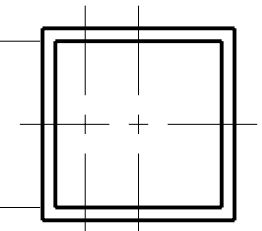


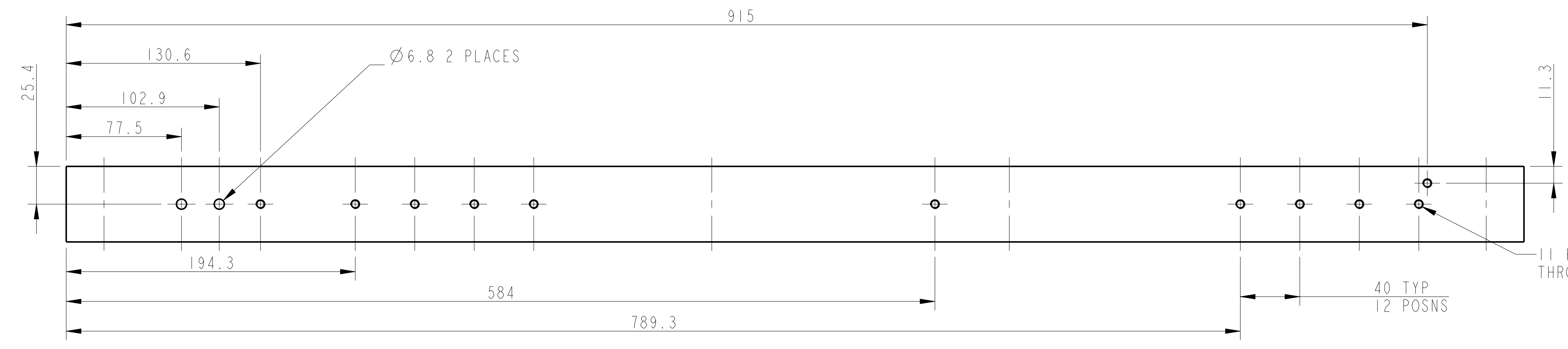
12 HOLES DRILL & TAP 1/4-20 UNC .005" OVERSIZE THRO' BOTH WALLS

44 ±0.2 SQ STOCK TYP
IF STOCK NOT WITHIN TOLERANCE MACHINE OUT X 6 DP R5 MAX TOOLING RAD AT EACH END



50.8 SQ STOCK

NOTE:
ENDS MUST BE SQUARE
(SEE ANGULAR TOLERANCE)



11 HOLES DRILL & TAP 1/4-20 UNC .005" OVERSIZE THRO' BOTH WALLS

40 TYP
12 POSNS

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 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 VIBRATOR TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES) TOLERANCES:
X.XX ±0.3 (1")
ANGULAR ±0.1°

MATERIAL: AL ALLOY 5083 OR SIMILAR
FINISH: CLEAN AND DEGREASED
√_{um} (1μin) Ra = 1.6 OR STOCK

NAME	DATE
DRAWN J. O'BELL	29/OCT/09
CHECKED J. O'D	29/OCT/09
APPROVED JOD	29/OCT/09

SCALE 1:21 PROJECTION

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
OP. GLASGOW UNIVERSITY GEC ROX GROUP
RUTHERFORD APPLETON LABORATORIES

SYSTEM aLIGO
SUB-SYSTEM SUS
NEXT ASSY QUAD TOOLING
PART NAME LEG
(LOWER STRUCTURE TOOLING)

DRG. NO. 0060303
SHEET 1 OF 1