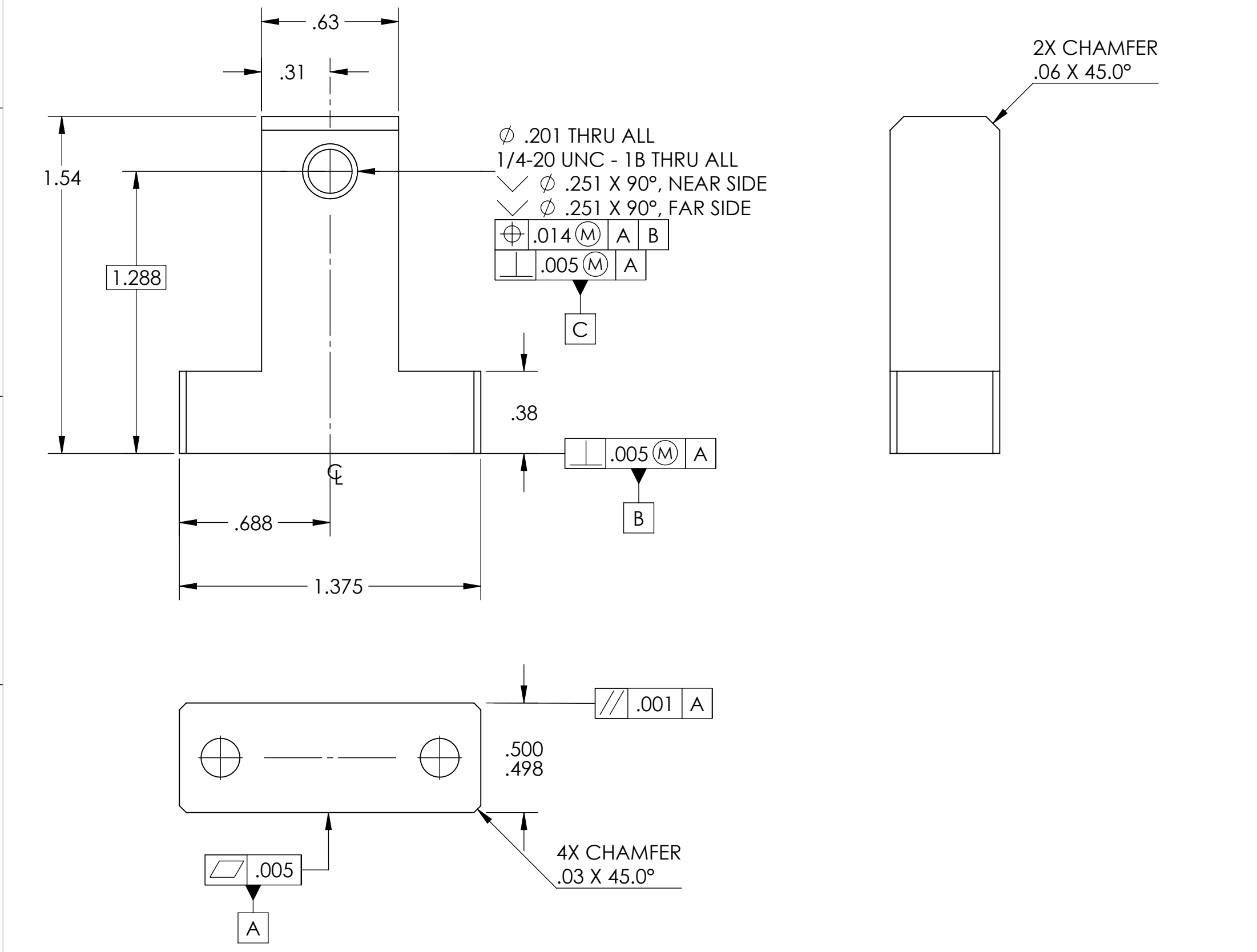
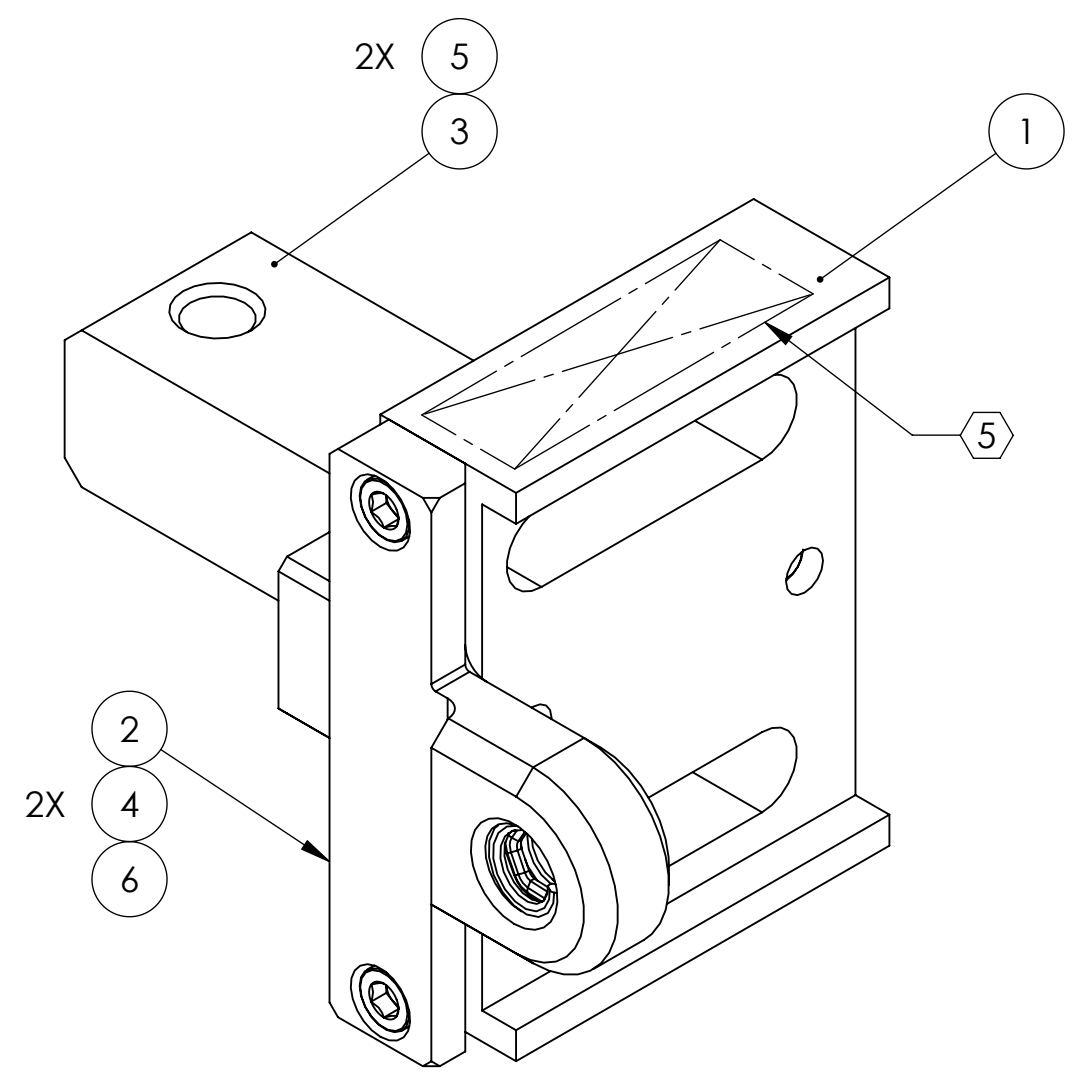


- NOTES CONTINUED:**
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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 = X.XXX 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. 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.
 10. UNLESS OTHERWISE SPECIFIED, MACHINE FILLET RADII .015 - .030.

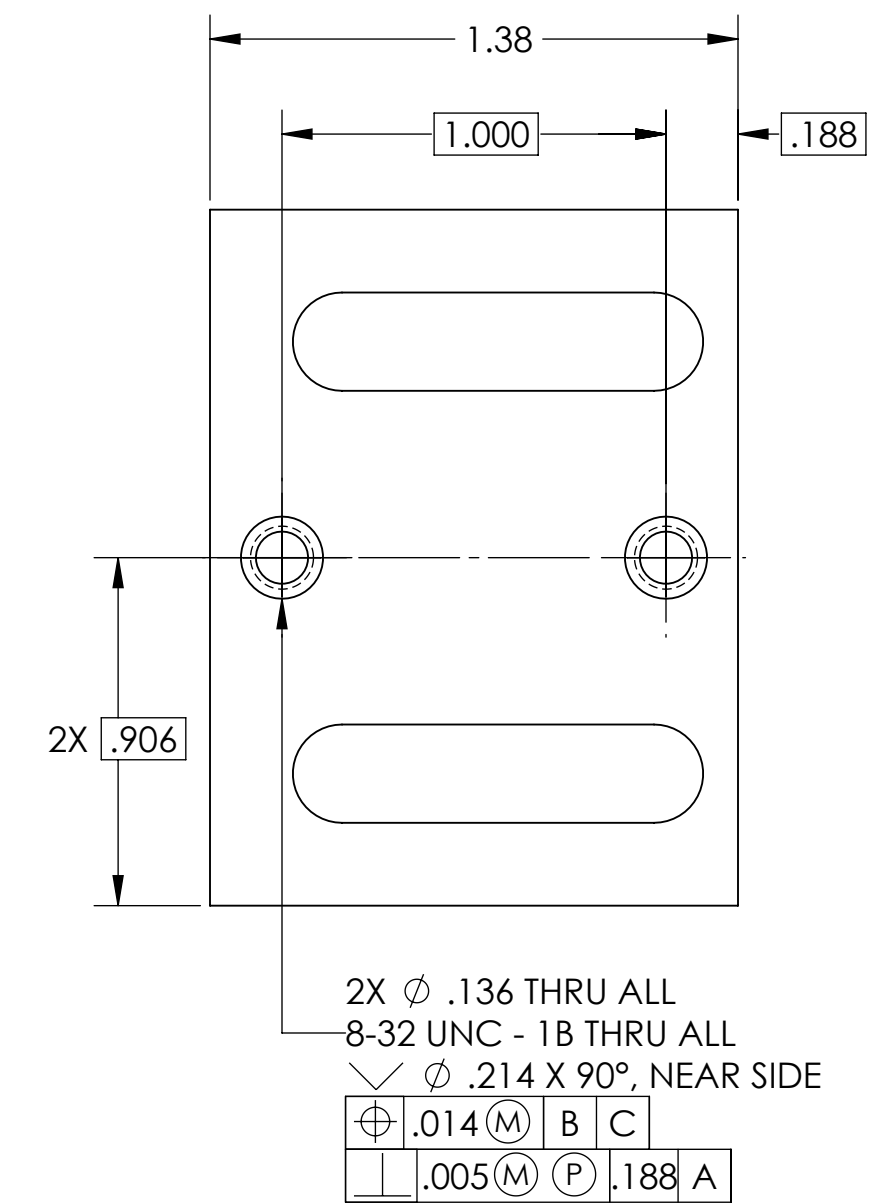
REV.	DATE	DCN #	DRAWING TREE #
v1	13 APR 2012	-	-
v4	26 FEB 2012	E1300148-x0	-
v5	16 SEP 2014	E1400368-x0	-



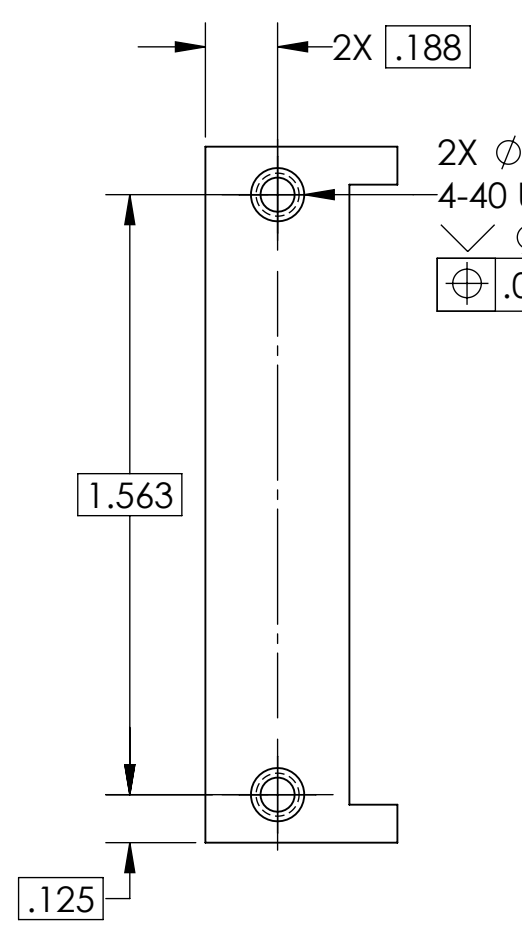
-103 DETAIL



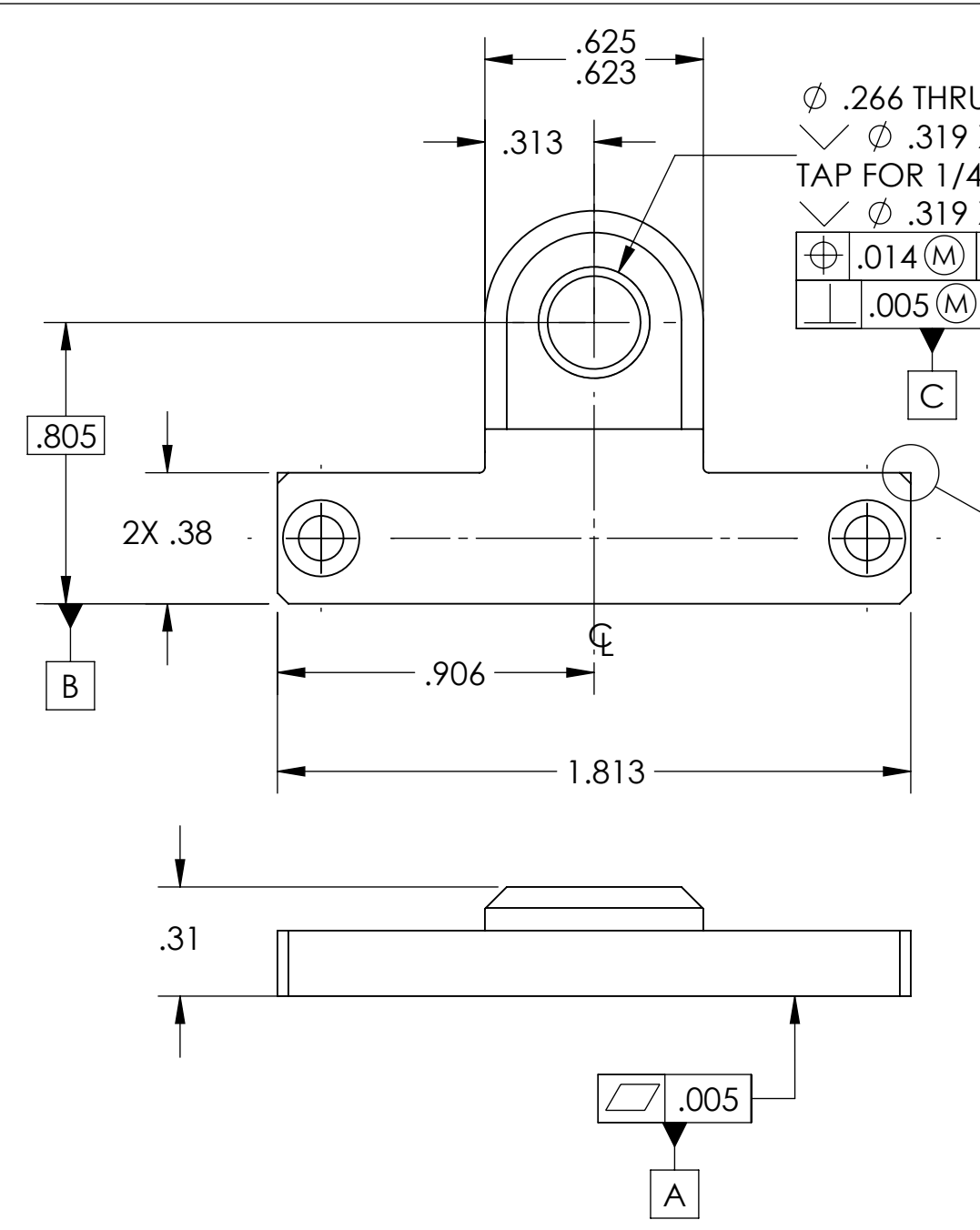
ISO VIEW



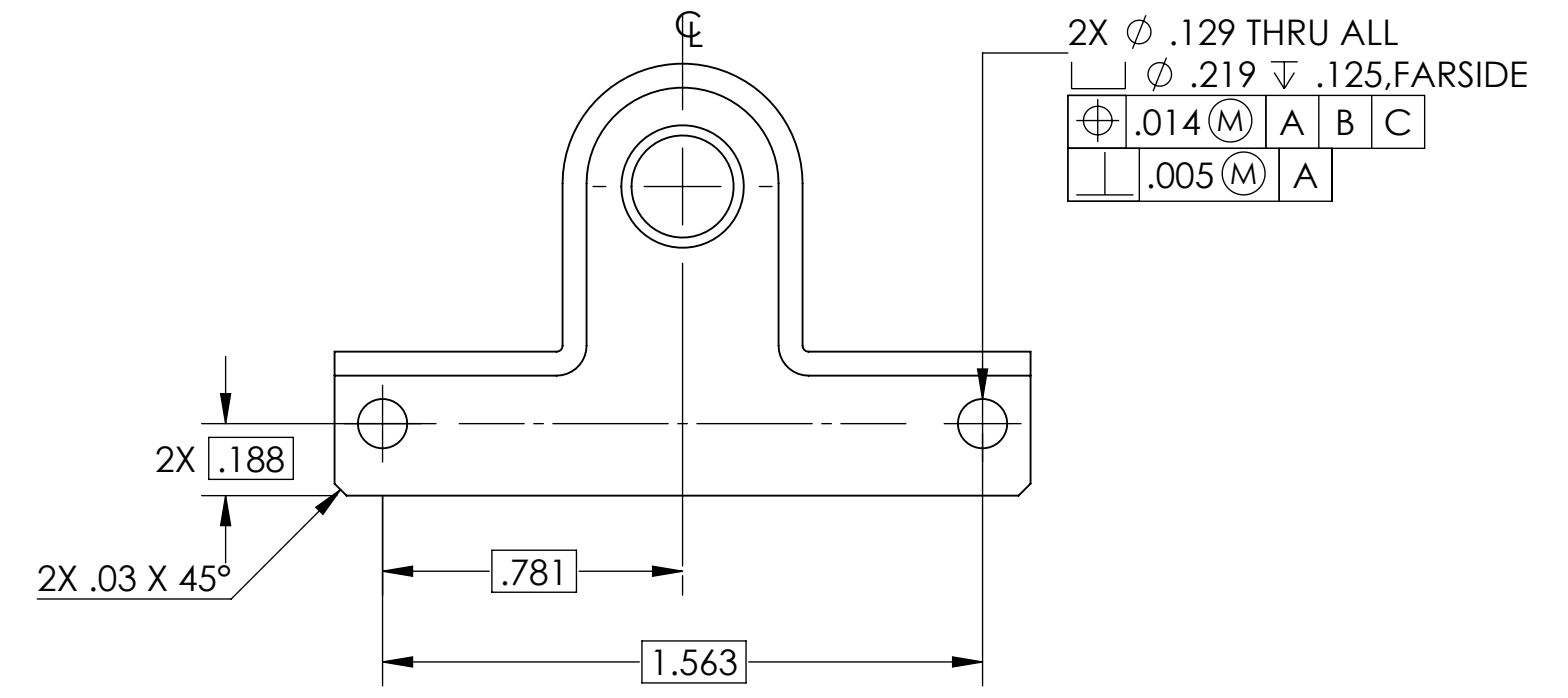
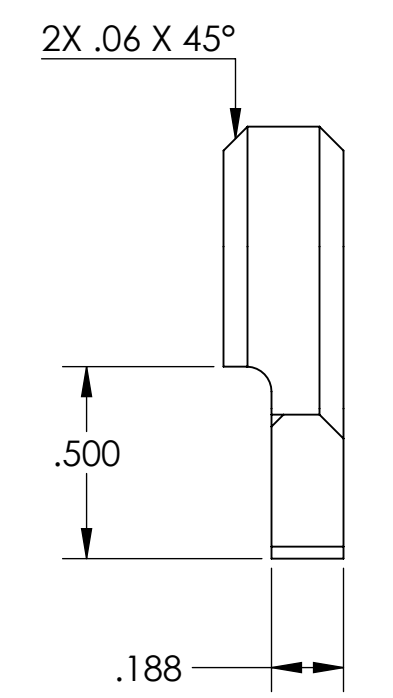
-101 DETAIL



-102 DETAIL



DETAIL A SCALE 4 : 1



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.
6	3585-4EN250 EMHART OR EQ.	HELICOIL, 1/4-20 X .25 LG.	NITRONIC 60	1
5	MS16995-26 OR EQ.	SCREW, SHC, 8-32 X .50 LG.	300 SSSL	2
4	MS16995-10 OR EQ.	SCREW, SHC, 4-40 X .38 LG.	300 SSSL	2
3	D1200606-103	ALIGO, COC, ETM /ITM FC SPRAY GUARD ASSY., RET PLUNGER MT.	PTFE	1
2	D1200606-102	ALIGO, COC, ETM /ITM FC SPRAY GUARD ASSY., THREADED BLOCK	6061-T6 Al	1
1	D1200606-101	ALIGO, COC, ETM /ITM FC SPRAY GUARD ASSY., CARRIAGE	6061-T6 Al	1

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .XX ± .01
 .XXX ± .005
 ANGULAR ± 0.5°

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 pinch
NEXT ASSY D1200490

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO
SUB-SYSTEM COC

PARTS LIST
 PART NAME ALIGO, COC, ETM /ITM FC SPRAY GUARD, CARRIAGE ASSY.

DESIGNER E.SANCHEZ 27 JUN 2012
DRAFTER E.SANCHEZ 28 JUN 2012
CHECKER SEE DCC
APPROVAL SEE DCC

SIZE DWG. NO. D
SCALE 1:1
PROJECTION FIRST ANGLE
REV. v5
 SHEET 1 OF 1