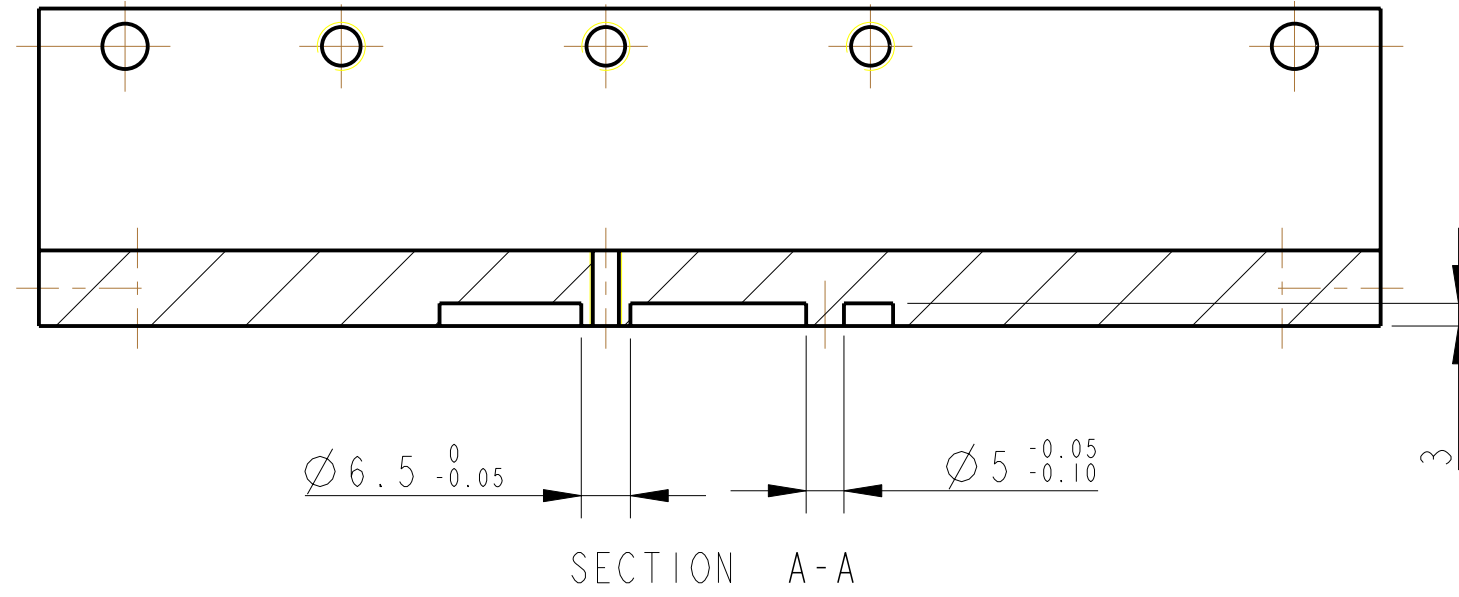


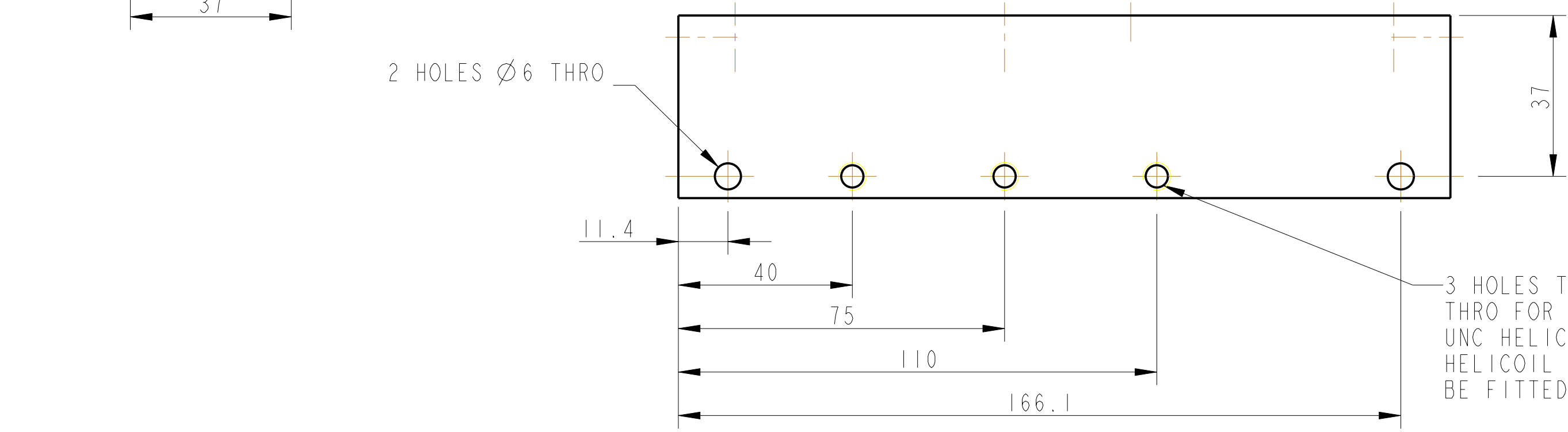
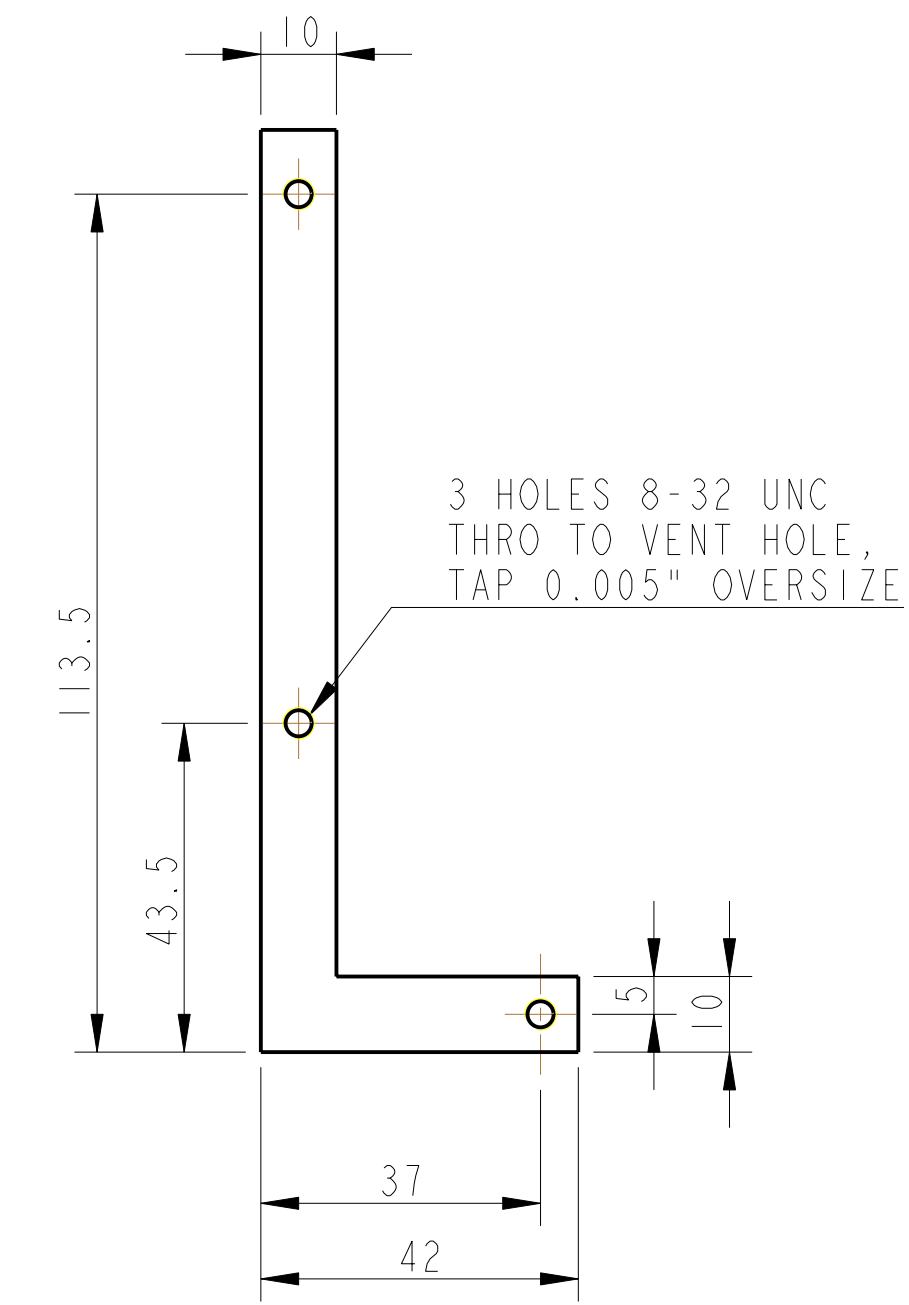
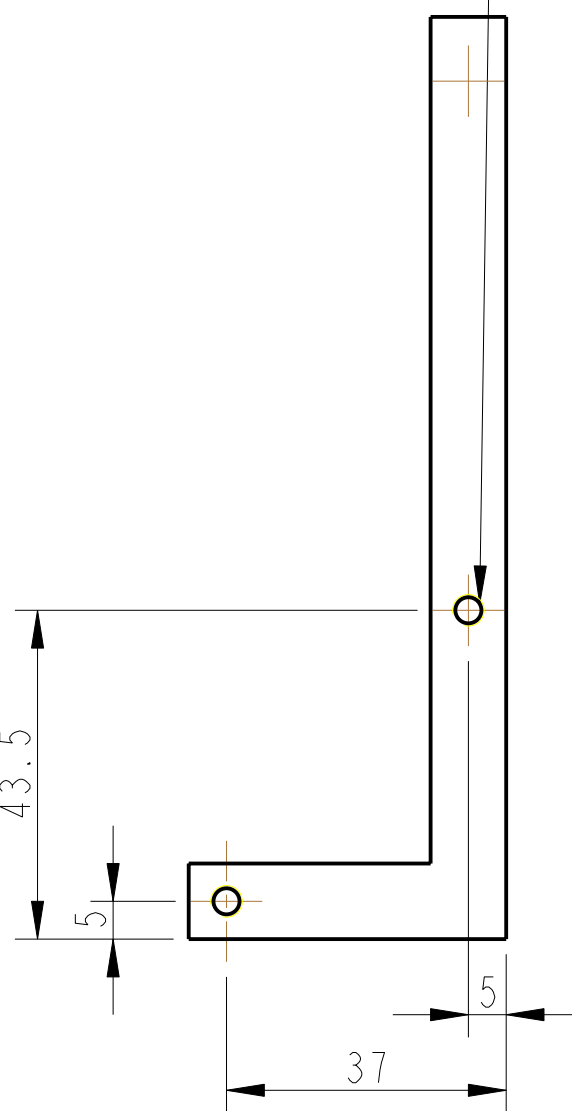
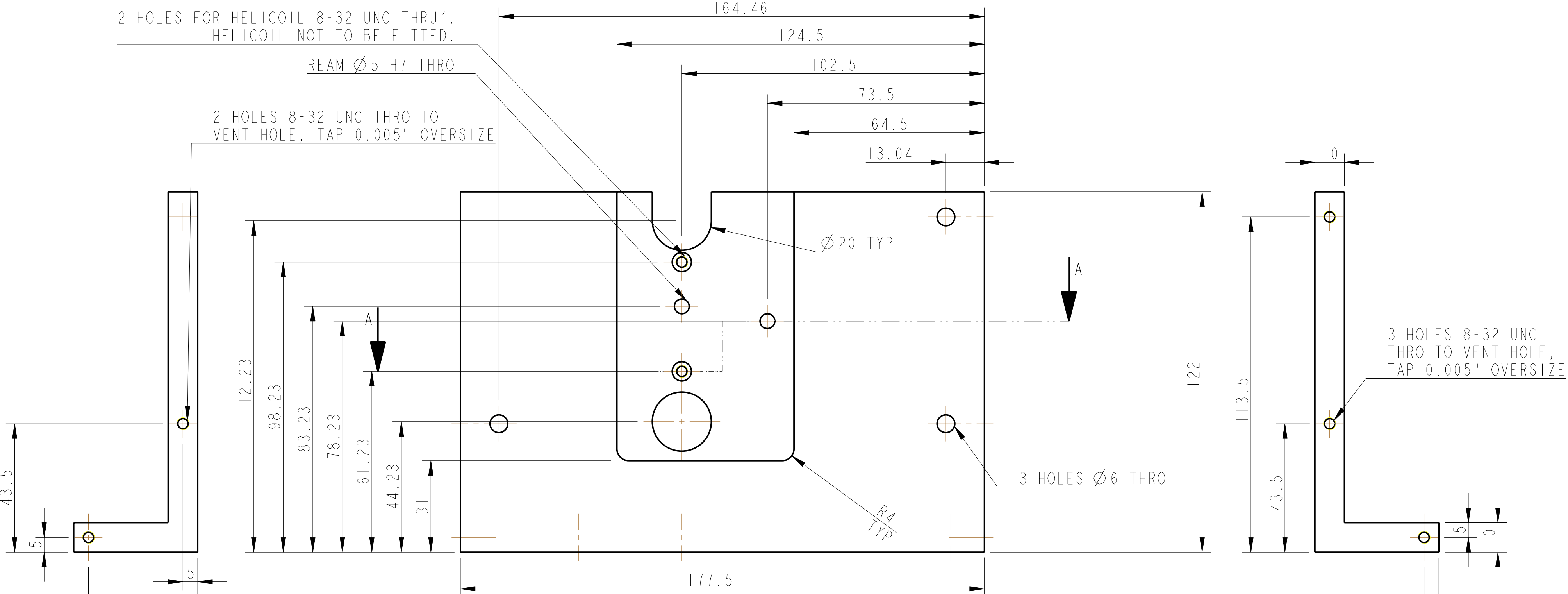
REV.	DATE	DCN #	DRAWING TREE #
B	21/DEC/07	E060260-B	
C	22/JULY/08	E080372	



2 HOLES FOR HELICOIL 8-32 UNC THRU',
HELICOIL NOT TO BE FITTED.

REAM $\varnothing 5$ H7 THRO

2 HOLES 8-32 UNC THRO TO
VENT HOLE, TAP 0.005" OVERSIZE



2 HOLES $\varnothing 6$ THRO

3 HOLES TAPPED THRO FOR 1/4-20 UNC HELICOIL, HELICOIL NOT TO BE FITTED

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 ± 0.2 mm
ANGULAR $\pm 0.25^\circ$

MATERIAL: AL ALLOY 6061

FINISH: CLEAN AND DEGREASED
 $\sqrt{\mu m}$ (min) Ra = 1.6

NAME	DATE
DRAWN I WILMUT	29/NOV/07
CHECKED MB	15/MAR/10
APPROVED JOD	15/MAR/10

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

SYSTEM **aLIGO**

SUB-SYSTEM **SUS**

NEXT ASSY **D060454**

PART NAME **TEST CHAIN UIM STOP**

DRG. NO. **D070545**

SCALE 1:1 PROJECTION