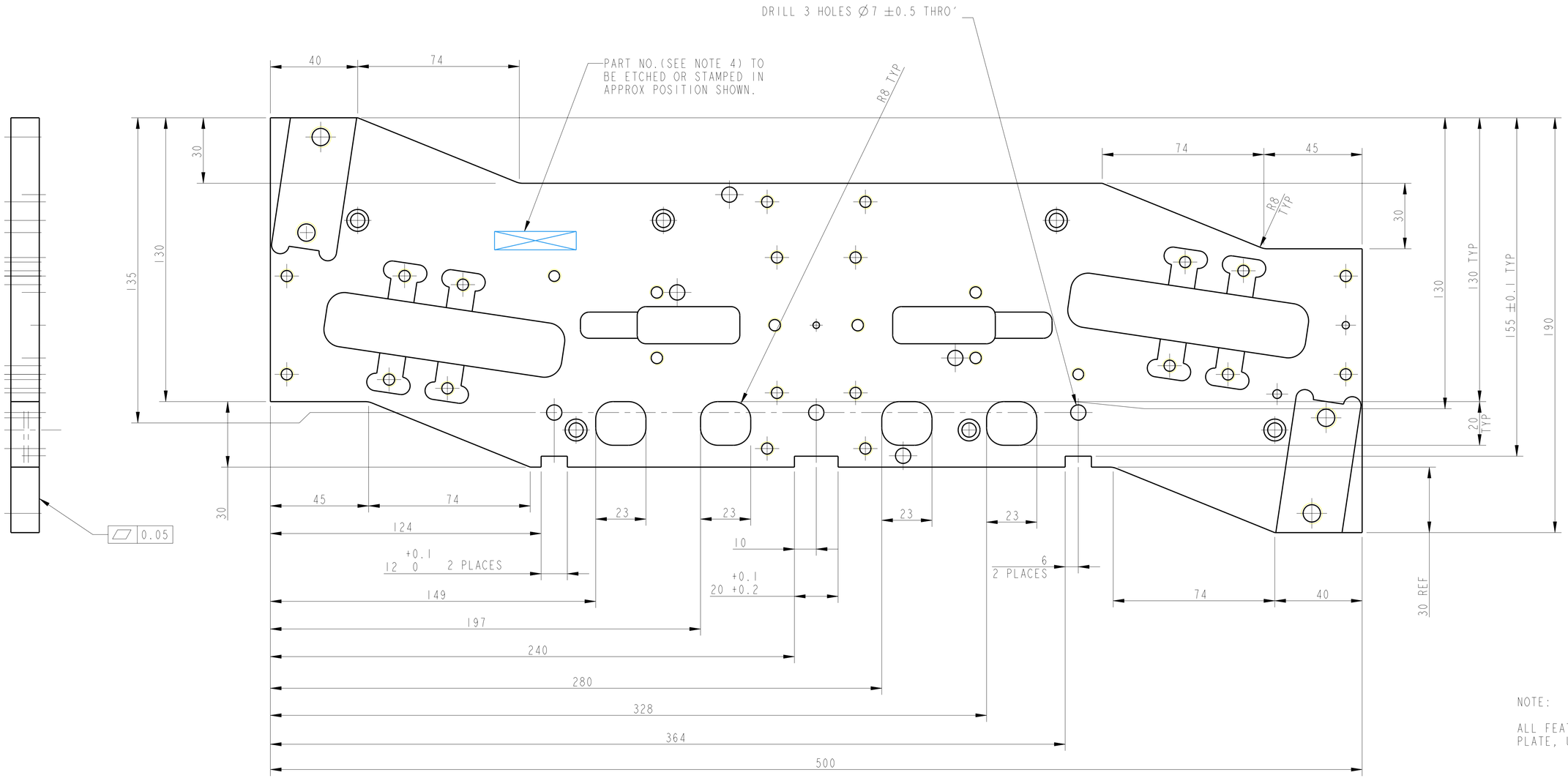
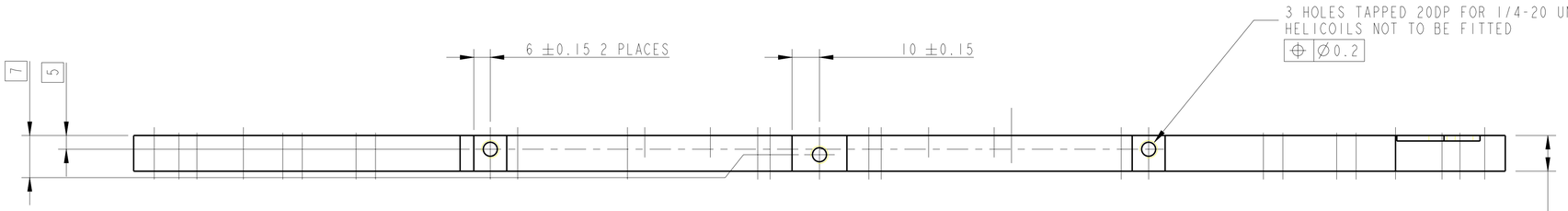
INTRALINK NAME: D060430-A

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)

1. REMOVE ALL SHARP EDGES, R.02 MIN.
2. DO NOT SCALE FROM DRAWING.
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).
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: D020188- 001. A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN MM
TOLERANCES:
0.2
±0.25 °
MATERIAL: ST.STEEL 316
FINISH: CLEAN, GREASE FREE
√(µm [µin]) Ra : 1.6

	NAME	DATE
DRAWN	J O'DELL	01/NOV/05
CHECKED	MB	15/MAR/10
APPROVED	JDD	15/MAR/10

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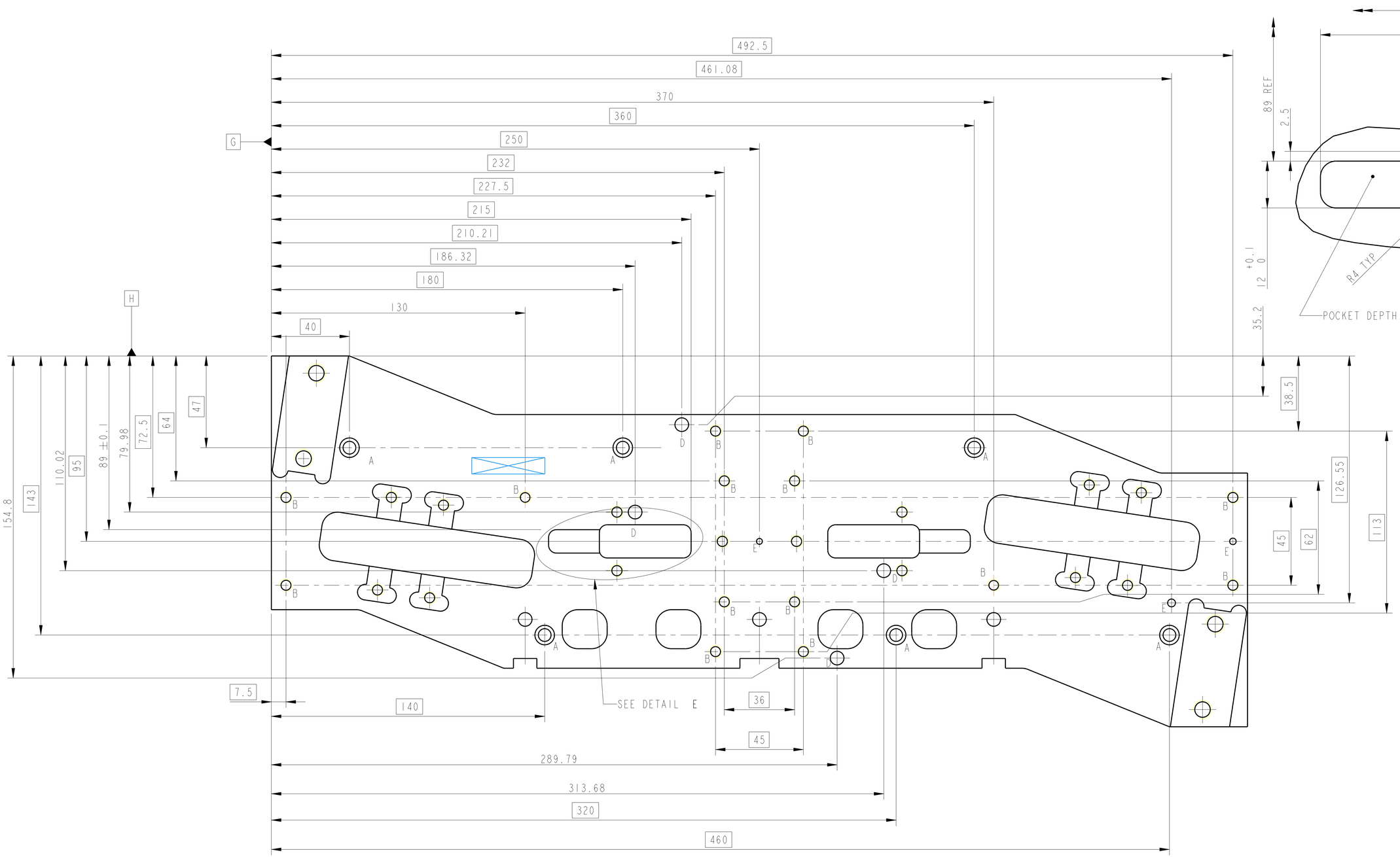
RUTHERFORD APPLETON LABORATORIES

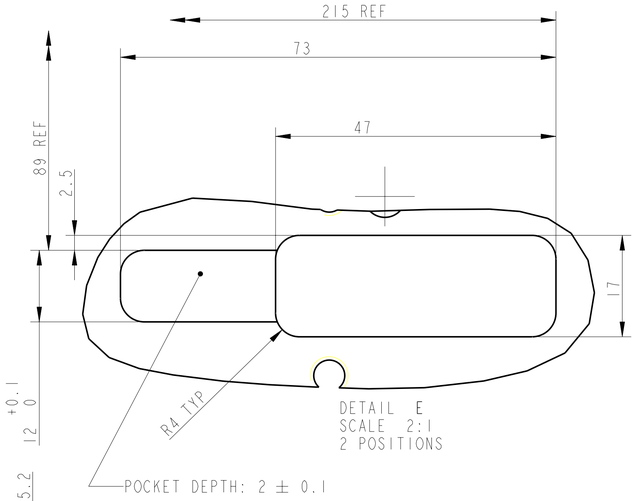
SYSTEM aLIGO
SUB-SYSTEM SUS - QUAD
NEXT ASSY TOP MASS QUAD
PART NAME BASE PLATE
-

SIZE D | DRG. NO. D060430 | REV. K.

SCALE 1:1 | PROJECTION: | SHEET 1 OF 4

INTRALINK NAME: D060430-A





DETAIL E
SCALE 2:1
2 POSITIONS

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: 14 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

HOLES MARKED E: BORE 3 HOLES Ø4 X 3DP

⌖ Ø0.1 G H

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DIMENSIONS ARE IN MM
TOLERANCES:
0.2
±0.25°
MATERIAL: ST.STEEL 316
FINISH: CLEAN, GREASE FREE
(Ra in µin) Ra : 1.6

	NAME	DATE
DRAWN	J O'DELL	01/NOV/05
CHECKED	MB	15/MAR/10
APPROVED	JDD	15/MAR/10

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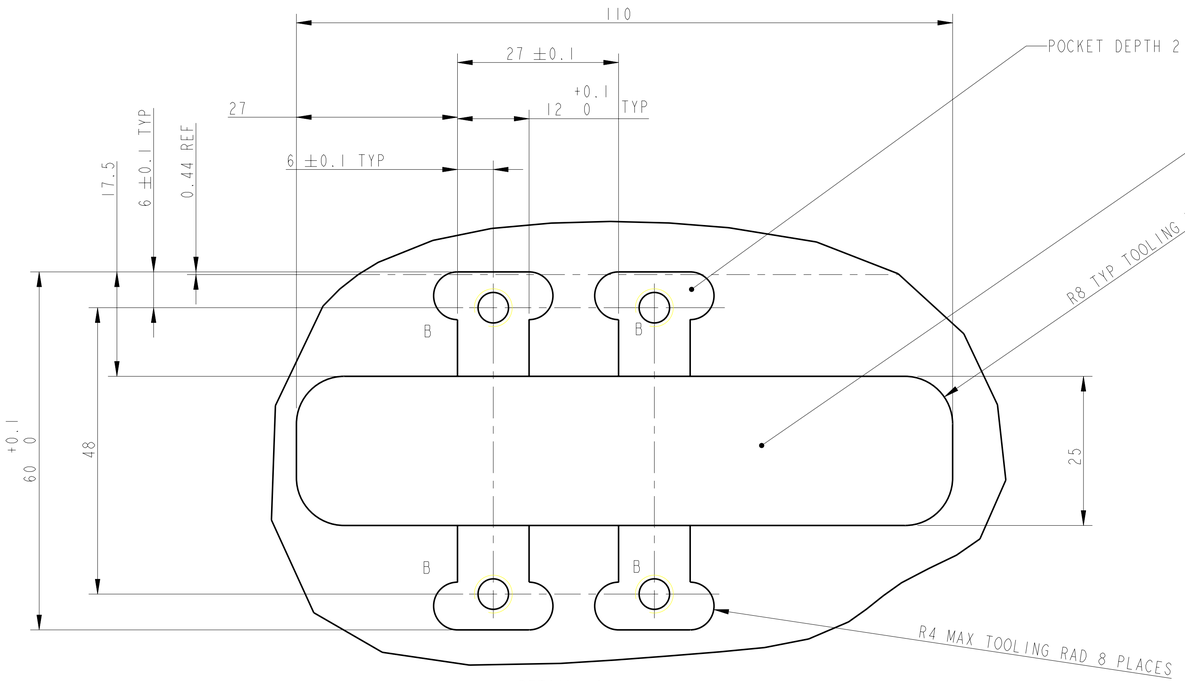
RUTHERFORD APPLETON LABORATORIES

SYSTEM aLIGO
SUB-SYSTEM SUS - QUAD
NEXT ASSY TOP MASS QUAD
PART NAME BASE PLATE
-

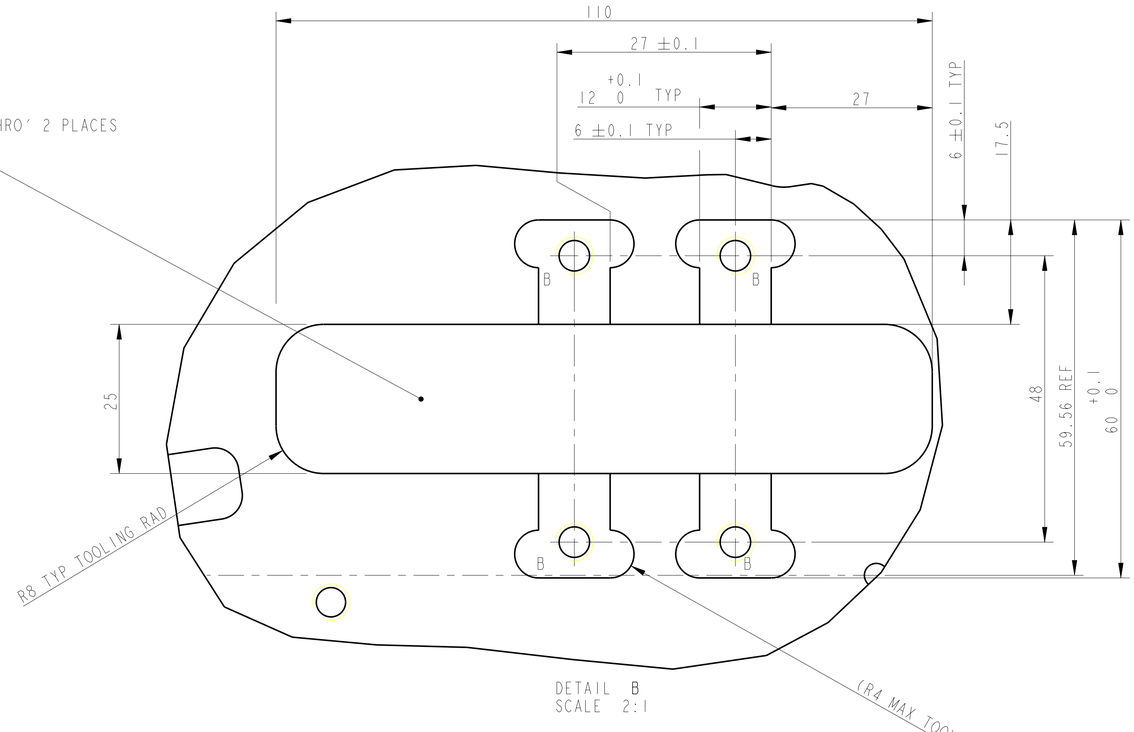
SIZE D | DRG. NO. D060430 | REV J

SCALE 1:1 PROJECTION: | SHEET 2 OF 4

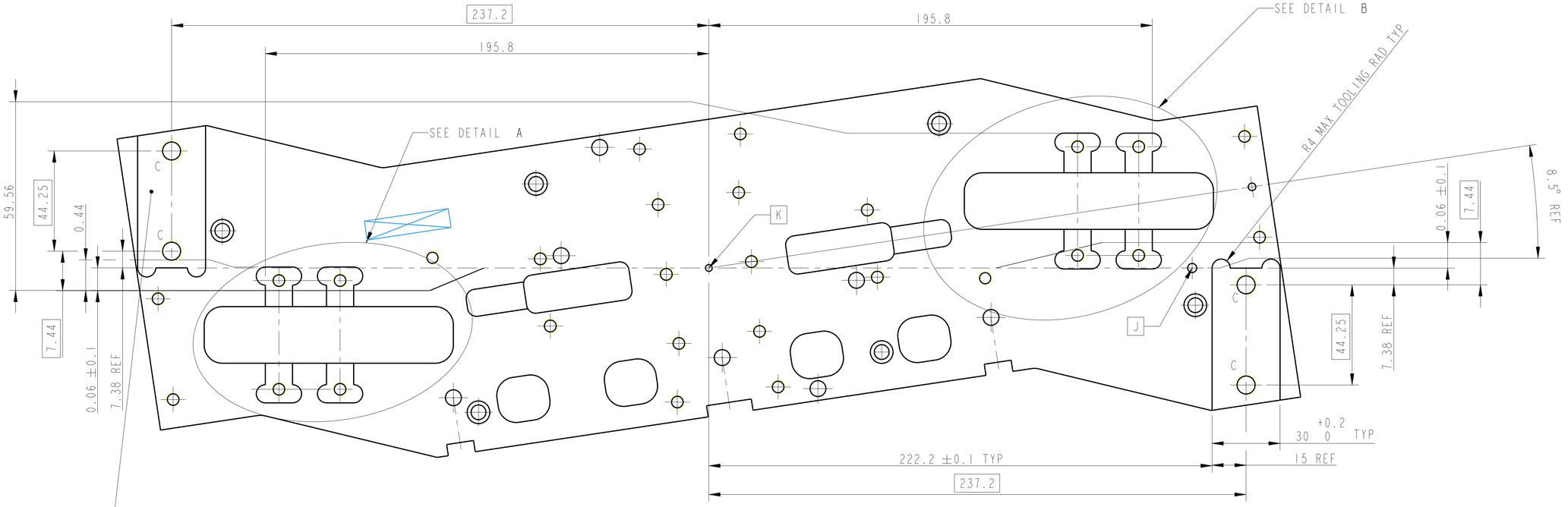
INTRALINK NAME: D060430-A



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

⌖	Ø0.15	K	J

NOTES: (UNLESS OTHERWISE SPECIFIED)

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DIMENSIONS ARE IN MM
TOLERANCES:
0.2
±0.25°
MATERIAL: ST.STEEL 316
FINISH: CLEAN, GREASE FREE
(Ra in µin) Ra = 1.6

	NAME	DATE
DRAWN	J. O'DELL	01/NOV/05
CHECKED	MB	15/MAR/10
APPROVED	JOD	15/MAR/10

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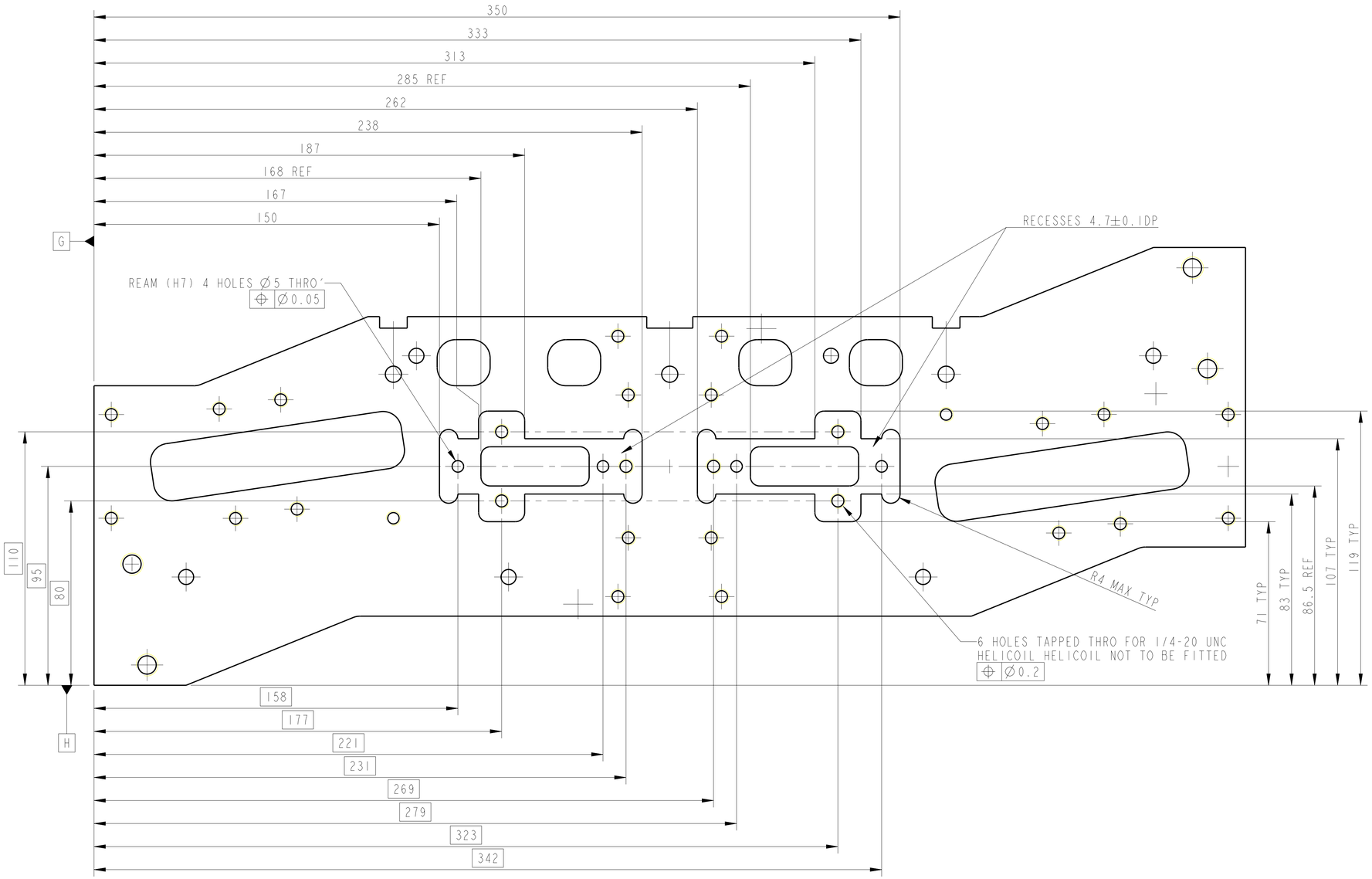
SYSTEM aLIGO
SUB-SYSTEM SUS . QUAD
NEXT ASSY TOP MASS QUAD
PART NAME BASE PLATE
-

SIZE D | DRG. NO. D060430 | REV J
SCALE 1:1 | PROJECTION | SHEET 3 OF 4

INTRALINK NAME: D060430-K



VIEW SHOWING FEATURES ON UNDERSIDE OF PLATE

NOTES: (UNLESS OTHERWISE SPECIFIED)

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DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X .XX ±0.2 (.1)
ANGULAR ±0.25 °

MATERIAL: ST.STEEL 316

FINISH: CLEAN, GREASE FREE
ρfum (µin) Ra : 1.6

	NAME	DATE
DRAWN	J. O'DELL	20/OCT/06
CHECKED	MB	15/MAY/10
APPROVED	JOD	15/MAR/10

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-

SIZE D | DRG. NO. D060430 | REV K.
SCALE 1:1 | PROJECTION | SHEET 4 OF 4