

NOTES CONTINUED:

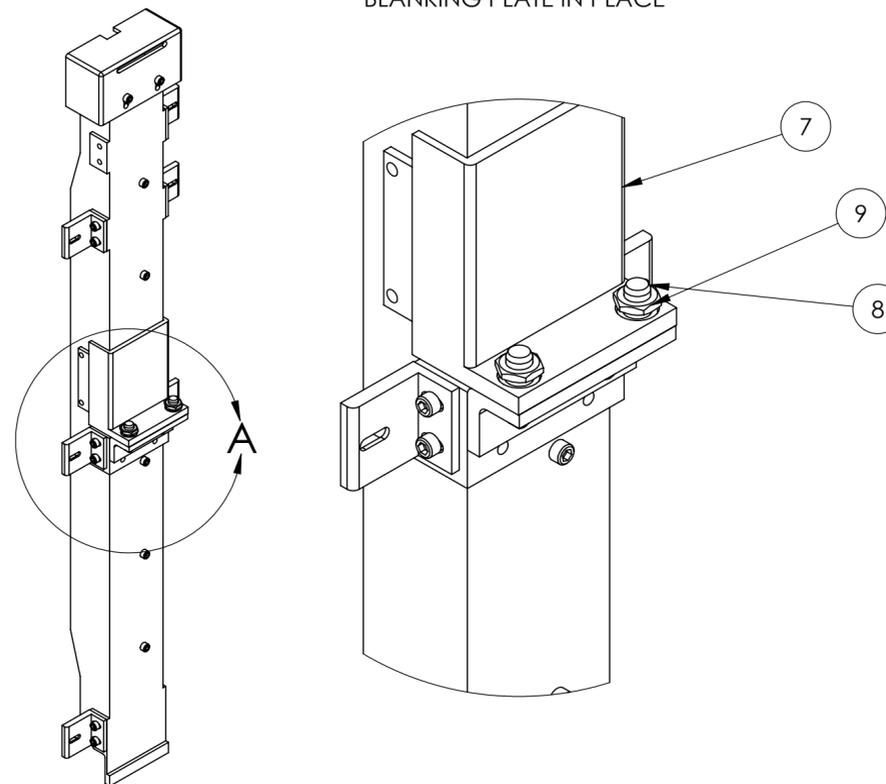
⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.

⑥ MACHINE ALL SURFACES.

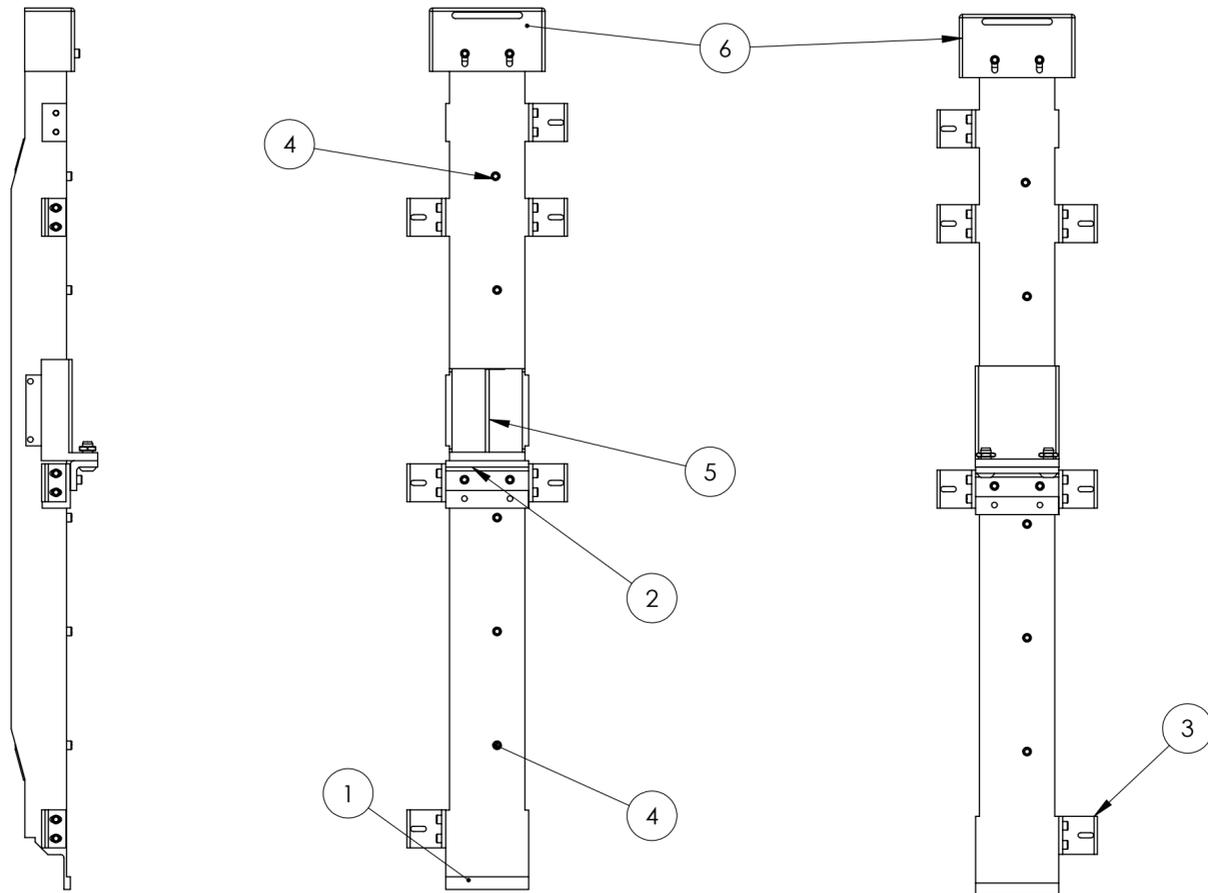
⑦ ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY. USE NITRONIC 60 THREAD INSERTS.

REV.	DATE	DCN #	DRAWING TREE #
-	-	-	-
-	-	-	-
-	-	-	-

BLANKING PLATE IN PLACE



DETAIL A  
SCALE 1 : 1.5



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
10		#8-32 HELICOIL THREADINSERTS1*Diameter	NITRONIC 60	21		21
9		5/16-18 LOCK NUT (U-C COMPONENTS N-31 18-A)	Ag -PLATED 300 SSTL	2		2
8		5/16-18 SKT HEAD BUTTON CAP SCREW 1"	STAINLESS STEEL	2		2
7	D0902513	ANGLE SECTION 5	6061-T6 (SS)	1		1
6	D1001660	FIBRE GUARD TOP CAP	6061-T6 (SS)	1		1
5	D0902508	FIBRE GUARD SEPERATOR	6061-T6 (SS)	1		1
4	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 0.3125 LONG	STAINLESS STEEL	21		21
3	D0902512	ANGLE SECTION 4	6061-T6 (SS)	6		6
2	D0902511	ANGLE SECTION 3	6061-T6 (SS)	1		1
1	D0902507	FIBRE GUARD MAIN BODY	6061-T6 (SS)	1		1
PARTS LIST						

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, R.02 MIN.
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	N/A	FINISH	1.6 μm
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**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM	ADVANCED LIGO	SUB-SYSTEM	SUS
NEXT ASSY			

PART NAME		FIBRE GUARD ASSEMBLY			
DESIGNER	L.Cunningham	25/06/10	SIZE	DWG. NO.	REV.
DRAFTER			c	D0902506	v8
CHECKER			SCALE: 1:4	PROJECTION:	SHEET 1 OF 2
APPROVAL					

DIMENSIONS ARE IN MILLIMETERS

TOLERANCES:  
.XX ± .10  
.XXX ± .010

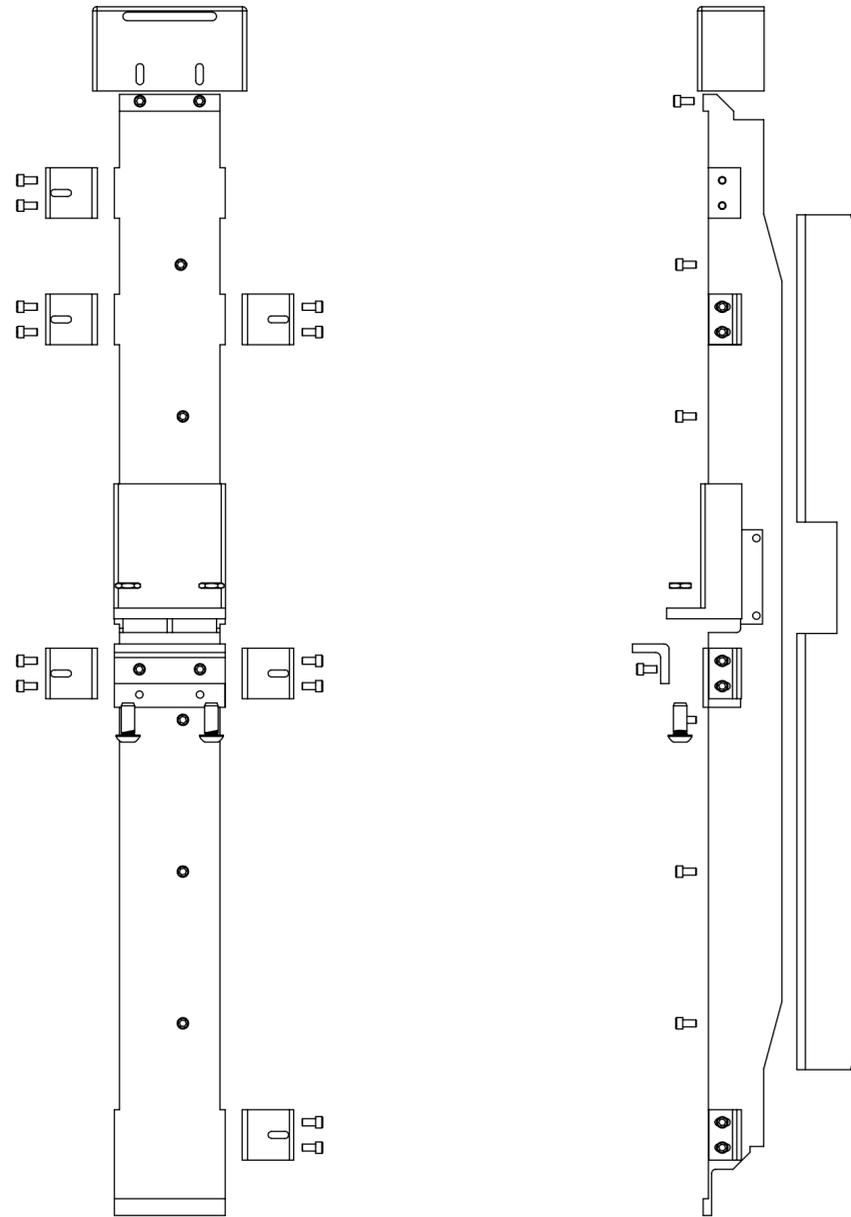
ANGULAR ± 0.2°

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REV.	DATE	DCN #	DRAWING TREE #



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<b>MATERIAL</b>	N/A	<b>FINISH</b>	1.6 μm
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<b>SYSTEM</b>	ADVANCED LIGO	<b>SUB-SYSTEM</b>	SUS
<b>NEXT ASSY</b>			

<b>PART NAME</b>				FIBRE GUARD ASSEMBLY			
<b>DESIGNER</b>	L Cunningham	<b>DATE</b>	25/06/10	<b>SIZE</b>	<b>DWG. NO.</b>	<b>REV.</b>	
<b>DRAFTER</b>				c	D0902506	v8	
<b>CHECKER</b>				<b>SCALE:</b> 1:4	<b>PROJECTION:</b>		
<b>APPROVAL</b>						SHEET 2 OF 2	