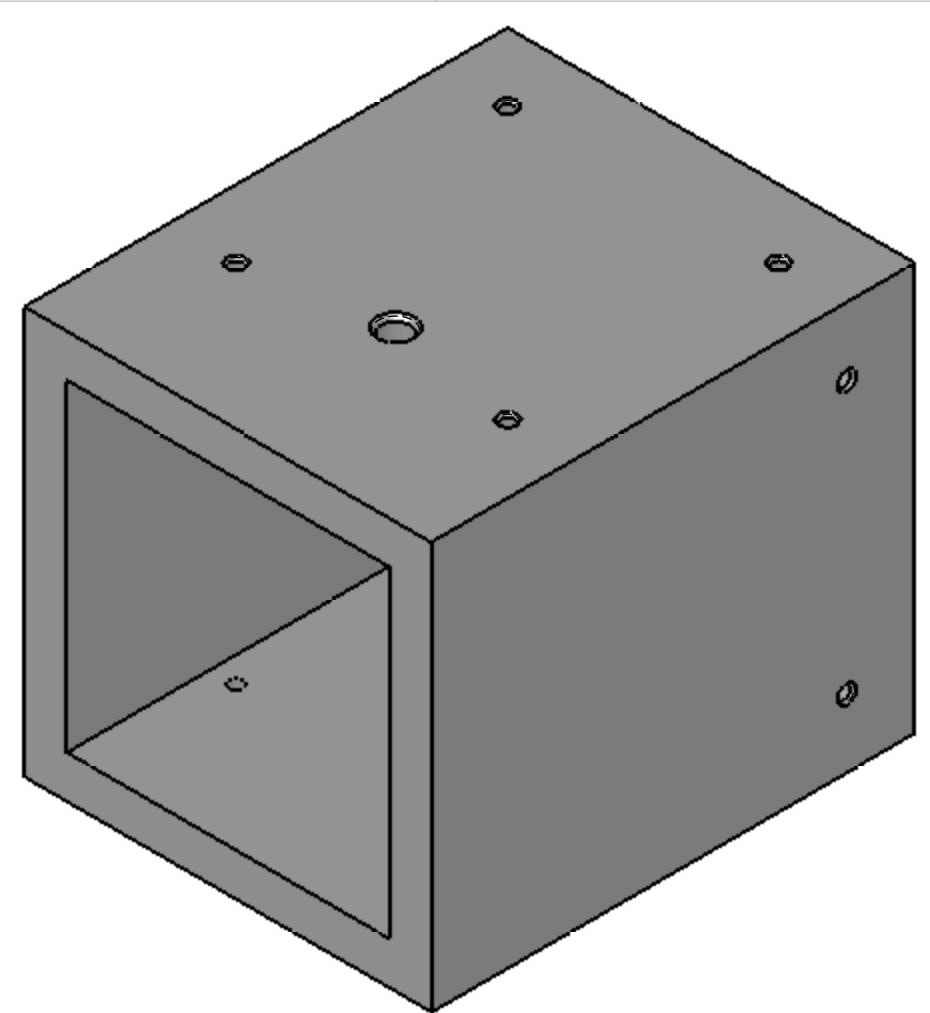
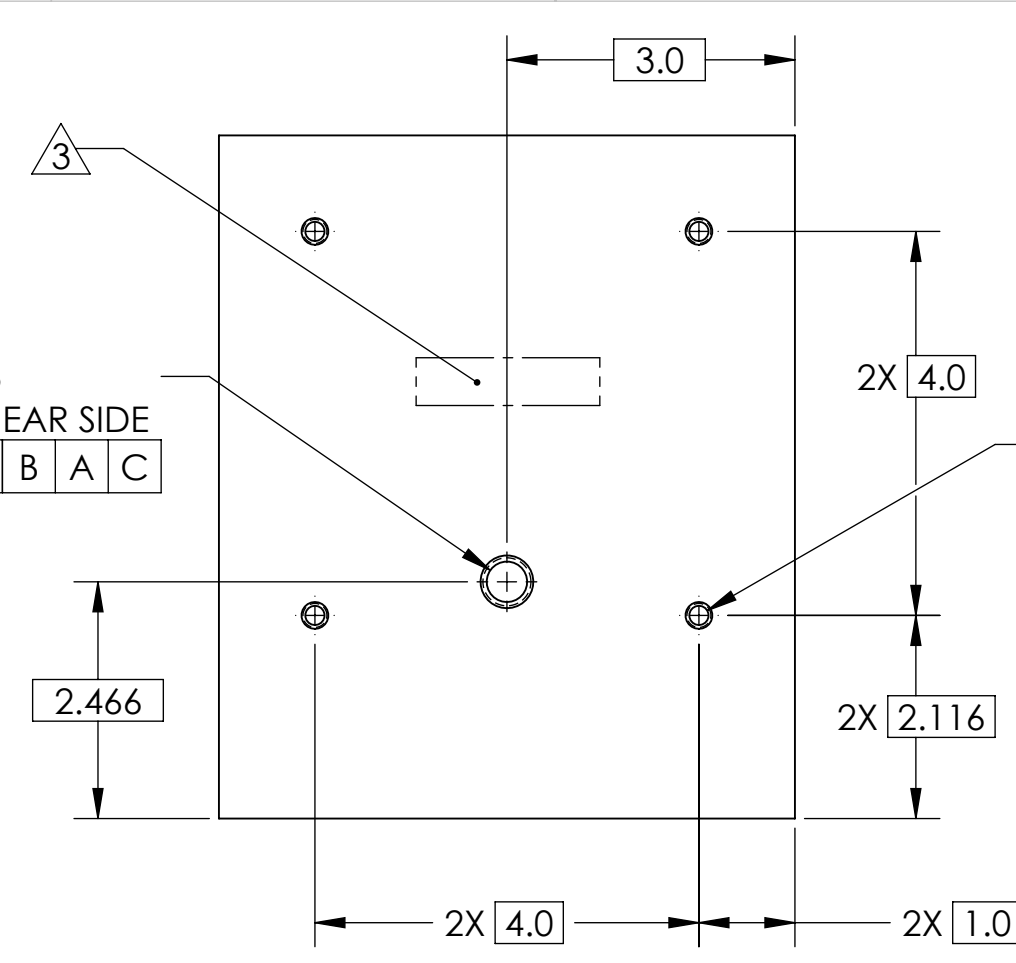


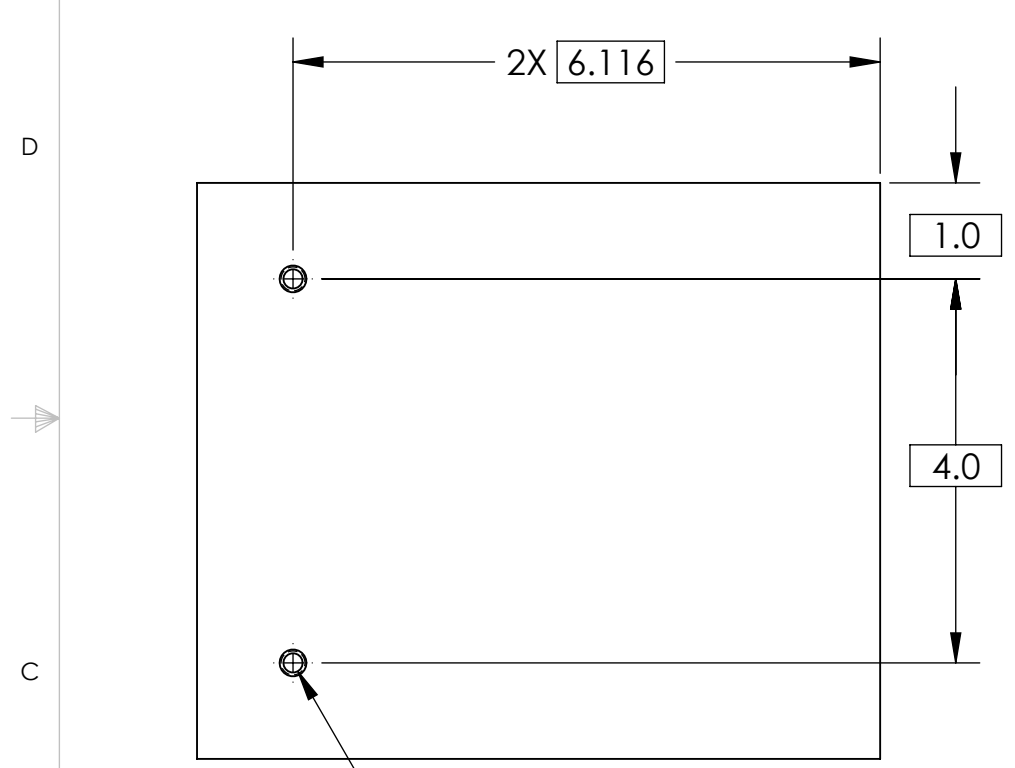
REV	DATE	APPROVAL	DESCRIPTION
00	06/18/2008	A. STEIN	PRE-RELEASE, FOR RFQ.
01	08/05/2008	A. STEIN	PROTOTYPE RELEASE. ADDED 1/2-13 HOLE.



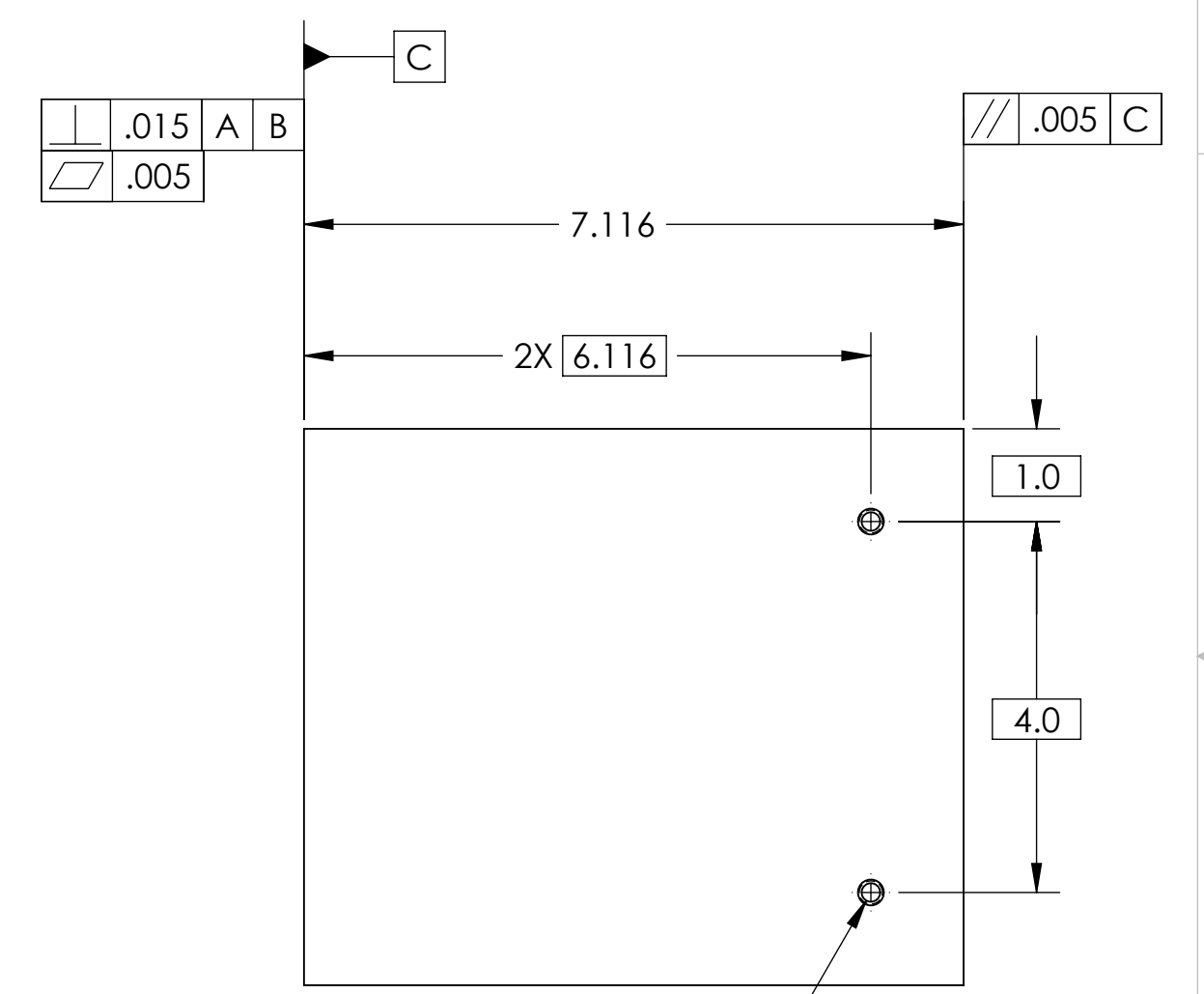
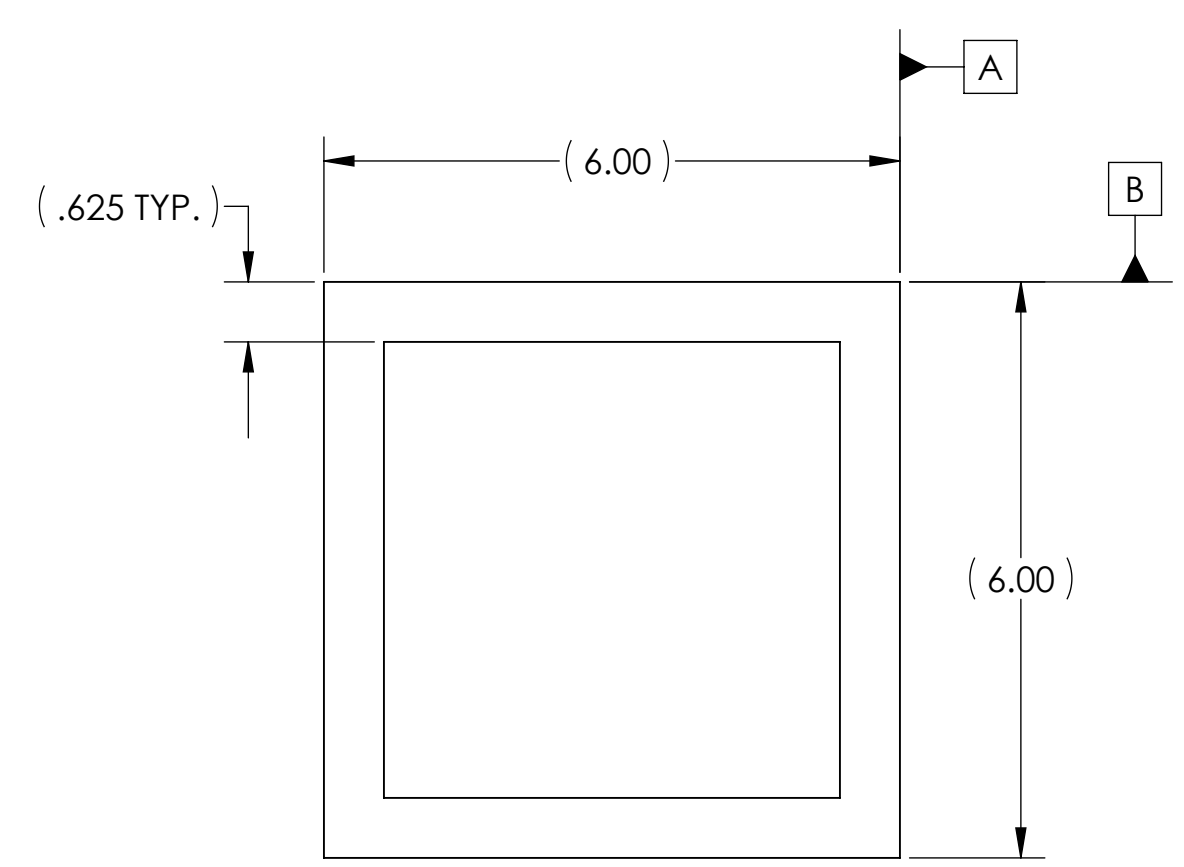
$\phi .422 \downarrow .63$
 $1/2-13 \text{ UNC } \downarrow .63$
 $\checkmark \phi .55 \times 82^\circ, \text{ NEAR SIDE}$
 $\oplus \phi .10 \text{ B A C}$



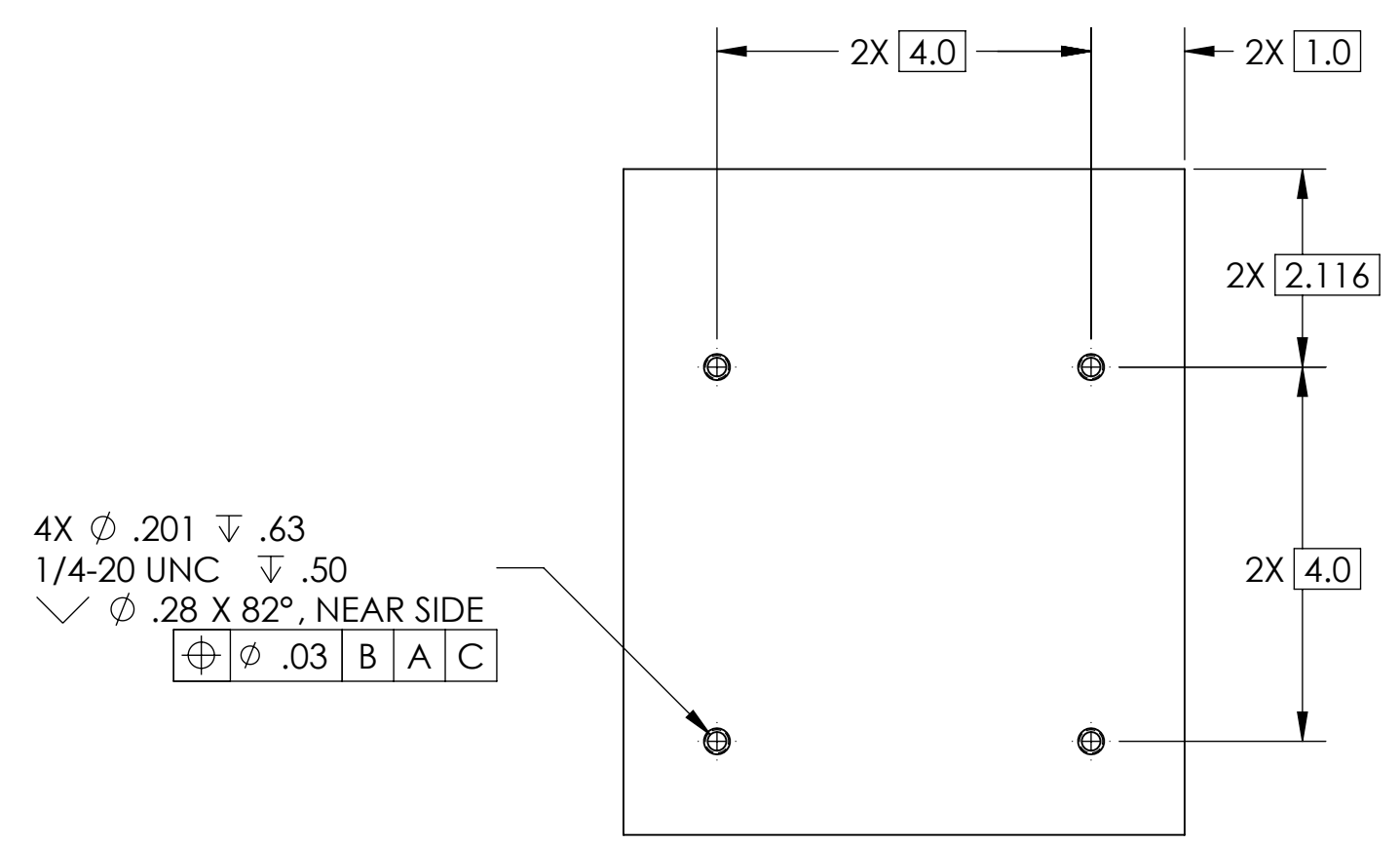
$4X \phi .201 \downarrow .63$
 $1/4-20 \text{ UNC } \downarrow .50$
 $\checkmark \phi .28 \times 82^\circ, \text{ NEAR SIDE}$
 $\oplus \phi .03 \text{ B A C}$



$2X \phi .201 \downarrow .63$
 $1/4-20 \text{ UNC } \downarrow .50$
 $\checkmark \phi .28 \times 82^\circ, \text{ NEAR SIDE}$
 $\oplus \phi .03 \text{ A B C}$



$2X \phi .201 \downarrow .63$
 $1/4-20 \text{ UNC } \downarrow .50$
 $\checkmark \phi .28 \times 82^\circ, \text{ NEAR SIDE}$
 $\oplus \phi .03 \text{ A B C}$



$4X \phi .201 \downarrow .63$
 $1/4-20 \text{ UNC } \downarrow .50$
 $\checkmark \phi .28 \times 82^\circ, \text{ NEAR SIDE}$
 $\oplus \phi .03 \text{ B A C}$

NOTES:

- 1) MAKE FROM 6"X6", 5/8"-WALL THICKNESS STRUCTURAL STEEL TUBE.
- 2) REFER TO DWG. # D080462 FOR TOLERANCES FOR WELDED STRUCTURE. WHERE REASONABLE, PIECE PART TOLERANCES MAY BE LOOSENED, PROVIDED FINAL WELDMENT CONFORMS TO D080462.
- 3) 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.

D080462-01
S/N - ###

NOTES: (UNLESS OTHERWISE SPECIFIED)		DIMENSIONS ARE IN INCHES		CALIFORNIA INSTITUTE OF TECHNOLOGY 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. 3. ALL MACHINING FLUIDS MUST BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE. E.G., MILACRON CIMTECH 410. 4. CLEAN THOROUGHLY TO REMOVE ALL OIL, DIRT, AND CHIPS.		TOLERANCES: XX ± 0.015 XXX ± 0.005	SURFACE ROUGHNESS: 63	SYSTEM ADVANCED LIGO	
SEE NOTES		ANGULAR ± 0.5°	SUB-SYSTEM SEI		
FINISH NONE		MATERIAL SEE NOTES		NEXT ASSY D080462	
DRAWN A. STEIN		NAME A. STEIN		PART NAME HAM CROSSBEAM CONNECTOR TUBE	
CHECKED		DATE 06/18/2008		SIZE DWG. NO. D080458	
APPROVED		SCALE: 1:2		PROJECTION: SHEET 1 OF 1	
		REV. 01			