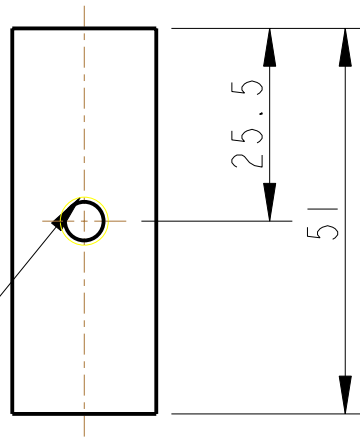
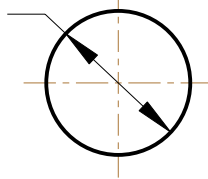


REV.	DATE	DCN #	DRAWING TREE #



DRILL AND TAP 1/4-20 UNC THRO

Ø 19.05 STOCK



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: ST STEEL  
300 SERIES

FINISH: CLEAN AND DEGRASED  
√μm [μin] Ra = 1.6 OR STOCK

	NAME	DATE
DRAWN	I WILMUT	22/Sep/06
CHECKED	J'OD	21/FEB/07
APPROVED	IW	22/FEB/07



SYSTEM **ADVANCED LIGO**

SUB-SYSTEM **SUS**

NEXT ASSY **QUAD N-PTYPE TOOLING**

PART NAME **LONG BARREL NUT  
(LOWER STRUCTURE TOOLING)**

SIZE <b>A</b>	DRG. NO. <b>D060301</b>	REV <b>C.</b>
SCALE 1:1	PROJECTION:	SHEET 1 OF 1