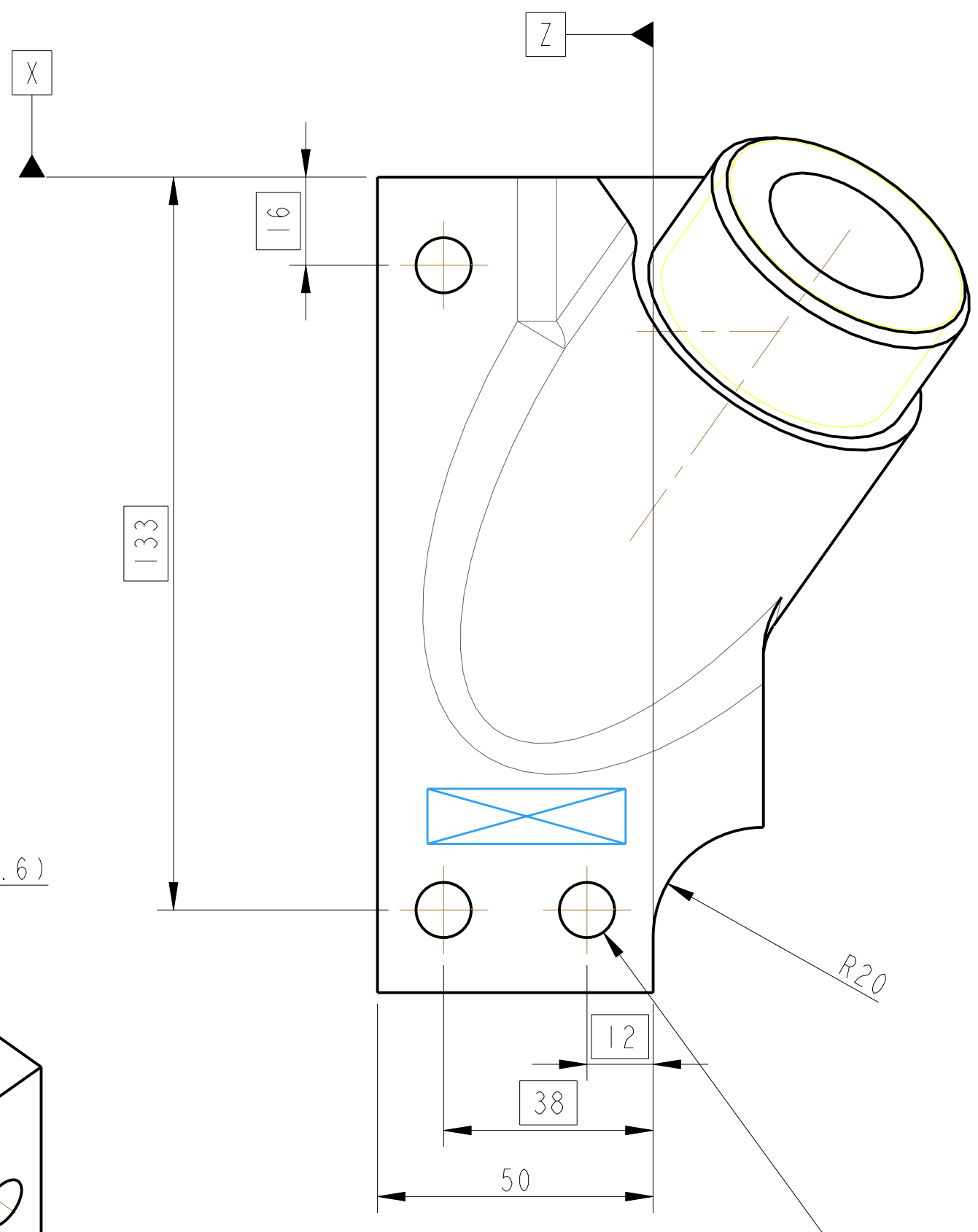
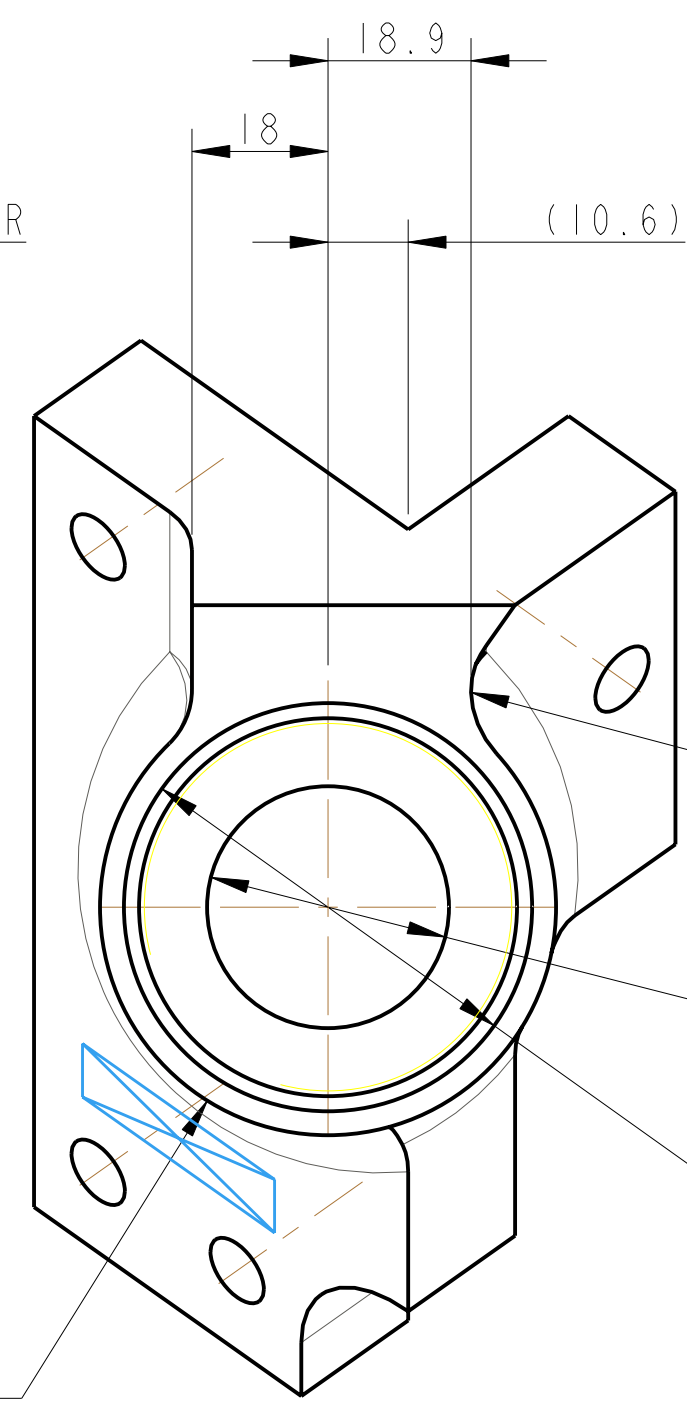
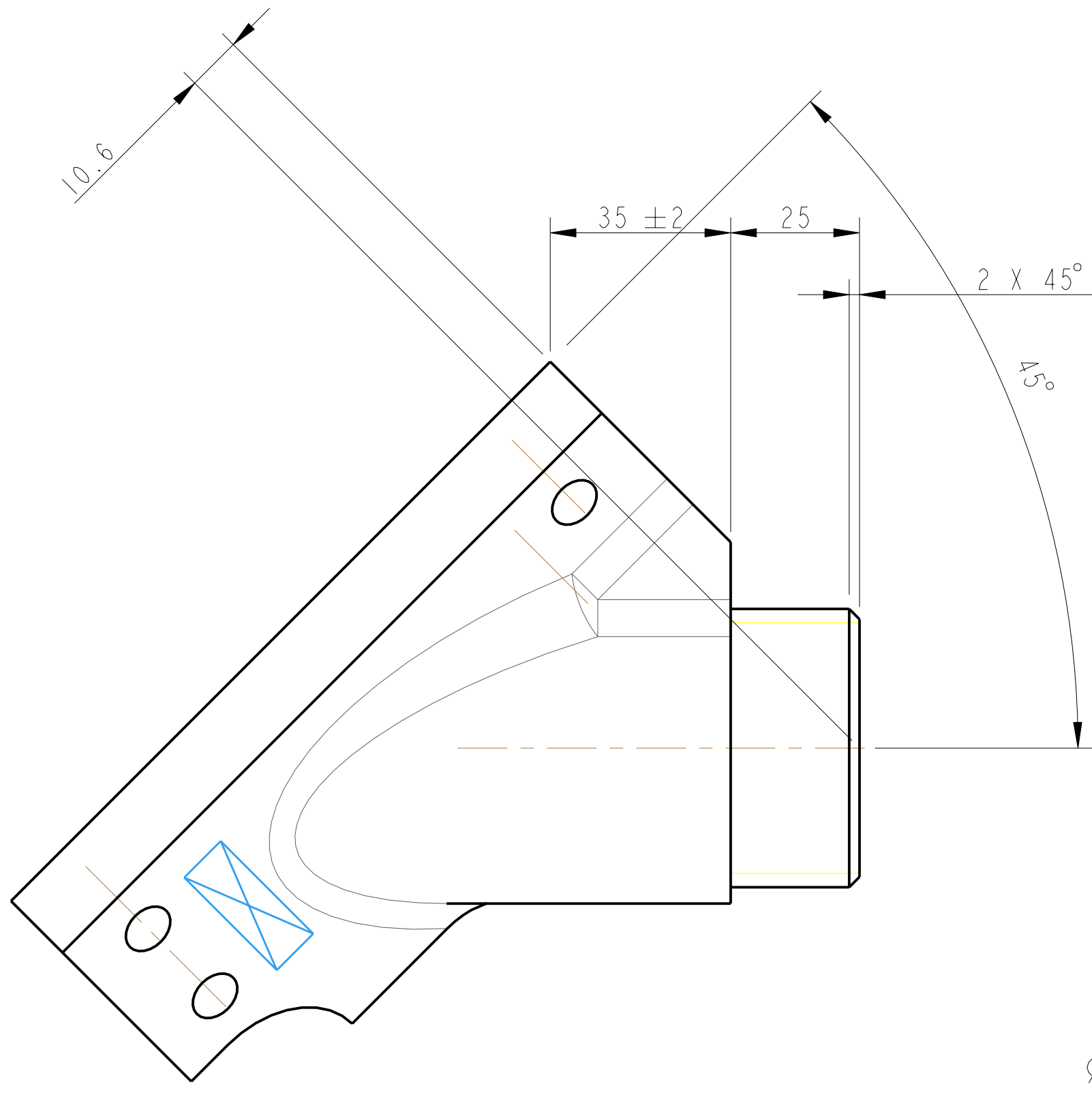
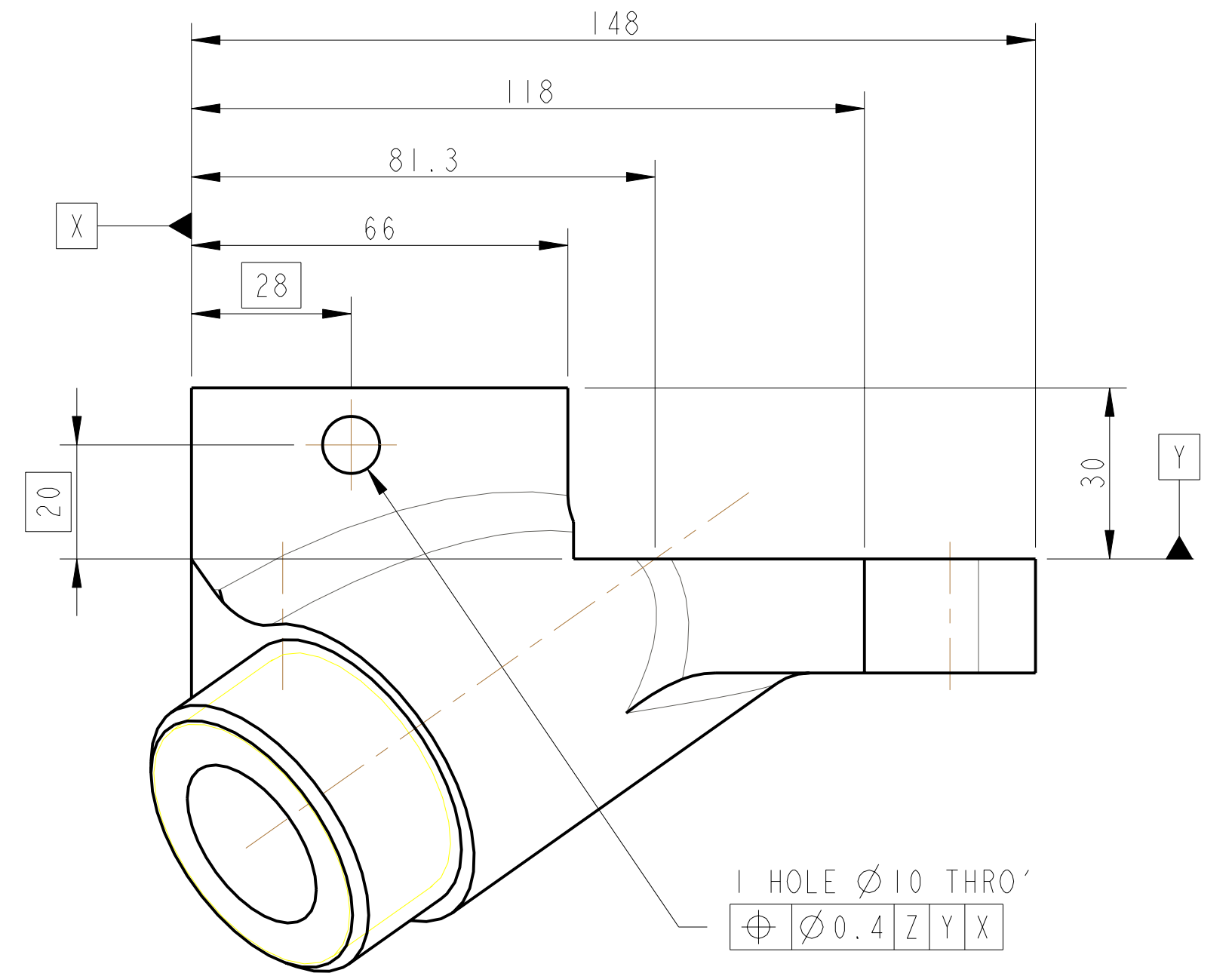
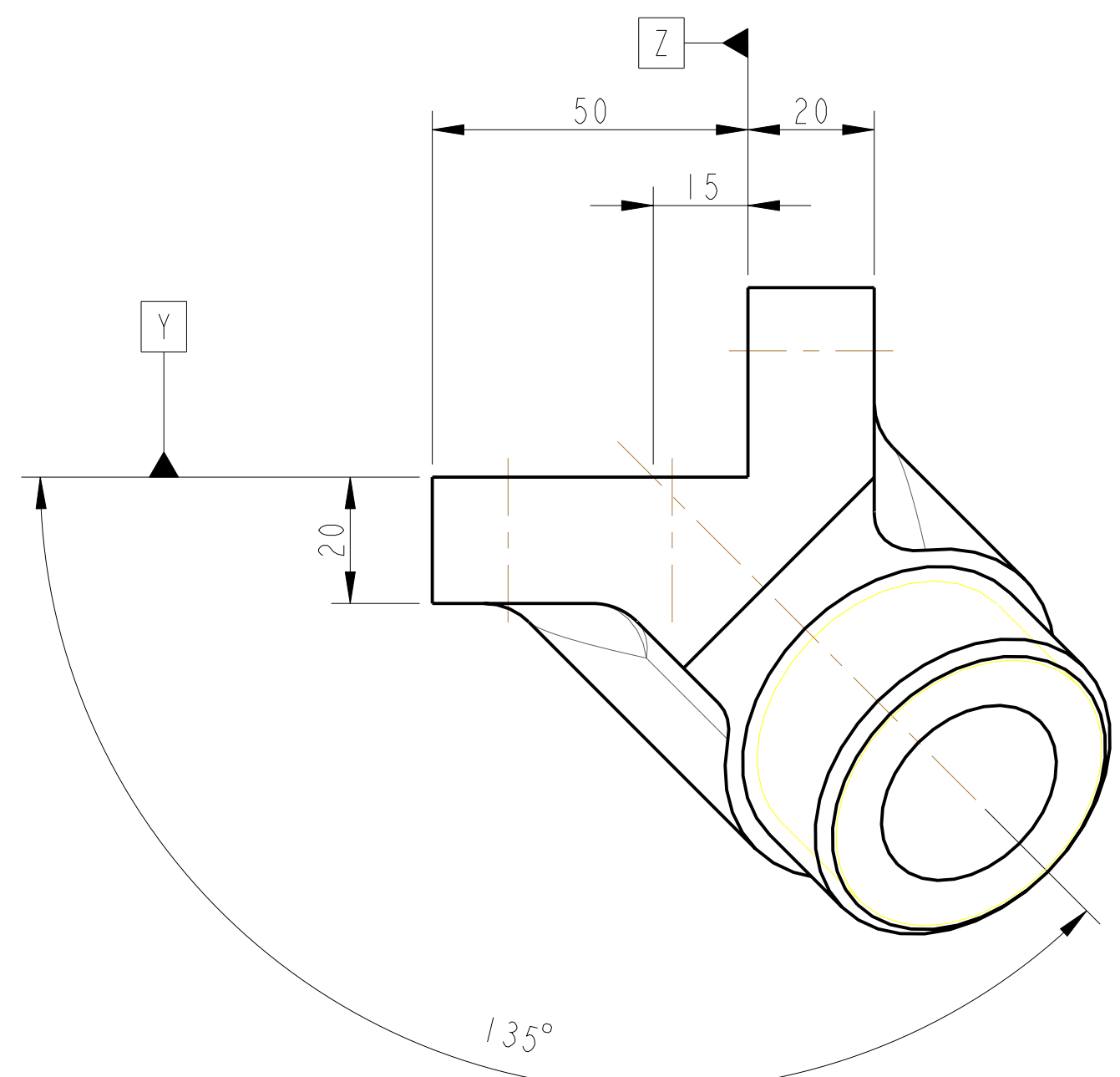


3D VIEW

PART# (SEE NOTE4) TO BE ETCHED OR STAMPED IN APPROX. POSITION SHOWN



R10 ± 10 TYP TOOLING RAD

DRILL Ø32 X 45 DP TO DRILL POINT THIS HOLE MAY BE DRILLED THROUGH FOR MANUFACTURING PURPOSES, BUT MUST IN THIS CASE BE REDUCED TO Ø20

M54 X 1.5 (F7) FULL THREAD UP TO SHOULDER, UNDERCUT IF NECESSARY

NOTES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY	
1. REMOVE ALL SHARP EDGES. R10Z MIN.	DIMENSIONS ARE IN mm (INCHES)	MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
2. DO NOT SCALE FROM DRAWING.	TOLERANCES:	OP. GLASGOW UNIVERSITY GED ROU GROUP	
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE. SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).	X .XX ± 0.2	RUTHERFORD APPLTON LABORATORIES	
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: 000100-001 - A VIBRATOR TOOL MAY BE USED.	ANGULAR ±0.25 °	ADVANCED LIGO	
	MATERIAL: AL ALLOY 5083 OR SIMILAR	SUB-SYSTEM SUS	
	FINISH: CLEAN, CEASE FREE √(um (1/10)) Ra = 1.6	NEXT ASSY THIS	
	DRAWN: J. O'BELL 07/01/09	PART NAME BS UPPER STRUCTURE	
	CHECKED: AJB	STAY BRACKET *1	
	APPROVED: JOD	DRG. NO. D080506	
		SCALE 1:1 PROJECTION	