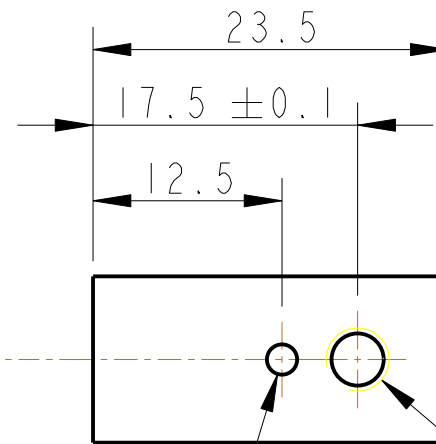
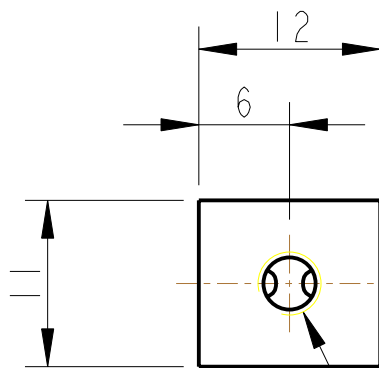


SECTION A-A



8-32 UNC
DRILL 0.005" OVERSIZE

Ø2 VENT HOLE

TAP FOR 8-32 UNC
HELICOIL.
HELICOIL NOT
TO BE FITTED

NOTES: (UNLESS OTHERWISE SPECIFIED)

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 PARTNUMBER 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: D020188- 001. A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN mm [INCHES]
TOLERANCES:

X.XX ±0.2 mm
ANGULAR ±0.25°

MATERIAL: AL ALLOY
5083

FINISH: CLEAN, GREASE FREE
√μm [μin]
Ra = 1.6

	NAME	DATE
DRAWN	J O'DELL	11/03/09
CHECKED	MB	15/MAR/10
APPROVED	JOD	15/MAR/10

 CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
IGR, GLASGOW UNIVERSITY GEO 600 GROUP
RUTHERFORD APPLETON LABORATORIES

SYSTEM	aLIGO
SUB-SYSTEM	SUS
NEXT ASSY	QUAD LOWER STRUCTURE
PART NAME	RINGHEATER ATTACHMENT PIECE QUAD LOWER STRUCTURE

SIZE	DRG. NO.	REV
A	D090438	B.
SCALE 2:1	PROJECTION:	SHEET 1 OF