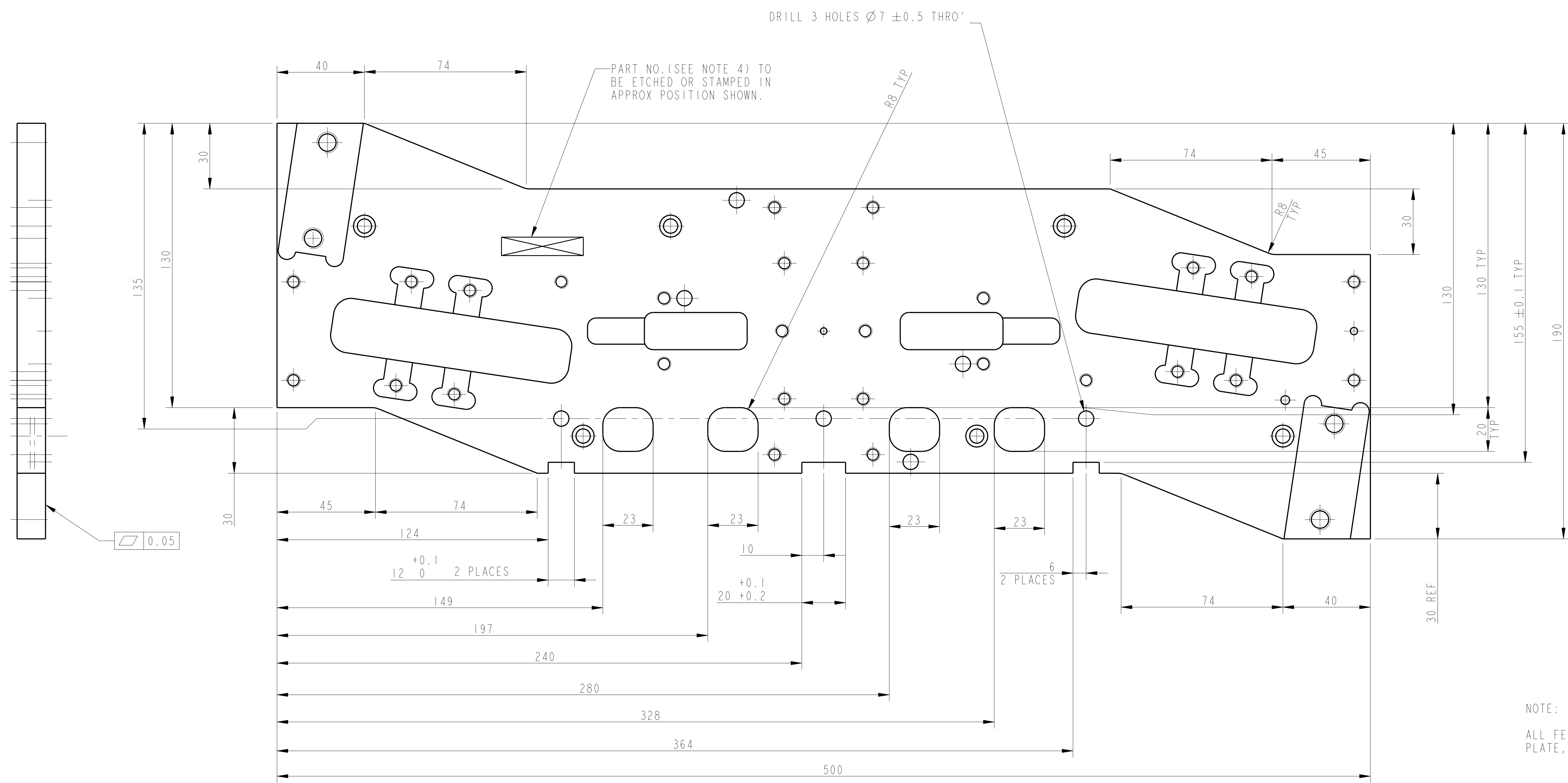
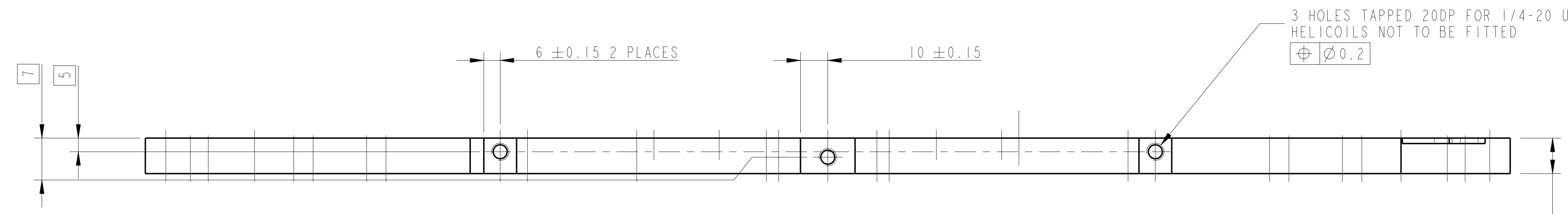


REV	DATE	DCN #	DRAWING TREE #
A	9/0CT/06	E060248	
B	7/0DEC/07	E060248-B	

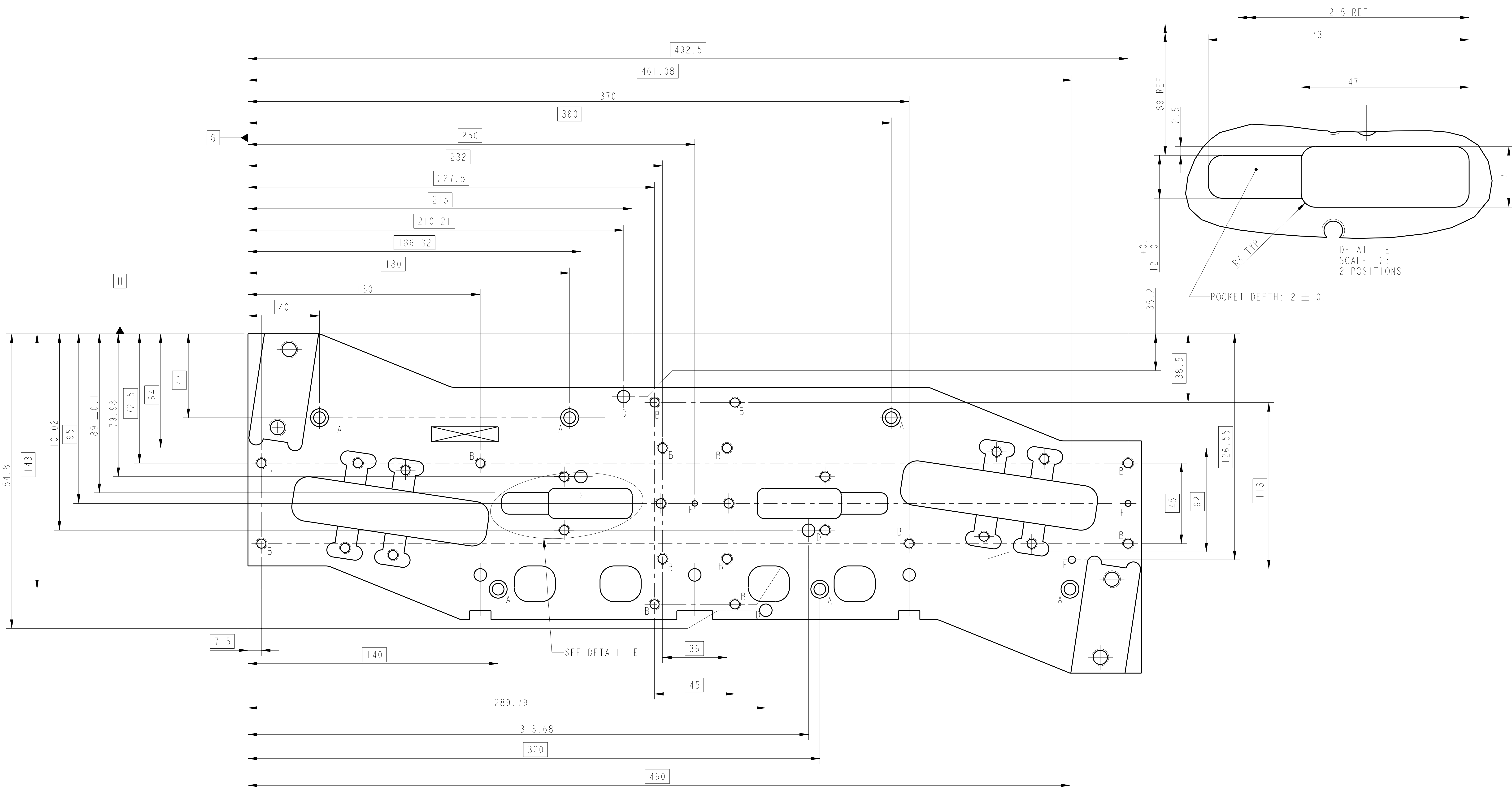


NOTE:
ALL FEATURES ARE MACHINED THRO' THE PLATE, UNLESS OTHERWISE STATED



3 HOLES TAPPED 20DP FOR 1/4-20 UNC HELICOILS
HELICOILS NOT TO BE FITTED
Ø0.2

NOTES: (UNLESS OTHERWISE SPECIFIED)		DIMENSIONS ARE IN MM TOLERANCES:		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY RUTHERFORD APPL. LAB. GROUP	
1. REMOVE ALL SHARP EDGES. R1.0Z MIN.		Ø.2		SYSTEM	ADVANCED LIGO
2. DO NOT SCALE FROM DRAWING.		±0.25 *		SUB-SYSTEM	SUS
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).				NEXT ASSY	TOP MASS QUAD INP TYPE
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.				PART NAME	BASE PLATE
		FINISH: CLEAN, GREASE FREE		NAME	
		√Ra (µm) Ra = 1.6		DATE	
				DRAWN	J. O'BELL 01/NOV/05
				CHECKED	AJB 12/MAY/08
				APPROVED	TW 02/DEC/05
				DRG. NO.	D060430
				SCALE	1:1
				PROJECTION	
				SHEET	1 OF 4



NOTE:

HOLES MARKED A: 6 HOLES, 1/4-20 UNC CLEARANCE HOLES (Ø6.5) AND C-BORED Ø10 X 7 DP

⊕ Ø0.2 | G H

HOLES MARKED B: 14 HOLES, TAPPED THRO' FOR 1/4-20 UNC, TAP 0.005" OVERSIZE

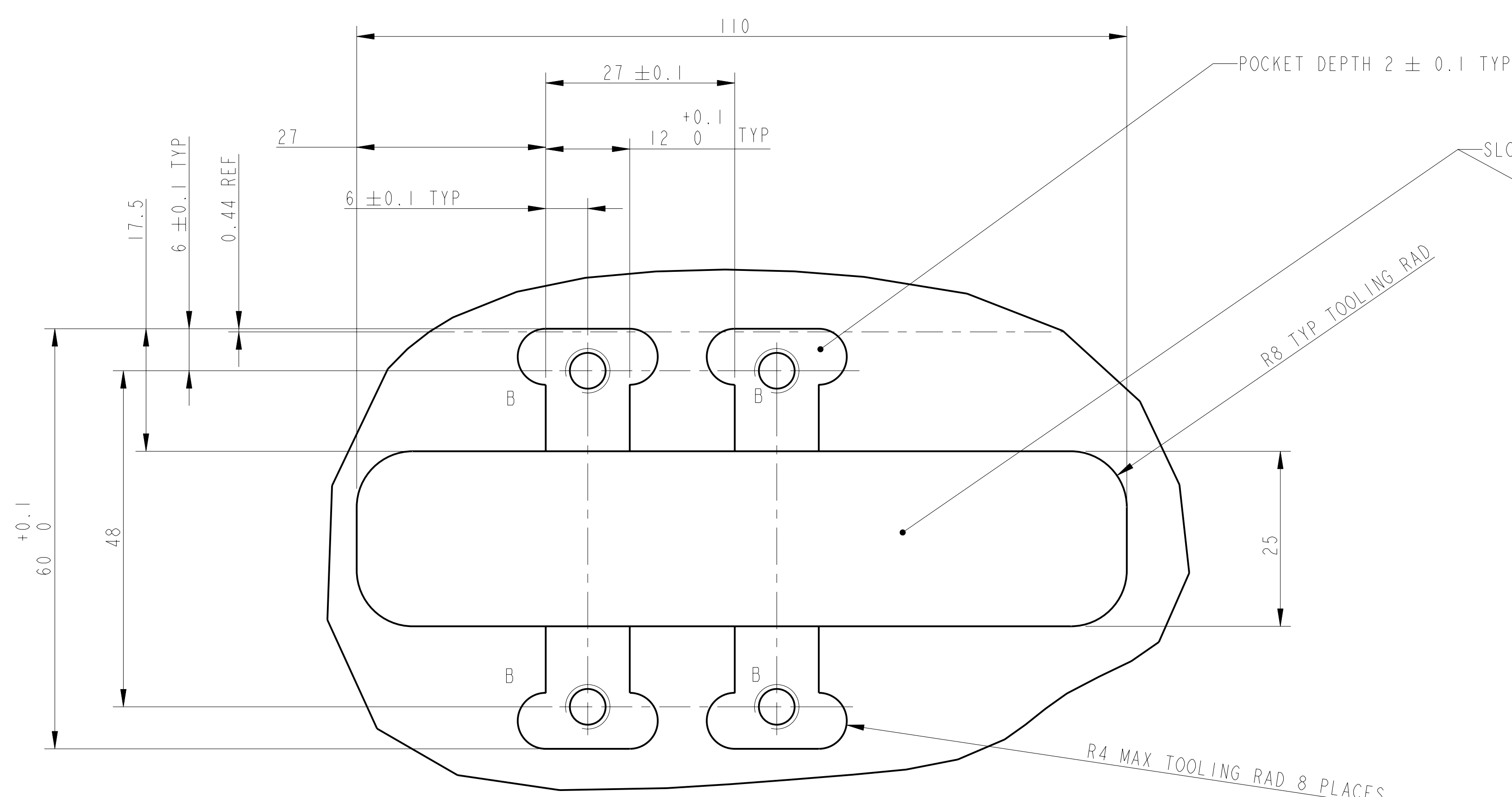
⊕ Ø0.2 | G H

HOLES MARKED D: 4 HOLES Ø7 X 4.5 DP FLAT BOTTOM

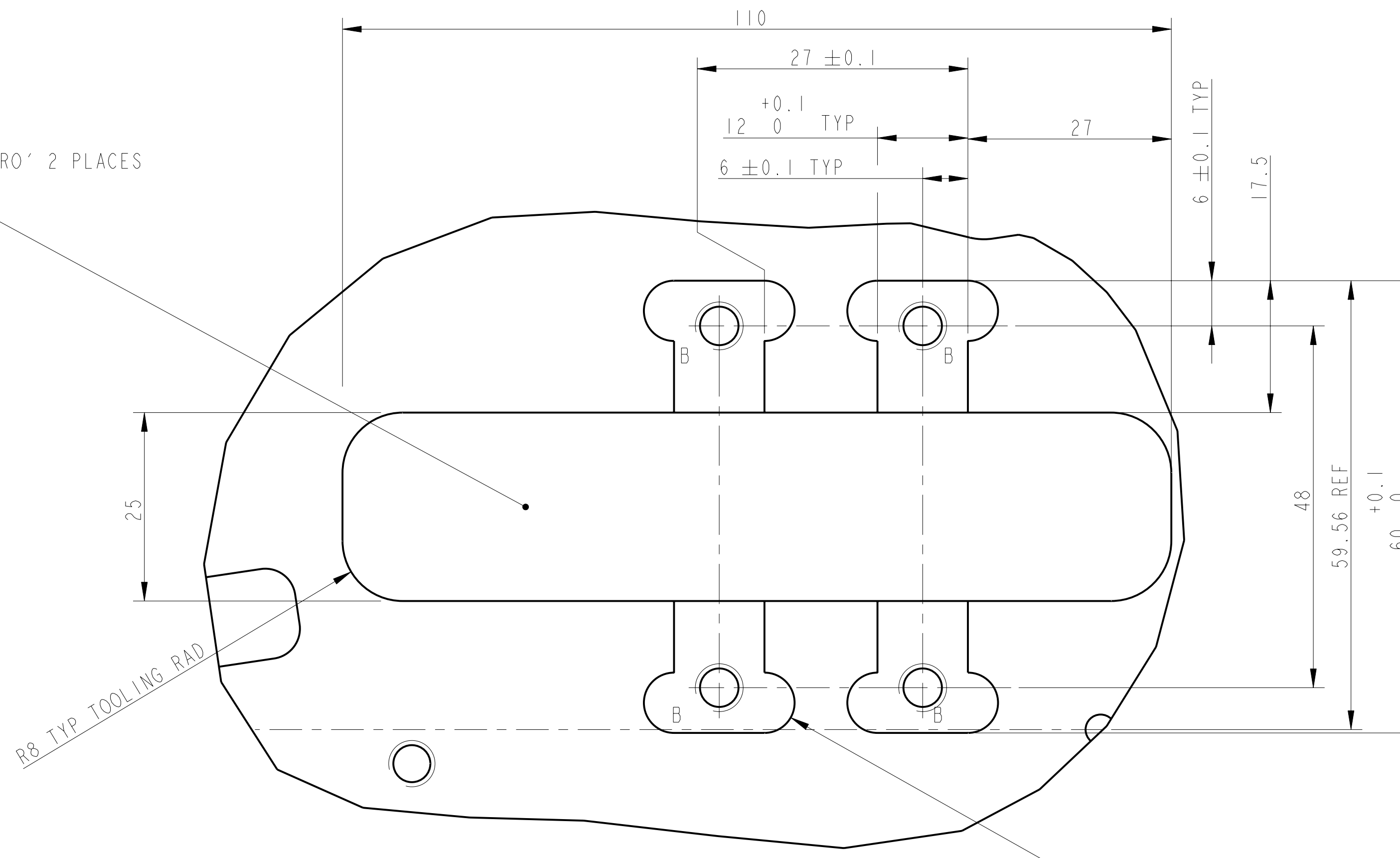
⊕ Ø0.1 | G H

HOLES MARKED E: BORE 3 HOLES Ø4 X 3DP

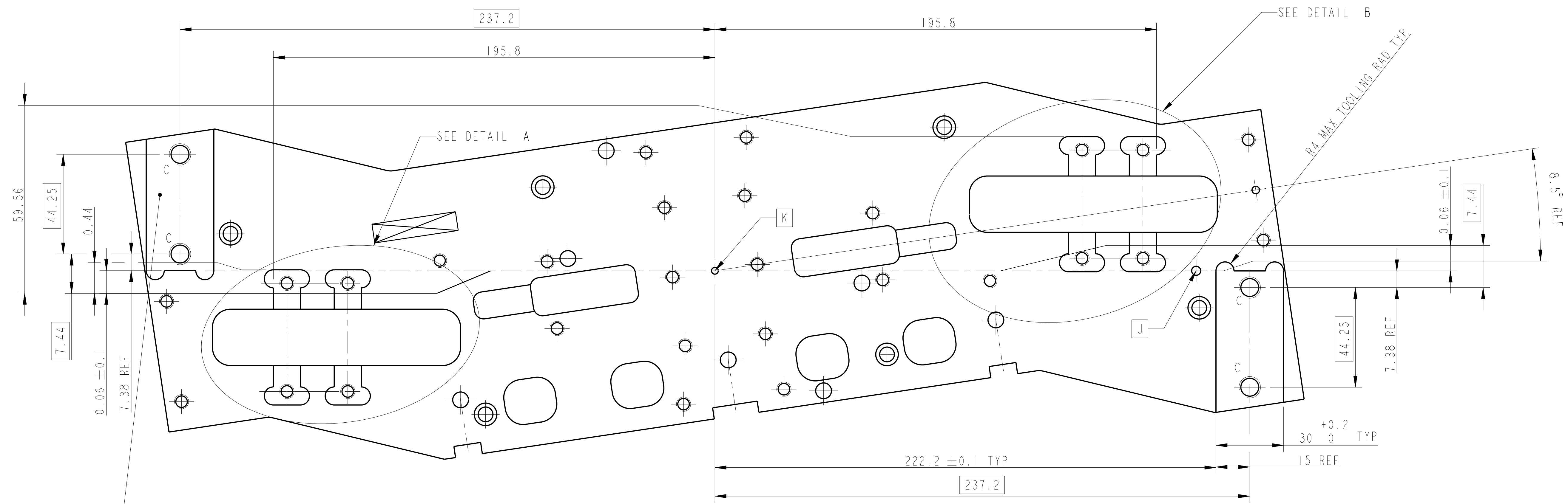
NOTES: (UNLESS OTHERWISE SPECIFIED)		DIMENSIONS ARE IN MM TOLERANCES:		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY OP. GLASGOW UNIVERSITY GEO. ROSS GROUP RUTHERFORD APPLETON LABORATORIES	
1. REMOVE ALL SHARP EDGES. R.02 MIN.	2. DO NOT SCALE FROM DRAWING.	3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE. SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).	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 VIBRATORY TOOL MAY BE USED.	FINISH: CLEAN, GREASE FREE	NAME: J. O'BELL
±0.25*	±0.1	±0.05*	±0.02	MATERIAL: ST-STEEL	DATE: 01/NOV/05
				SYSTEM: ADVANCED LIGO	STN: 12MAY08
				SUB-SYSTEM: SUS	DRG. NO.: D060430
				NEXT ASSY: TOP MASS QUAD INP TYPE	SCALE: 1:1 PROJECTION: 1st ANGLE
				PART NAME: BASE PLATE	SHEET: 2 OF 4



DETAIL A
SCALE 2:1

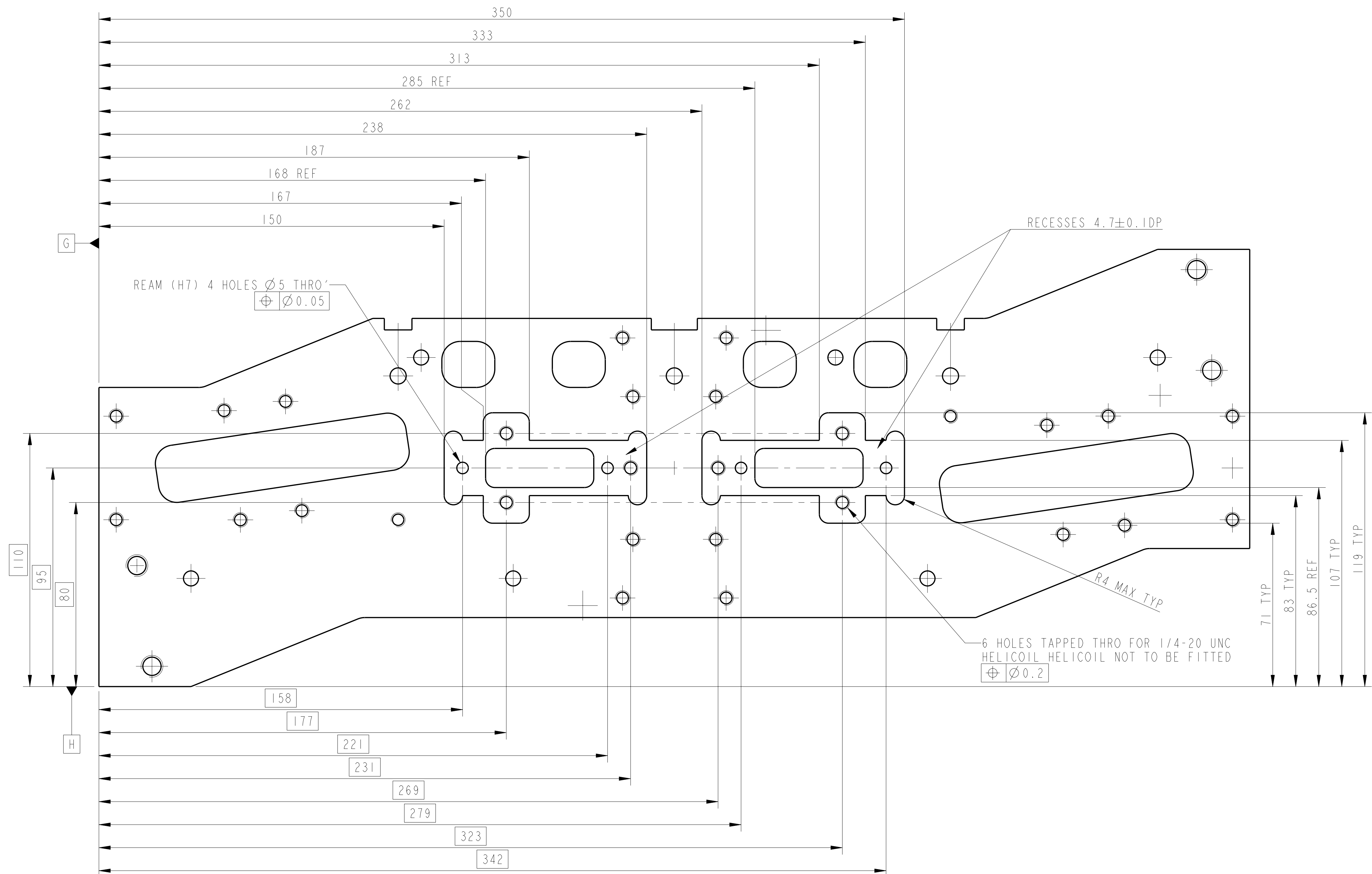


DETAIL B
SCALE 2:1



NOTE:
 HOLES MARKED B: 8 HOLES, TAPPED FOR 1/4-20 UNC 0.005" OVERSIZE, TAP THRO
 HOLES MARKED C: 4 HOLES, TAPPED THRO' FOR 3/8-16 UNC HELICOIL, HELICOIL NOT TO BE FITTED
 ⌀0.15 [K] [J]

NOTES: (UNLESS OTHERWISE SPECIFIED)		DIMENSIONS ARE IN MM TOLERANCES:		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY OP. GLASSON UNIVERSITY GEC ROX GROUP RUTHERFORD APPLICTION LABORATORIES	
1. REMOVE ALL SHARP EDGES. R.02 MIN.	2. DO NOT SCALE FROM DRAWING.	3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE. SUCH AS CINCINNATI MILACRON'S CIMTECH 410 (STAINLESS STEEL).	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: D060430-001 - A VIBRATOR TOOL MAY BE USED.	0.2 ±0.25*	NAME: DATE: DRAWN: J. O'BELL 01/NOV/05 BY: CHECKED: AJB 12/MAY/08 DRG. NO.: D060430 APPROVED: TW 02/DEC/05
MATERIAL: ST-STEEL	FINISH: CLEAN, GREASE FREE	RO: 1.6	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: SUS	SCALE: 1:1 PROJECTION: 4
NEXT ASSY: TOP MASS QUAD INP TYPE	PART NAME: BASE PLATE	SHEET: 3 OF 4			



VIEW SHOWING FEATURES ON UNDERSIDE OF PLATE

NOTES: (UNLESS OTHERWISE SPECIFIED)

- REMOVE ALL SHARP EDGES. 0.02 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: 000100-001 - A VIBRATOR TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES)
TOLERANCES:
X XX ±0.2 (1)
ANGULAR ±0.25°

MATERIAL: ST-STEEL
FINISH: CLEAN, GREASE FREE
Ra = 1.6
√Ra (1μm)

NAME	DATE	BY
DRAWN J. O'BELL	20/04/06	STW
CHECKED AJB	12/MAY/08	
APPROVED TW	02/DEC/05	

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
OP. GLASGOW UNIVERSITY ICFR ROSS GROUP
RUTHERFORD APPLINGTON LABORATORIES

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

DRG. NO.: **D060430**
SCALE: 1:1
PROJECTION: SHEET 4 OF 4