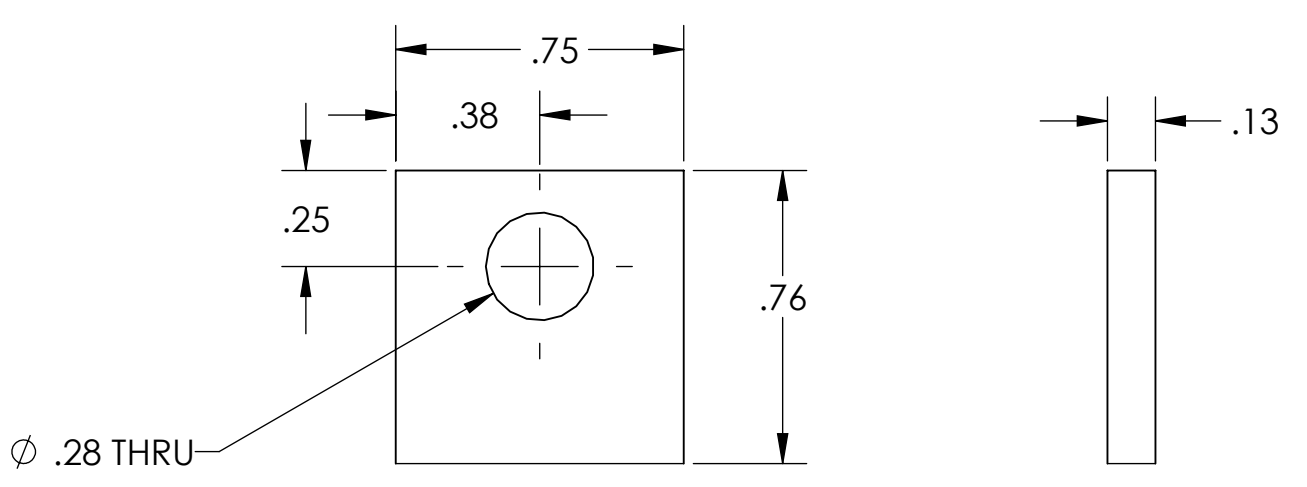
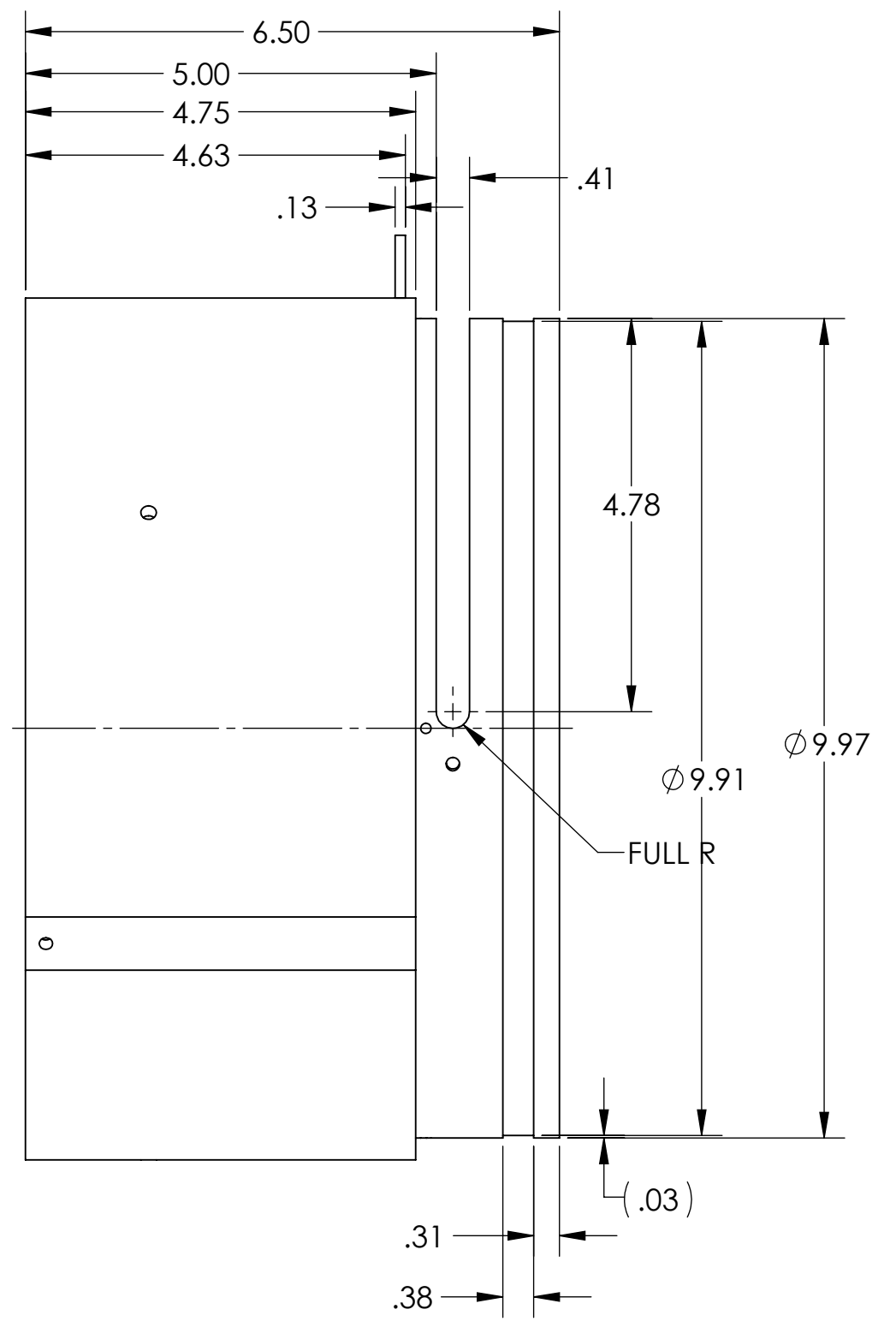
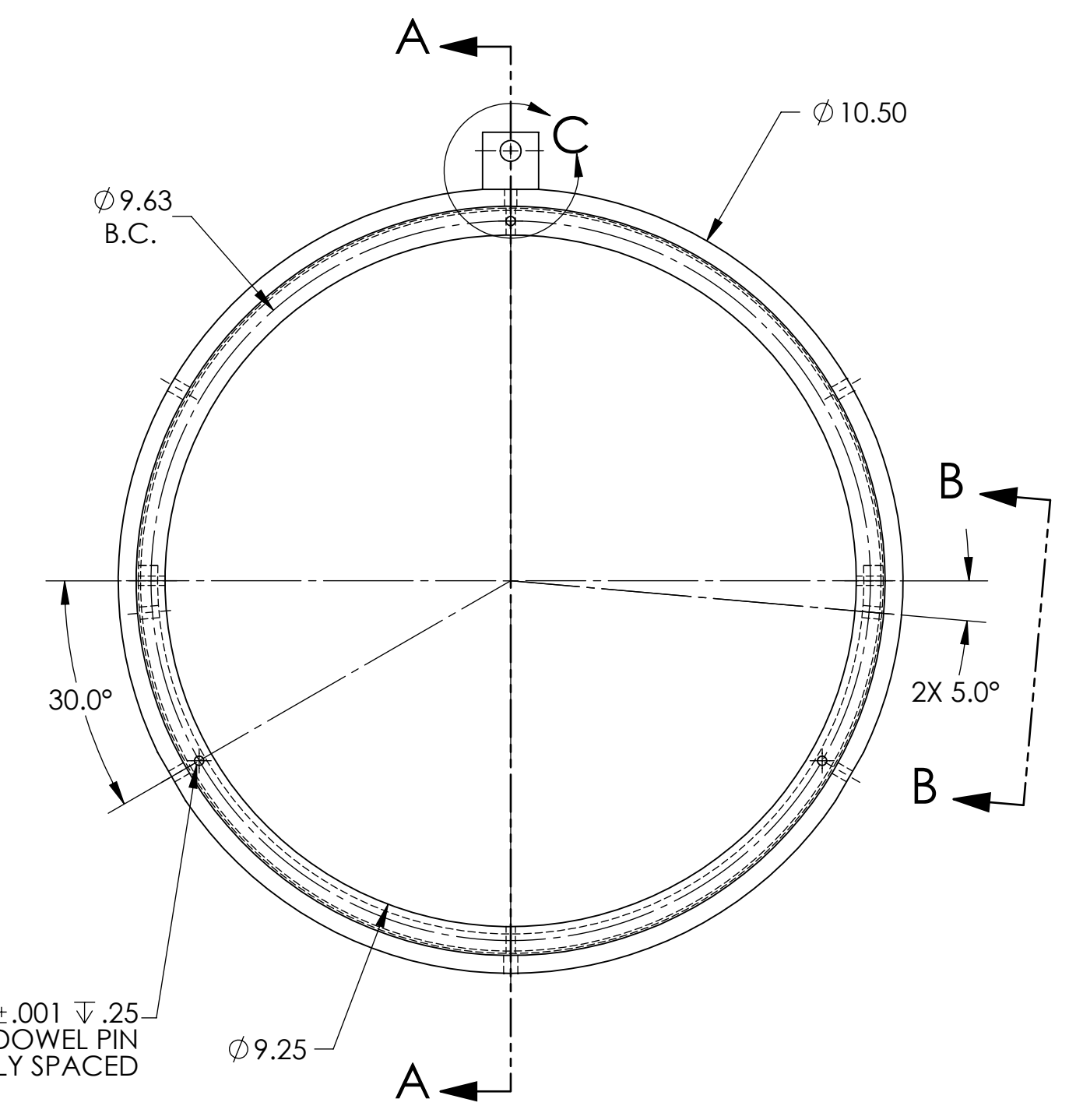
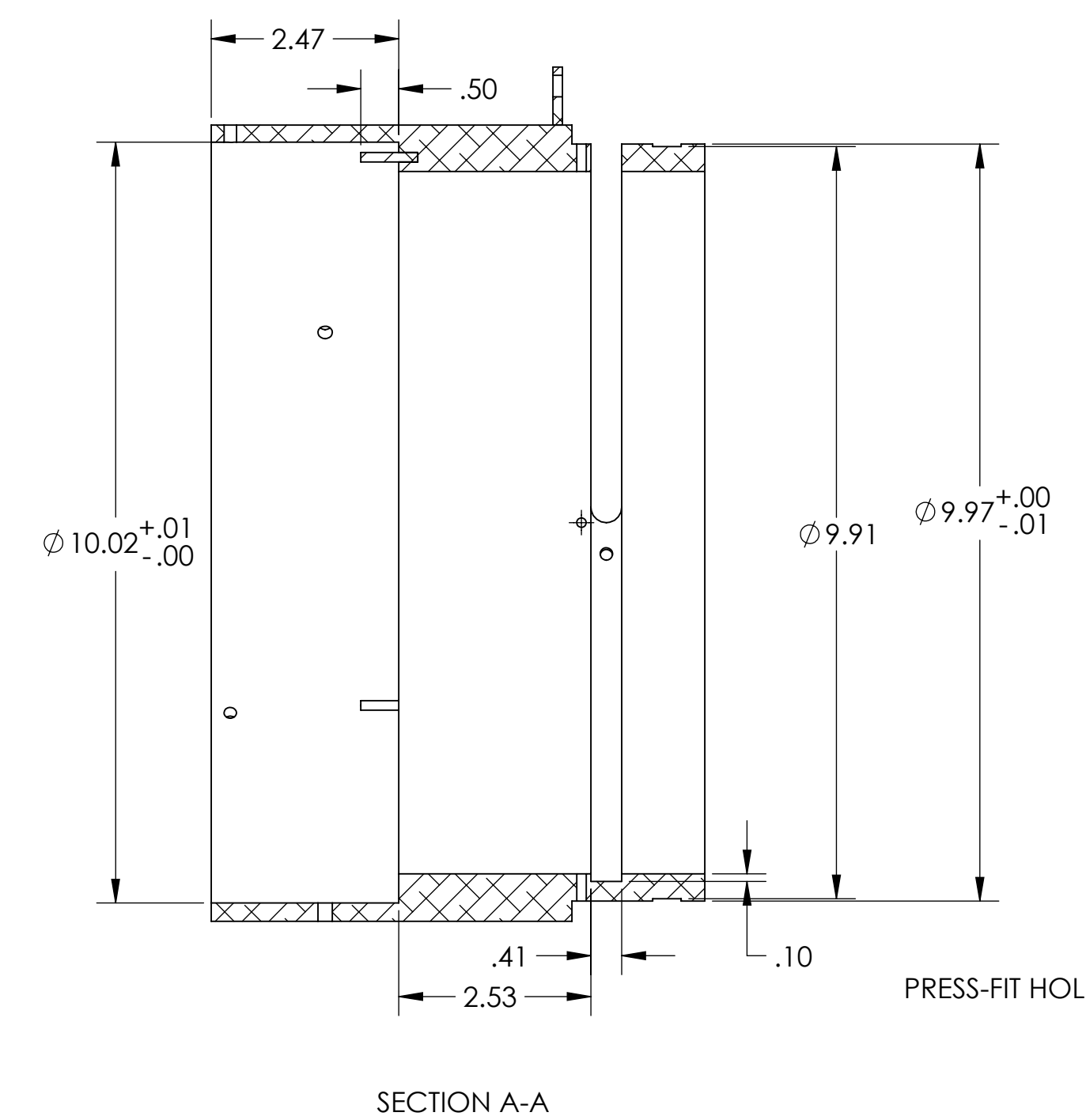
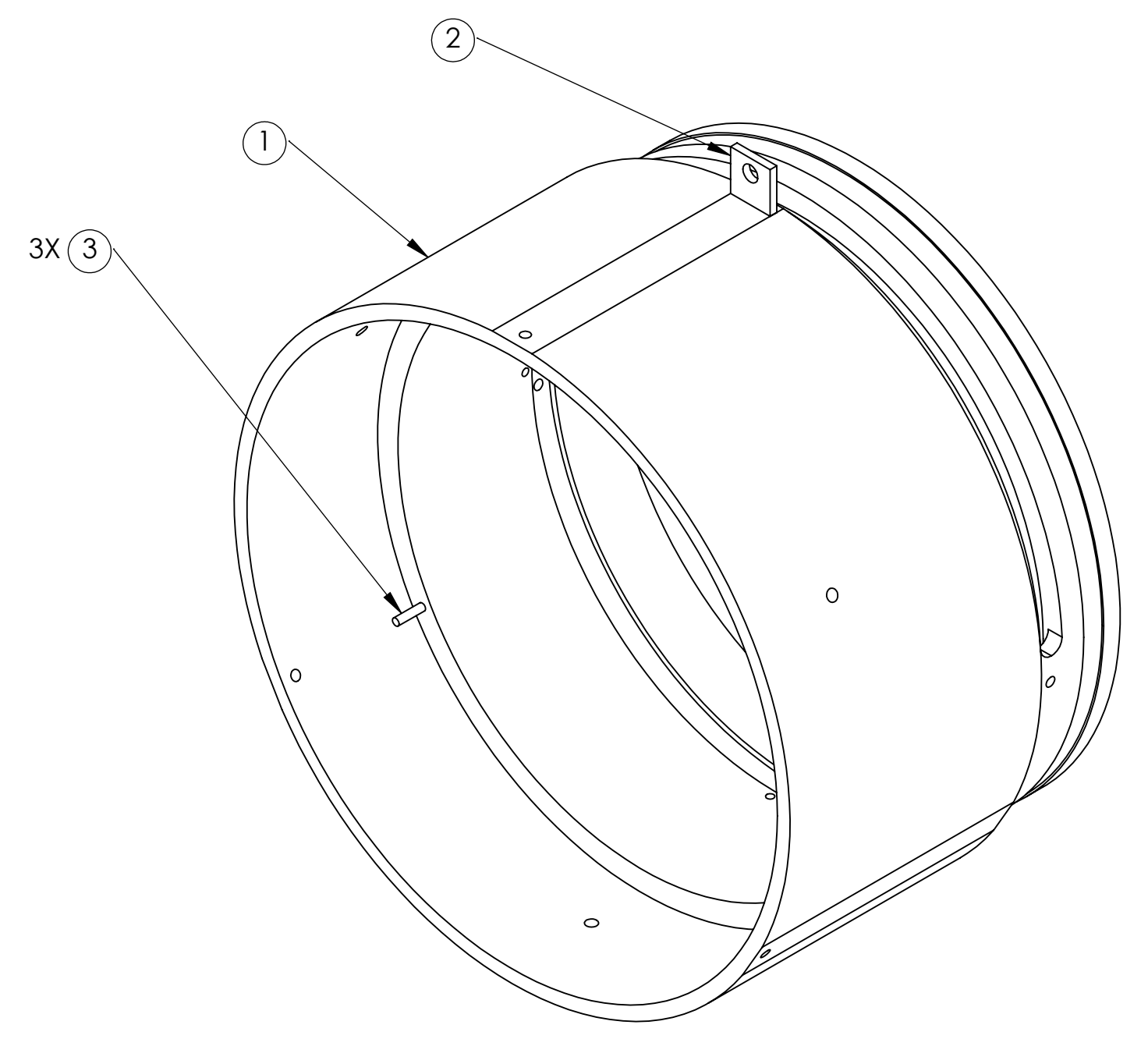
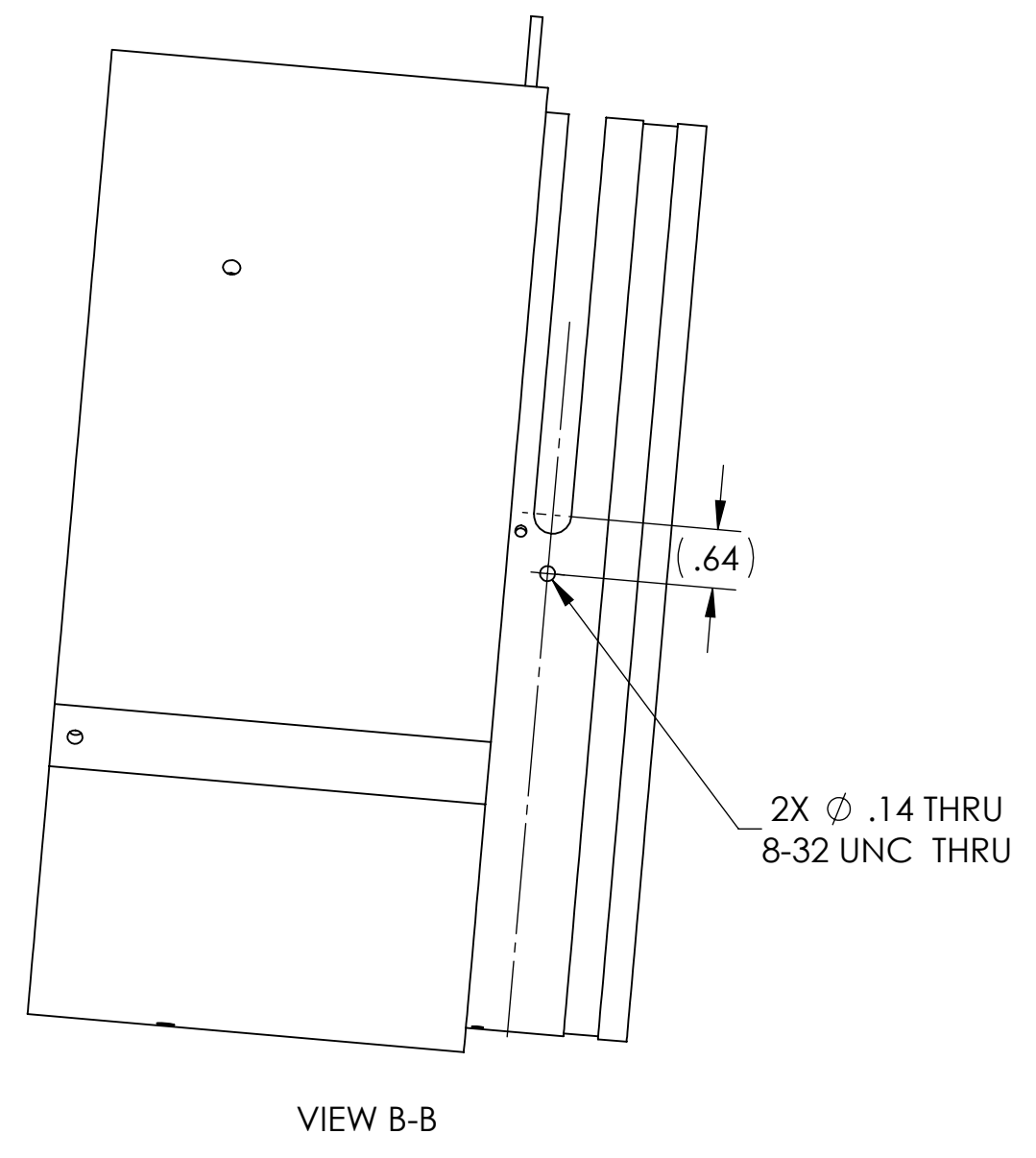
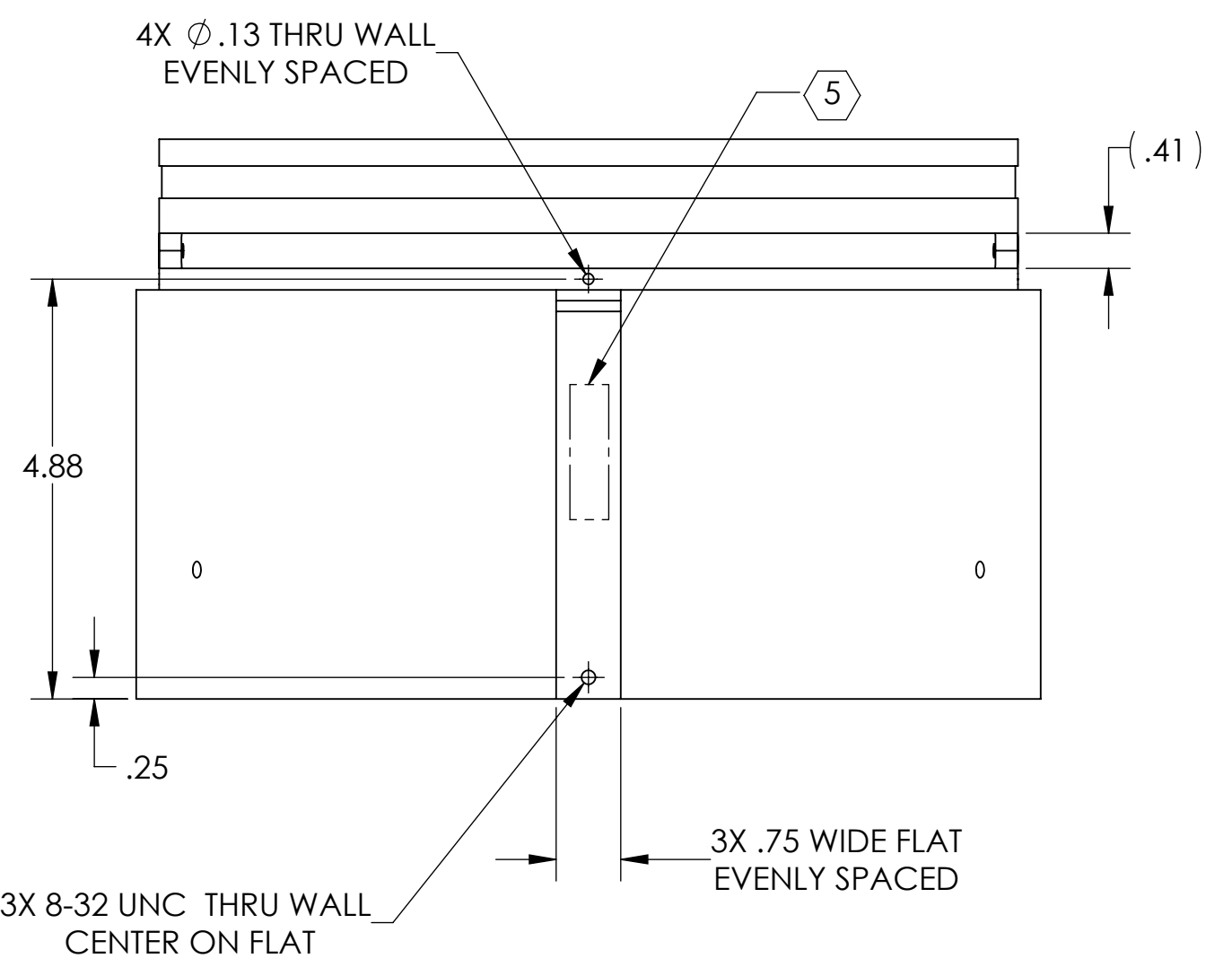
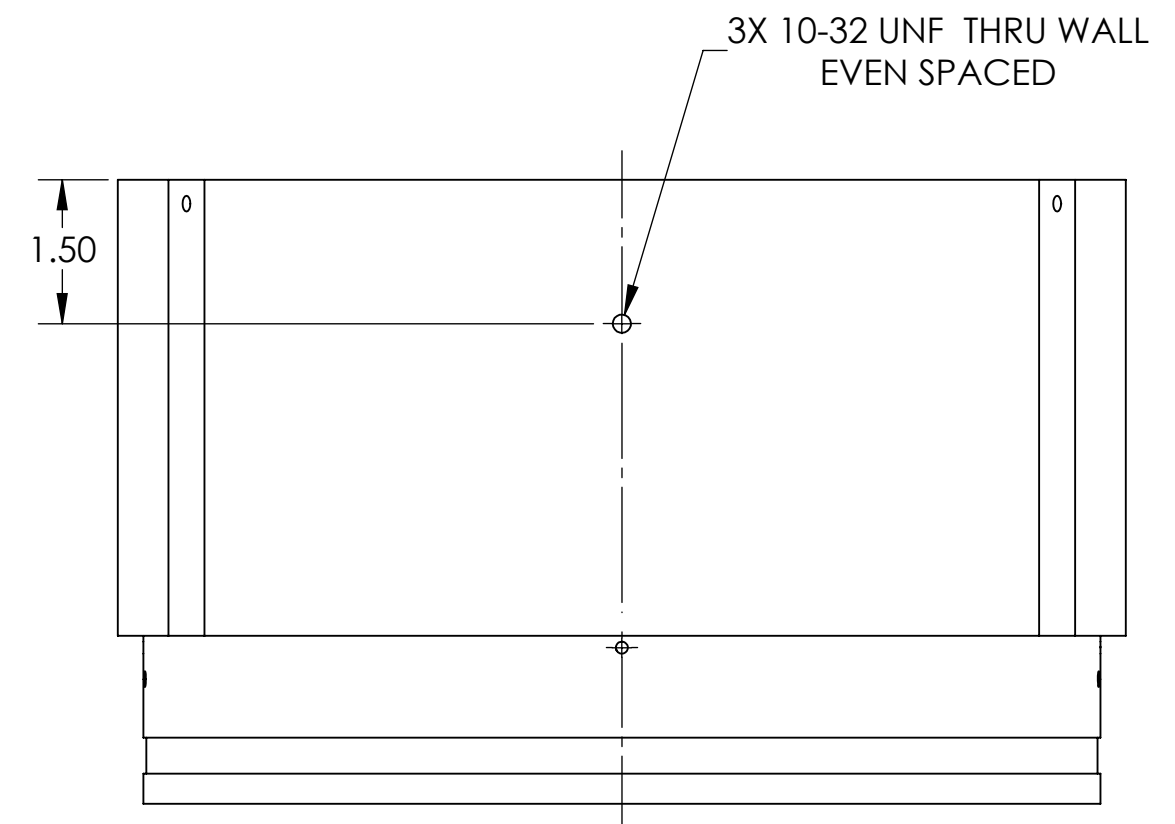
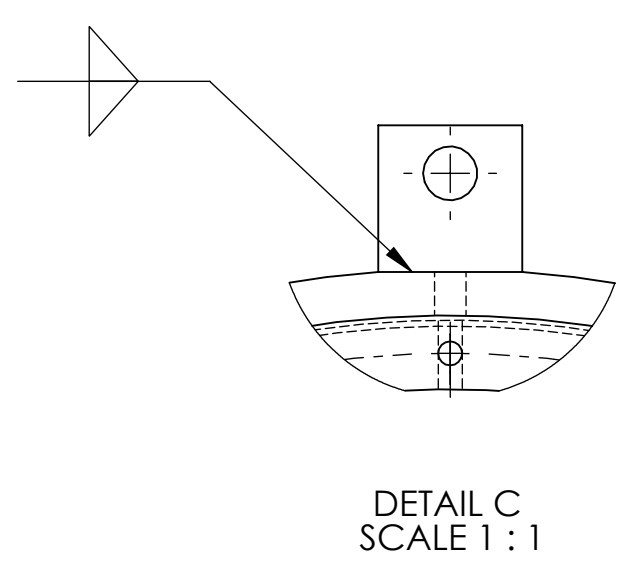


NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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 = 7.47 LBS.
 7. ITEMS 1 AND 2 CAN BE MADE FROM ONE PIECE IF DESIRED.



ITEM #2
 SCALE 1:2
 SEE DETAIL C FOR
 WELD CALLOUT



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ
3	97395A451	1/8" DOWEL PIN, 3/4" LONG, McMASTER-CARR	316 SSTL	3
2	D1200873-2	LOCKING TAB, .76" X .75" .125" THICK	6061-T6-AL	1
1	D1200873-1	HIGH POWER VIEWPORT GUARD	6061-T6 AL	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°

MATERIAL: 6061-T6 Al
 FINISH: 63 μinch
 NEXT ASSY: D1200963

CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY
 SYSTEM: ADVANCED LIGO
 SUB-SYSTEM: AOS

PART NAME: HIGH POWER VIEWPORT GUARD
 DESIGNER: TQ, NGUYEN
 DRAFTER: TQ, NGUYEN
 CHECKER: L. AUSTIN
 APPROVAL: M. SMITH
 DATE: 15 JUN 2012
 SIZE: D
 DWG. NO.: D1200873
 REV.: v1
 SCALE: 1:2
 PROJECTION: 1st Angle
 SHEET 1 OF 1

D1200873.dwg, High Power Viewport Guard, PART PDM REV: X-003, DRAWING PDM REV: X-006