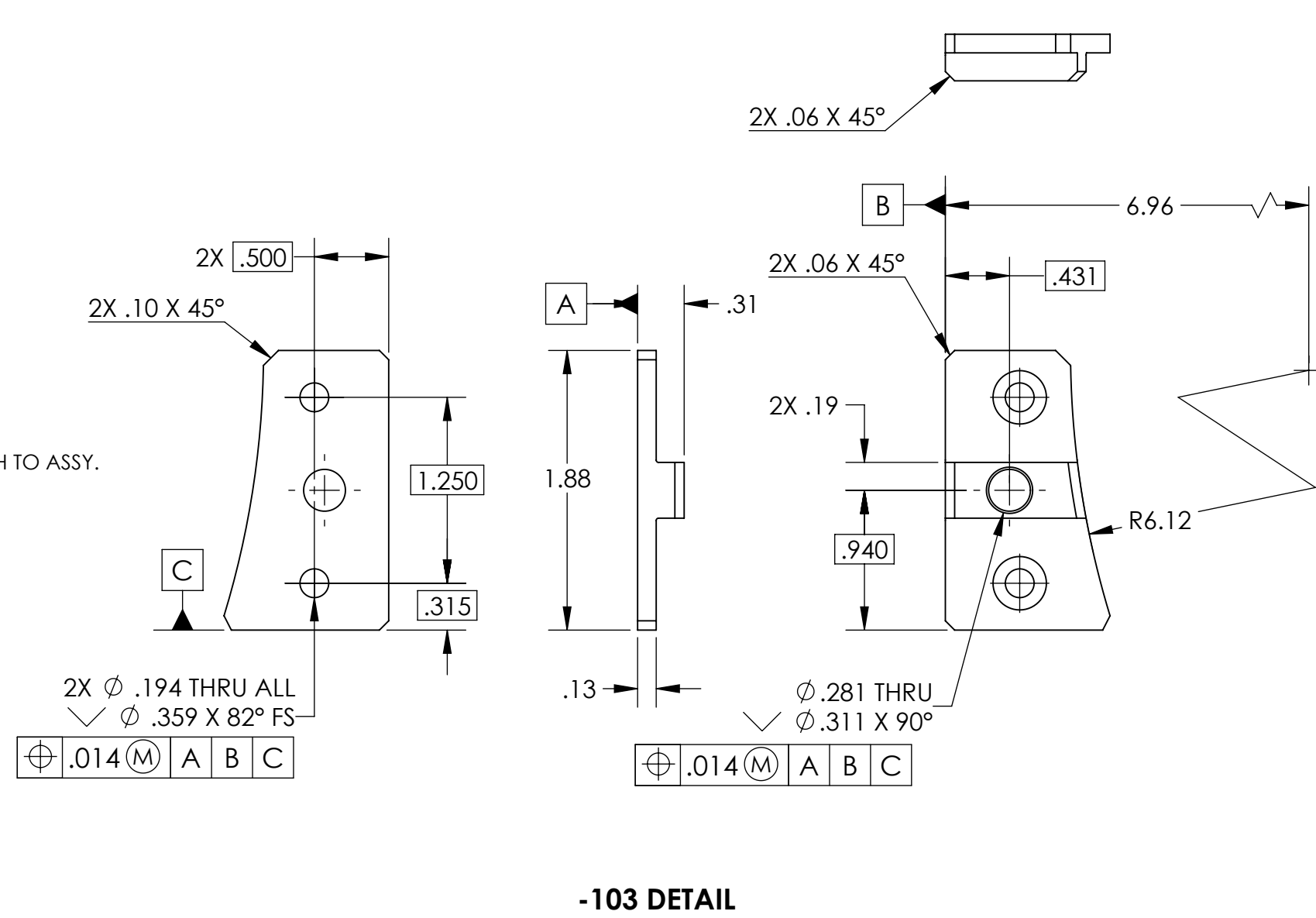
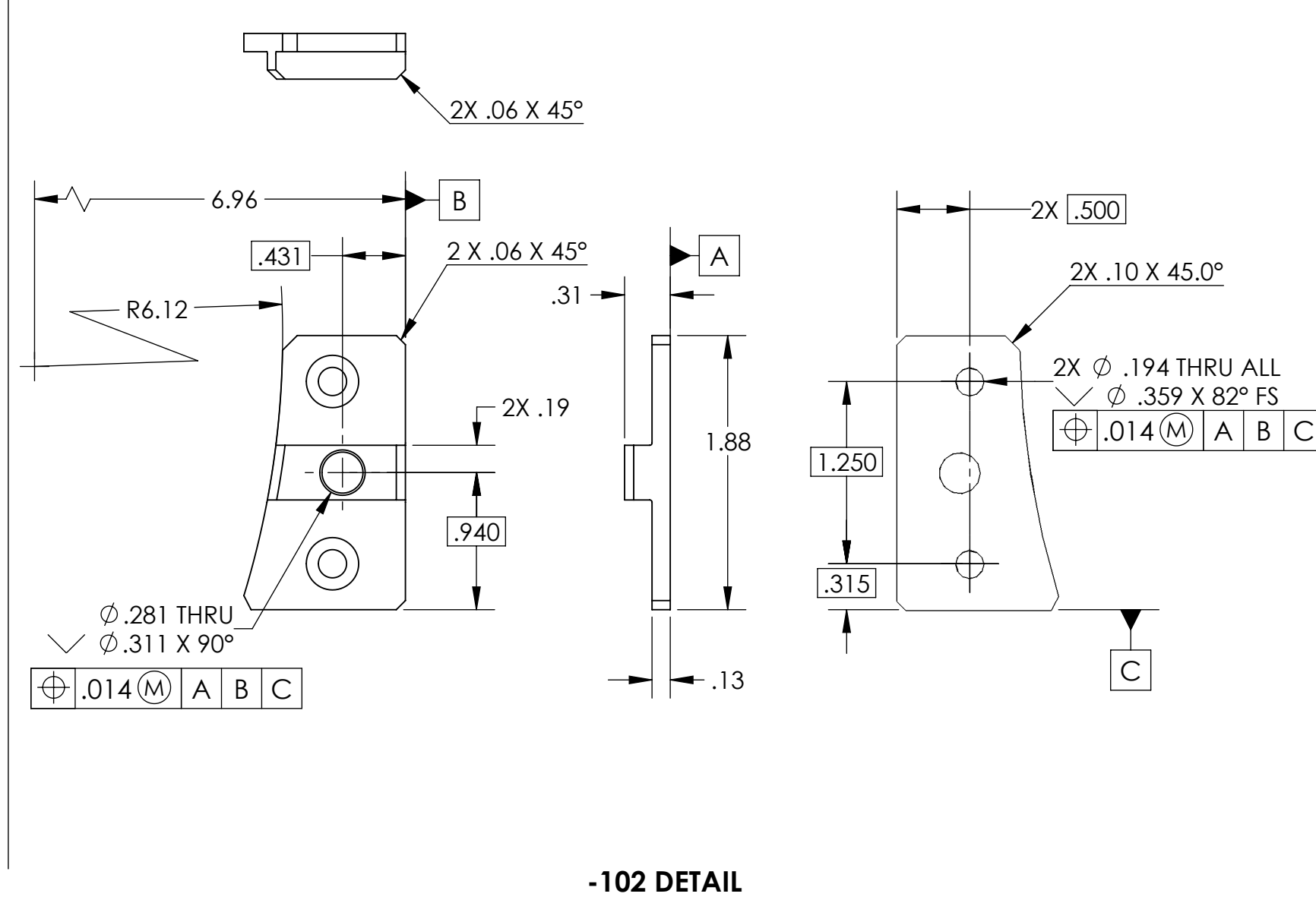


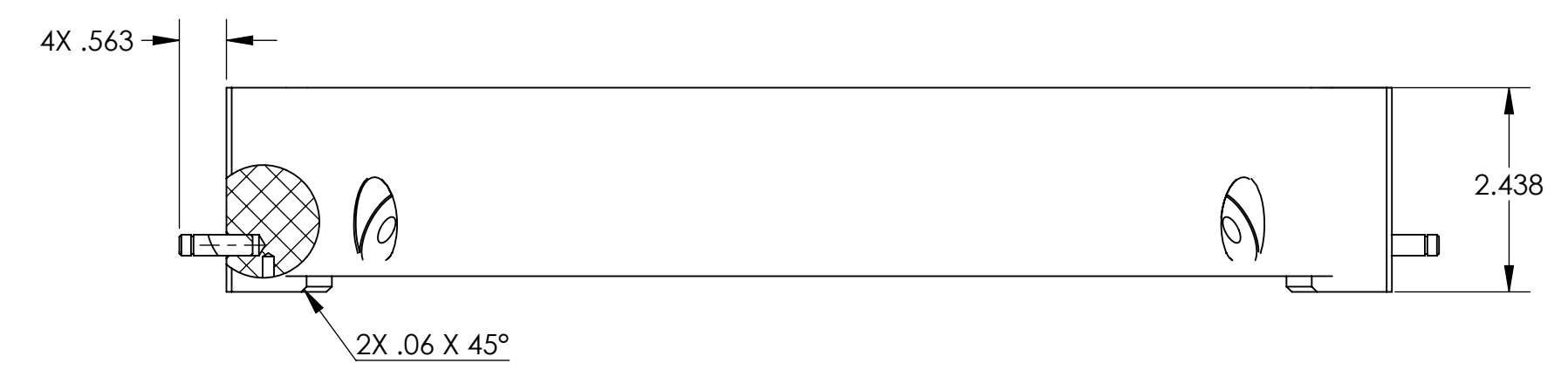
- NOTES CONTINUED:**
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-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.



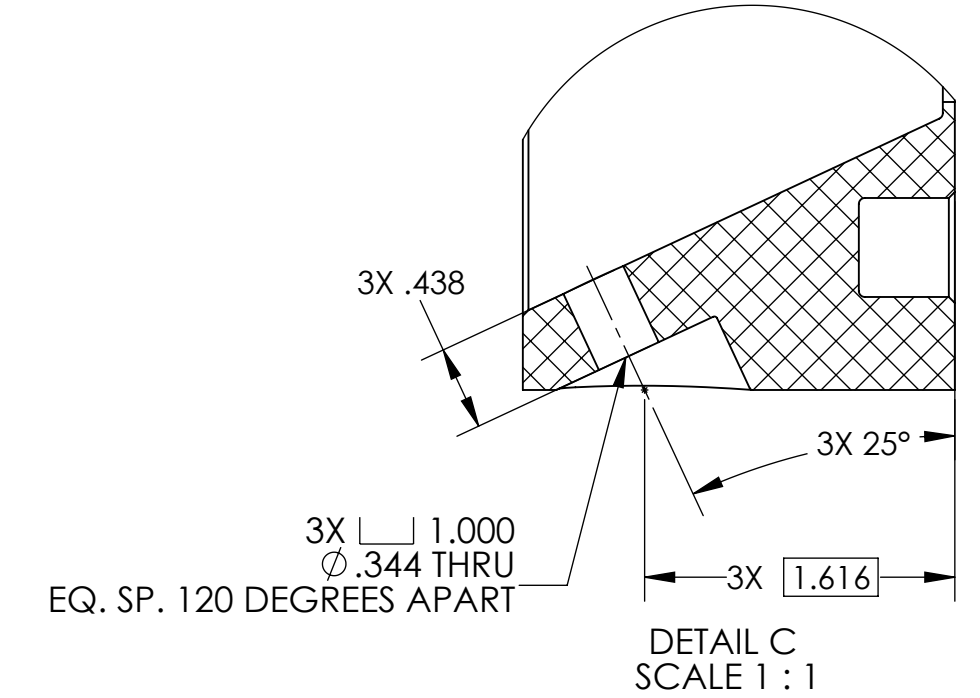
-103 DETAIL



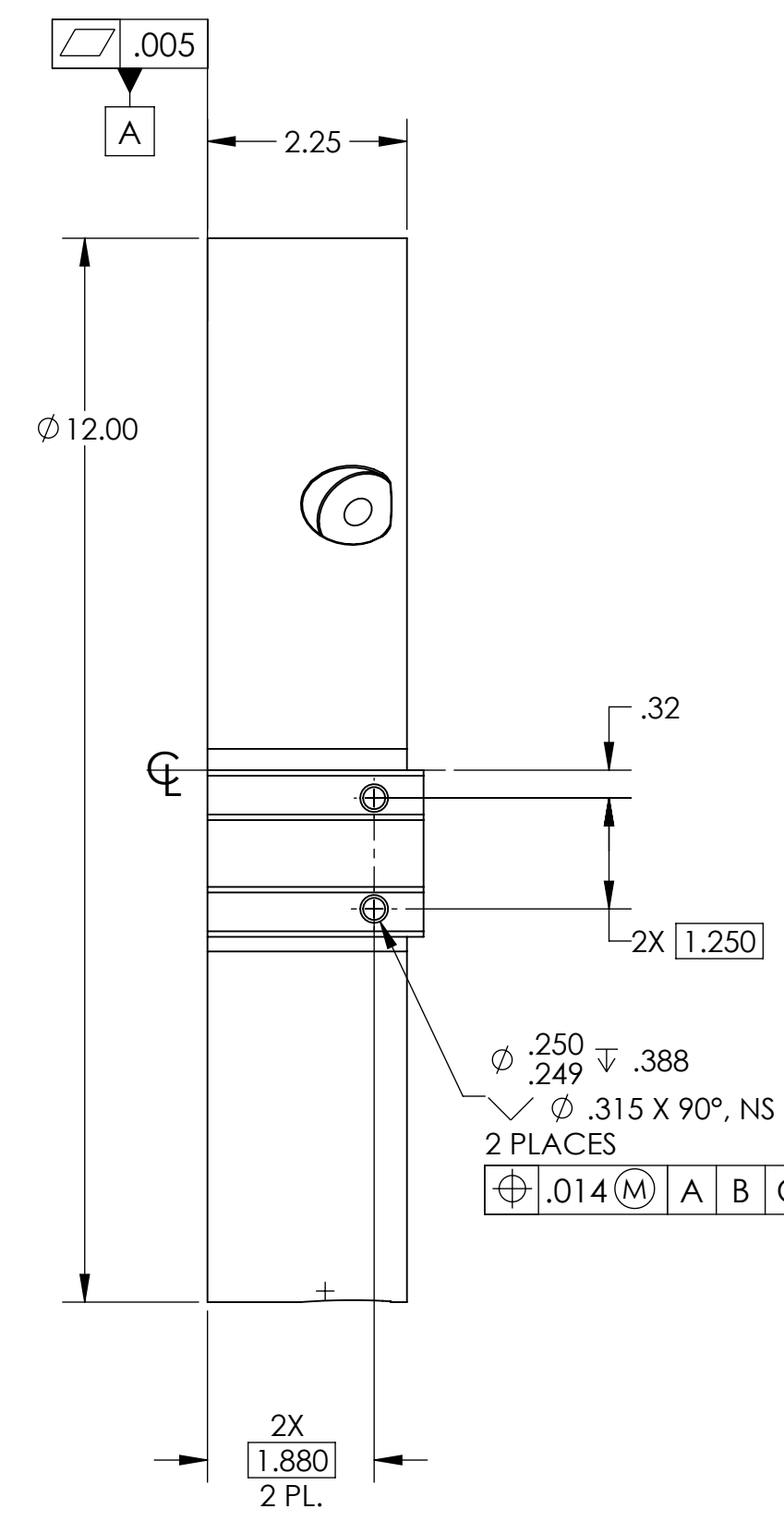
-102 DETAIL



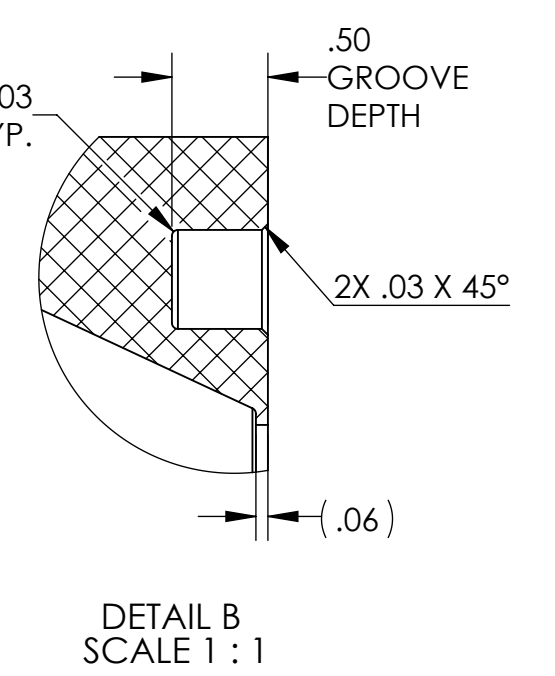
-104 DETAIL



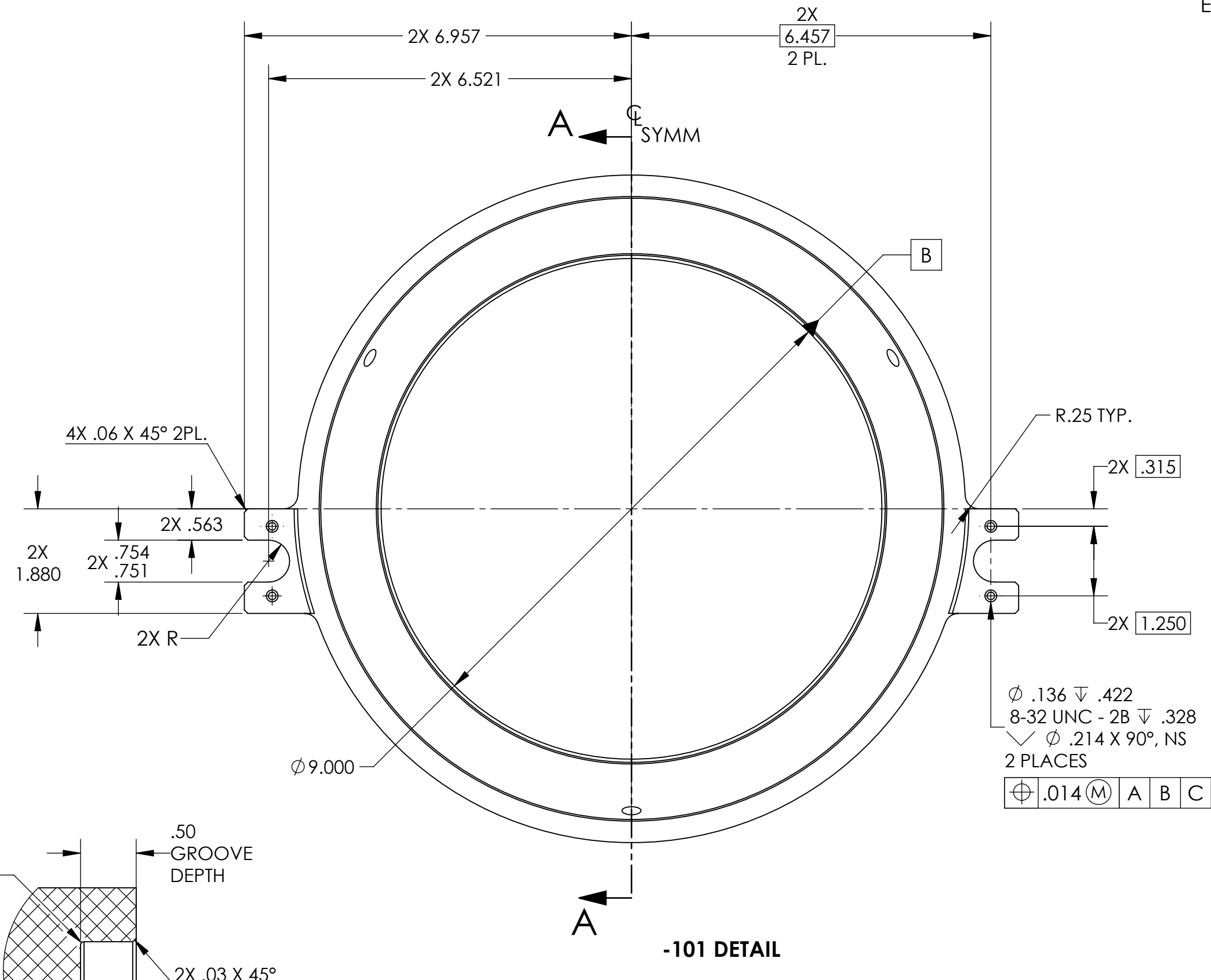
DETAIL C SCALE 1:1



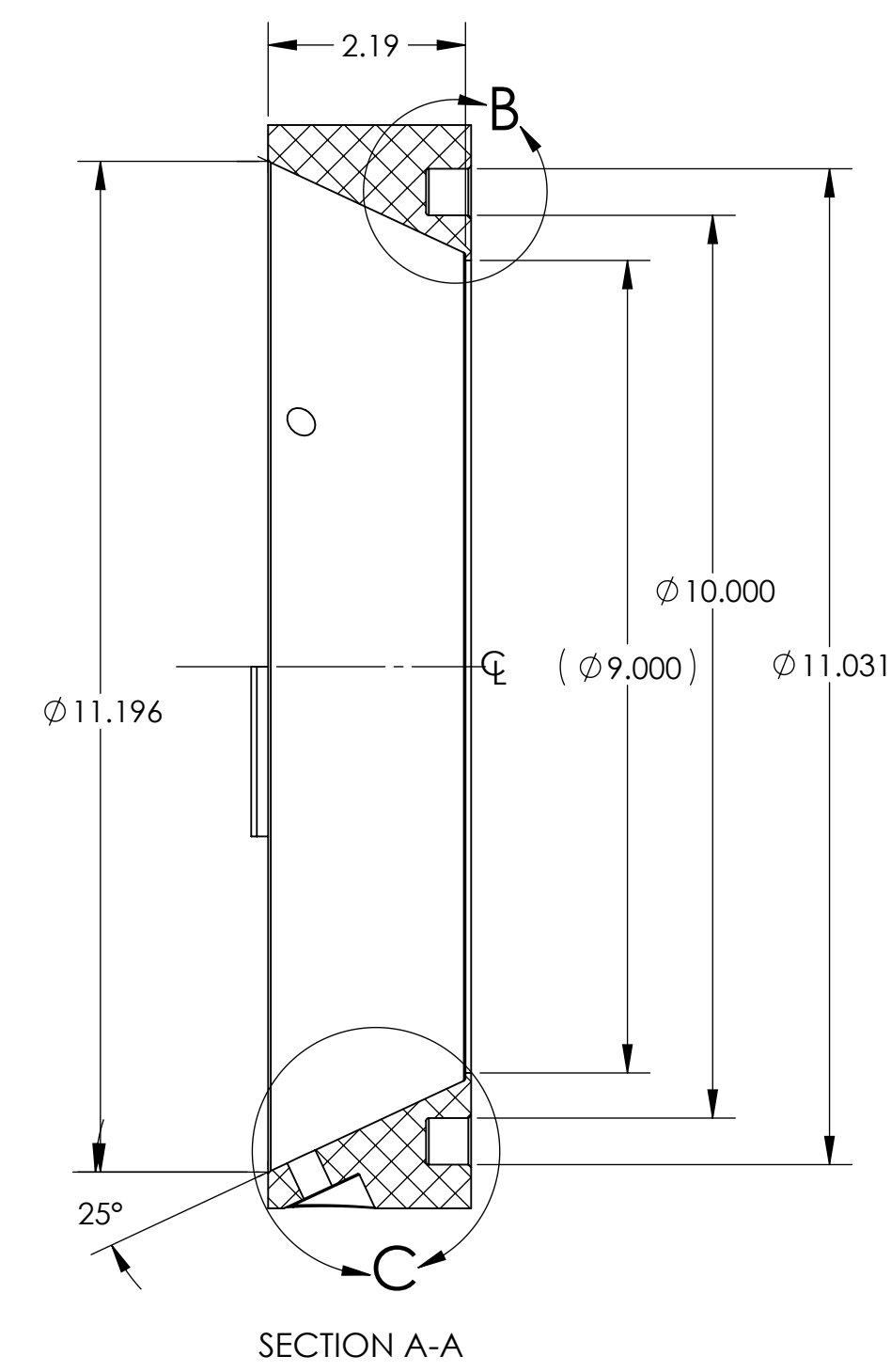
-101 DETAIL



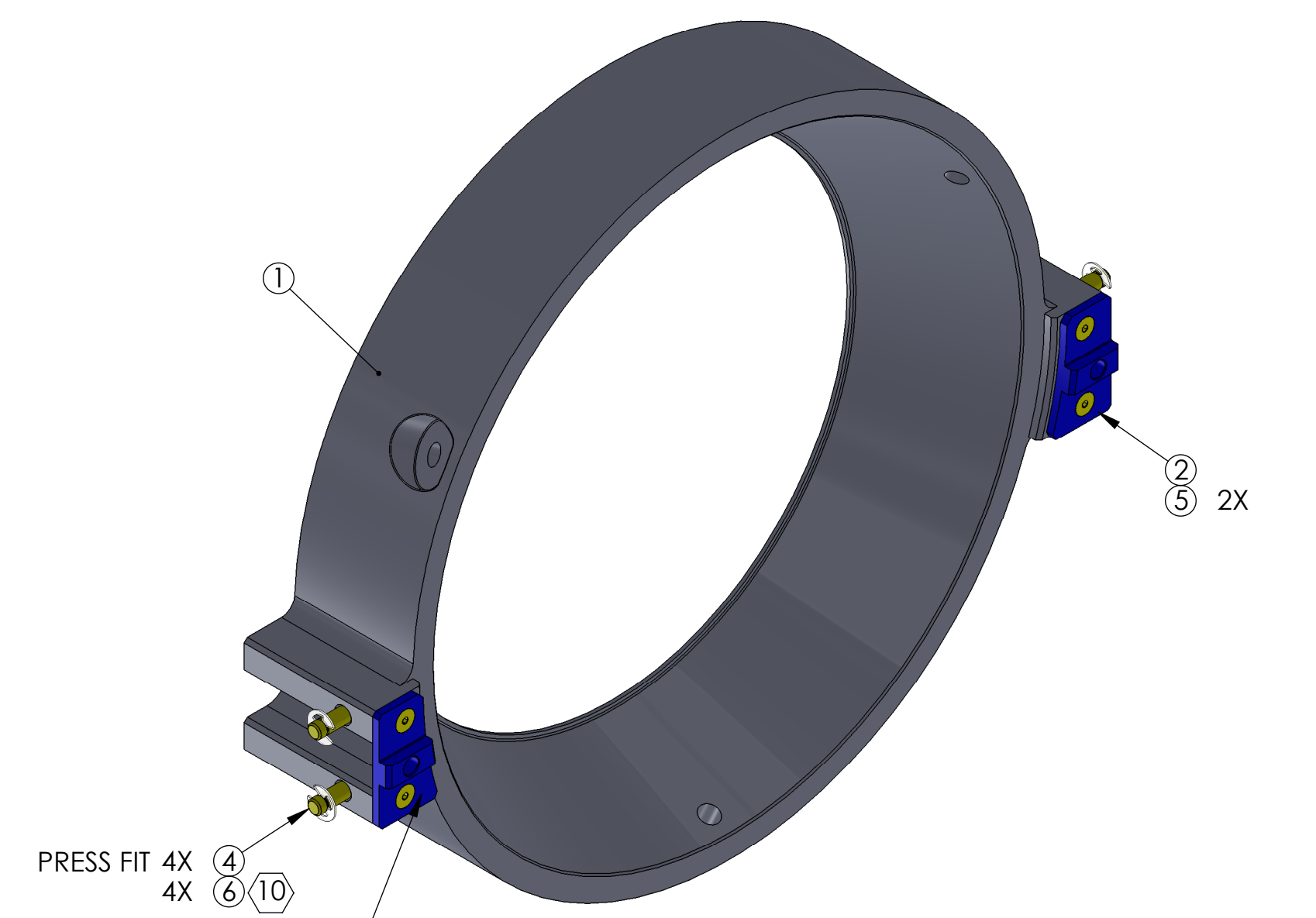
DETAIL B SCALE 1:1



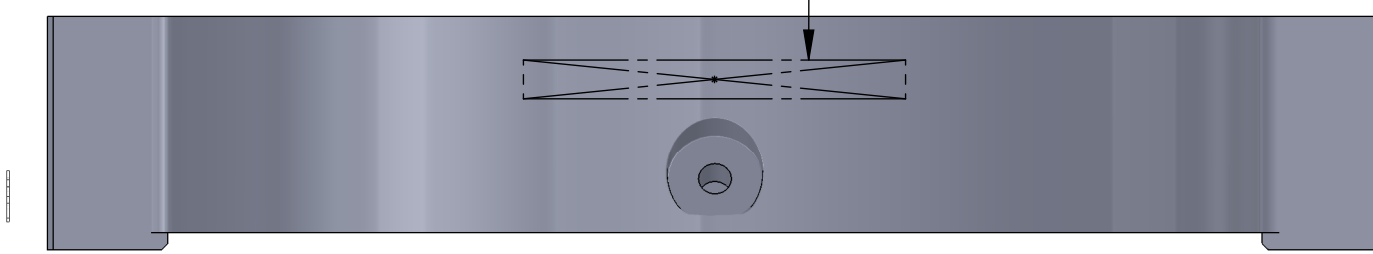
-101 DETAIL



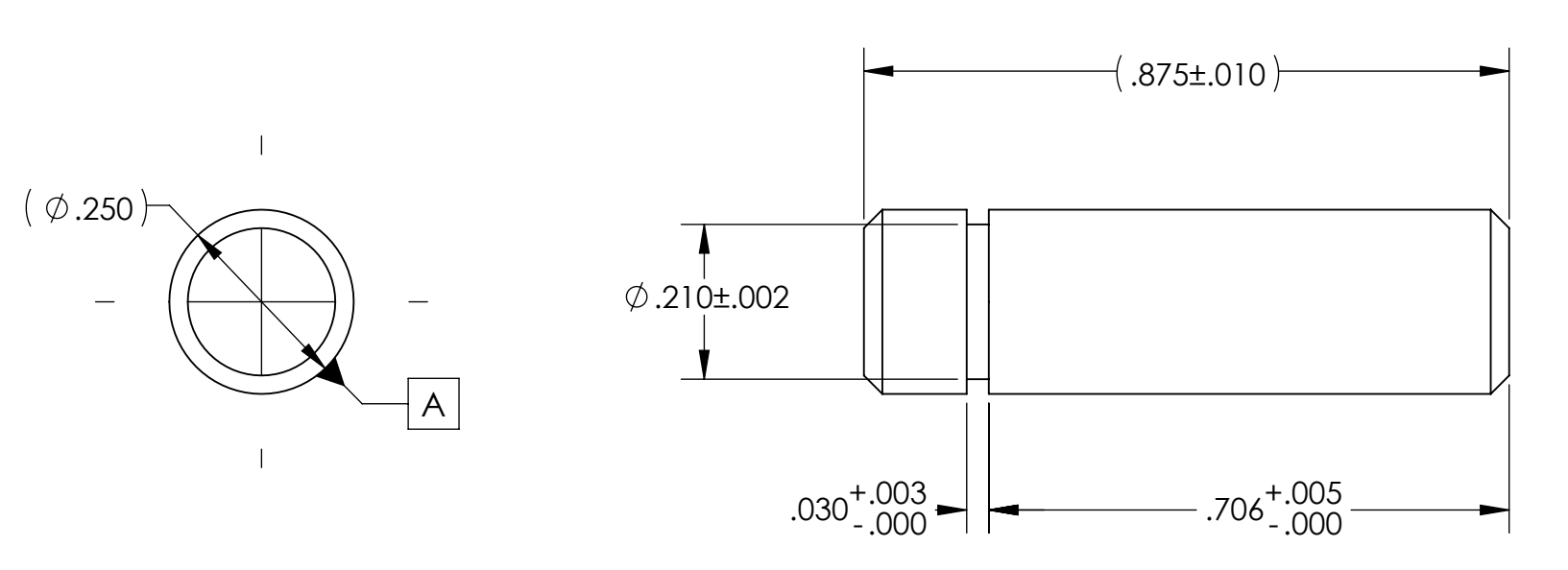
SECTION A-A



ISO VIEW



-104 DETAIL



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ
6	98408A120 McMASTER-CARR	RETAINING RING, 1/4 SHAFT, SIDE-MOUNT	300 SSSL	4
5	MS24671-13 OR EQ.	SCREW, FHSC, 8-32 X .38 LG.	300 SSSL	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	DELTRIN 100	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
1. INTERPRET DRAWING PER ASME Y14.5-1994.	
2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY 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
ANGULAR	± 0.5°

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
ADVANCED LIGO		ALIGO, SUS, QUAD, SPRAY GUARD ASSY., MT. RING	
DESIGNER	E.SANCHEZ	16 MAR 2012	SIZE DWG. NO.
DRAFTER	E.SANCHEZ	22 MAR 2012	D
CHECKER	SEE DCC	SEE DCC	D1200484
APPROVAL	SEE DCC	SEE DCC	v2
SCALE	1:2	PROJECTION	SHEET 1 OF 1

D1200484-ALIGO, SUS, QUAD, SPRAY GUARD ASSY., MT. RING ASSY., PART PDM REV: X013, DRAWING PDM REV: X011