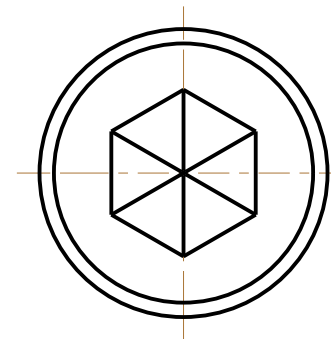
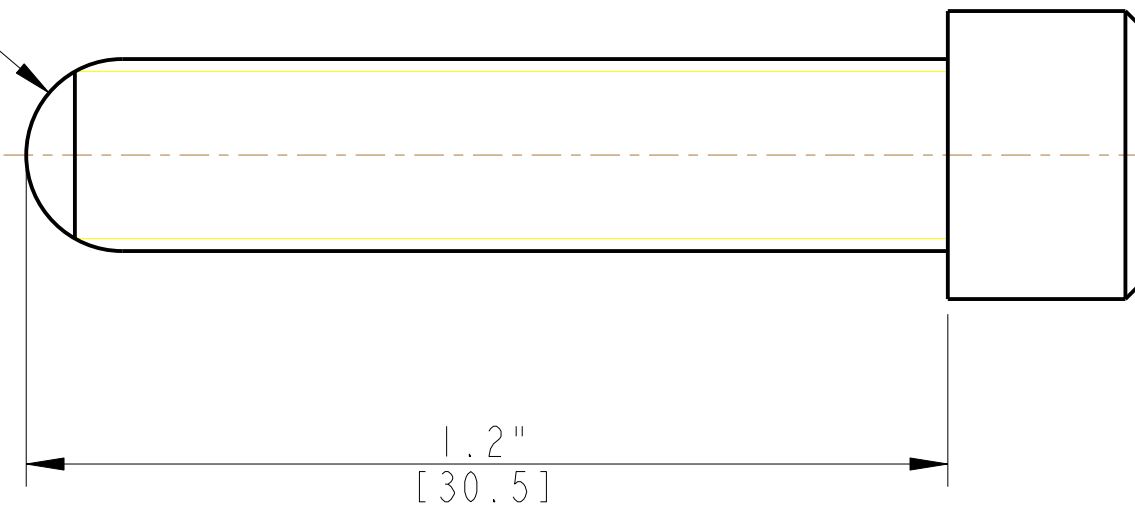


(R0.13")
FULL RAD



NOTE:

USE A STANDARD 1/4-20 UNC SCREW, FULLY THREADED (EXTEND THREAD IF NECESSARY) AND MACHINE TO THE SPECIFIED LENGTH, AND CREATE ROUND TIP

ADDITIONAL NOTES:

5. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
7. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO), REFER TO LIGO-E0900364.
8. NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. IN GENERAL WELD REPAIRS AND PRESS FIT INSERT REPAIRS ARE NEVER ACCEPTABLE; THE MATERIAL SHOULD BE MADE WITH VIRGIN MATERIAL. SPECIAL CIRCUMSTANCES CAN BE REVIEWED IF/WHEN BROUGHT TO THE ATTENTION OF LIGO CONTRACTING OFFICERS REPRESENTATIVE (COTR) THROUGH A MATERIAL REVIEW BOARD (MRB) PROCESS, REFER TO LIGO-E0900364.

NOTES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY IGR, GLASGOW UNIVERSITY GEO 600 GROUP RUTHERFORD APPLETON LABORATORIES	
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:		SYSTEM ADVANCED LIGO QUAD
	X.XX ±0.2 mm ANGULAR ±0.25 °		SUB-SYSTEM SUS
	MATERIAL: ST. STEEL 304-316		NEXT ASSY D1101963
	FINISH: CLEAN, GREASE FREE √μm [μin] Ra = 1.6		PART NAME 1/4" 20 UNC CAP HEAD, SPHERICAL TIP QUAD SHORT EQ STOPS
	NAME	DATE	SIZE B
DRAWN	J O'DELL	12/OCT/11	DRG. NO. D1101960
CHECKED	J'OD	12/OCT/11	REV A.
APPROVED	JOD	12/OCT/11	SCALE 4:1 PROJECTION: SHEET 1 OF 1