



ITEM	QTY	SPARE	TOTAL	PART NUMBER	DESCRIPTION	MATERIALS
1	2			D049298	CAPTURE AND UNION PLATE; (LOWER STRUCTURE TOOLING)	AL ALLOY; 5083
2	8			D049301	LONG BARREL NUT; (LOWER STRUCTURE TOOLING)	ST STEEL; 300 SERIES
3	1			D1001498	TOP PLATE; LSST MAIN CHAIN	AL ALLOY; 5083 OR SIMILAR
4	1			D1001499	TOP PLATE; LSST MAIN CHAIN	AL ALLOY; 5083 OR SIMILAR
5	4			D1001500	LEG; (LOWER STRUCTURE TOOLING)	AL ALLOY; 5083 OR SIMILAR
6	4				1/4" 20 UNC X 1" CAP HEAD; .	
7	8				1/4" 20 UNC X 2" CAP HEAD; .	

  

PARTS LIST		MATERIALS	
1	2		
2	8		
3	1		
4	1		
5	4		
6	4		
7	8		

  

NOTES: (UNLESS OTHERWISE SPECIFIED)

- REMOVE ALL SHARP EDGES. R: 0.25 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).
- SCORE, 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: D001000-001 - A VIBRATOR TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES) TOLERANCES:

XX.XX ±.01A (1) ANGULAR ±.01A \*

MATERIAL: AS DRW

FINISH: AS DRW

√um (1μm) Ra: . . . . .

NAME	DATE	SIZE
DRAWN J. O'DELL	08/JUN/10	STD
CHECKED J. O'D	08/JUN/10	
APPROVED JOD	08/JUN/10	

SCALE: 3:16 PROJECTION:

CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY  
 GLASGOW UNIVERSITY GEO ROSS GROUP  
 RUTHERFORD APPLETON LABORATORIES

SYSTEM: aLIGO  
 SUB-SYSTEM: SUS  
 NEXT ASSY: QUAD TOOLING  
 PART NAME: LSST MAIN CHAIN  
 LSST

DRG. NO. D1001497  
 SHEET 1 OF 1