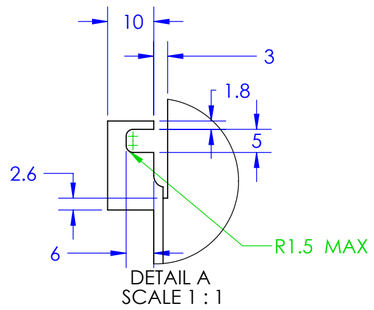
NOTES CONTINUED:

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 USE ONLY NITRONIC 60 HELICOILS

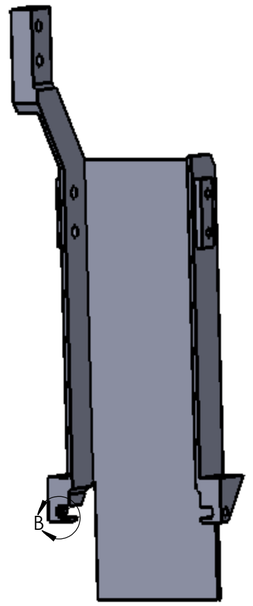
REV.	DATE	DCN #	DRAWING TREE #



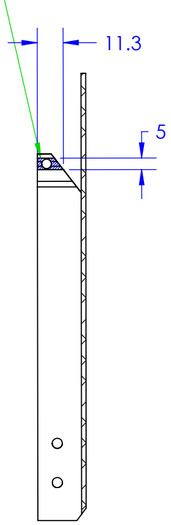
DETAIL A
SCALE 1 : 1

SLOT CUT THRU FOR CATIVE SCREW THREADED PART

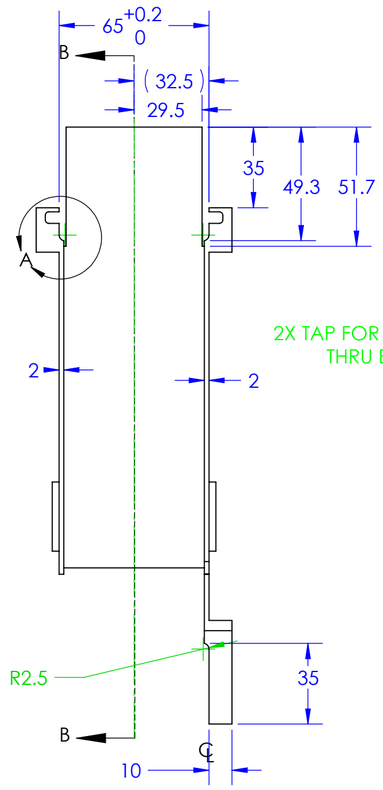
DETAIL B
SCALE 1 : 1



2X THRU SLOTS CUT AS SHOWN FOR CAPTIVE SCREWS

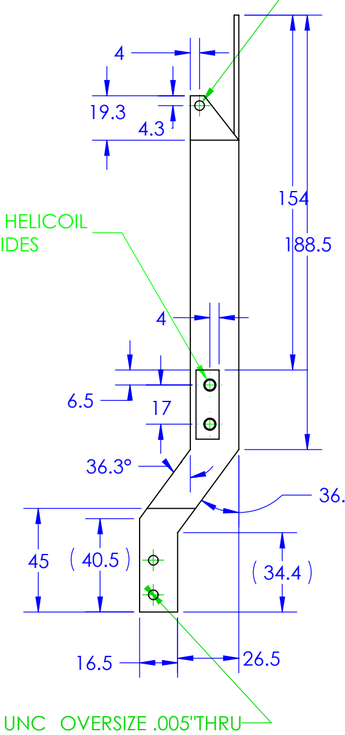


SECTION B-B

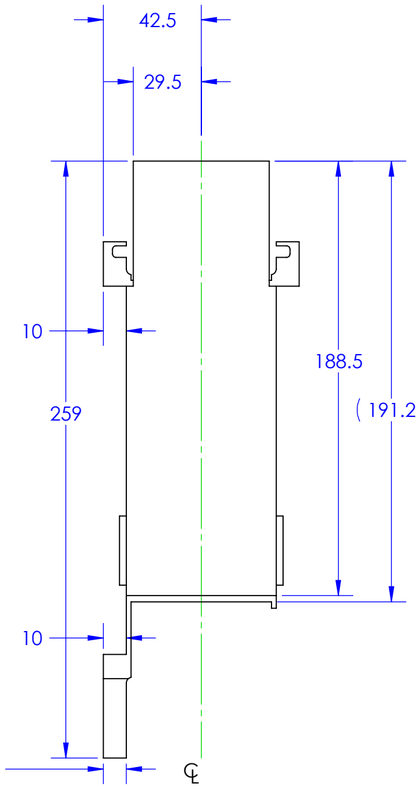


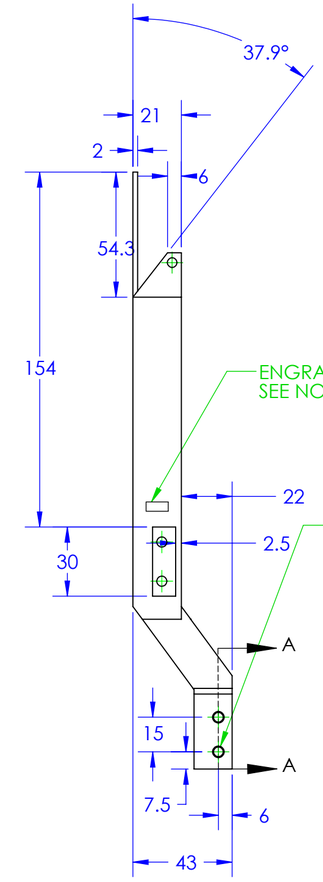
#8-32 UNC OVERSIZE .005" THRU ALL

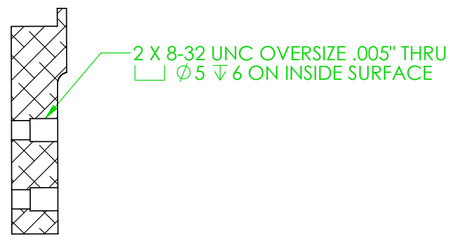
2X TAP FOR #8-32 HELICOIL THRU BOTH SIDES



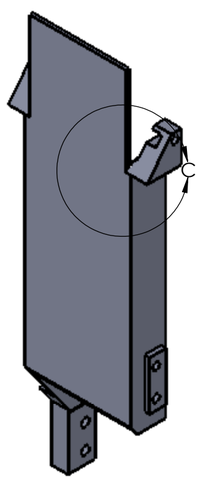
2X #8-32 UNC OVERSIZE .005"THRU

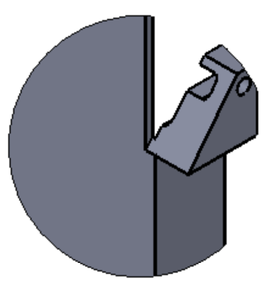




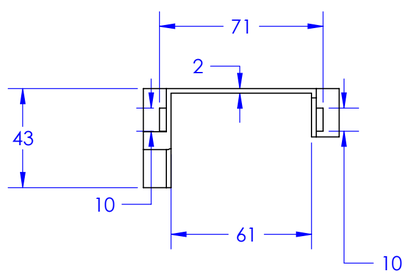


SECTION A-A
SCALE 1 : 1





DETAIL C
SCALE 1 : 1



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN MM

TOLERANCES:
.X ± 0.1
.XX ± 0.01

ANGULAR ± 0.2°

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 µm

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO

SUB-SYSTEM SUS

NEXT ASSY

PART NAME FIBRE GUARD INTERNAL SECTION TOP RIGHT SIDE

DESIGNER	L.CUNNINGHAM	02/11/11	
DRAFTER	L Cunningham	03/11/11	
CHECKER	R.JONES	14/11/11	
APPROVAL			

SIZE C **DWG. NO.** D1102150 **REV.** V5

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