

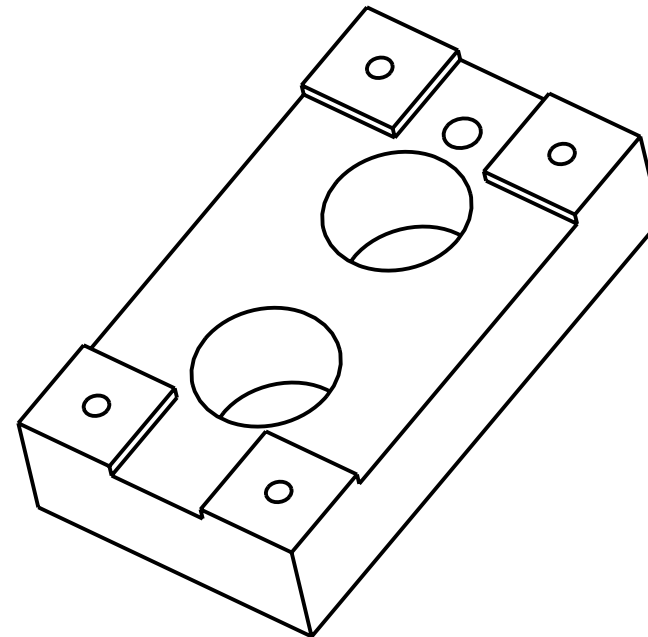
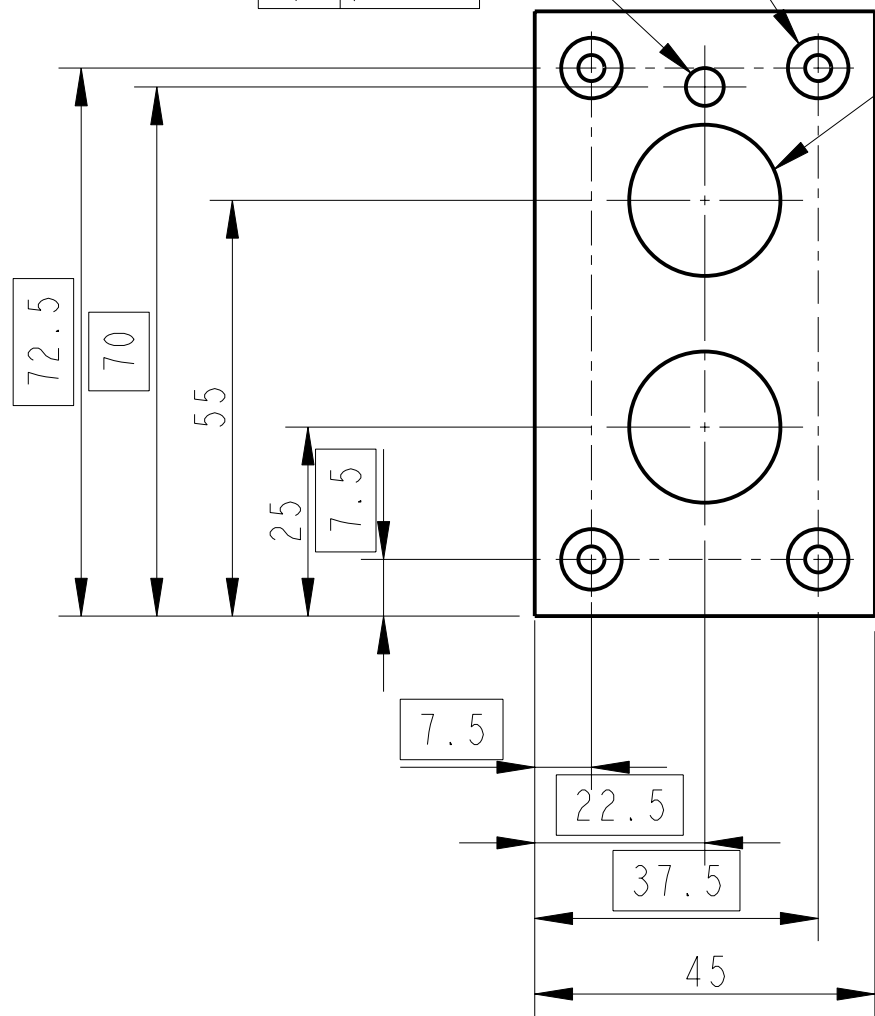
PART No. SEE NOTE 4

DRILL 4 HOLES $\varnothing 4.5$
CBORE $\varnothing 8 \times 5.3$ DP

$\varnothing 0.2$

REAM $\varnothing 5$
 $\varnothing 0.1$

DRILL $\varnothing 10$



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	
5083 T6 OR 6061 T6	
FINISH: CLEAN AND DEGREASED	
$\sqrt{\mu m}$ [μin] $R_a = 1.6$	
NAME	DATE
DRAWN I WILMUT	10/OCT/07
CHECKED J'OD	1/NOV/07
APPROVED RJG	10/OCT/07

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES	
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	SUS
NEXT ASSY	QUAD ITM/ETM
PART NAME	TABLECLOTH PADS (UPPER STRUCTURE)
SIZE	B
DRG. NO.	D070247
REV	A.
SCALE	1:1
PROJECTION	
SHEET	1 OF 2

