



NOTES: (UNLESS OTHERWISE SPECIFIED)

- CUTTING FLUIDS TO BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE, & SILICONE.
- STEEL STAMP OR ENGRAVE THE DRAWING PART NUMBER ON NOTED FACE OF PART FOLLOWED BY 'S/N', THEN A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS TO START AT 001 FOR FIRST PART AND PROCEED IN A CONSECUTIVE MANNER TO A MAXIMUM OF 999, FOR EACH SUCCEEDING PART PRODUCED. USE 0.13 HIGH CHARACTERS. EXAMPLE: D990038-A S/N 001

		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES							LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		
		TOLERANCES: FRACTIONAL ± ANGULAR ± ANGULAR MACH ± BEND ± TWO PLACE DECIMAL ±.01		THREE PLACE DECIMAL ±.005 FINISHED SURFACE RMS BREAK CORNERS IN: OUT: .005-.010 REMOVE ALL BURRS						PLATE BEAM DUMP BACKPLATE OFFSET BSC7, 4KITMXHR4, BSC8, 4KITMYHR4	
		MATERIAL: 6061-T6 ALU JIG PLATE 1/4" THICK		HEAT TREAT:		FINISH:				CAD FILE: D990236-B.dwg	
DWG. NO.		DESCRIPTION		USED ON:		NEXT ASS'Y: D990206		REV		SIZE DWG. NO. B D990236-B	
REFERENCE DRAWINGS						ISSUE DESCRIPTION		APPR'D CHECK DRWN DATE		SCALE NTS SHEET 1 OF 1	