REV.	DATE	DCN #	DRAWING TREE #
v1	23 MAR 2012	-	-
v2	27 JUN 2012	E1200307-x0	-
v3	28 JAN 2013	E1300087-x0	-

NOTES CONTINUED:

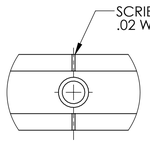
Ⓢ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE 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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

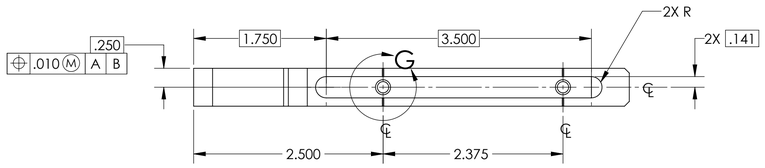
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

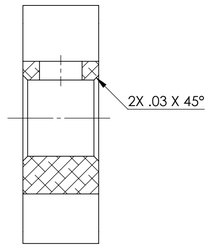
8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

9. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .015 MAX.

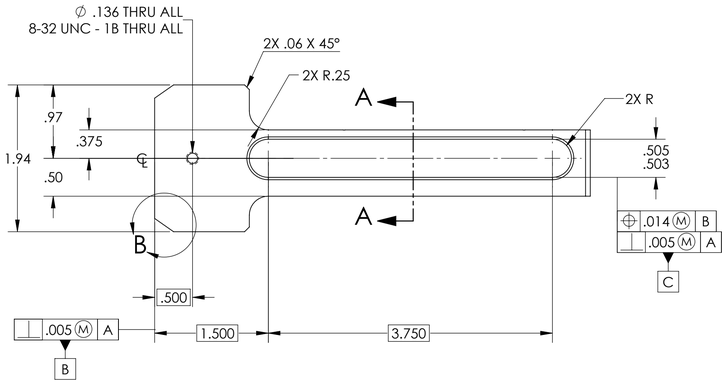


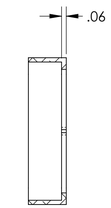
DETAIL G
SCALE 2 : 1
2 PL.



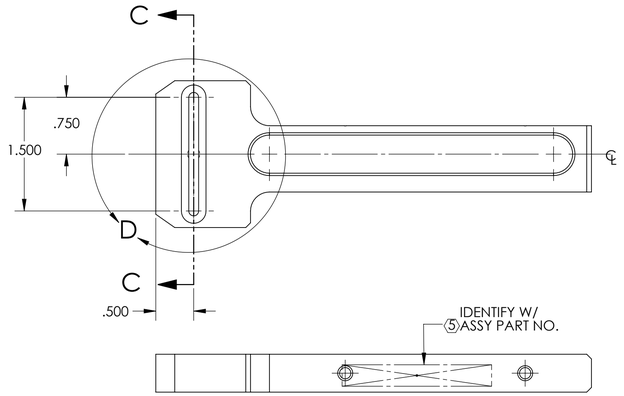


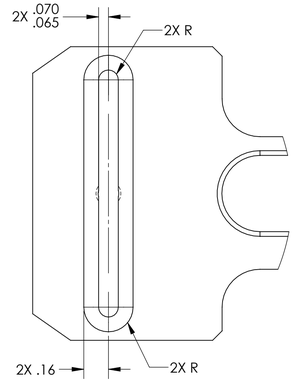
SECTION A-A
SCALE 2 : 1





SECTION C-C

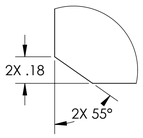




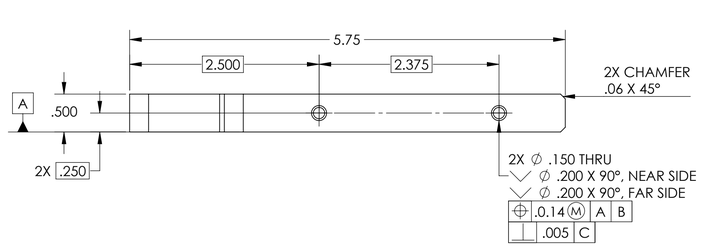
DETAIL D
SCALE 2 : 1

-101 DETAIL

-102 DETAIL



DETAIL B
SCALE 2 : 1



BLANK
(MAKE FROM: 6061-T6 AL)

SECTION E-E

DETAIL F
SCALE 2 : 1

ISO VIEW
(-2 DETAIL)

ISO VIEW
(-1 DETAIL)

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	D1200486-1/REQ	D1200486-2/QTY.
4	9464K108 McMASTER-CARR OR EQ.	O-RING, .112 ID X .103 ID. X .318 OD.	-	2	2
3	D1200491	ALIGO, COC, ETM_ITM FC SPRAY GUARD ASSY., SCREW, SHC, 8-32 X .75 LG., GROOVED	300 SSTL	2	2
2	D1200486-102	ALIGO, COC, ETM /ITM FC SPRAY GUARD ASSY., LH SLIDE	MAKE FROM: BLANK	-	1
1	D1200486-101	ALIGO, COC, ETM /ITM FC SPRAY GUARD ASSY., RH SLIDE	MAKRE FROM: BLANK	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: 63 µinch

LIGO — CALIFORNIA INSTITUTE OF TECHNOLOGY, MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: COC
NEXT ASSY: D1200490

PART NAME: ALIGO, COC, ETM /ITM FC SPRAY GUARD, SLIDE ASSY.

			SIZE	DWG. NO.	REV.
DESIGNER	E.SANCHEZ	16 MAR 2012			
DRAFTER	E.SANCHEZ	23 MAR 2012	D	D1200486	v3
CHECKER	SEE DCC	SEE DCC			
APPROVAL	SEE DCC	SEE DCC	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1

D1200486 ALIGO_COC_ETM_ITM FC SPRAY GUARD ASSY., SLIDE ASSY., PART PDM REV: X-X16, DRAWING PDM REV: X-X11