

NOTES: (UNLESS OTHERWISE SPECIFIED)

- REMOVE ALL SHARP EDGES.
R0.2 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
CMTTECH 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: 000100-001 - A VIBRATORY
TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X XX ± 0.2
ANGULAR ±0.25 °

MATERIAL: AL ALLOY
6061 OR SIMILAR

FINISH: CLEAN, GREASE FREE
√(µm) Ra = 1.6

NAME	DATE	BY
DRAWN	REVISED	DEC 2007
CHECKED	J'00	JAN 2008
APPROVED	TW	JAN 2008

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
OPR. - GLASSBORO UNIVERSITY GEG RES GROUP
RUTHERFORD APPLIION LABORATORIES

SYSTEM: **ADVANCED LIGO**

SUB-SYSTEM: **SUS**

NEXT ASSY: **DOB0005**

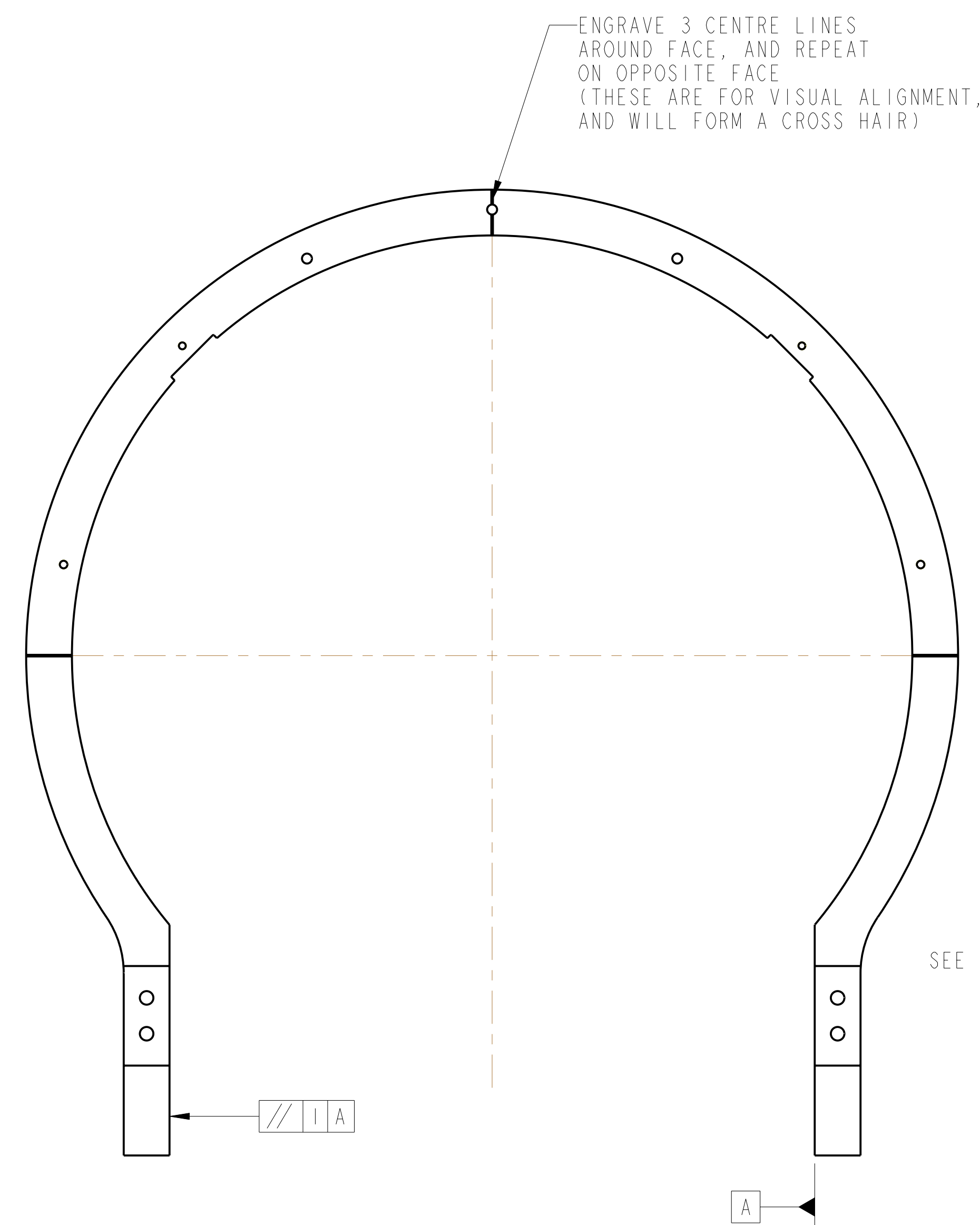
PART NAME: **BS LOWER STRUCTURE**

BS LS BOTTOM HALF

DRG. NO.: **DOB0006**

SCALE: 1:1 PROJECTION: **E**

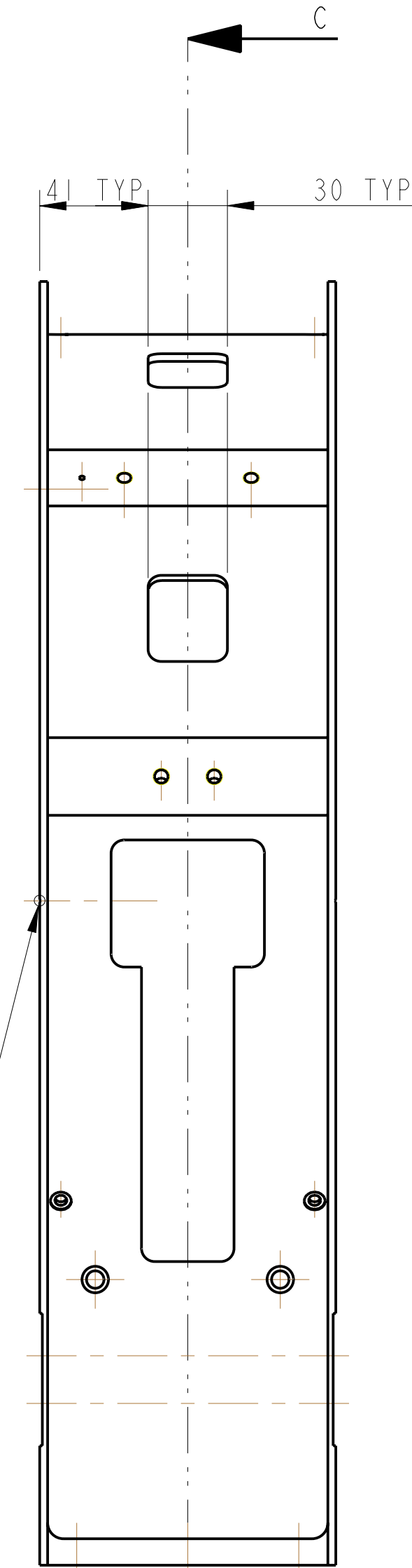
SHEET 1 OF 2



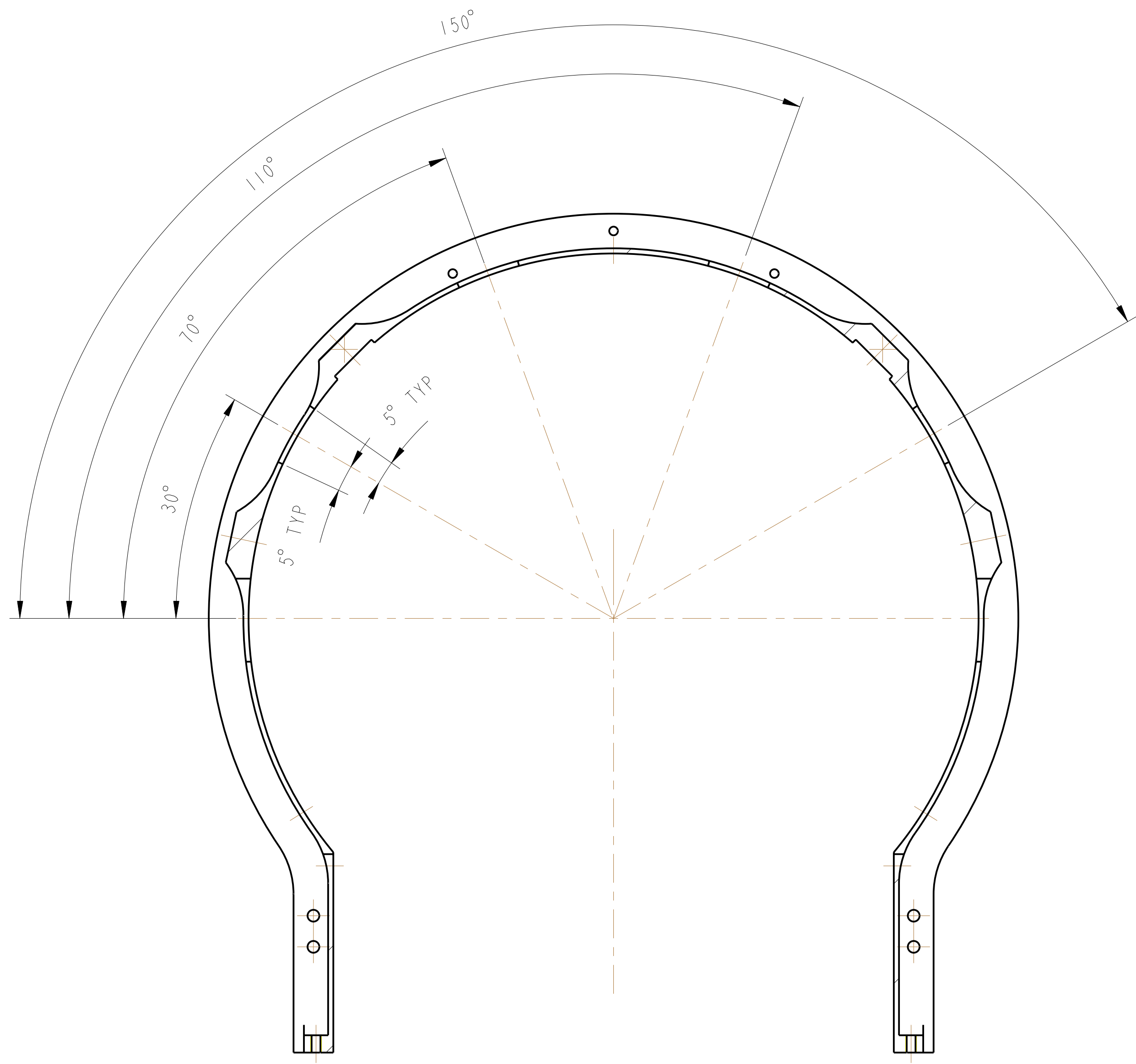
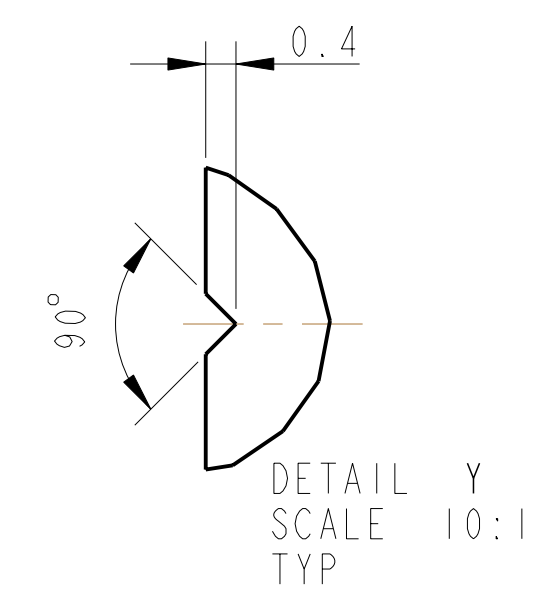
ENGRAVE 3 CENTRE LINES
AROUND FACE, AND REPEAT
ON OPPOSITE FACE
(THESE ARE FOR VISUAL ALIGNMENT,
AND WILL FORM A CROSS HAIR)

/// I A

A



SEE DETAIL Y



SECTION C-C

NOTES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY	
1. REMOVE ALL SHARP EDGES. R.02 MIN.	DIMENSIONS ARE IN mm (INCHES)	MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
2. DO NOT SCALE FROM DRAWING.	TOLERANCES:	RUTHERFORD APPLINGTON LABORATORIES	
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SODIUM, CHLORINE AND SILICONE. SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).	ANGULAR ±0.25 °	SYSTEM	ADVANCED LIGO
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. USE 07" HIGH CHARACTERS. EXAMPLE: D080006-001 - A VIBRATORY TOOL MAY BE USED.	MATERIAL: AL ALLOY 6061 OR SIMILAR	SUB-SYSTEM	SUS
	FINISH: CLEAN, GREASE FREE √um (µin) Ra = 1.6	NEXT ASSY	THIS
	DRAWN: J'00	PART NAME	BS LOWER STRUCTURE
	CHECKED: J'00	DRG. NO.	D080006
	APPROVED: TW	SCALE	1:21 PROJECTION
			SHEET 2 OF 2