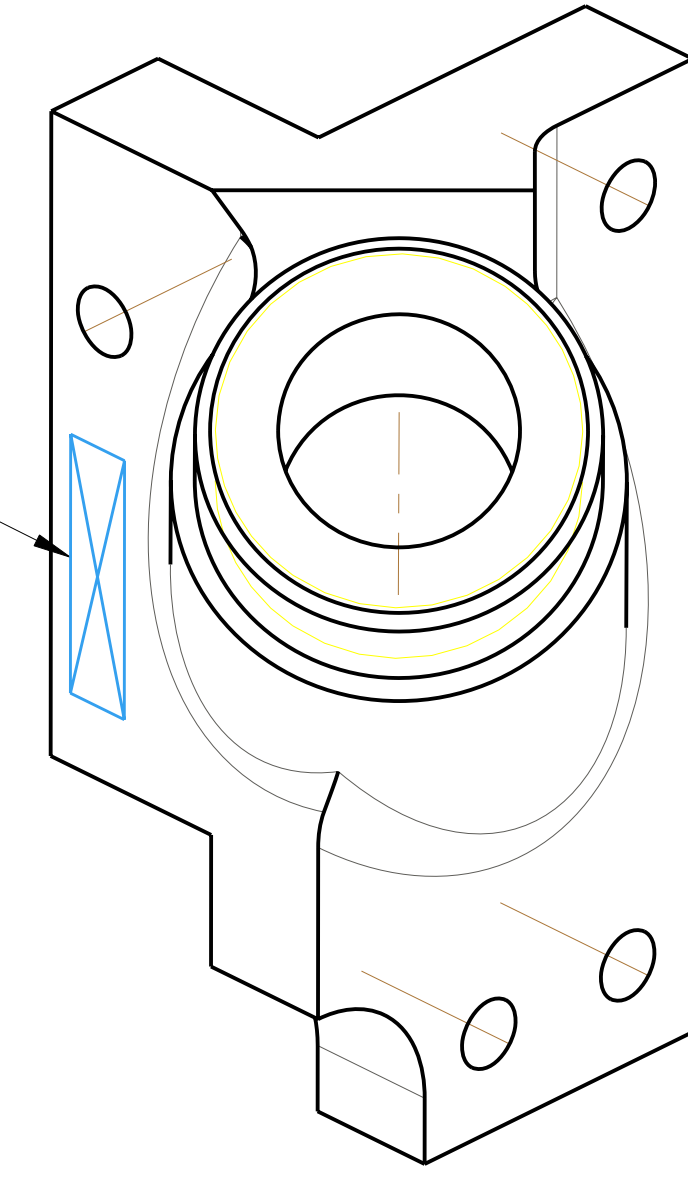
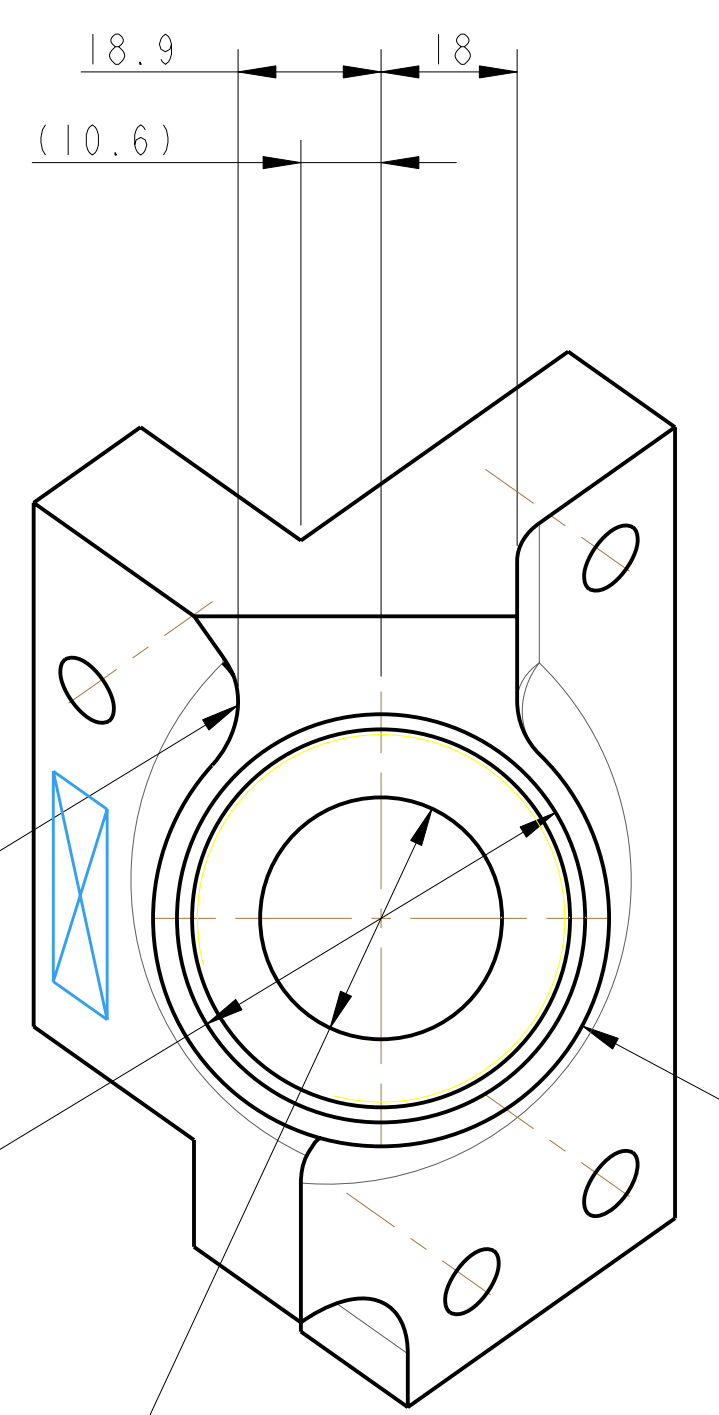
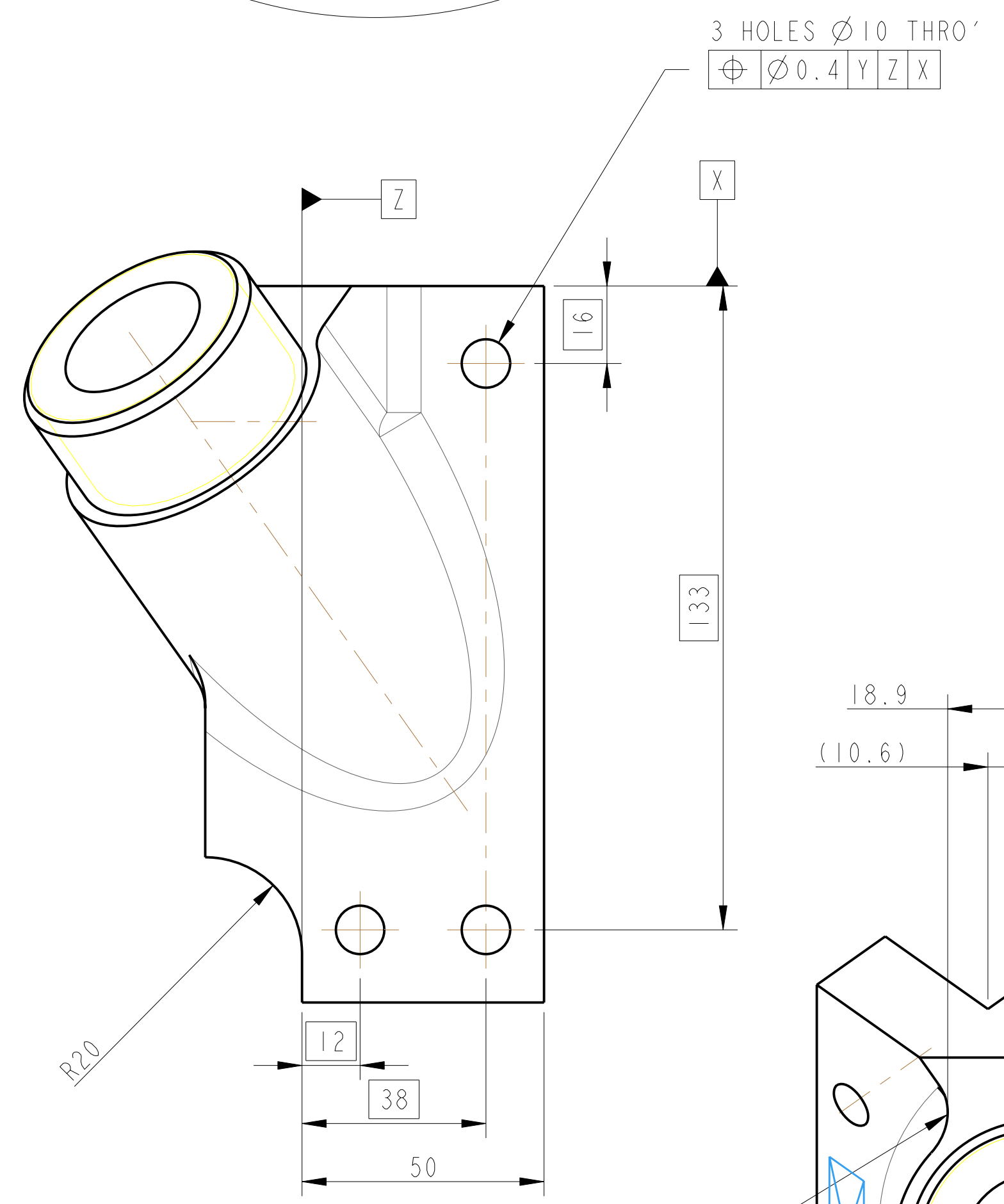
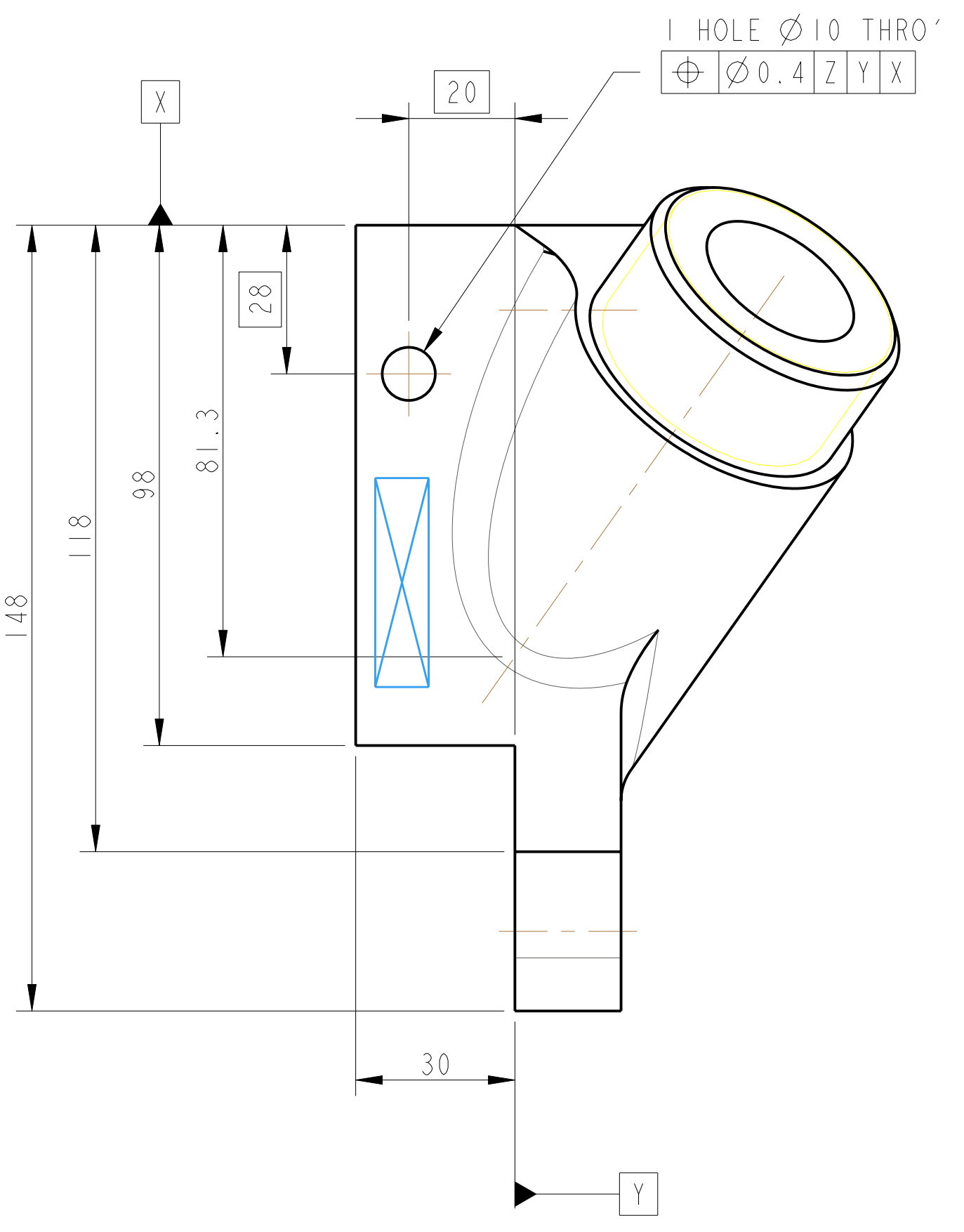


PART# (SEE NOTE4) TO BE ETCHED OR STAMPED IN APPROX. POSITION SHOWN



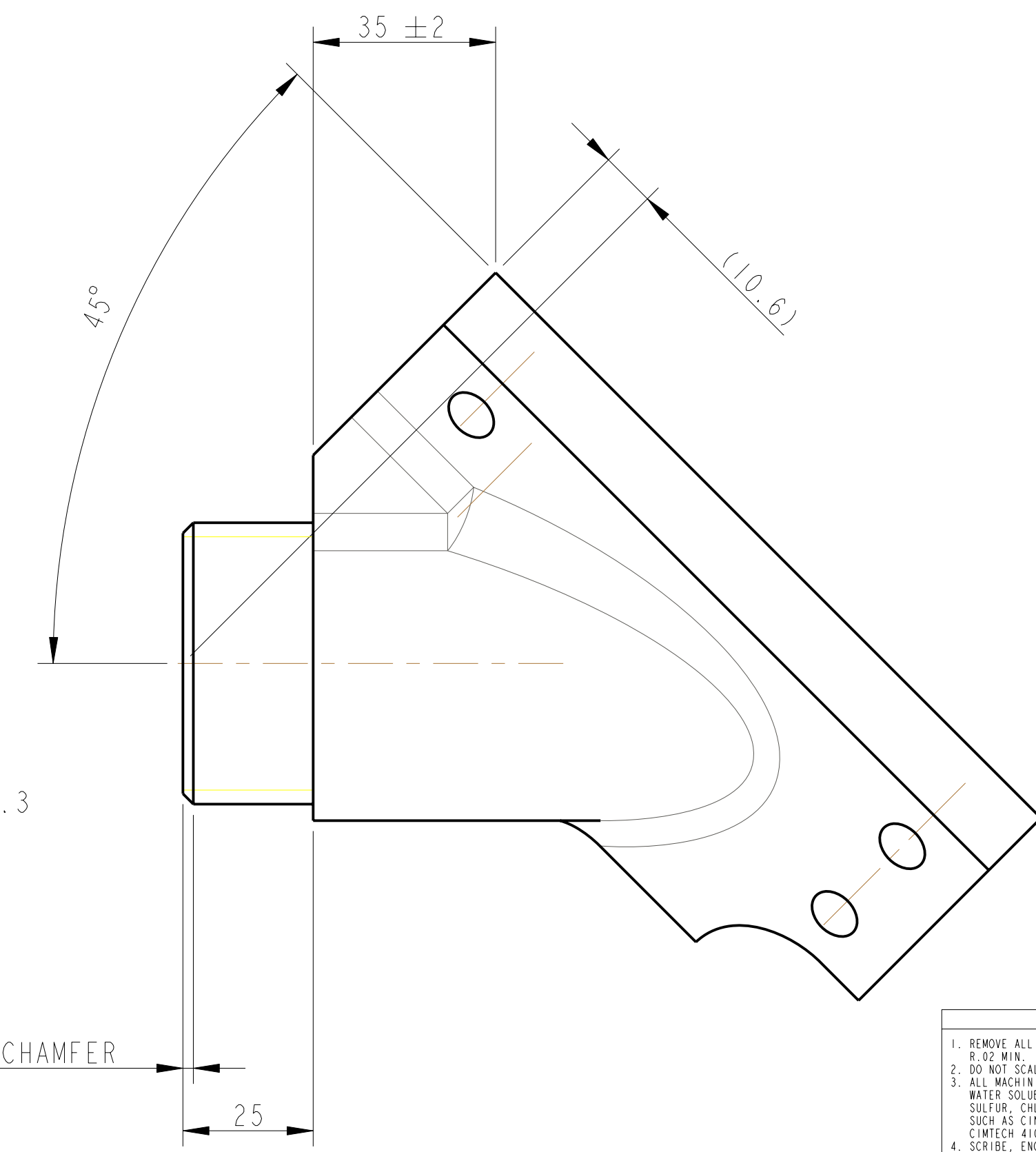
3D VIEW



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

R10 ± 10 TYP TOOLING RAD

DRILL Ø32 ±1 X 45 DP TO DRILL POINT THIS HOLE MAY BE DRILLED THROUGH FOR MANUFACTURING PURPOSES, BUT MUST IN THIS CASE BE REDUCED TO Ø20



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: D080507-001 - A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES) TOLERANCES:

X, XX ± .13 ANGLUAR ±0.25 °

MATERIAL: AL ALLOY 5083 OR SIMILAR

FINISH: CLEAN, GREASE FREE √(µm) Ra = 1.6

NAME	DATE
DRAWN J. O'BELL	07/01/09
CHECKED AJB	...
APPROVED JOD	...

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY RUTHERFORD APPLTON LABORATORIES

SYSTEM: ADVANCED LIGO

SUB-SYSTEM: SUS

NEXT ASSY: THIS

PART NAME: BS UPPER STRUCTURE STAY BRACKET *2

DRG. NO.: D080507

SCALE: 1:1 PROJECTION: F