INTRALINK NAME: D060376

REV.	DATE	DCN #	DRAWING TREE #
A	18/OCT/06	E060247	-
B	19/DEC/07	E060247-B	-
J	21/JULY/08	E080371	-

ALL HOLES DIMENSIONED ON THIS VIEW
TAPPED 1/4-20 UNC THRU' 0.005"
OVERSIZE ⌖ Ø0.15

115 ±0.4
95 ±0.4
85 ±0.4
6 TYP
R6 TYP
Ø7 TYP
4 RECESSES 2 DP
48 TYP
6 TYP
6.89 +0.05 0
13.11 ±0.4
33.11 ±0.4
53.11 +0.05 0
+0.1 12 0 TYP

DETAIL B
SCALE 2:1

16 STOCK
520
508
487.5 TYP
387.5 TYP
229
62
237.5
45
210.5
190 REF
140 REF
260
132.5 TYP
32.5 TYP
32.5

1 HOLE TAPPED FOR 1/4-20UNC HELICOIL, HELICOIL NOT TO BE FITTED ⌖ Ø0.1
90
8

SEE DETAIL A
D
180
155
146
130
90
88.5
78.75
72
50
34
25
Ø13 TYP
12
65
65
0
53
24
38
46
46
38
309.5
R6 TYP
91.5
101.25
39.75
36.4
36
115
15.2
39.75
36.4

3 HOLES MARKED 'D' Ø8 X 2 DP
FLAT BOTTOMED

ALL OTHER HOLES DIMENSIONED ON THIS VIEW
TAPPED 1/4-20 UNC THRU' 0.005" OVERSIZE ⌖ Ø0.2

90
1 HOLE TAPPED FOR 1/4-20UNC HELICOIL, HELICOIL NOT TO BE FITTED ⌖ Ø0.1
8

53.11 +0.05 0
33.11 ±0.4
13.11 ±0.4
6.89 +0.05 0
6
115 ±0.4
95 ±0.4
6 TYP
85 ±0.4
Ø7 TYP
DETAIL C
SCALE 2:1
4 RECESSES 2 DP
R6 TYP
48
+0.1 12 0 TYP

ALL HOLES DIMENSIONED ON THIS VIEW
TAPPED 1/4-20 UNC THRU' 0.005" OVERSIZE ⌖ Ø0.15

246.92
209.7
+0.1 30 0 TYP
231.92 ±0.1
164.84
RECESS 2 DP TYP
34.25
5.99
73.68
70.12
1.39 ±0.1
SEE DETAIL C
SEE DETAIL B
TOOLING R&D TYP
6.5
70.12
73.68
1.39 ±0.1
5.99
34.25
164.84
209.7
231.92 ±0.1
246.92

190 ±0.5
140 ±0.5
RECESS 2 DP
190 REF
R5 TYP
229.39
243.39
276.61
290.61
DETAIL A
SCALE 2:1
+0.1 5 0
+0.1 5 0

ALL OTHER HOLESDIMENSIONED ON THIS VIEW
FOR HELICOLIS 1/4-20 UNC X 1.5 d lg THRU' ⌖ Ø0.2
HELICOILS NOT TO BE FITTED

PART NO. (SEE NOTE 4)
TO BE ETCHED OR STAMPED
IN APPROX POSITION SHOWN.

ALL HOLES MARKED A DIMENSIONED ON THIS VIEW
TAPPED FOR HELICOILS 1/4-20 UNC THRU' ⌖ Ø0.15
HELICOILS NOT TO BE FITTED.

ALL OTHER DIMENSIONED HOLES ON THIS VIEW TAPPED
1.4-20 UNC THRU X 0.005" OVERSIZE ⌖ Ø0.15

NOTES: (UNLESS OTHERWISE SPECIFIED)
1. REMOVE ALL SHARP EDGES, 0.02 MIN.
2. DO NOT SCALE FROM DRAWING.
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF CHLORINE, SULFUR AND NITRITE COMPOUNDS, SUCH AS CIMCOMAST, MILACRON'S CIMTECH 410 (STAINLESS STEELS).
4. DRIBE, ENGRAVE OR STAMP DRAWING PART NUMBER ON NOTED SURFACE OF PART. ALSO DRIBE, ENGRAVE OR STAMP NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST PART AND PROCEED CONSECUTIVELY. USE .25" HIGH CHARACTERS. STAMP DESIGNATION -001- A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X .XX ±0.2 mm (INCHES)
ANGULAR ±0.25°
MATERIAL: ST STEEL 304/316
FINISH: CLEAN AND DEGREASED Ra 3.2 / 6

	NAME	DATE
DRAWN	J WILMOT	18/AUG/06
CHECKED	A JR	13/JUNE/08
APPROVED	A JR	21/JULY/08

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY LIGO LABORATORY: LIVINGSTON OBSERVATORY HANFORD OBSERVATORY MIT: RESEARCH ROOM & FACILITY LASER INTERFEROMETER APPLETON LABORATORIES

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: QUAD N-PTYPE UI MASS
PART NAME: MASS BASE PLATE

SIZE: E
DRG. NO.: D060376
REV: J
SCALE: 1:1 PROJECTION: SHEET 1 OF 1