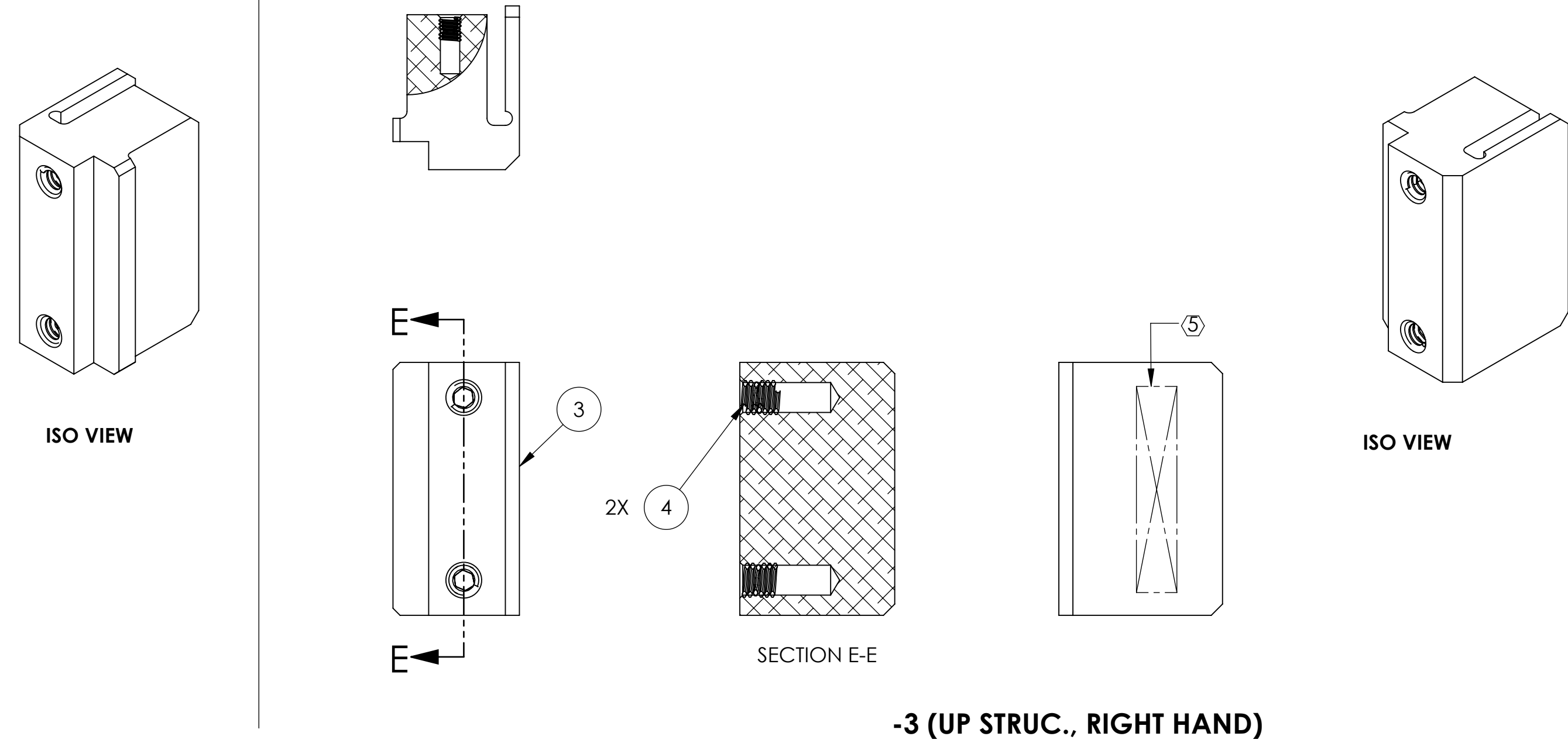
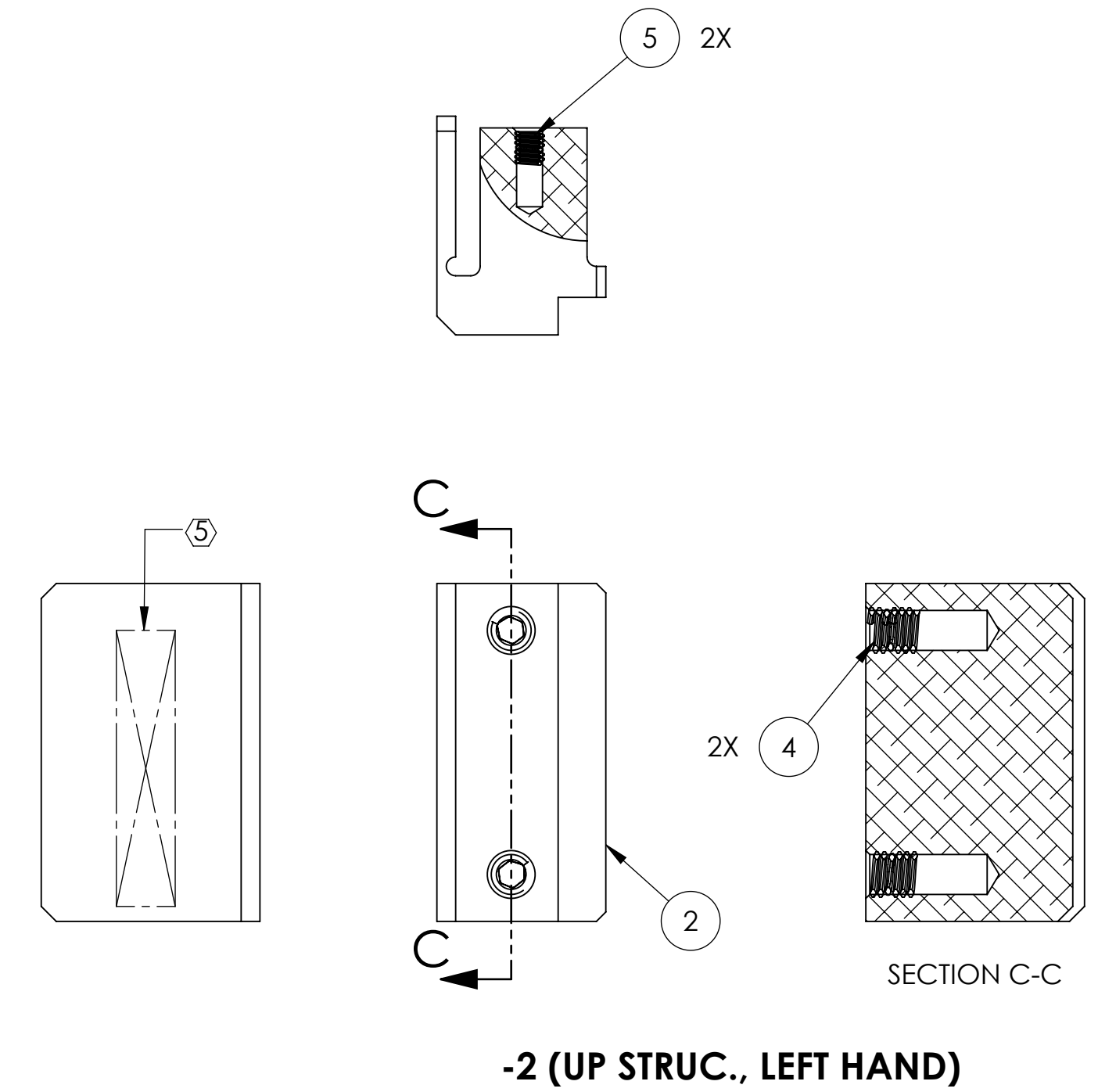
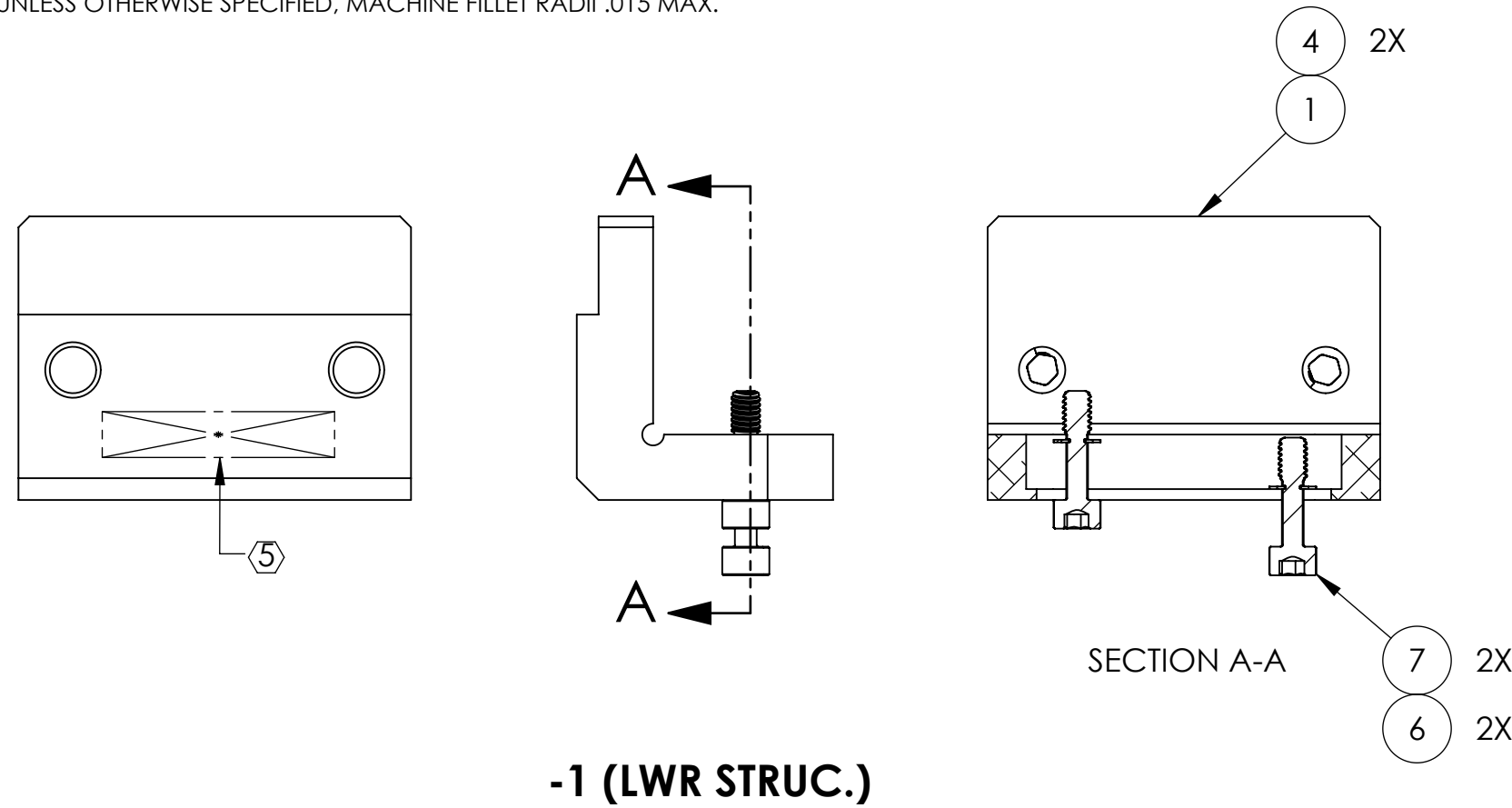
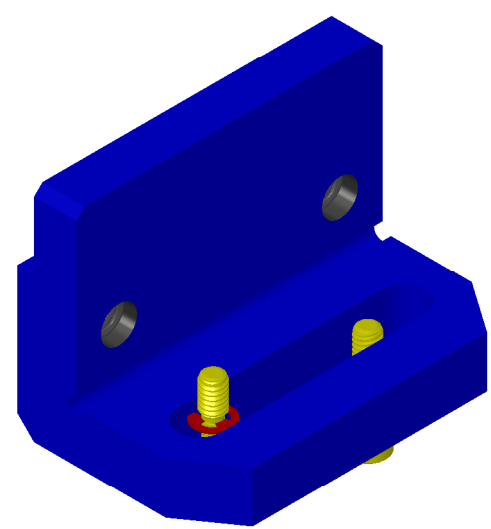
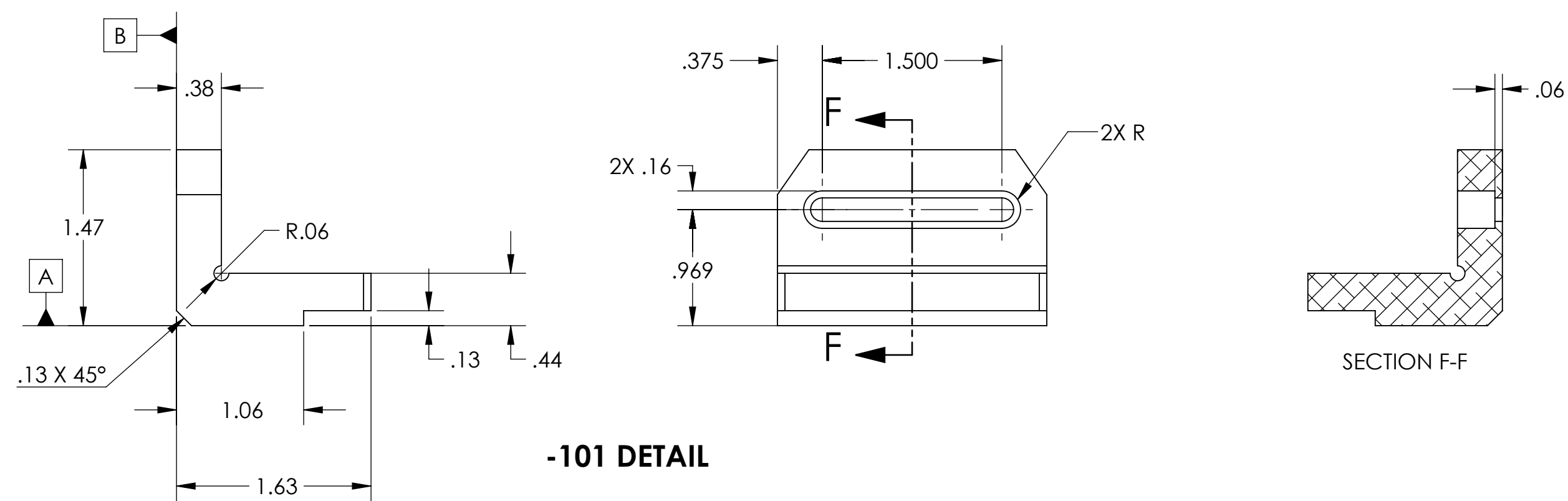
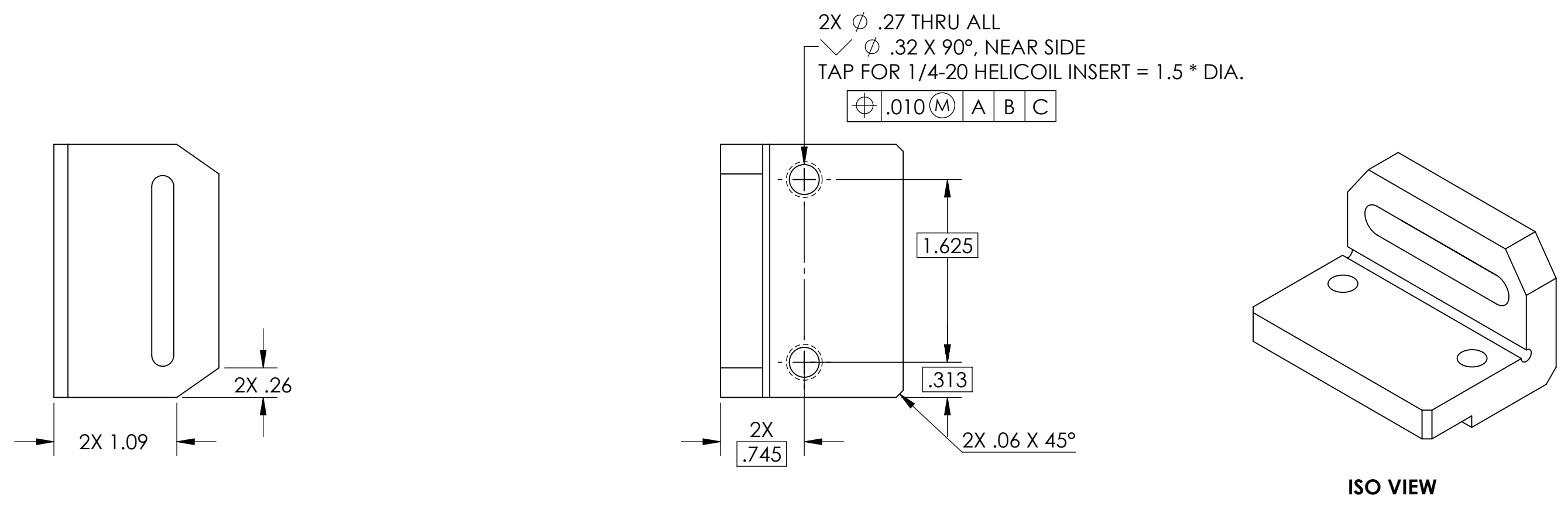


- NOTES CONTINUED:**
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364.
 7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 8. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
 9. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
 10. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
 11. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .015 MAX.



REV.	DATE	DCN #	DRAWING TREE #
v1	23 MAR 2012	E1200307-x0	-
-	-	-	-
-	-	-	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	D1200486-1/QTY.	D1200486-2/QTY.	D1200486-3/QTY.
7	D1200491	ALIGO, SUS, QUAD, SPRAY GUARD ASSY., SCREW, SHC, 8-32 X .63 LG., GROOVED	300 SSSL	2	-	-
6	94981A120 MCMMASTER-CARR	RETAINING RING, 1/8 SHAFT, TYPE E, SIDE MT.	304, 316 OR 302 SSSL	2	-	-
5	3585-2EN246	HELICOIL, 8-32 X 1.5 DIA.	NITRONIC 60	-	2	2
4	3585-4EN375	HELICOIL, 1/4-20 X 1.5 DIA.	NITRONIC 60	2	2	2
3	D1200486-103	ALIGO, SUS, QUAD, SPRAY GUARD ASSY., MT. BRACKET (UPR STRUCT, RH)	6061-T6 AI	-	-	1
2	D1200486-102	ALIGO, SUS, QUAD, SPRAY GUARD ASSY., MT. BRACKET (UPR STRUCT, LH)	6061-T6 AI	-	1	-
1	D1200486-101	ALIGO, SUS, QUAD, SPRAY GUARD ASSY., MT. BRACKET (LWR STRUCT)	6061-T6 AI	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.

DIMENSIONS ARE IN INCHES

TOLERANCES:
 .XX ± .01
 .XXX ± .005

ANGULAR ± 0.5°

ADVANCED LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

ALIGO, SUS, QUAD, SPRAY GUARD ASSY., MT. BRACKET

DESIGNER: E.SANCHEZ 16 MAR 2012
 DRAFTER: E.SANCHEZ 23 MAR 2012
 CHECKER: SEE DCC SEE DCC
 APPROVAL: SEE DCC SEE DCC

SIZE: D DWG. NO. **D1200486** REV. v1

SCALE: 1:1 PROJECTION: SHEET 1 OF 2

8

7

6

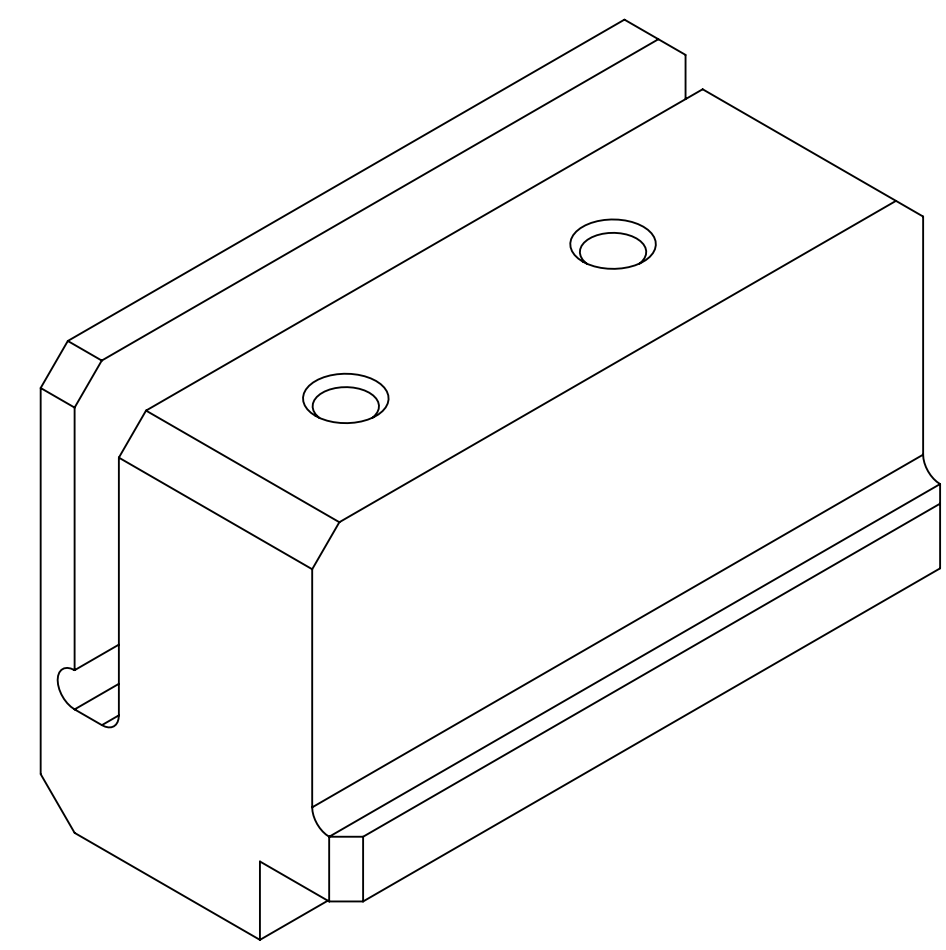
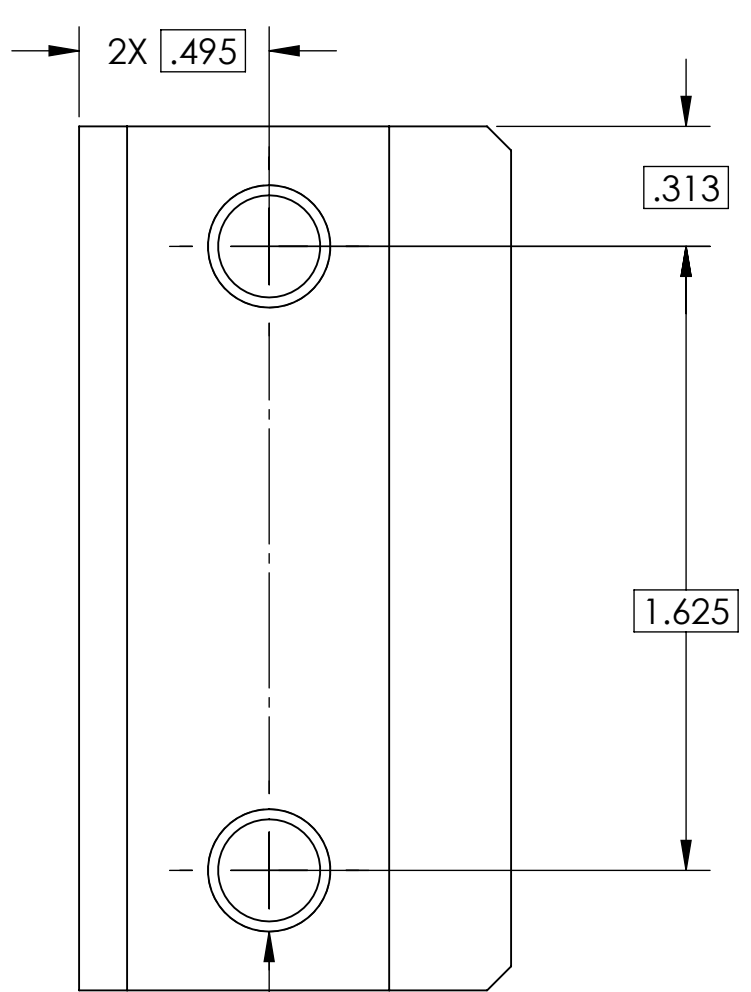
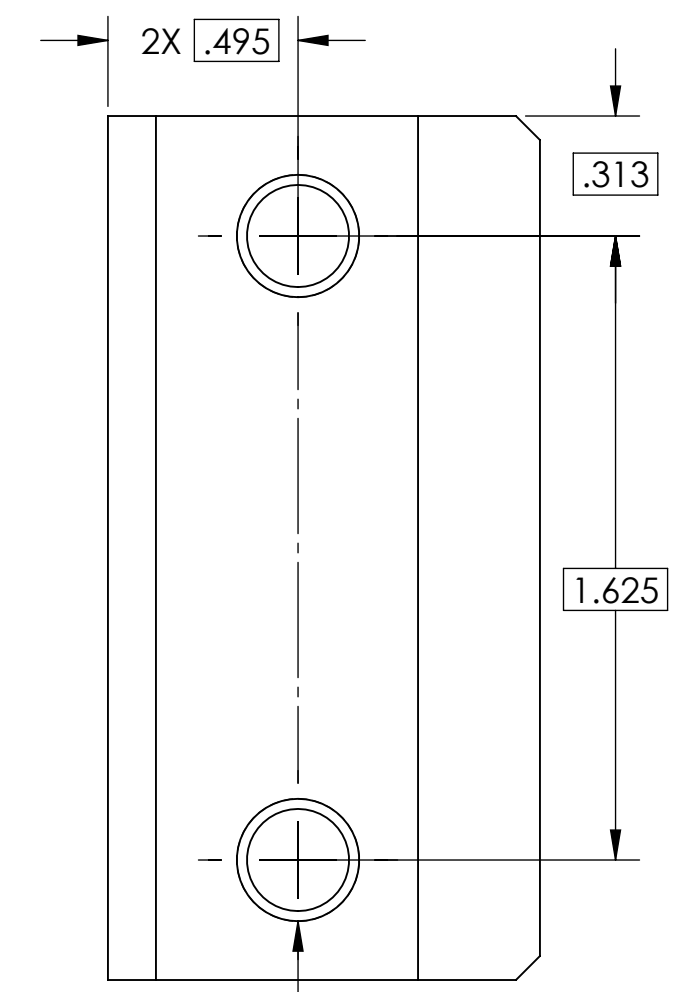
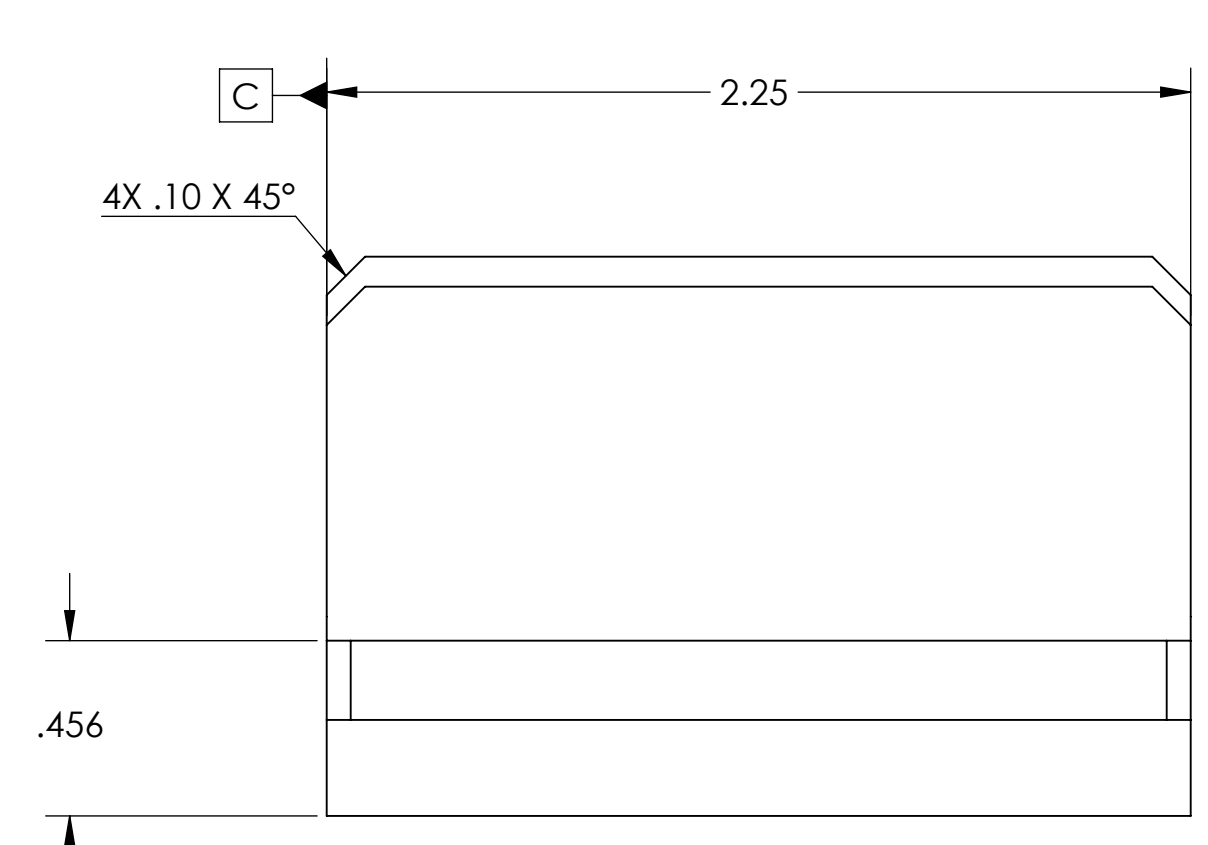
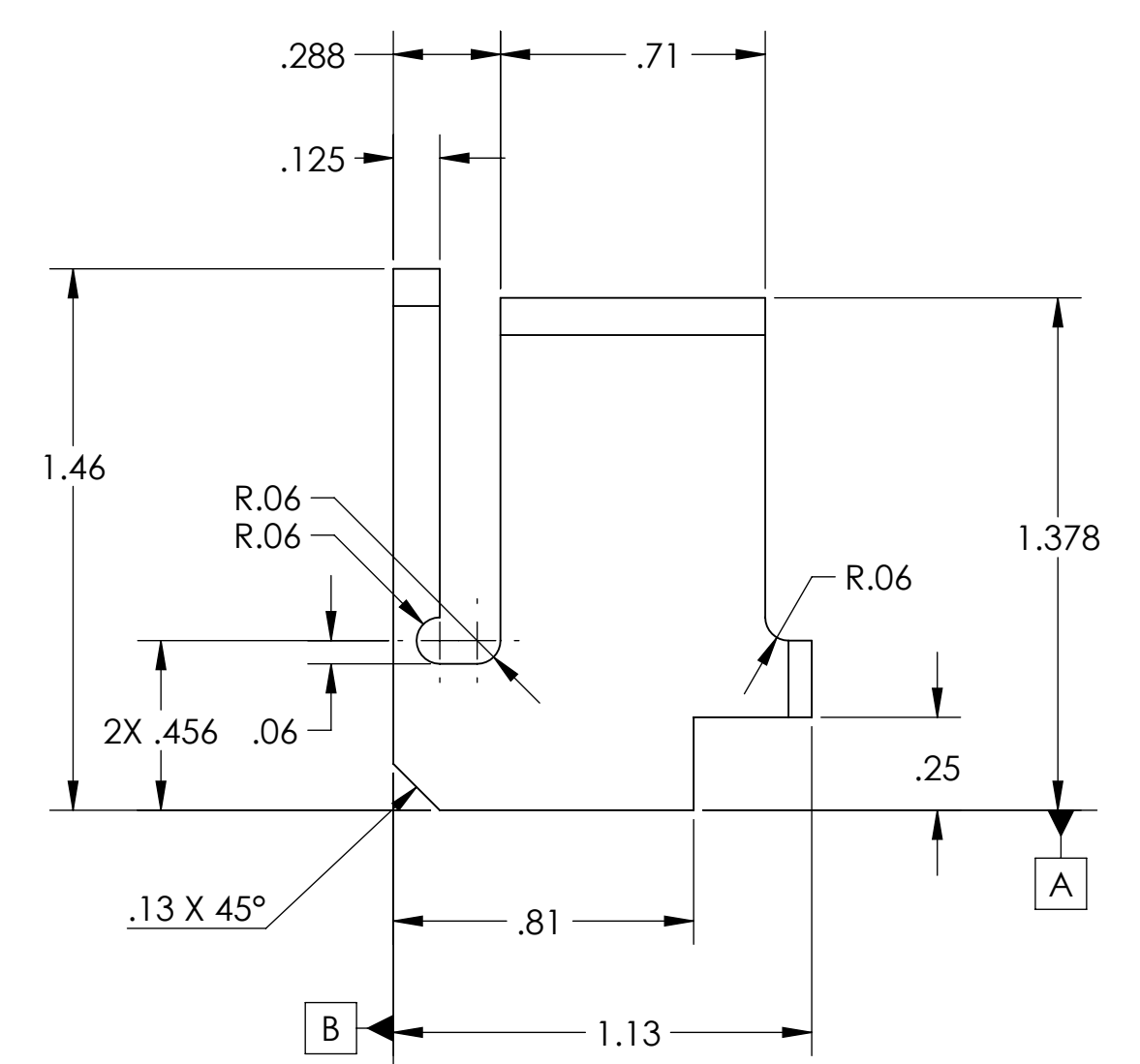
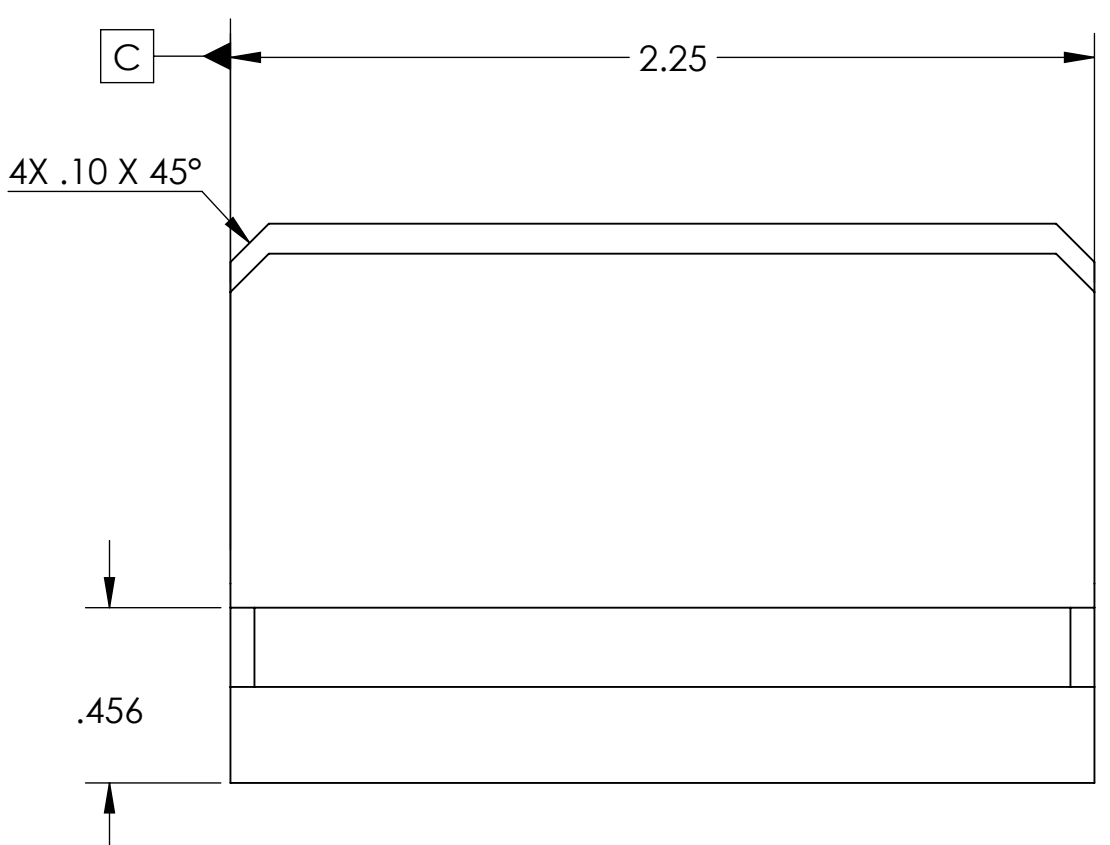
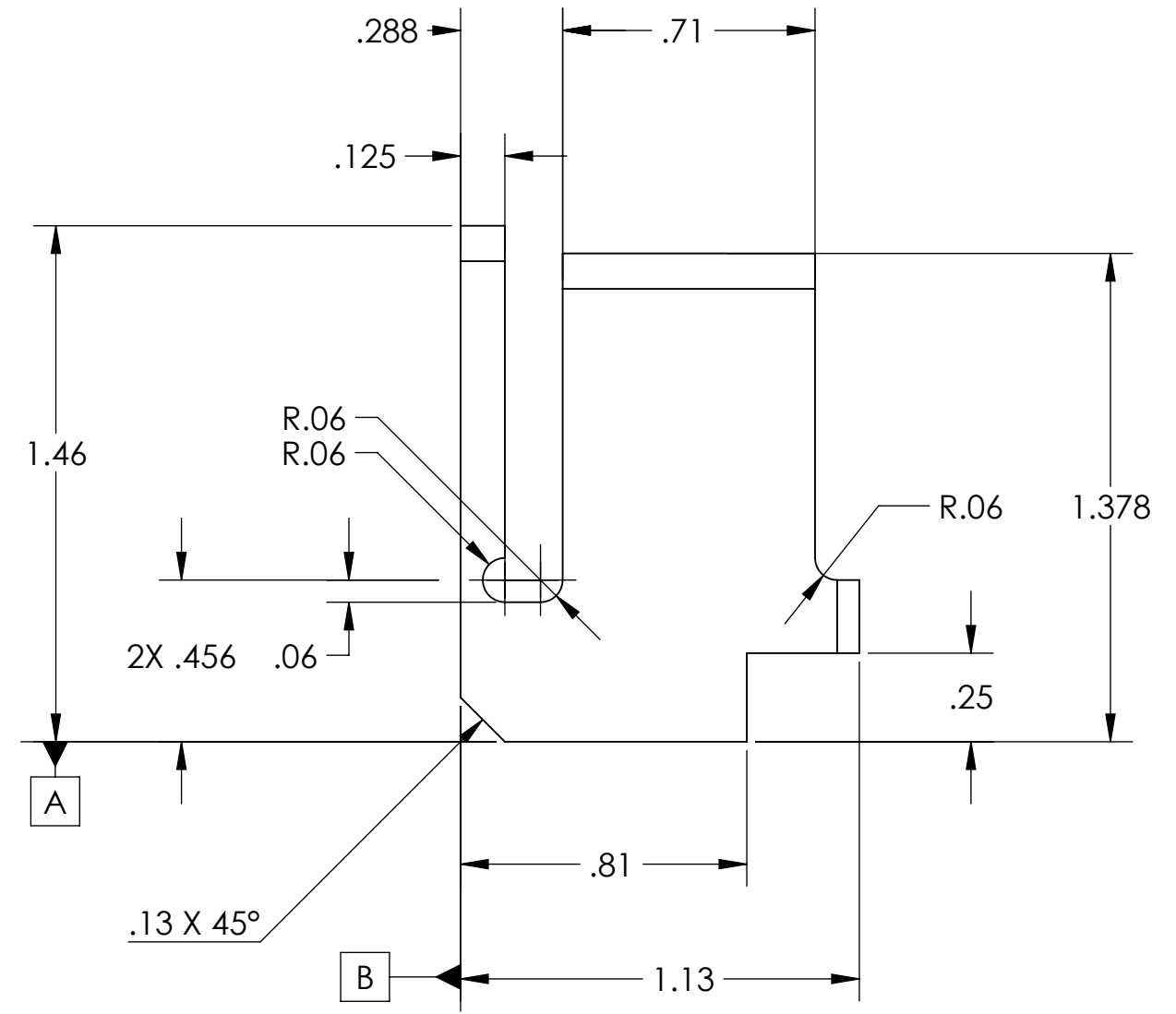
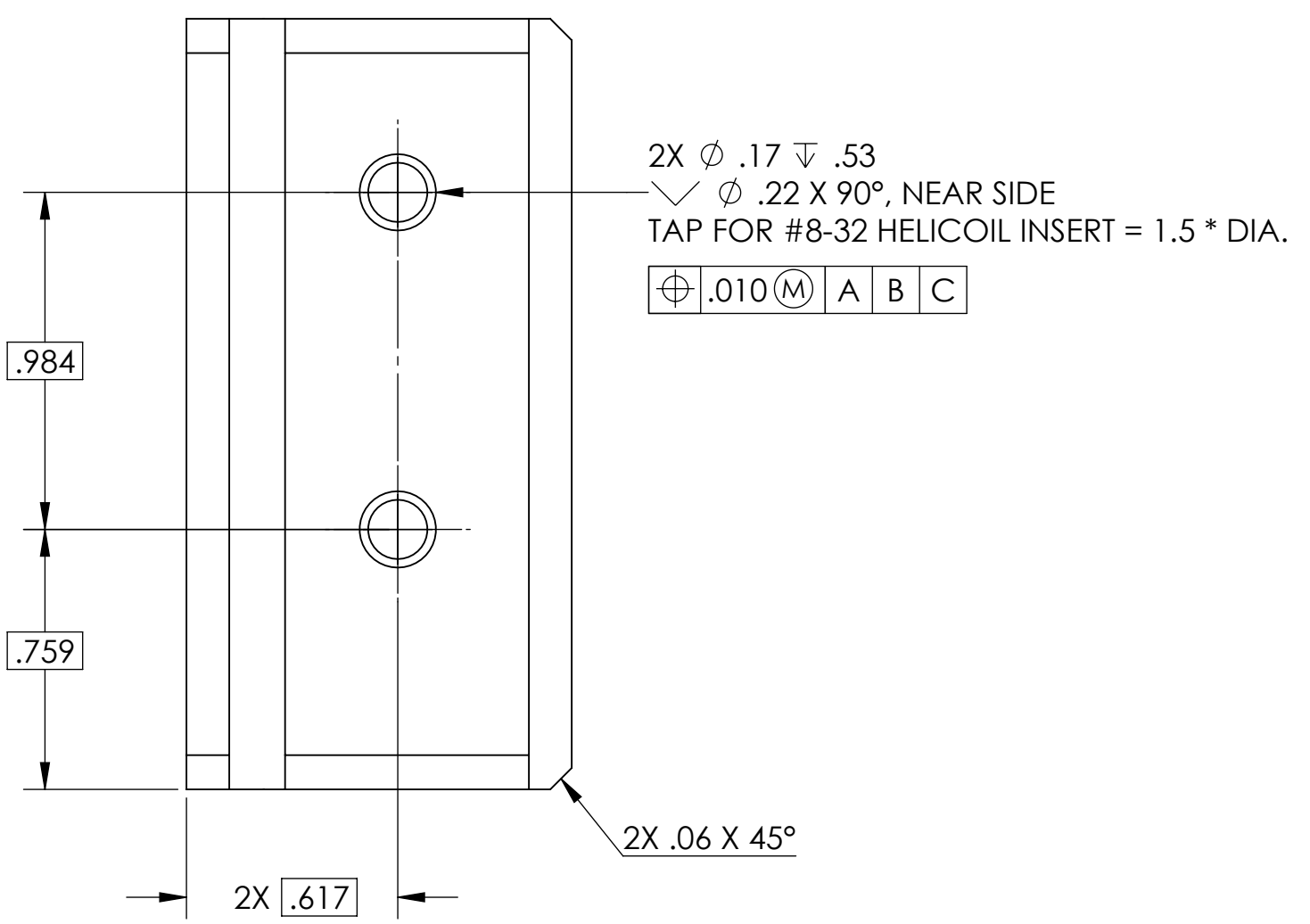
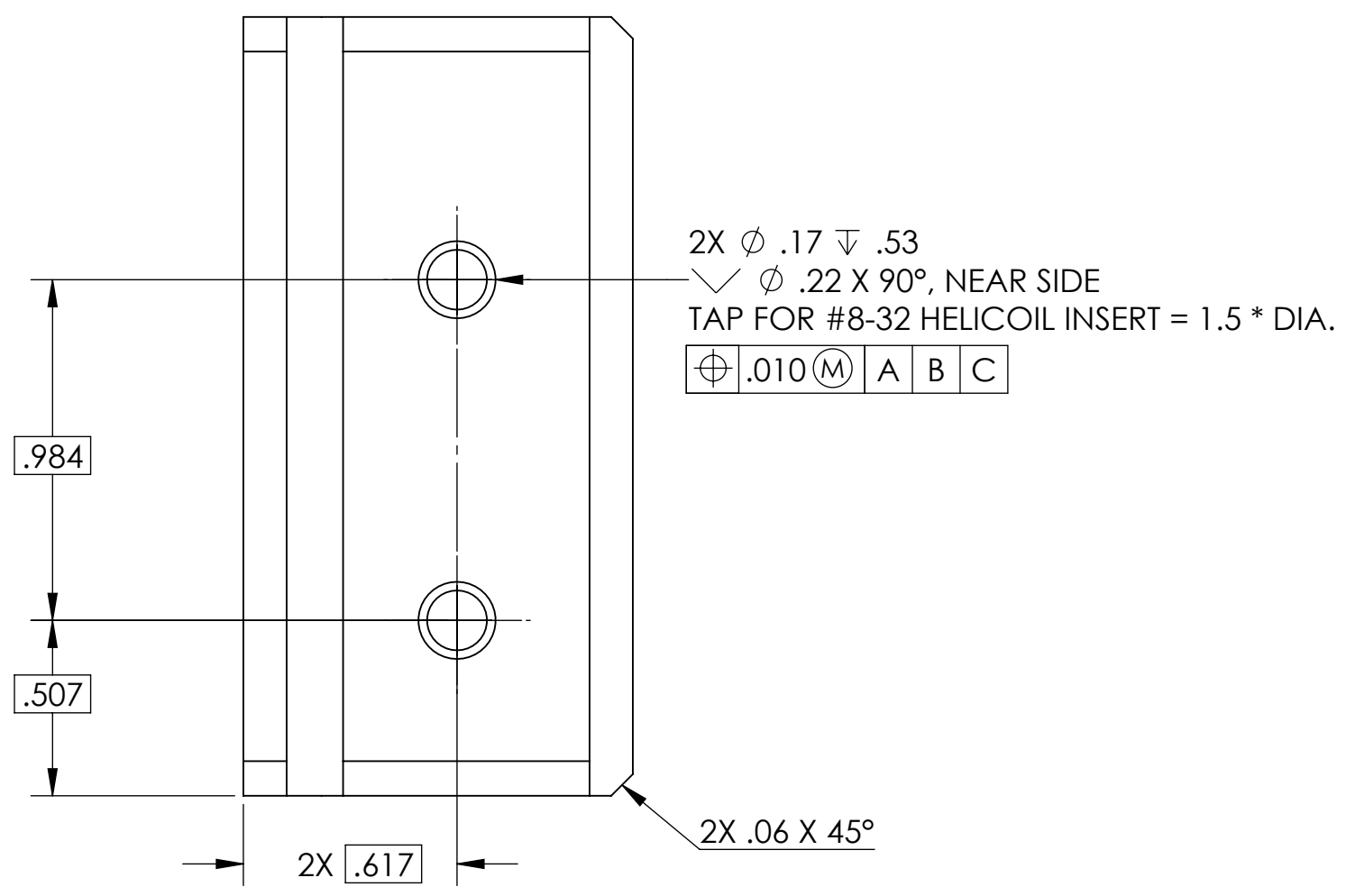
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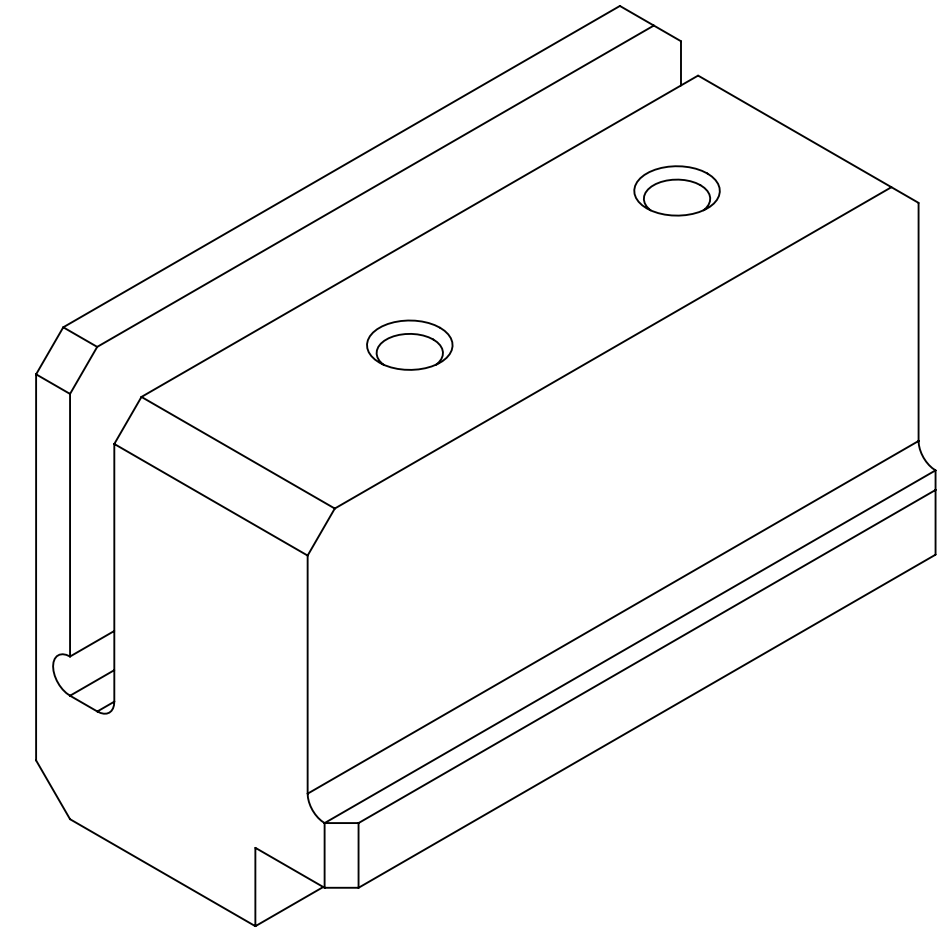
3

2

1



ISO VIEW



ISO VIEW

2X Ø .27 ±.81
 ✓ Ø .32 X 90°, NEAR SIDE
 TAP FOR 1/4-20 HELICOIL INSERT = 1.5 * DIA.
 ±.010 (M) A B C

2X Ø .27 ±.81
 ✓ Ø .32 X 90°, NEAR SIDE
 TAP FOR 1/4-20 HELICOIL INSERT = 1.5 * DIA.
 ±.010 (M) A B C

-102 DETAIL

-103 DETAIL

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE DWG. NO.	D1200486	v1
SCALE: 2:1		PROJECTION:
		SHEET 2 OF 2

D1200486 ALICO SUS GUARD SPRAY GUARD ASSY - MT BRACKET PART PDM REV-X-002 DRAWING PDM REV-X-000