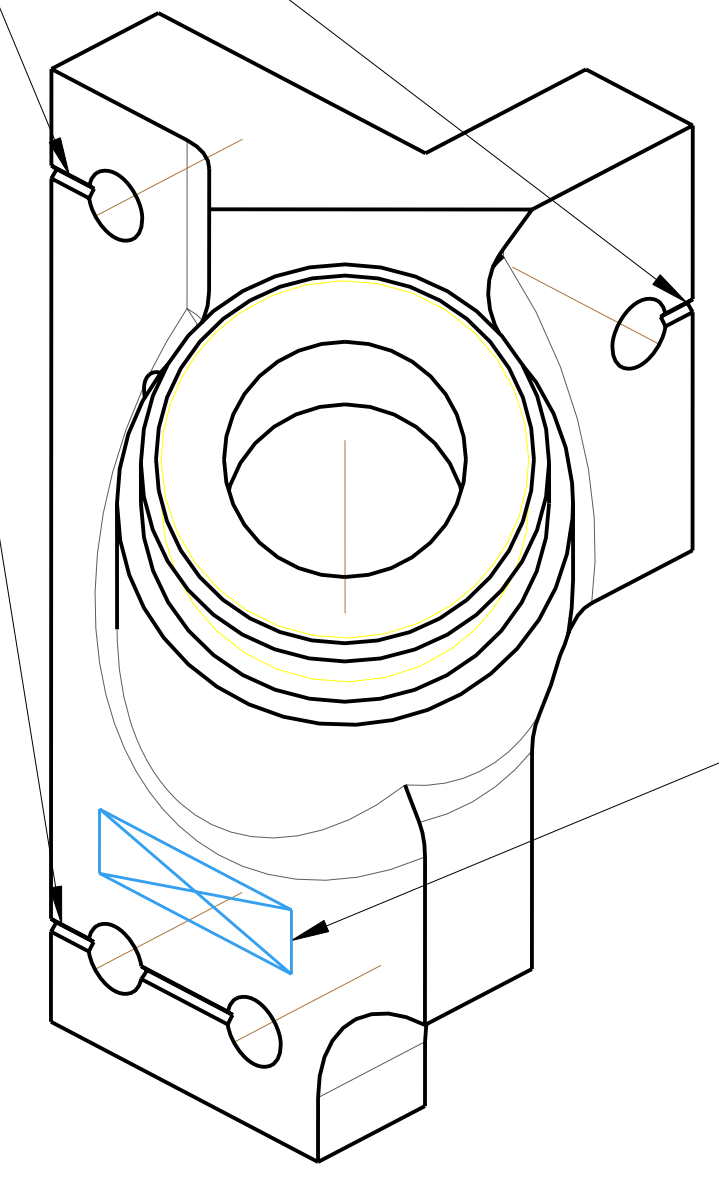
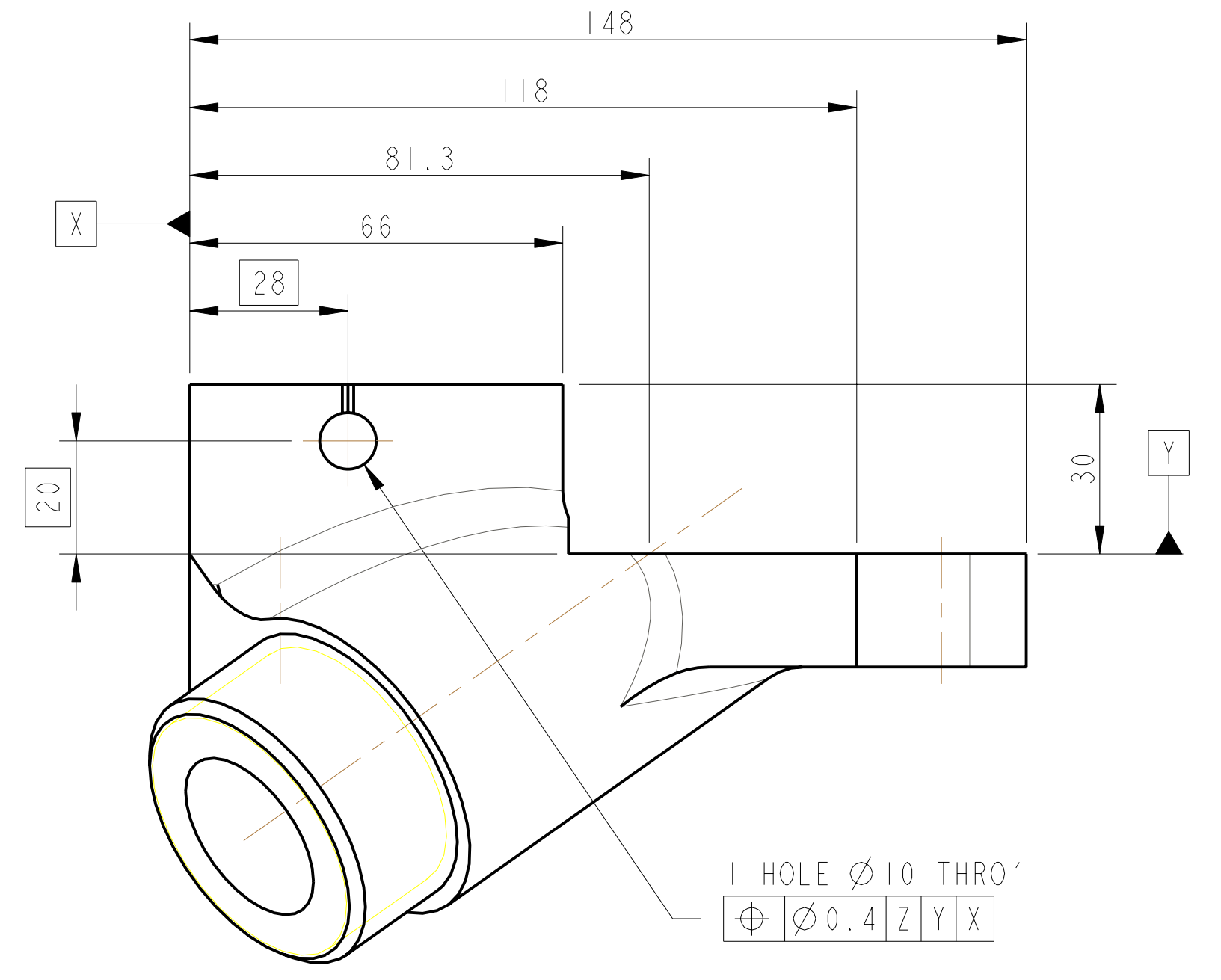
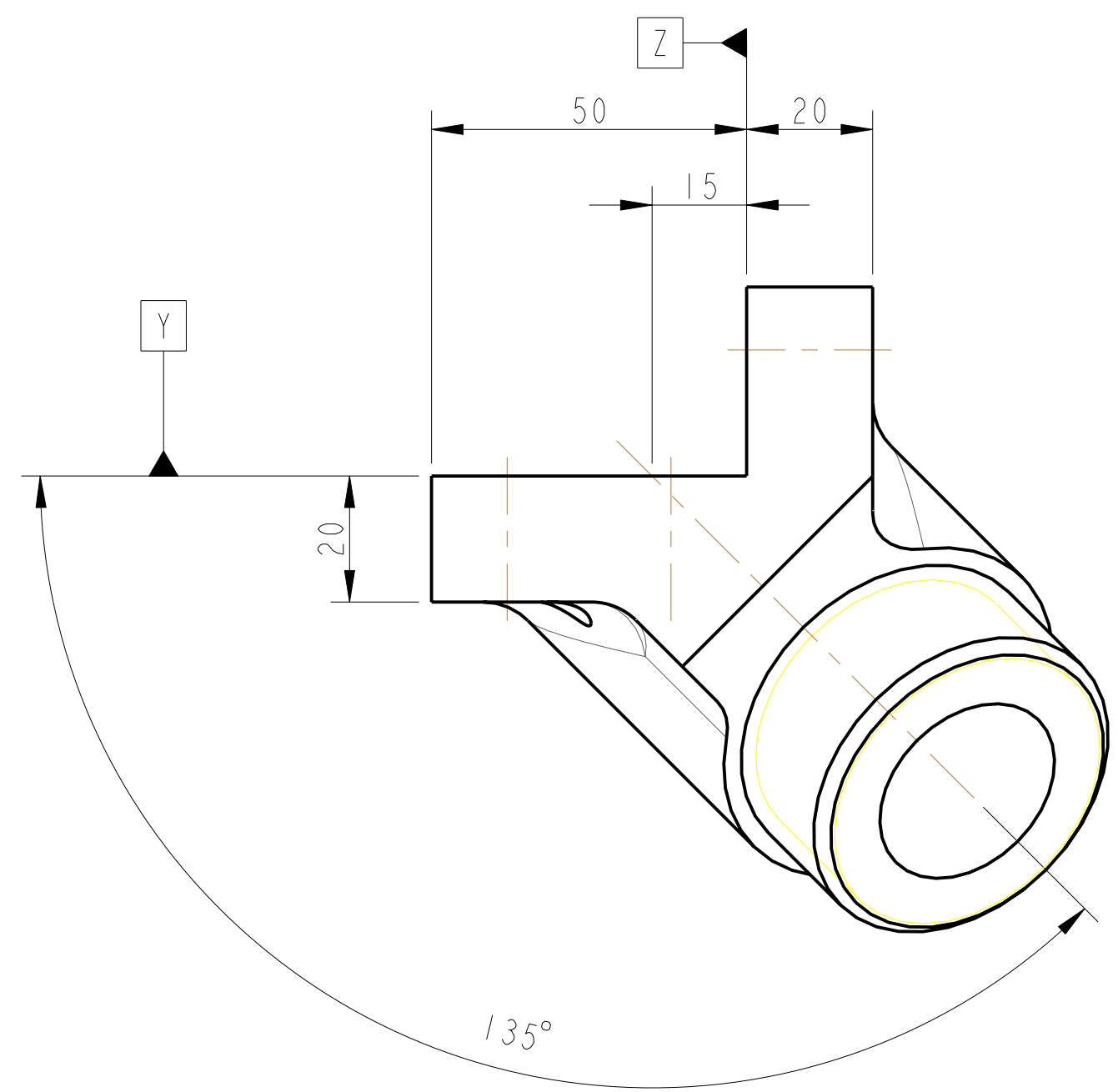


ENGRAVE 90° VEE GROOVE
(LEAK PATH) X 1 DP
3 PLACES

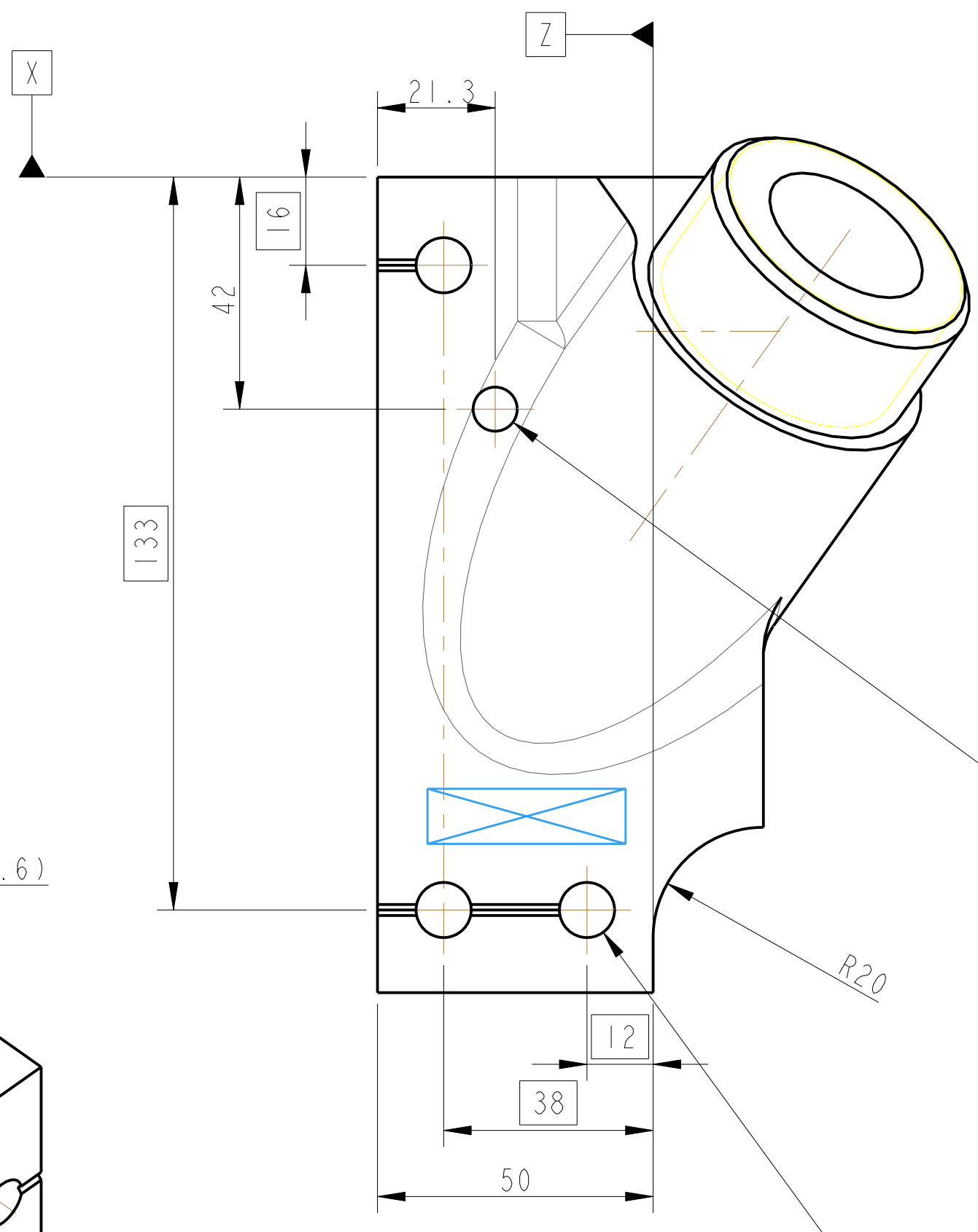
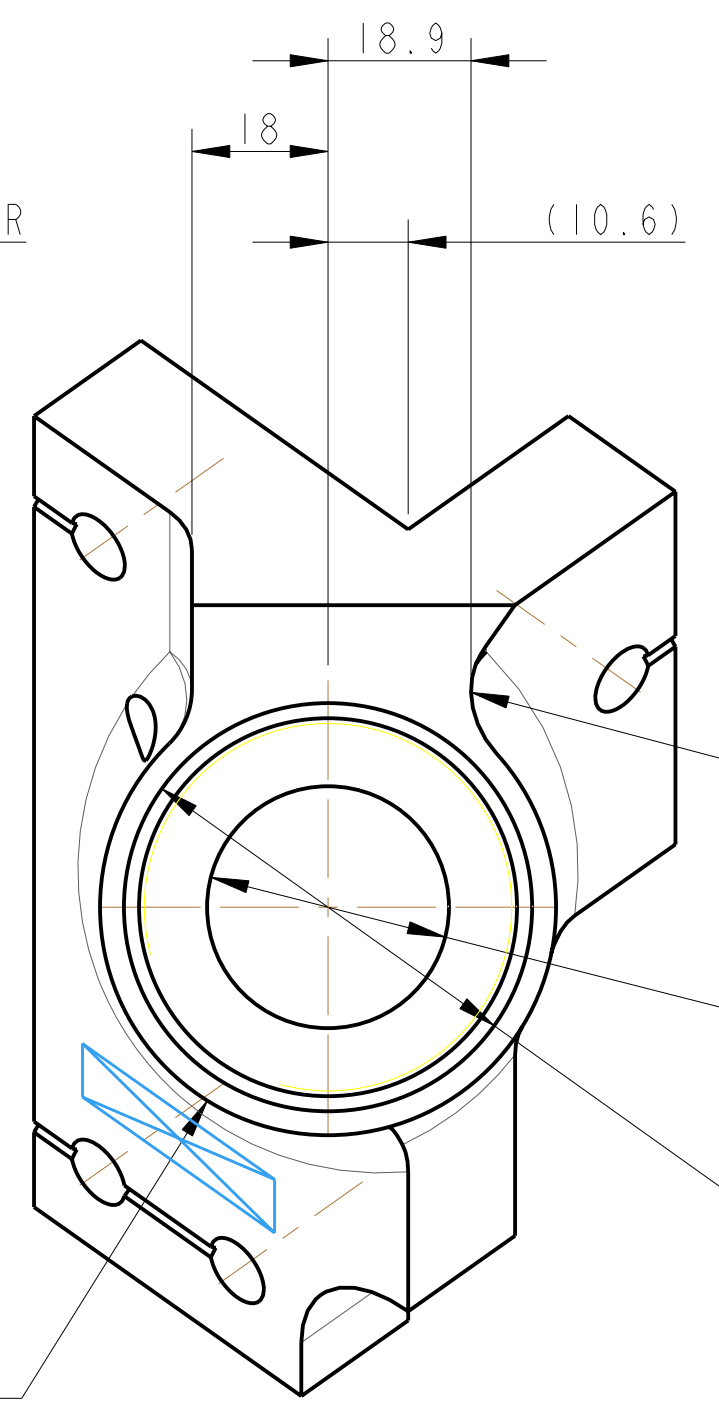
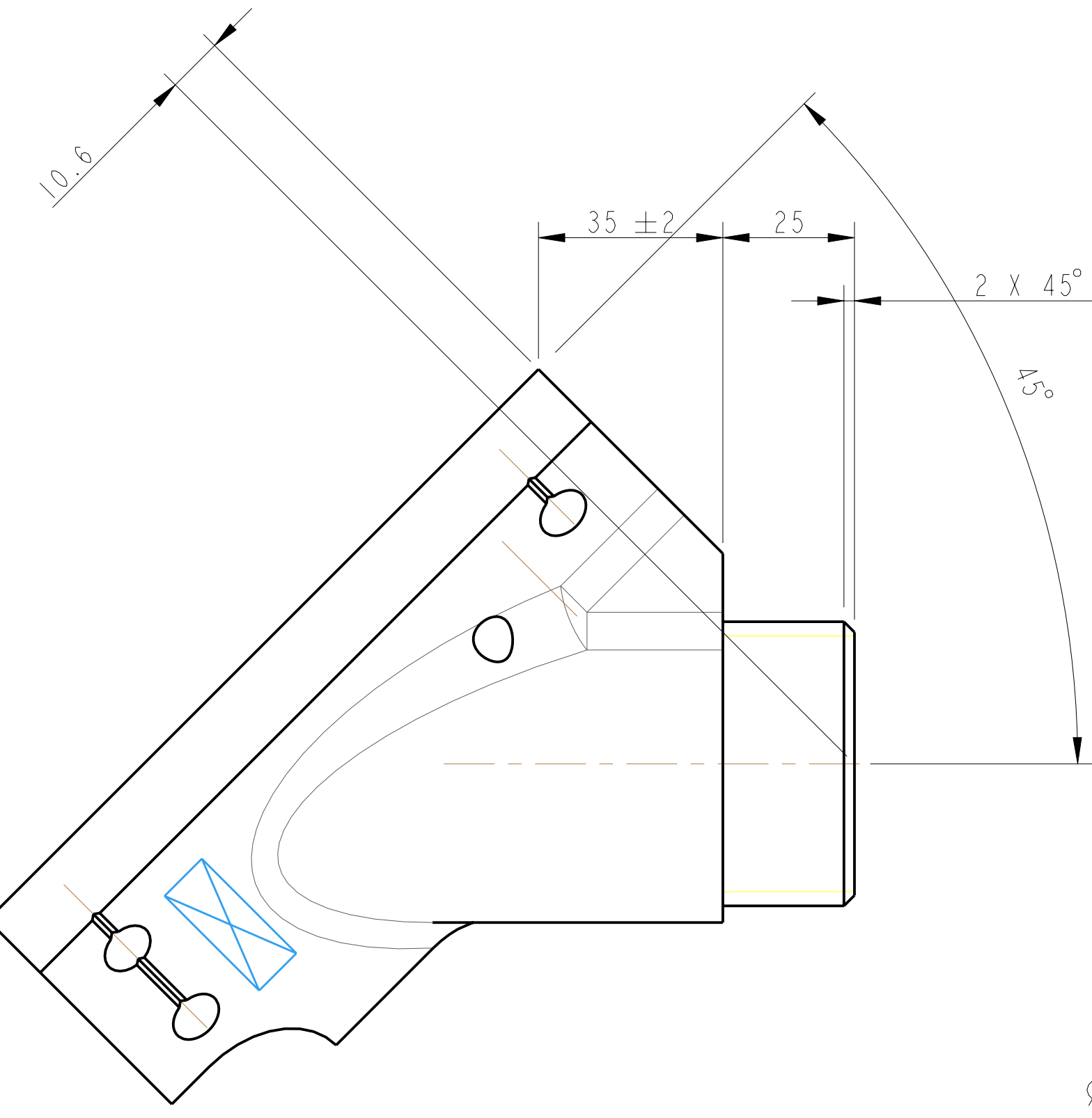


3D VIEW

PART# (SEE NOTE4) TO
BE ETCHED OR STAMPED IN
APPROX. POSITION SHOWN



1 HOLE Ø10 THRO'
⊕ Ø0.4 Z Y X



Ø8 THRO'
R20
3 HOLES Ø10 THRO'
⊕ Ø0.4 Y Z X

R10 ± 10 TYP TOOLING RAD
DRILL Ø32 X 45 DP TO DRILL POINT
THIS HOLE MAY BE DRILLED THROUGH
FOR MANUFACTURING PURPOSES,
BUT MUST IN THIS CASE BE REDUCED TO Ø20

M54 X 1.5 (F7) FULL THREAD
UP TO SHOULDER.
UNDERCUT IF NECESSARY

Ø60.3

NOTES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY	
1. REMOVE ALL SHARP EDGES. R1.02 MIN.	DIMENSIONS ARE IN mm (INCHES)	MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
2. DO NOT SCALE FROM DRAWING.	TOLERANCES:	OP. GLASGOW UNIVERSITY GEG ROU GROUP	
3. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE. SUCH AS CINCINNATI MILACRON'S CINTECH 410 (STAINLESS STEEL)	X .XX ± 0.2 ANGULAR ±0.25 °	RUTHERFORD APPLTON LABORATORIES	
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: D080506-001 - A VIBRATOR TOOL MAY BE USED.	MATERIAL: AL ALLOY S905 OR SIMILAR	SYSTEM: ADVANCED LIGO	SYSTEM: SUS
	FINISH: CLEAN, CEASE FREE √μm (1μin) Ra = 1.6	NEXT ASSY: BS/FM UPPER STRUCTURE	SUB-SYSTEM: SUS
	DRAWN: J. O'BELL 07/01/09	PART NAME: BS UPPER STRUCTURE	STAY BRACKET *1
	CHECKED: AJB	DRG. NO.: D080506	SHEET 1 OF 1
	APPROVED: JOD	SCALE: 1:1	PROJECTION: 1st