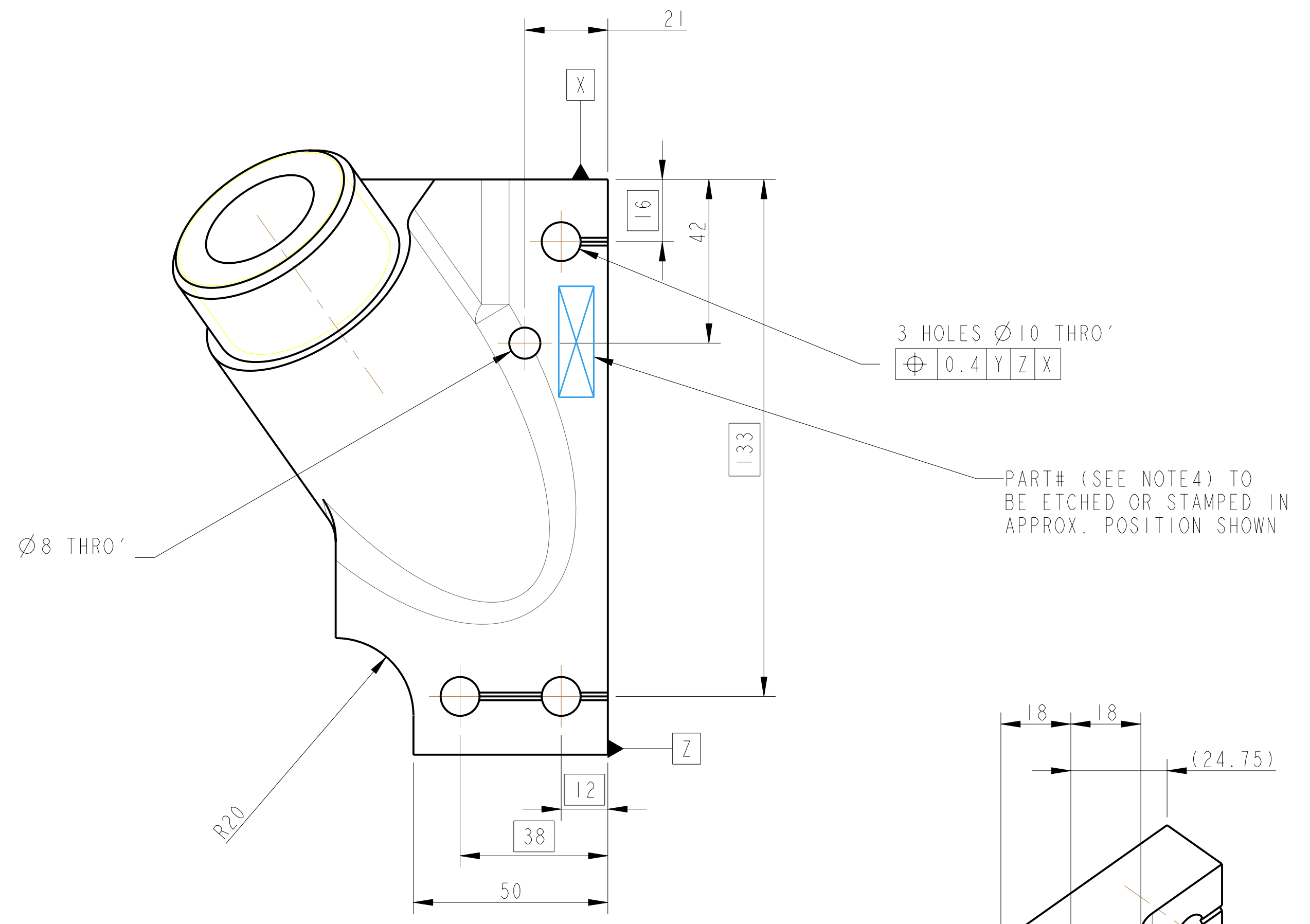


3D VIEW

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



3 HOLES $\varnothing 10$ THRO'
 $\oplus 0.4$ Y Z X

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

$\varnothing 8$ THRO'

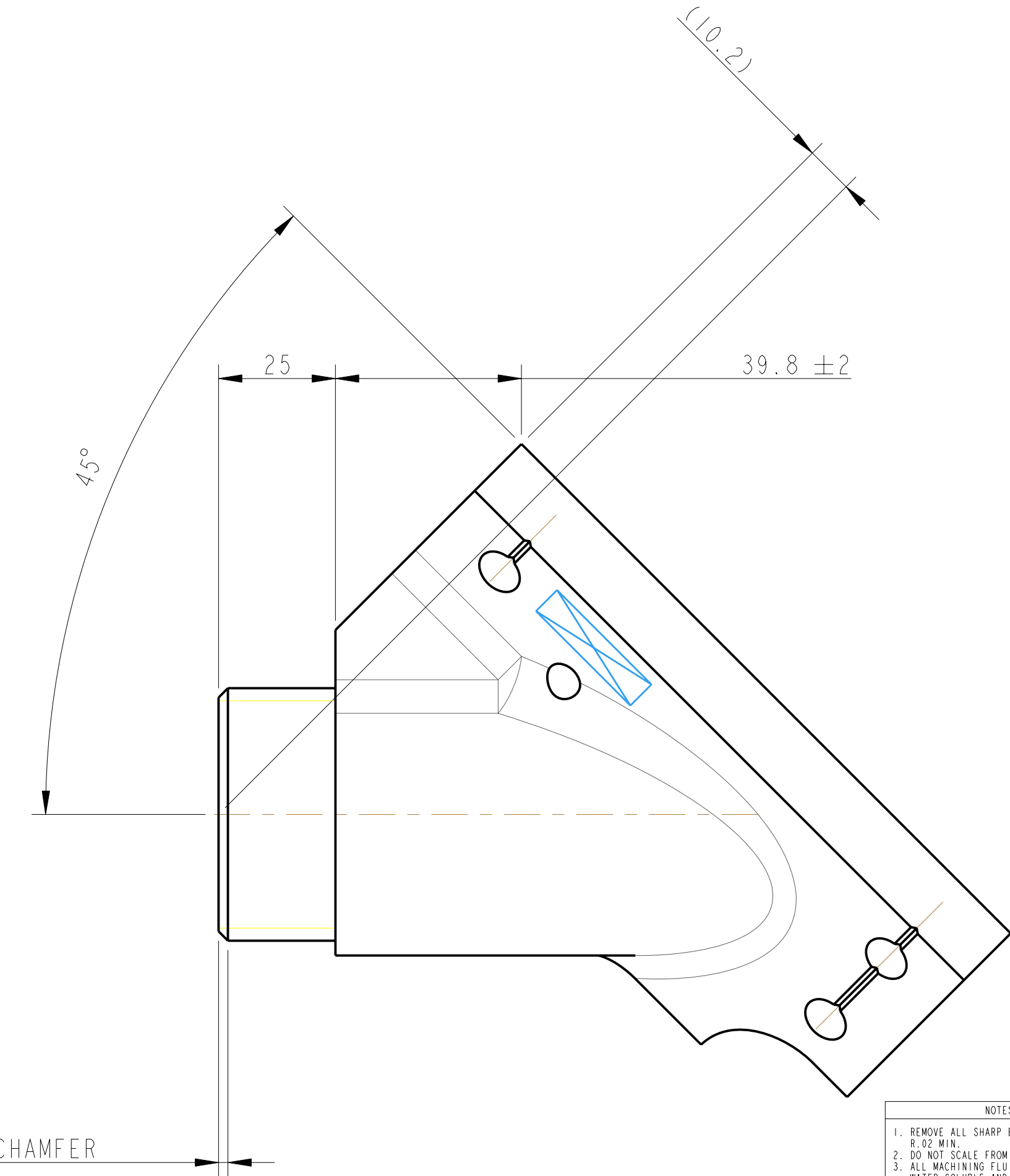
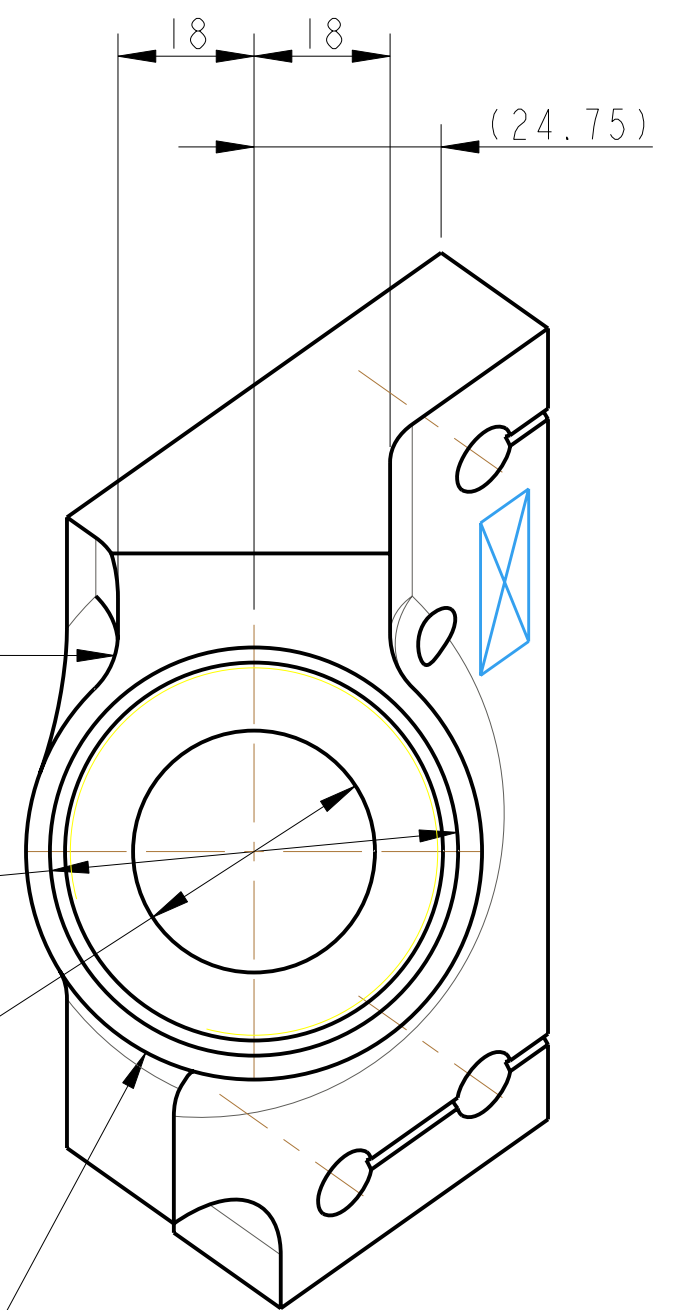
R20

R10 \pm 10 TYP TOOLING RAD

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

DRILL $\varnothing 32$ X 45 DP TO DRILL POINT
THIS HOLE MAY BE DRILLED THROUGH
FOR MANUFACTURING PURPOSES,
BUT MUST IN THIS CASE BE REDUCED TO $\varnothing 20$

$\varnothing 60.3$



NOTES: (UNLESS OTHERWISE SPECIFIED)

- REMOVE ALL SHARP EDGES. R1.0Z 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 CMTTECH 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: D080508-001 - A VIBRATORY TOOL MAY BE USED.

DIMENSIONS ARE IN mm (INCHES) TOLERANCES:

X .XX \pm 0.2
ANGULAR $\pm 0.25^\circ$

MATERIAL: AL ALLOY S903 OR SIMILAR

FINISH: CLEAN, GREASE FREE
 $\sqrt{\mu m}$ (1011) Ra = 1.6

NAME	DATE
DRAWN J. O'BELL	09/01/09
CHECKED AJB	...
APPROVED JOD	...

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY
OP. GLASGOW UNIVERSITY GEC ROX GROUP
RUTHERFORD APPLTON LABORATORIES

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: SUS
NEXT ASSY: BS/FM UPPER STRUCTURE
PART NAME: BS UPPER STRUCTURE
STAY BRACKET *3
DRG. NO.: D080508
SCALE: 1:1 PROJECTION: G