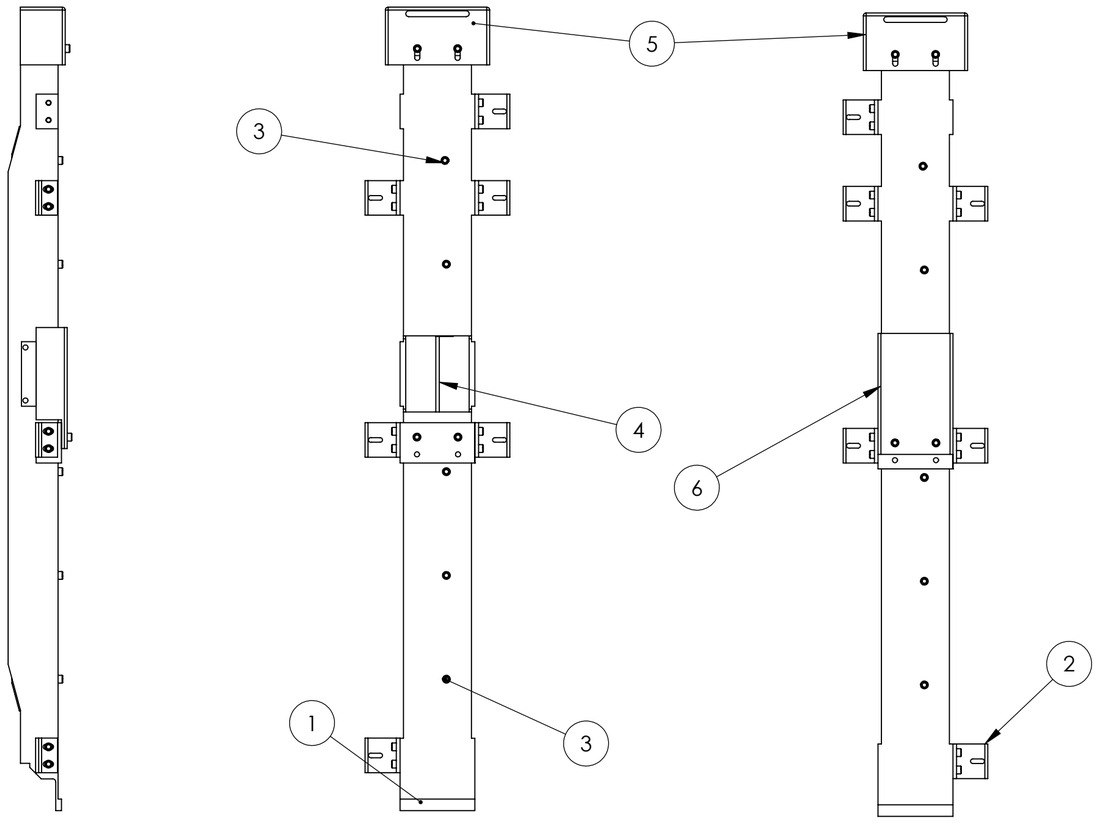
NOTES CONTINUED:

⟨5⟩ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.

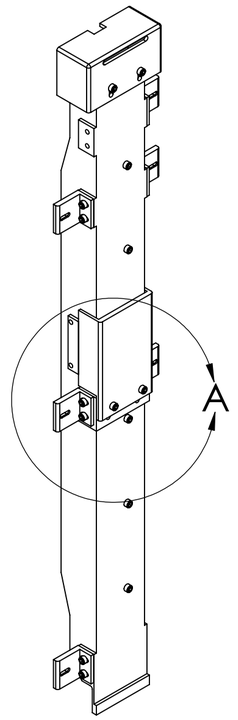
⟨6⟩ MACHINE ALL SURFACES.

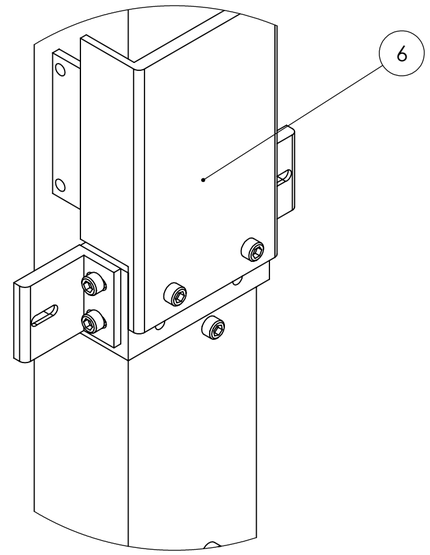
⟨7⟩ ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY. USE NITRONIC 60 THREAD INSERTS.

REV.	DATE	DCN #	DRAWING TREE #
-	-	-	-
-	-	-	-
-	-	-	-



BLANKING PLATE IN PLACE





DETAIL A
SCALE 1 : 1.5

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
7		#8-32 HELICOIL THREADINSERTS1*Diameter	NITRONIC 60	31		31
6	D1102271	fibre guard window cover	6061-T6 Al	1		1
5	D1001660	FIBRE GUARD TOP CAP	6061-T6 (SS)	1		1
4	D0902508	FIBRE GUARD SEPERATOR	6061-T6 (SS)	1		1
3	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 0.3125 LONG	Ag-PLATED 300 SSTL	21		21
2	D1102285	REPLACEMENT Angle Section 4	6061-T6 (SS)	6		6
1	D0902507	FIBRE GUARD MAIN BODY	6061-T6 (SS)	1		1

PARTS LIST

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN MILLIMETERS

TOLERANCES:
.XX ± .10
.XXX ± .010

ANGULAR ± 0.2°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, R.02 MIN.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

MATERIAL N/A

FINISH 1.6 µm

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO

SUB-SYSTEM SUS

NEXT ASSY

PART NAME FIBRE GUARD ASSEMBLY

DESIGNER	L Cunningham	25/06/10
DRAFTER		
CHECKER		
APPROVAL		

SIZE C **DWG. NO.** D0902506 **REV.** V9

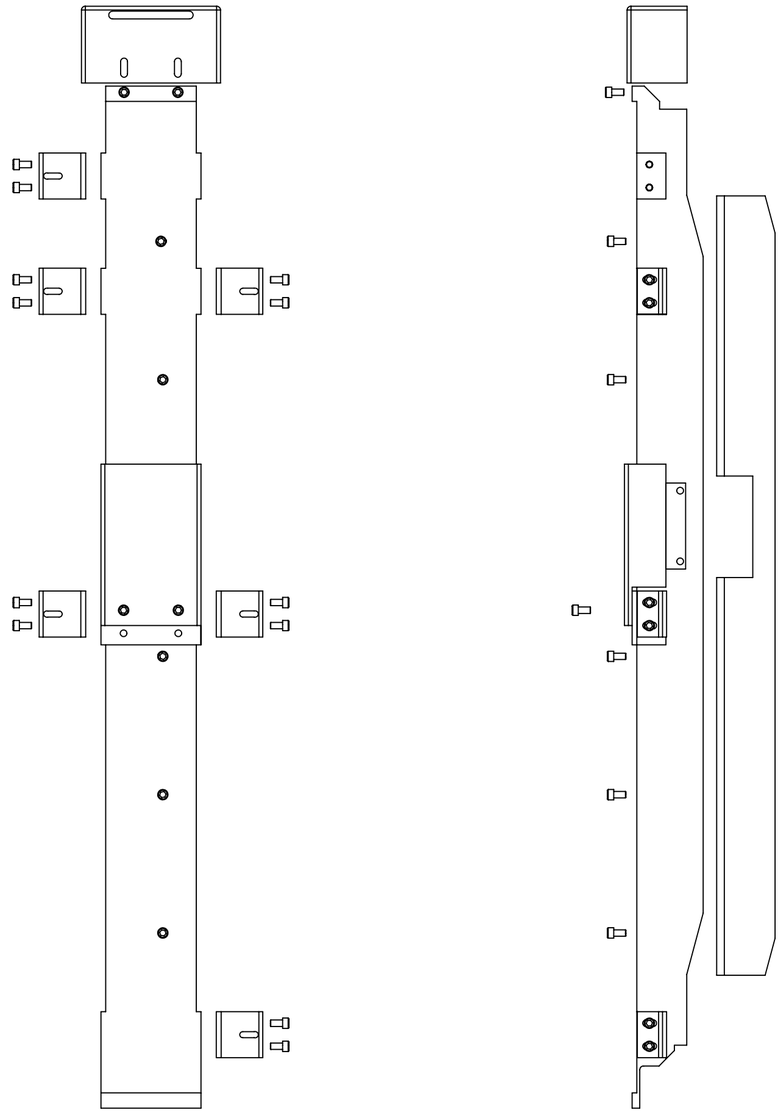
SCALE: 1:4 **PROJECTION:** SHEET 1 OF 2

NOTES CONTINUED:

⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS.
EXAMPLE: DXXXXXXX-VY, S/N 001.
A VIBRATORY TOOL MAY BE USED.

⑥ MACHINE ALL SURFACES.

REV.	DATE	DCN #	DRAWING TREE #



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)									
DIMENSIONS ARE IN MILLIMETERS TOLERANCES: .XX ± .10 .XXX ± .010 ANGULAR ± 0.2°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: FIBRE GUARD ASSEMBLY				
	MATERIAL: N/A	FINISH: 1.6 µm	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: SUS	DESIGNER: L Cunningham	25/06/10	SIZE: C	DWG. NO.: D0902506	REV.: V9
			NEXT ASSY		DRAFTER				
					CHECKER				
					APPROVAL		SCALE: 1:4	PROJECTION:	SHEET 2 OF 2