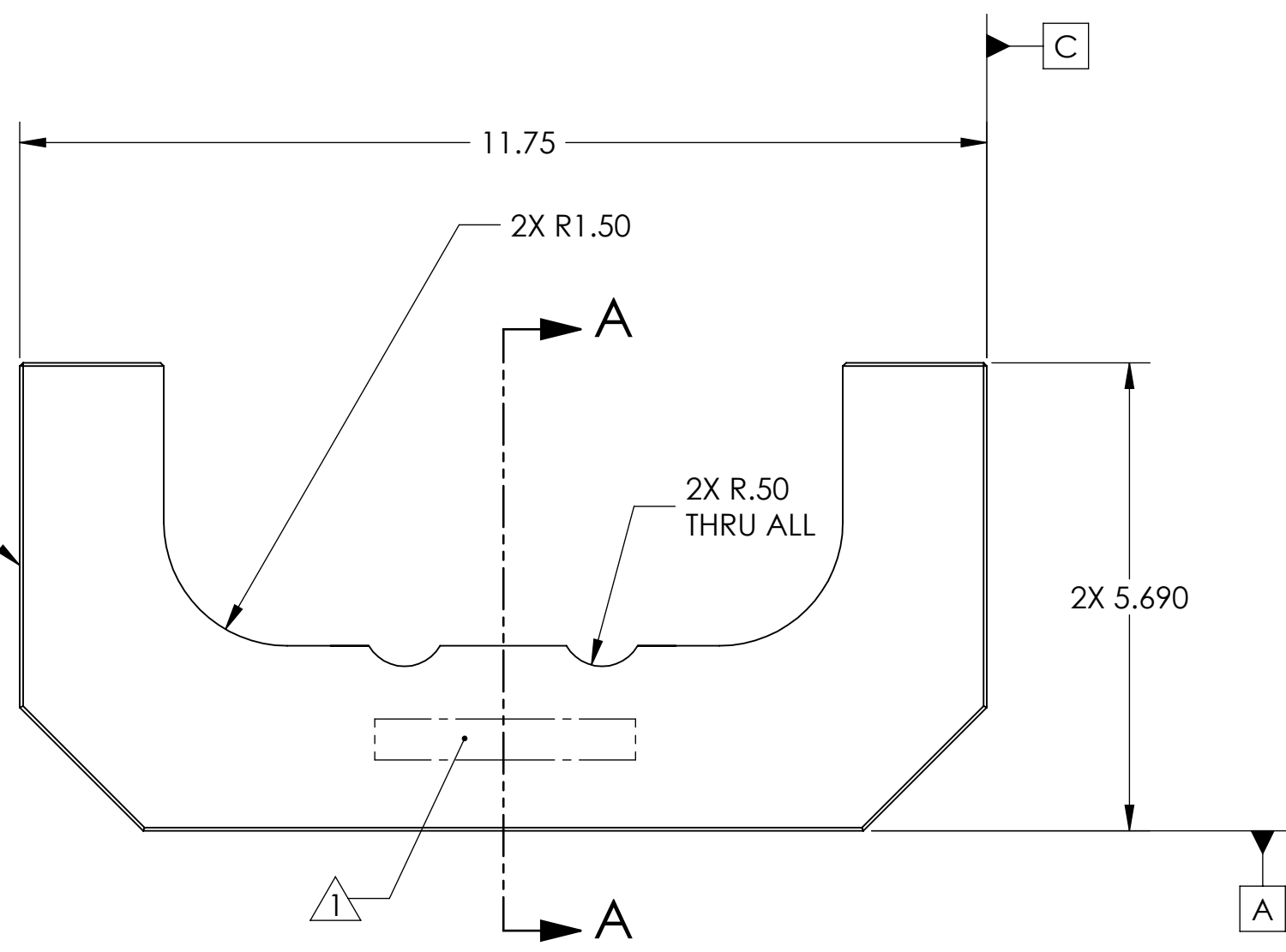
4X ϕ .516 ∇ 1.06
 ∇ ϕ .65 X 82°, NEAR SIDE
 TAP FOR 1/2-20 HELICOIL INSERT = 1.5 * DIA.
 $\oplus \phi$.015 A B C

4X R.50

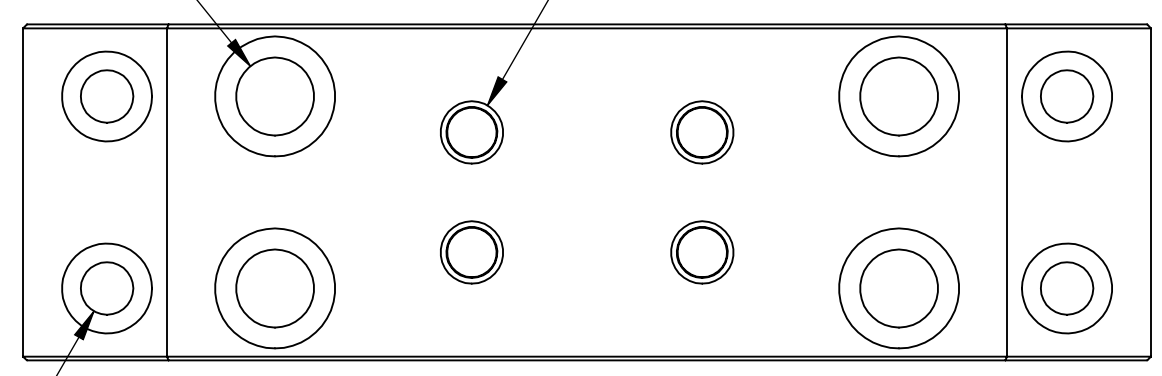
2X .04 X 45° CHAMFER ALL AROUND



2X .04 X 45° CHAMFER ALONG OUTER EDGE BOTH SIDES



4X ϕ .813 THRU ALL
 ∇ ϕ 1.25 X 82°, NEAR SIDE
 $\oplus \phi$.015 (M) A B C



4X ϕ .547 THRU ALL
 ∇ ϕ .94 ∇ DP SHOWN
 ∇ ϕ .65 X 82°, FAR SIDE
 $\oplus \phi$.010 (M) A B C

4X ϕ .531 ∇ .50
 ∇ ϕ .65 X 82°, NEAR SIDE
 $\oplus \phi$.015 A B C
 (HELI-COIL BOUNDARY AND SCREW ACCESS)

NOTES:

1) WHERE INDICATED, MECHANICALLY SCRIBE, STAMP, OR ENGRAVE THE FOLLOWING INFORMATION AS SHOWN BELOW: PART NUMBER-REVISION, FOLLOWED ON THE NEXT LINE WITH A UNIQUE 3-DIGIT SERIAL NUMBER STARTING AT 001 FOR THE FIRST PART AND INCREMENTING THEREAFTER. USE 0.12" TALL CHARACTERS UNLESS PART SIZE DICTATES SMALLER. LETTERING MUST BE VISIBLE AFTER PAINTING, IF APPLICABLE.

D080375-02
 S/N - ###

NOTES: (UNLESS OTHERWISE SPECIFIED)		DIMENSIONS ARE IN INCHES		CALIFORNIA INSTITUTE OF TECHNOLOGY LIGO MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP	
1. DO NOT SCALE FROM DRAWING.	2. REMOVE ALL SHARP EDGES. LEAVE .005 X 45° MIN CHAMFER, OR .005 MIN RADIUS.	TOLERANCES: XX ± 0.015 XXX ± 0.005	SURFACE ROUGHNESS: ✓	SYSTEM	ADVANCED LIGO
3. ALL MACHINING FLUIDS MUST BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE. E.G., MILACRON CIMATECH 410.	4. CLEAN THOROUGHLY TO REMOVE ALL OIL, DIRT, AND CHIPS.	ANGULAR ± 0.5°		SUB-SYSTEM	SEI
THIS PRINT & THE EMBEDDED CAD MODEL ARE THE DOCUMENTATION OF RECORD. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS IN THE MODEL ARE BASIC, WITH TOLERANCES GIVEN BY:		MATERIAL	ALUMINUM 2024-T351	NEXT ASSY	D080373
		FINISH	NONE	PART NAME	CLAMP CAP, HAM SUPPORT TUBE
DRAWN	A. STEIN	DATE	06/18/2008	SIZE	DWG. NO. D080375
CHECKED				REV.	02
APPROVED				SCALE: 1:2	PROJECTION: \oplus
				SHEET 1 OF 1	