NOTES CONTINUED:

Ⓢ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK 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. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

6. APPROXIMATE WEIGHT = 2.40 LB.

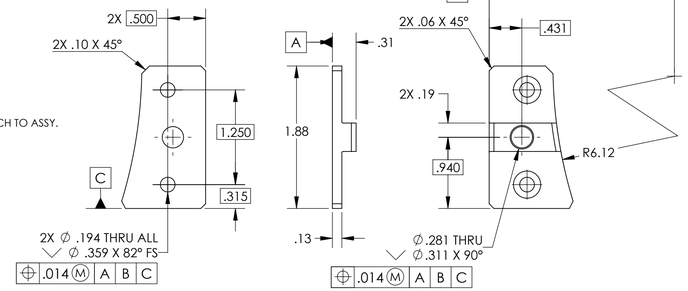
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

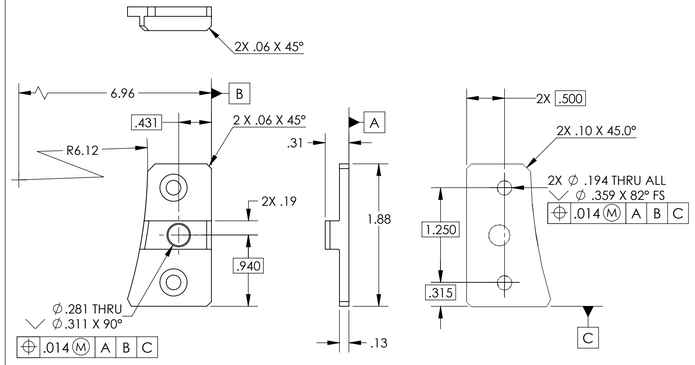
9. UNLESS OTHERWISE SPECIFIED MACHINE FILLET RADII .015 - .030

⑩ ITEM 5: DO NOT INSTALL RETAINING RINGS. BAG, TAG, AND ATTACH TO ASSY.

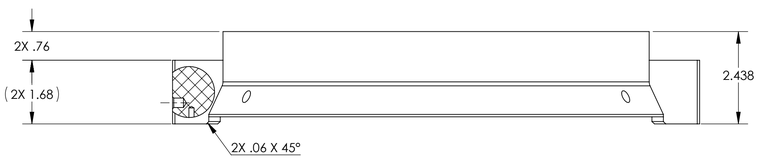
REV.	DATE	DCN #	DRAWING TREE #
v1	22 MAR 2012	E1200307-x0	-
-	-	-	-
-	-	-	-

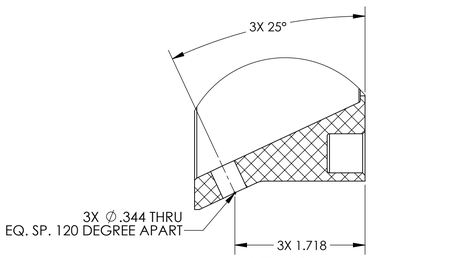


-103 DETAIL

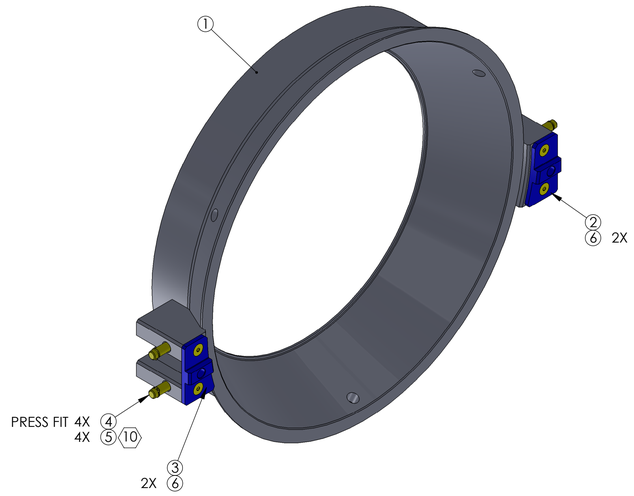


-102 DETAIL

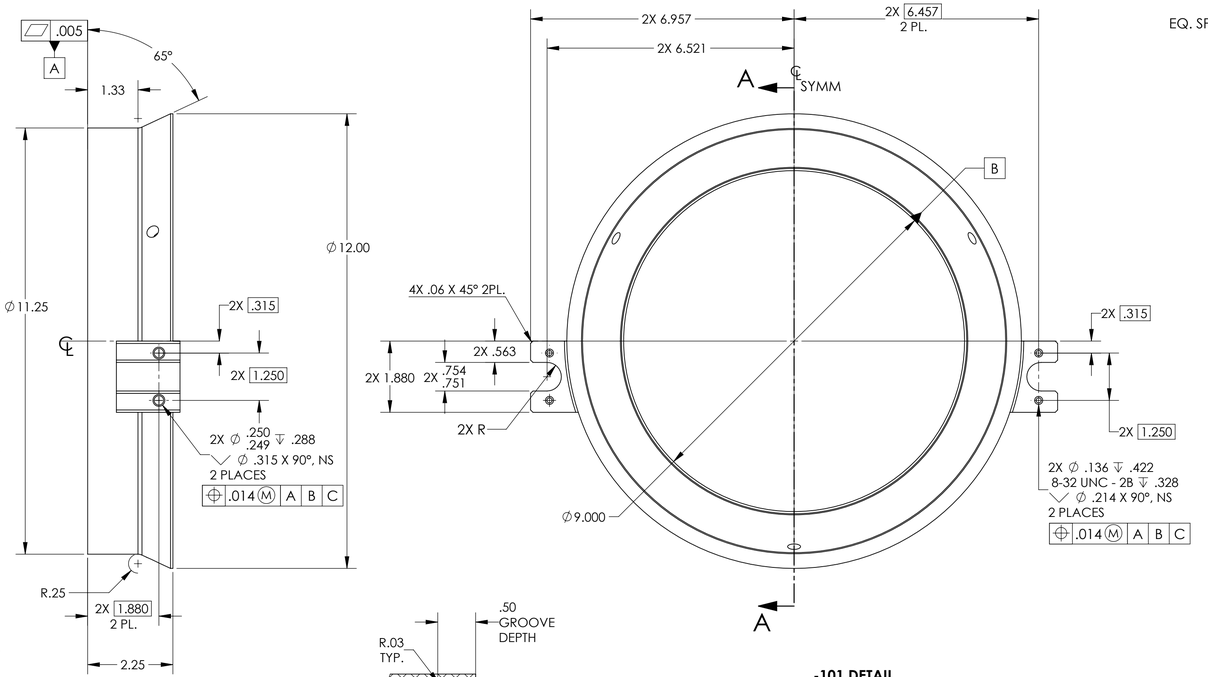




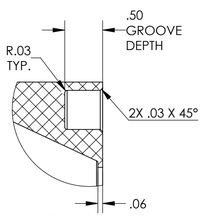
DETAIL C
SCALE 1 : 1



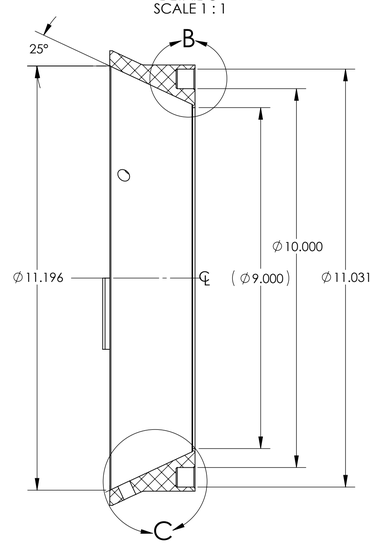
ISO VIEW



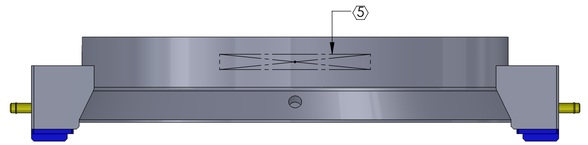
-101 DETAIL



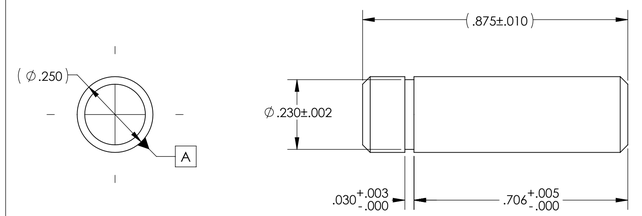
DETAIL B
SCALE 1 : 1



SECTION A-A



-104 DETAIL



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ
6	MS24671-13 OR EQ.	SCREW, FHSC, 8-32 X .38 LG.	300 SSTL	4
5	95304A226 McMASTER-CARR OR EQ.	RETAINING RING, 1/4 SHAFT	300 SSTL	4
4	D1200484-104	DOWEL PIN, 1/4 DIA. X .88 LG. (GROOVED)	MAKE FROM: 90145A541 McMASTER-CARR	4
3	D1200484-103	ALIGO, SUS, QUAD, SPRAY GUARD ASSY., STRIKE PLATE LH.	6061-T6 Al	1
2	D1200484-102	ALIGO, SUS, QUAD, SPRAY GUARD ASSY., STRIKE PLATE RH.	6061-T6 Al	1
1	D1200484-101	ALIGO, SUS, QUAD, SPRAY GUARD ASSY., MT/ RING	DELRIN 100	1

PARTS LIST

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .01
.XXX ± .005

ANGULAR ± 0.5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATLEY R.02 FOR SHEET METAL PARTS.
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: SEE PARTS LIST
FINISH: N/A µinch
NEXT ASSY: D1200490

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: COC

PART NAME: ALIGO, SUS, QUAD, SPRAY GUARD ASSY., MT. RING

DESIGNER	E.SANCHEZ	16 MAR 2012	SIZE	DWG. NO.	REV.
DRAFTER	E.SANCHEZ	22 MAR 2012	D	D1200484	v1
CHECKER	SEE DCC	SEE DCC			
APPROVAL	SEE DCC	SEE DCC	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1

D1200484 ALIGO, SUS, QUAD, SPRAY GUARD ASSY., MT. RING ASSY., PART PDM REV: X-006, DRAWING PDM REV: X-006