

4

3

2

1

NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	14 JUL 2009	E0900198	E080191
v2	18 MAY 2010	E1000166	E080191
-	-	-	-

D

D

C

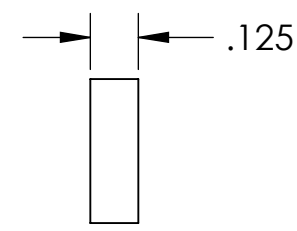
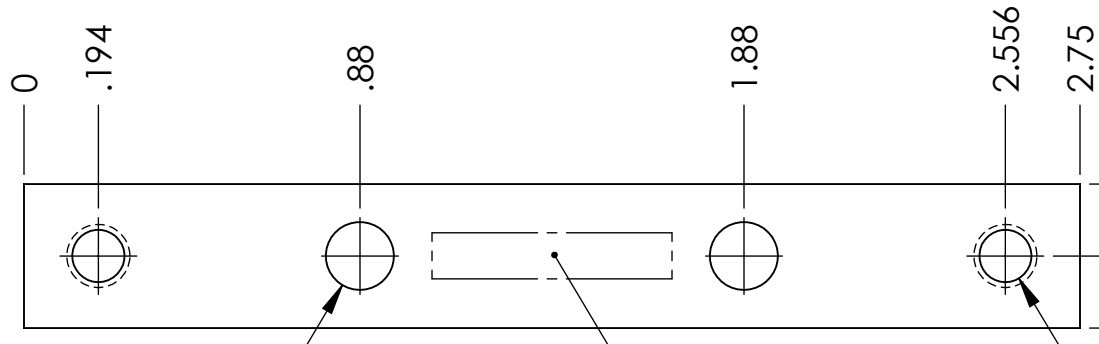
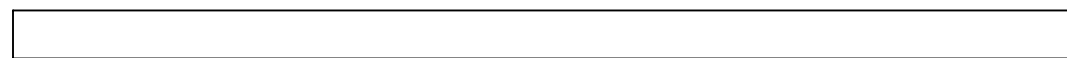
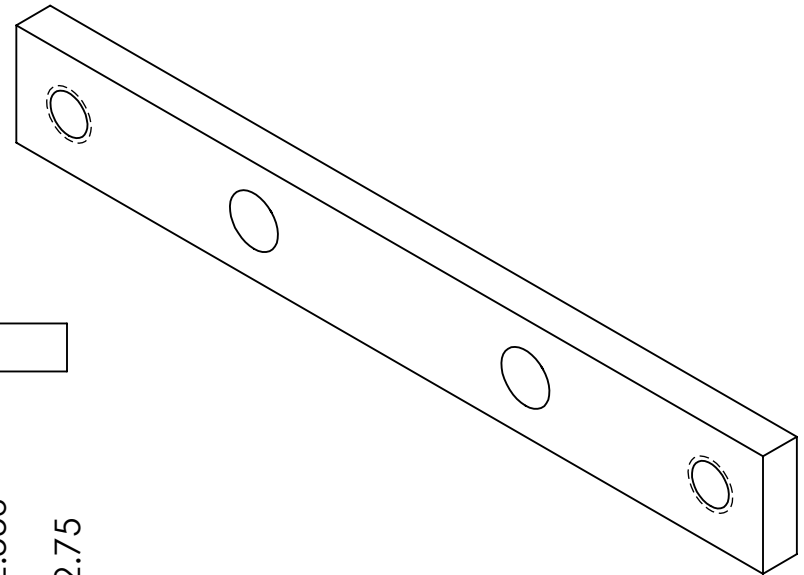
C

B

B

A

A



2X ϕ .177 THRU

5

2X #8-32 UNC THRU ALL +.005 OVERSIZE TAP

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES	1. INTERPRET DRAWING PER ASME Y14.5-1994.
TOLERANCES: .XX \pm .01 .XXX \pm .005	2. REMOVE ALL SHARP EDGES, R.02 MIN.
ANGULAR \pm 0.5°	3. DO NOT SCALE FROM DRAWING.
	4. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.
MATERIAL 304, 316 OR 302 SSSL	FINISH 32 μ inch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **SUS**

NEXT ASSY: **UPPER MASS ASSY**

PART NAME GUARD, LOWER BLADE		DESIGNER D. BRIDGES	DATE 07 JUL 2010	SIZE A	DWG. NO. D080221	REV. v2
DRAFTER D. BRIDGES		DATE 07 JUL 2010		SCALE: 2:1		PROJECTION:
CHECKER C. TORRIE		DATE 09 JUL 2010		SHEET 1 OF 1		
APPROVAL						