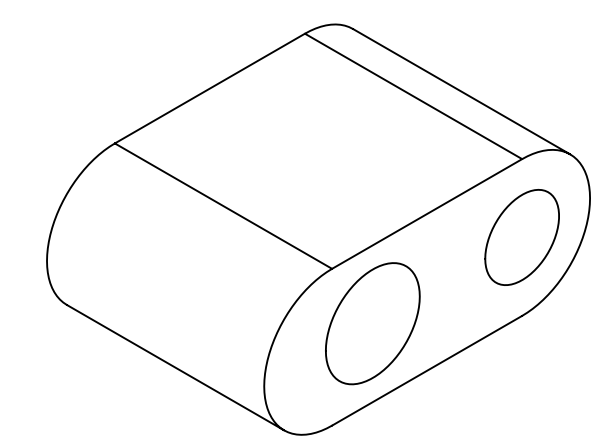
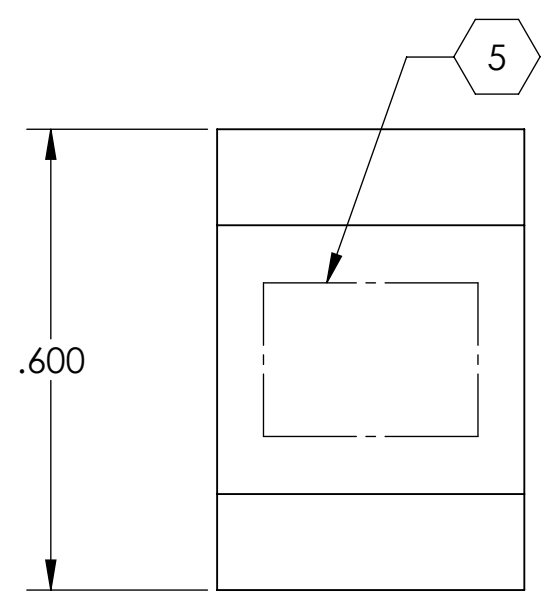


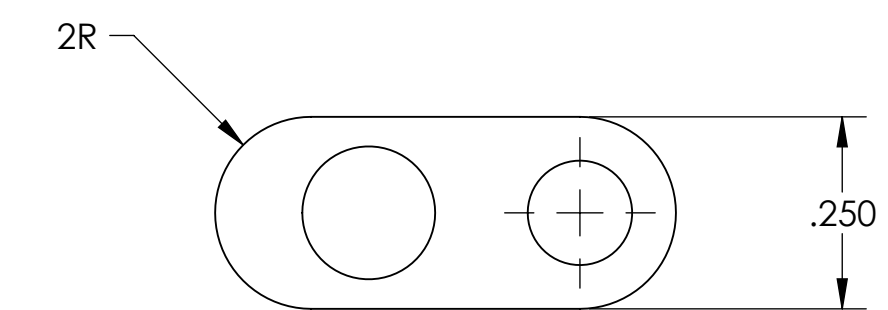
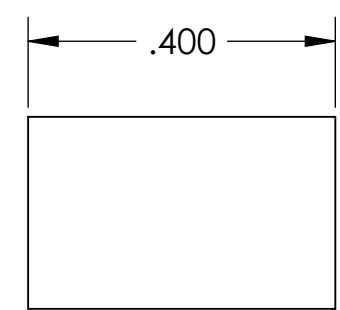
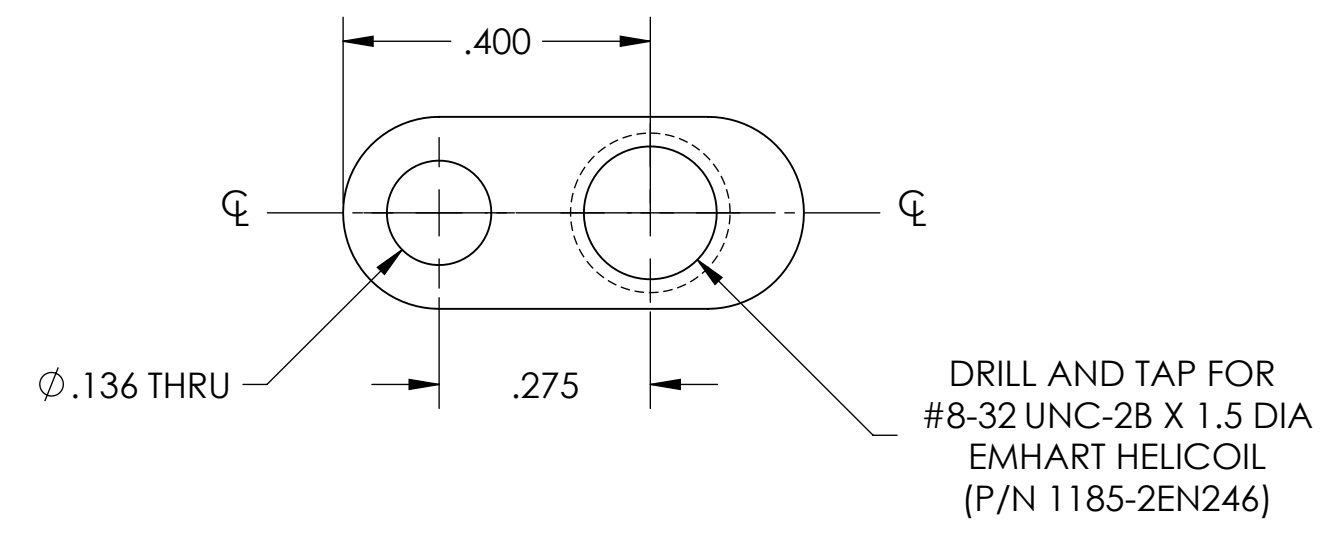
NOTES CONTINUED:

- 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 101 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. APPROXIMATE WEIGHT = 0.012 LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
- 10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	09 JUL 2010	E0900501	E0900353
-	-	-	-
-	-	-	-



ISOMETRIC VIEW



<p>NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)</p> <p>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.</p>		<p>LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY</p>		<p>PART NAME LOCKING ASSY, BLADE GUARD</p>							
<p>DIMENSIONS ARE IN INCHES</p> <p>TOLERANCES: .XX ± .03 .XXX ± .005</p> <p>ANGULAR ± 0.5°</p>		<p>SYSTEM ADVANCED LIGO</p>		<p>SUB-SYSTEM SUS</p>		<p>DESIGNER B. MOORE 06 JUL 2010 DRAFTER B. MOORE 08 JUL 2010 CHECKER M. MEYER 08 JUL 2010 APPROVAL</p>		<p>SIZE DWG. NO. c D1001656</p>		<p>REV. v1</p>	
<p>MATERIAL 304, 316 OR 302 SSTL</p>		<p>FINISH 32 μinch</p>		<p>NEXT ASSY D020535</p>		<p>SCALE: 4:1 PROJECTION: </p>		<p>SHEET 1 OF 1</p>			