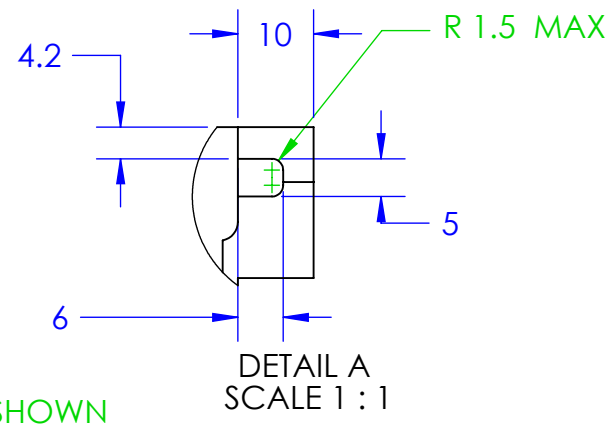


**NOTES CONTINUED:**  
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: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

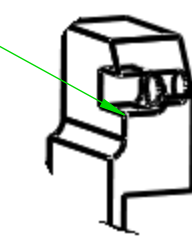
⑥ MACHINE ALL SURFACES.

⑦ USE ONLY NITRONIC 60 HELICOILS

REV.	DATE	DCN #	DRAWING TREE #



SLOT CUT FOR THREADED PART OF CAPTIVE SCREW



#8-32 UNC OVERSIZE .005" THRU ALL

2X TAP FOR #8-32 HELICOIL THRU BOTH SIDES

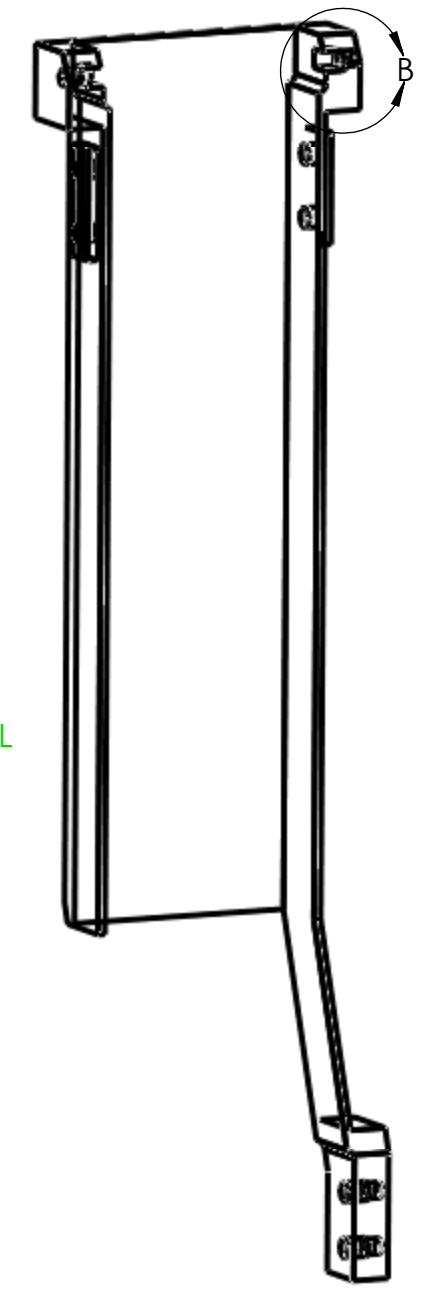
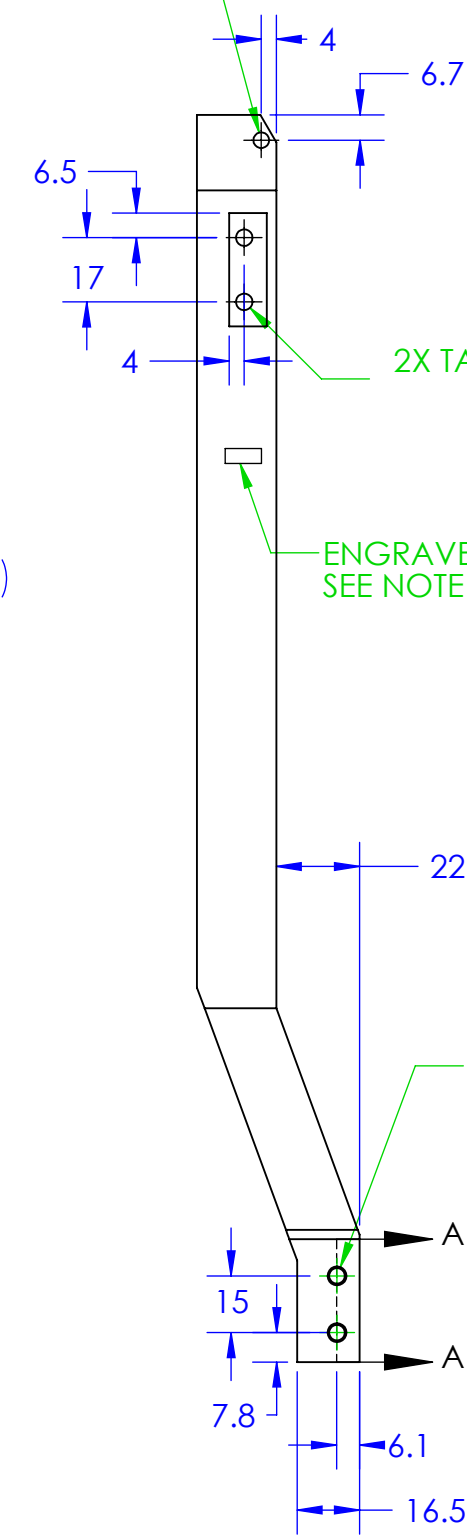
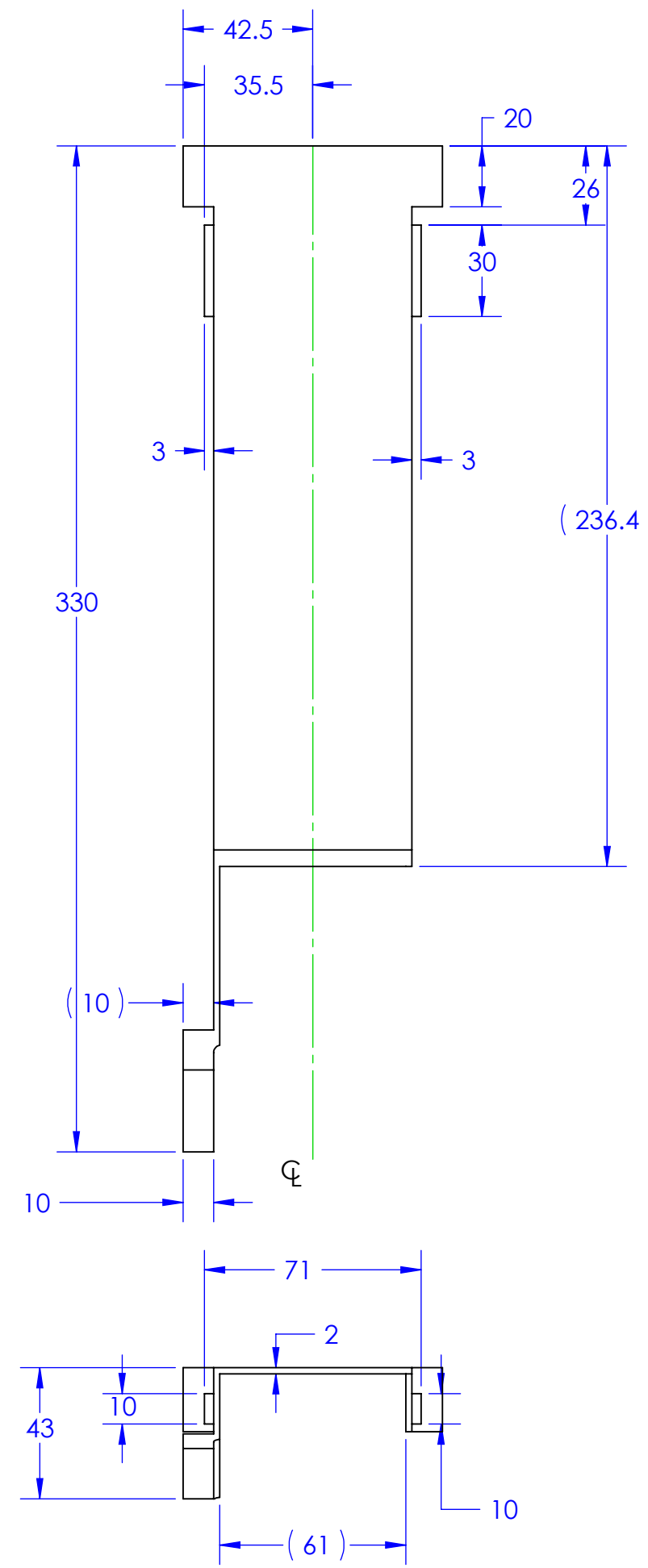
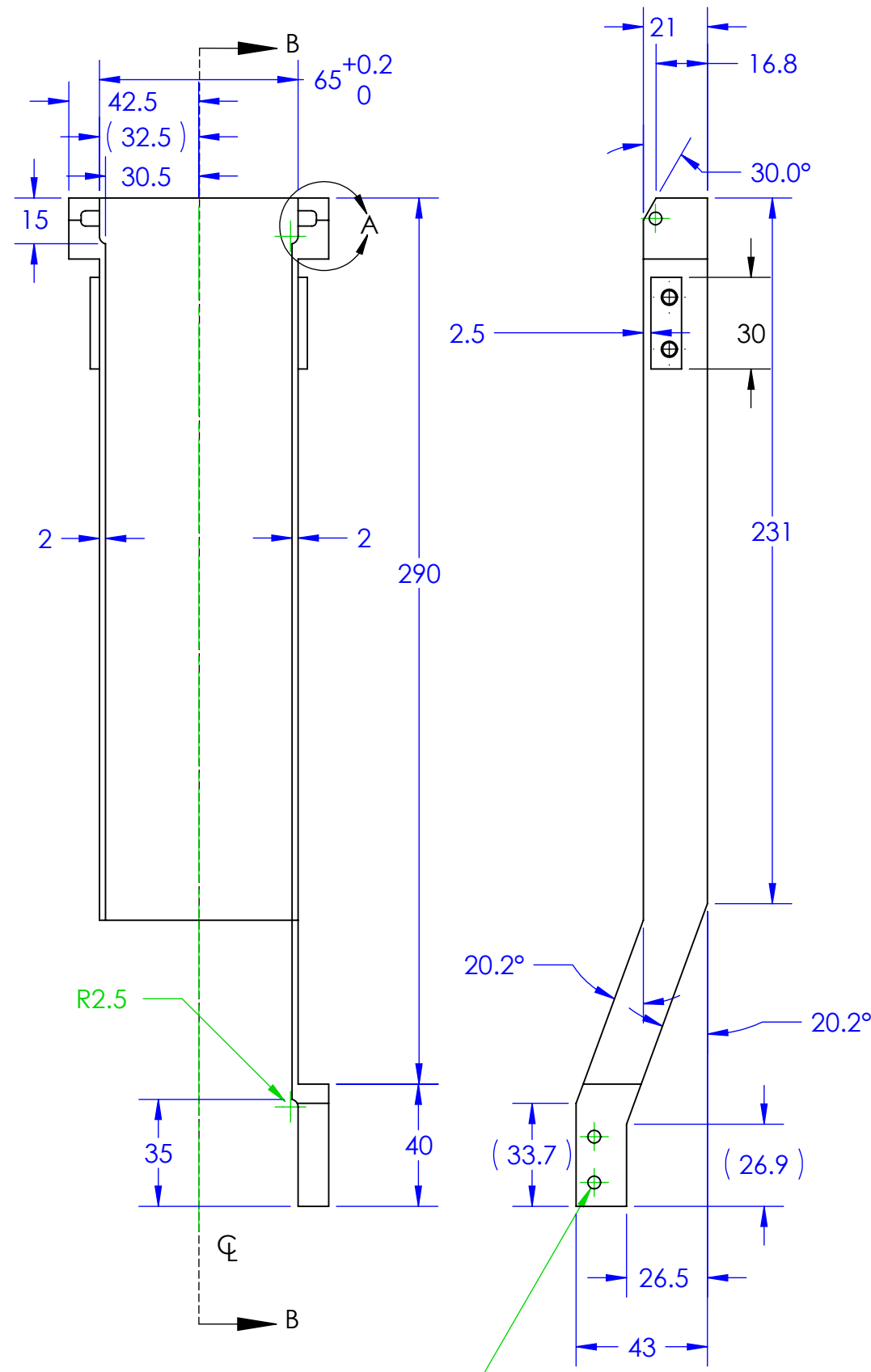
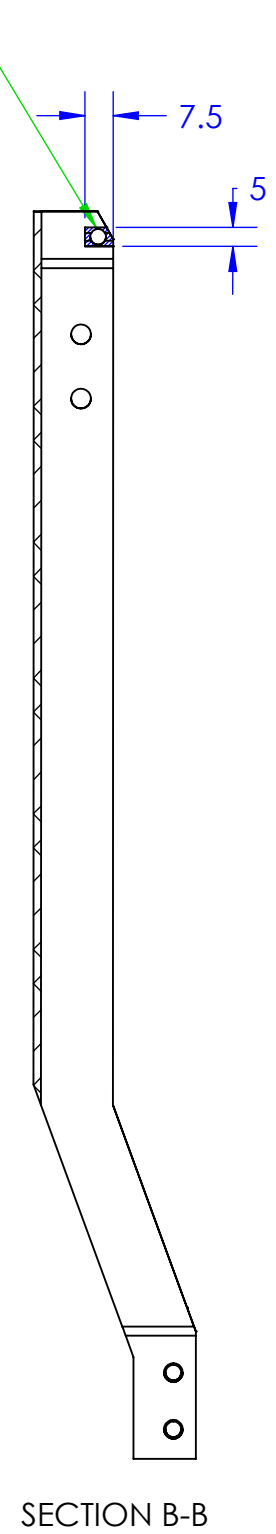
ENGRAVE PART NO SEE NOTE 5

2 X  $\perp$   $\phi 5 \nabla 6$

2 X 8-32 UNC OVERSIZE .005" THRU  $\perp$   $\phi 5 \nabla 6$  ON INSIDE SURFACE

SECTION A-A  
SCALE 1 : 1

2X SLOTS 7.5  $\nabla$  CUT AS SHOWN FOR CAPTIVE SCREWS



**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, R.5 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** 6061-T6 Al **FINISH** 1.6  $\mu$ m

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

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

NEXT ASSY

PART NAME: **fibre guard internal section right side**

DESIGNER	L.CUNNINGHAM	02/11/11	SIZE	DWG. NO.	REV.
DRAFTER	L.Cunningham	03/11/11	c	<b>D1102148</b>	v5
CHECKER	R.JONES	14/11/11			
APPROVAL			SCALE: 1:2	PROJECTION:	SHEET 1 OF 1

DIMENSIONS ARE IN MM  
 TOLERANCES:  
 .X  $\pm$  0.1  
 .XX  $\pm$  0.01  
 ANGULAR  $\pm$  0.2°