



NOTE:
ENDS MUST BE SQUARE
(SEE ANGULAR TOLERANCE)

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 (1)
ANGULAR ±0.1°

MATERIAL: AL ALLOY S903 OR SIMILAR
FINISH: CLEAN AND DEGREASED √um (1μm) Ra = 1.6 OR STOCK

NAME	DATE
DRAWN J. O'BELL	08/JUN/10
CHECKED J. O'D	08/JUN/10
APPROVED JOD	08/JUN/10

CALIFORNIA INSTITUTE OF TECHNOLOGY
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RUTHERFORD APPLTON LABORATORIES

SYSTEM: **ADVANCED LIGO**
SUB-SYSTEM: **SUS**
NEXT ASSY: **QUAD N-PTYPE TOOLING**
PART NAME: **LEG**
(LOWER STRUCTURE TOOLING)

DRG. NO.: **D1001500**
SCALE: 1:21 PROJECTION: SHEET 1 OF 1