



NOTES: (UNLESS OTHERWISE SPECIFIED)

- REMOVE ALL SHARP EDGES. R.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 ±0.3 (11)  
ANGULAR ±0.25°

MATERIAL: AL ALLOY  
SUS304 OR SIMILAR

FINISH: CLEAN AND DEGREASED  
√μm (11μin) Ra = 1.6

|          |           |           |
|----------|-----------|-----------|
| DRAWN    | J. O'BELL | 29/OCT/09 |
| CHECKED  | J. O'BELL | 29/OCT/09 |
| APPROVED | JOD       | 29/OCT/09 |

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

SYSTEM: aLIGO  
SUB-SYSTEM: SUS  
NEXT ASSY: QUAD TOOLING  
PART NAME: TOP PLATE LARGE  
(LOWER STRUCTURE TOOLING)  
DRG. NO.: D060300  
SCALE: 1:21 PROJECTION: SHEET 1 OF 1