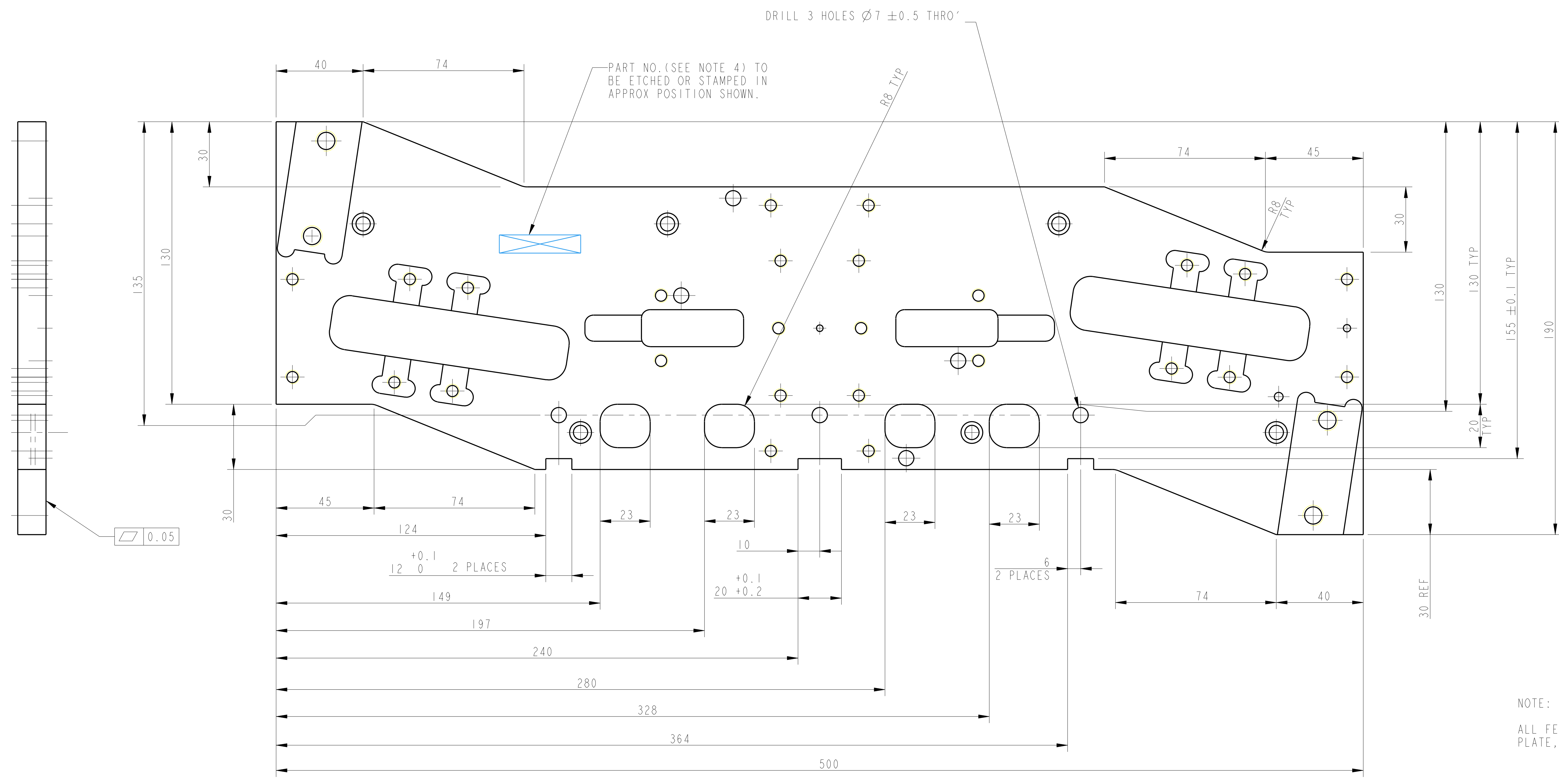
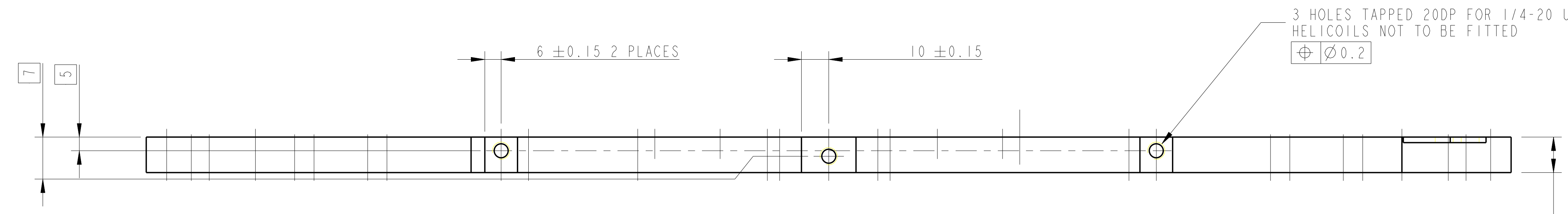


REV.	DATE	DCN #	DRAWING TREE #
A	9/OCT/06	E060248	
B	17/DEC/07	E060248-B	



NOTE:  
ALL FEATURES ARE MACHINED THRO' THE PLATE, UNLESS OTHERWISE STATED



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: 000000-001. A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN MM  
TOLERANCES:  
Ø.2  
±0.25\*

MATERIAL: AL ALLOY 5083

FINISH: CLEAN, GREASE FREE  
Ra = 1.6

DRAWN	J O'DELL	01/NOV/05
CHECKED	1W	07/DEC/05
APPROVED	1W	08/DEC/05

SCALE: 1:1 PROJECTION: SHEET 1 OF 1

CALIFORNIA INSTITUTE OF TECHNOLOGY  
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DR. GLASSON UNIVERSITY GEO 600 GROUP  
RUTHERFORD APPLETON LABORATORIES

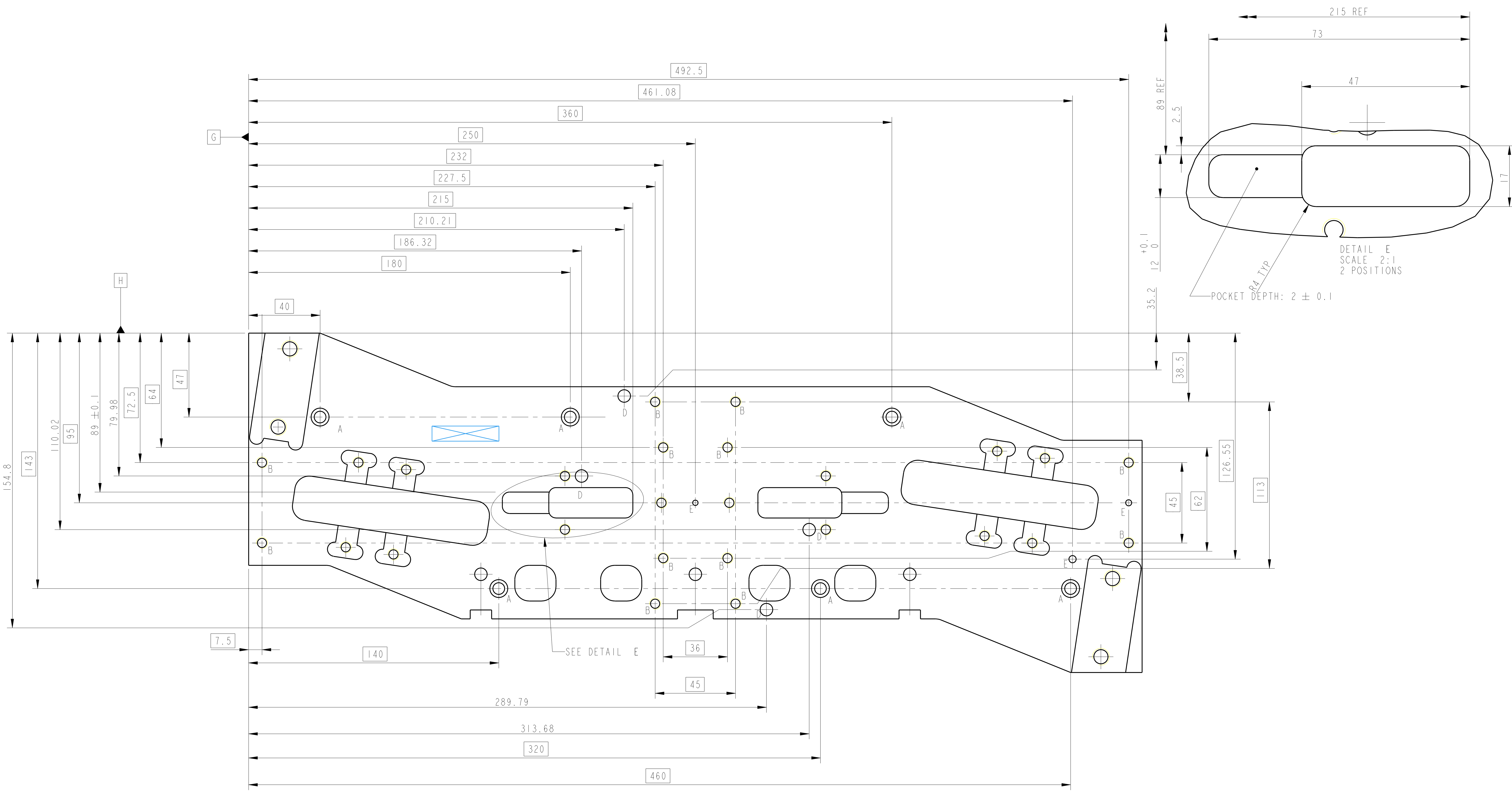
SYSTEM: **ADVANCED LIGO**

SUB-SYSTEM: **SUS**

NEXT ASSY: **TOP MASS QUAD N-P TYPE**

PART NAME: **BASE PLATE**

DRG. NO.: **D060430**



NOTE:

HOLES MARKED A: 6 HOLES, 1/4-20 UNC CLEARANCE HOLES (Ø6.5) AND C-BORED Ø10 X 7 DP

⊕ Ø0.2 | G H

HOLES MARKED B: 12 HOLES, TAPPED THRO' FOR 1/4-20 UNC, TAP 0.005" OVERSIZE

⊕ Ø0.2 | G H

HOLES MARKED D: 4 HOLES Ø7 X 4.5 DP FLAT BOTTOM

⊕ Ø0.1 | G H

HOLES MARKED E: BORE 3 HOLES Ø4 X 3DP

NOTES: (UNLESS OTHERWISE SPECIFIED)

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- 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: 000000-001. A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN MM  
TOLERANCES:  
0.2  
±0.25\*

MATERIAL: AL ALLOY 5083

FINISH: CLEAN, GREASE FREE  
Ra = 1.6

NAME	DATE
DRAWN J. O'BELL	01/NOV/05
CHECKED J.W.	07/DEC/05
APPROVED J.W.	08/DEC/05

SCALE 1:11 PROJECTION

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DR. GLASSON UNIVERSITY GEO. BOO GROUP  
RUTHERFORD APPLETON LABORATORIES

SYSTEM: **ADVANCED LIGO**

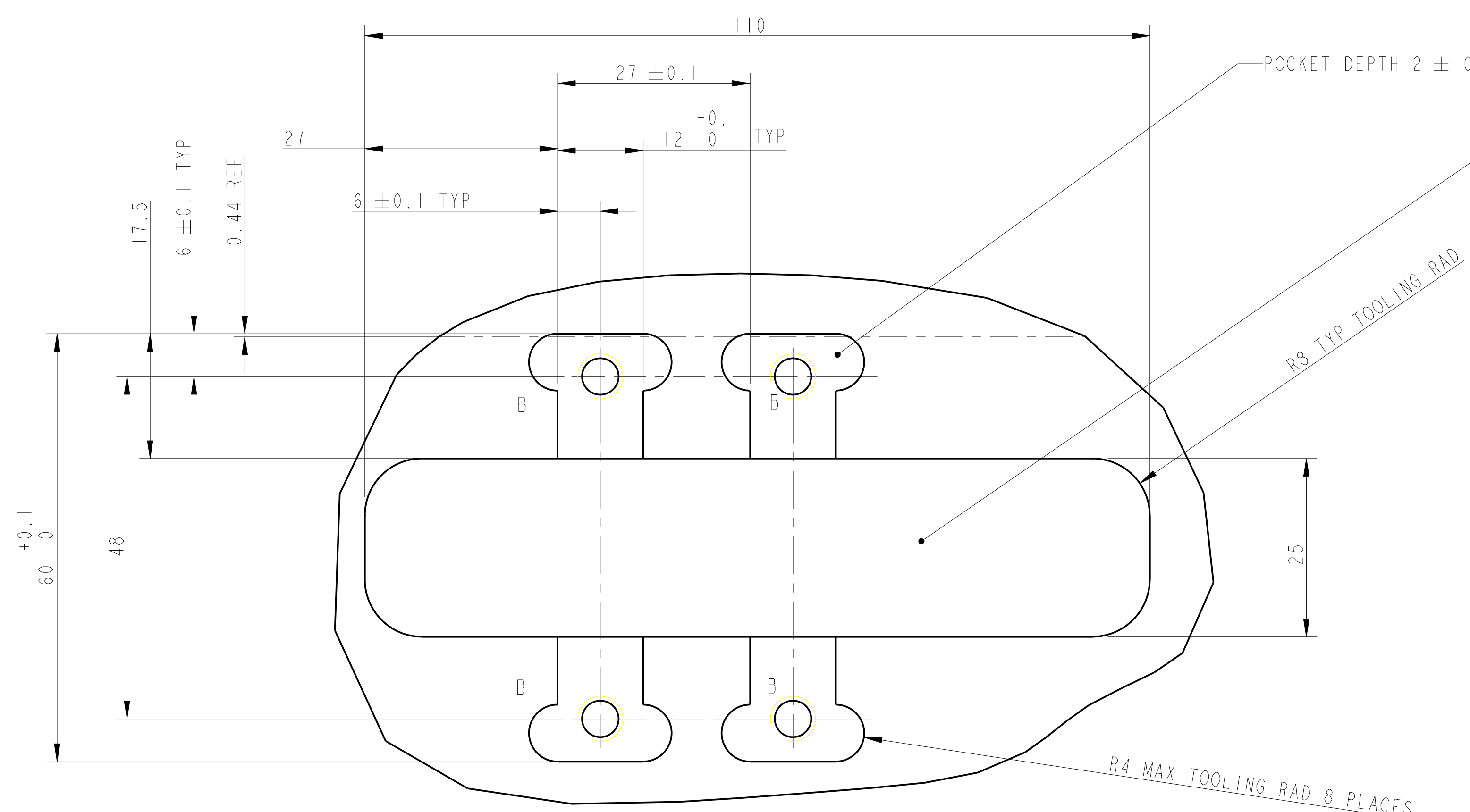
SUB-SYSTEM: **SUS**

NEXT ASSY: **TOP MASS QUAD INP TYPE**

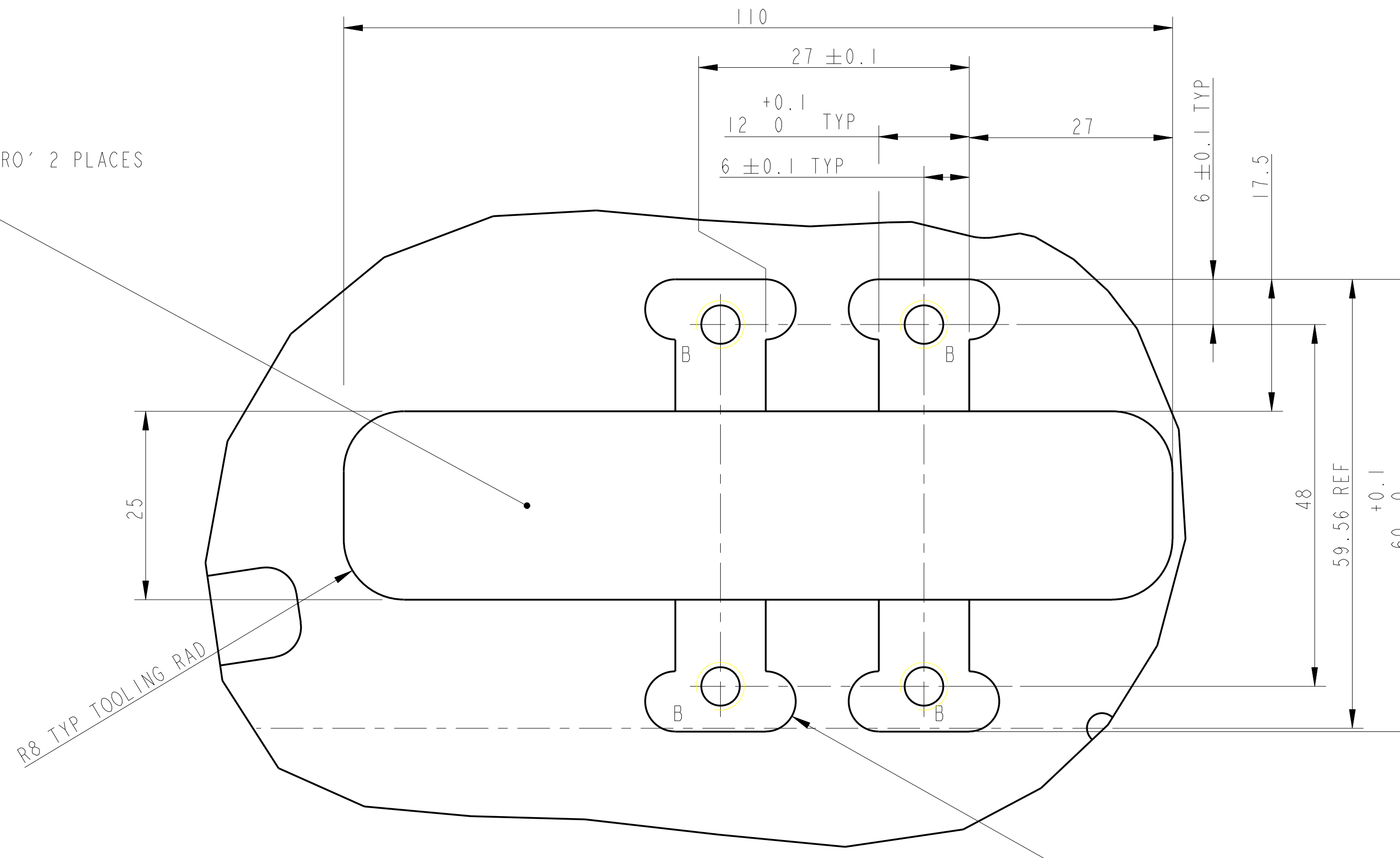
PART NAME: **BASE PLATE**

DRG. NO.: **D060430**

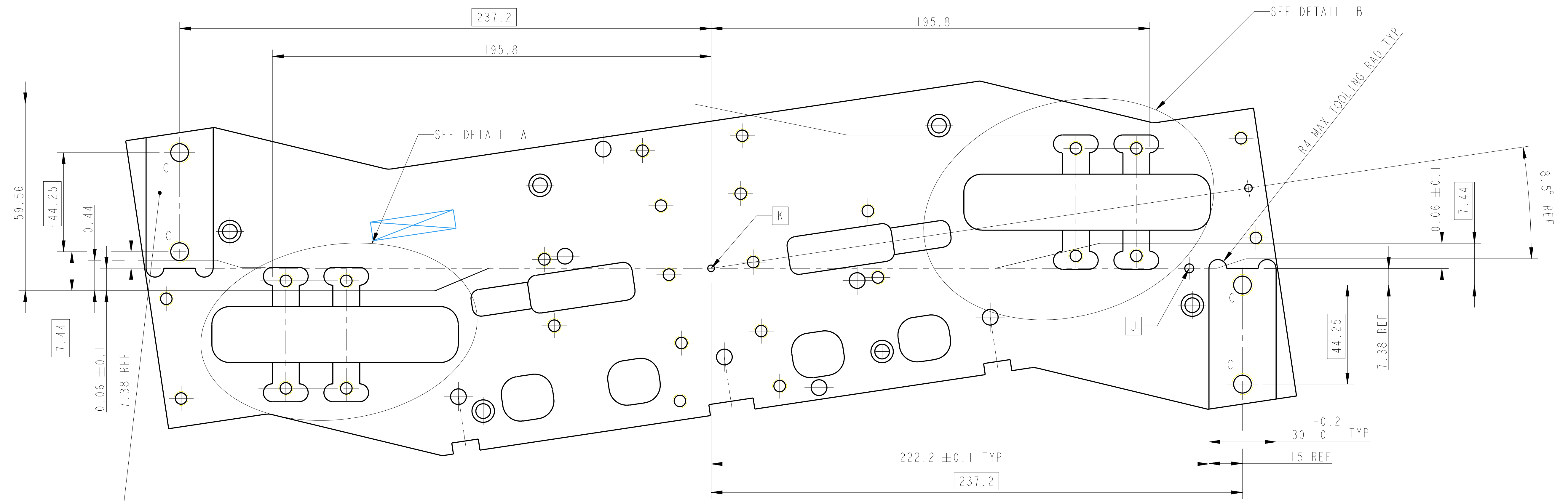
SHEET 2 OF 01



DETAIL A  
SCALE 2:1



DETAIL B  
SCALE 2:1

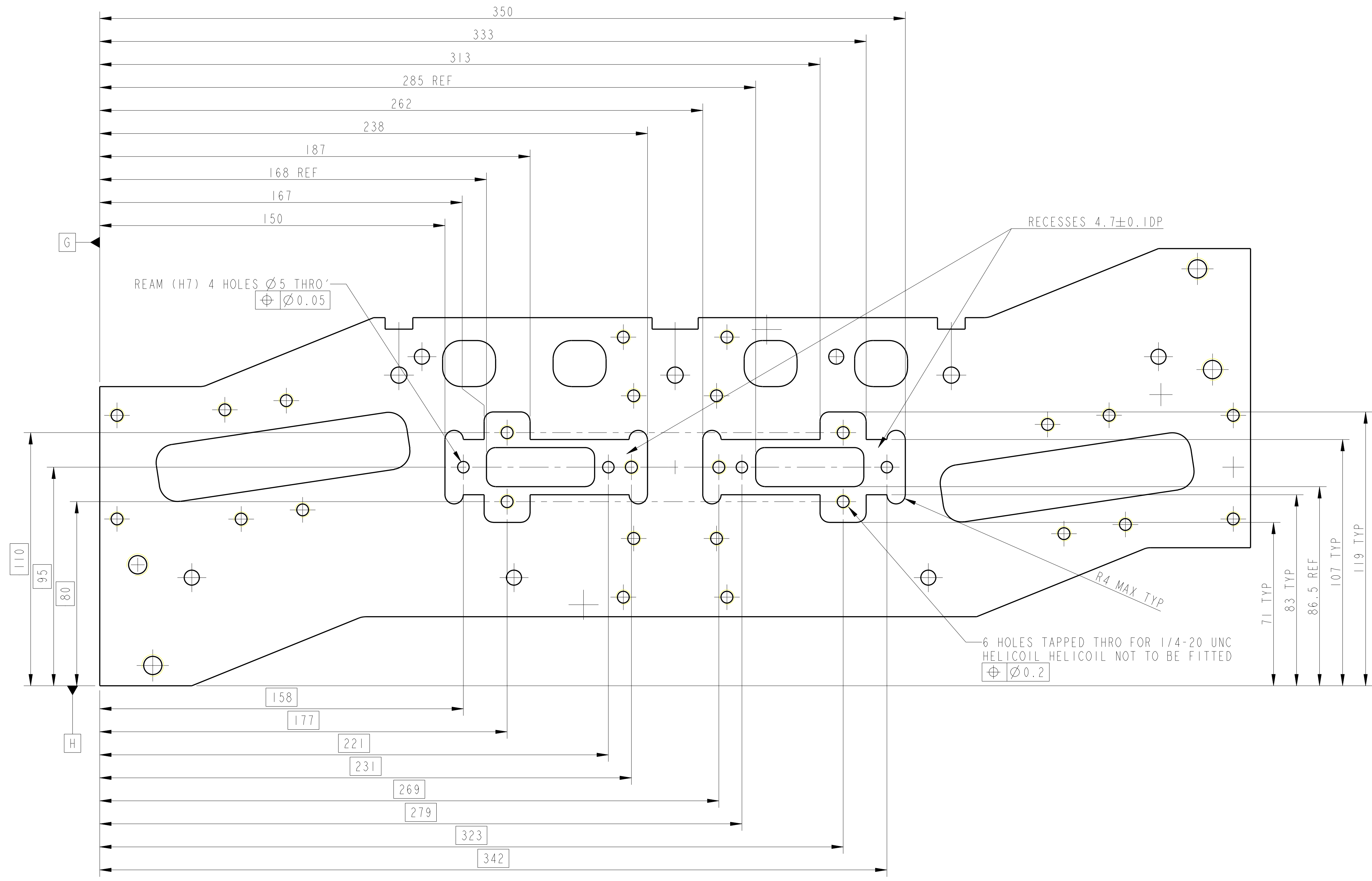


NOTE:  
HOLES MARKED B: 8 HOLES, TAPPED FOR 1/4-20 UNC 0.005" OVERSIZE, TAP THRO'  
HOLES MARKED C: 4 HOLES, TAPPED THRO' FOR 3/8-16 UNC HELICOIL, HELICOIL NOT TO BE FITTED

⊕ ∅0.15 [K] [J]

RECESS DEPTH 2 ± 0.1  
2 PLACES

NOTES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY	
1. REMOVE ALL SHARP EDGES.	2. DO NOT SCALE FROM DRAWING.	3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE.	4. SCRIBES, ENGRAVS 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.
5. USE 07° HIGH CHARACTERS. EXAMPLE: 000000-001. A VIBRATORY TOOL MAY BE USED.			
DIMENSIONS ARE IN MM TOLERANCES:		MATERIAL: AL ALLOY 5083	
±0.25 °		FINISH: CLEAN, GREASE FREE Ra = 1.6	
SYSTEM: ADVANCED LIGO		SUB-SYSTEM: SUS	
NEXT ASSY: TOP MASS QUAD INP TYPE		PART NAME: BASE PLATE	
DRAWN: J O'BELL 01/NOV/05	CHECKED: J W 07/DEC/05	APPROVED: J W 08/DEC/05	SCALE: 1:1 PROJECTION: 4 SHEET 3 OF 3



VIEW SHOWING FEATURES ON UNDERSIDE OF PLATE

NOTES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY	
1. REMOVE ALL SHARP EDGES. R.02 MIN.		MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
2. DO NOT SCALE FROM DRAWING.		DR. GLASSON UNIVERSITY GEO 600 GROUP	
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE. SUCH AS CINCINNATI MILCORP'S CIMTECH 410 (STAINLESS STEEL)		RUTHERFORD APPLETON LABORATORIES	
4. 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.		SYSTEM <b>ADVANCED LIGO</b>	
USE 07* HIGH CHARACTERS. EXAMPLE: 000000-001 - A VIBRATORY TOOL MAY BE USED.		SUB-SYSTEM <b>SUS</b>	
DIMENSIONS ARE IN mm (INCHES)		NEXT ASSY <b>QUAD N-TYPE TOP MASS</b>	
TOLERANCES:		PART NAME <b>BASE PLATE</b>	
X, Y, Z ±0.2 (1)		FINISH: CLEAN, GREASE FREE	
ANGULAR ±0.25°		Ra = 1.6	
MATERIAL: AL ALLOY 5083		NAME: DATE:	
DRAWN: J. O'BELL 20/01/06		DRG. NO. <b>D060430</b>	
CHECKED: IW 07/DEC/05		APPROVED: IW 08/DEC/05	
APPROVED: IW 08/DEC/05		SCALE: 1:11 PROJECTION:  SHEET: 4 OF 4	