

TAP 2 HOLES
1/4-20 UNC THRO
0.005\"/>

TAP 12 HOLES 1/4-20 UNC THRO
EQ SP ON 148 PCD
0.005\"/>

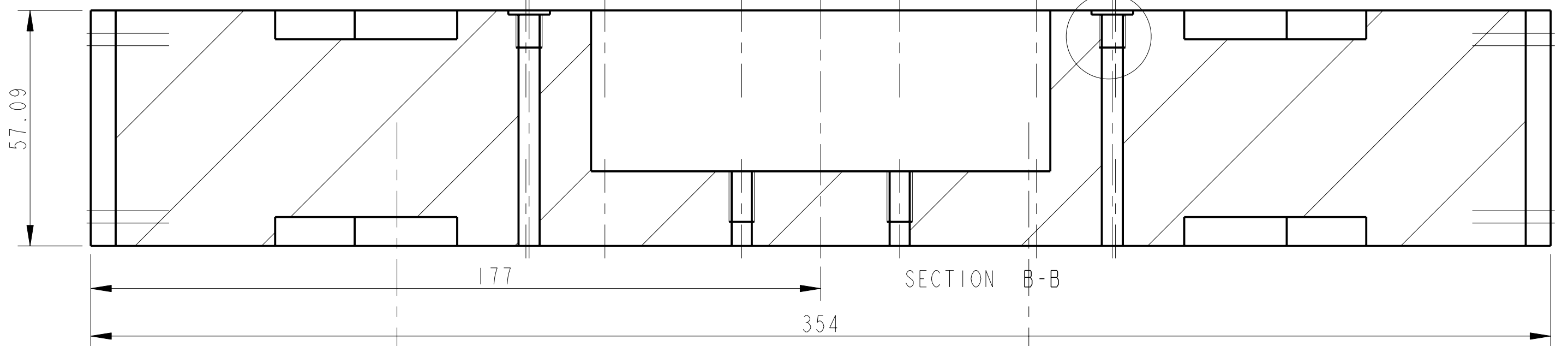
DRILL THRO' AND TAP
1/4\"/>

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

DRILL AND TAP 4 HOLES
FOR 8-32-UNC X 20 DP HELICOILS
2 POSITIONS
HELICOILS NOT TO BE FITTED

R2 TYP TOOLING RAD

SEE DETAIL Z



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: D080369-001 - A VIBRATOR TOOL MAY BE USED.

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

MATERIAL: AL ALLOY 6061-T6

FINISH: CLEAN
Ra: 1.6

NAME	DATE	STY
DRAWN J. O'BELL	FEB/10	
CHECKED J. O'D	FEB/10	
APPROVED JOD	FEB/10	

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: BS/FM
PART NAME: BS ROUND MASS BODY
BEAMSPLITTER ROUND MASS

DRG. NO.: D080369
SCALE: 1:1
PROJECTION: 4
SHEET: 1 OF 1