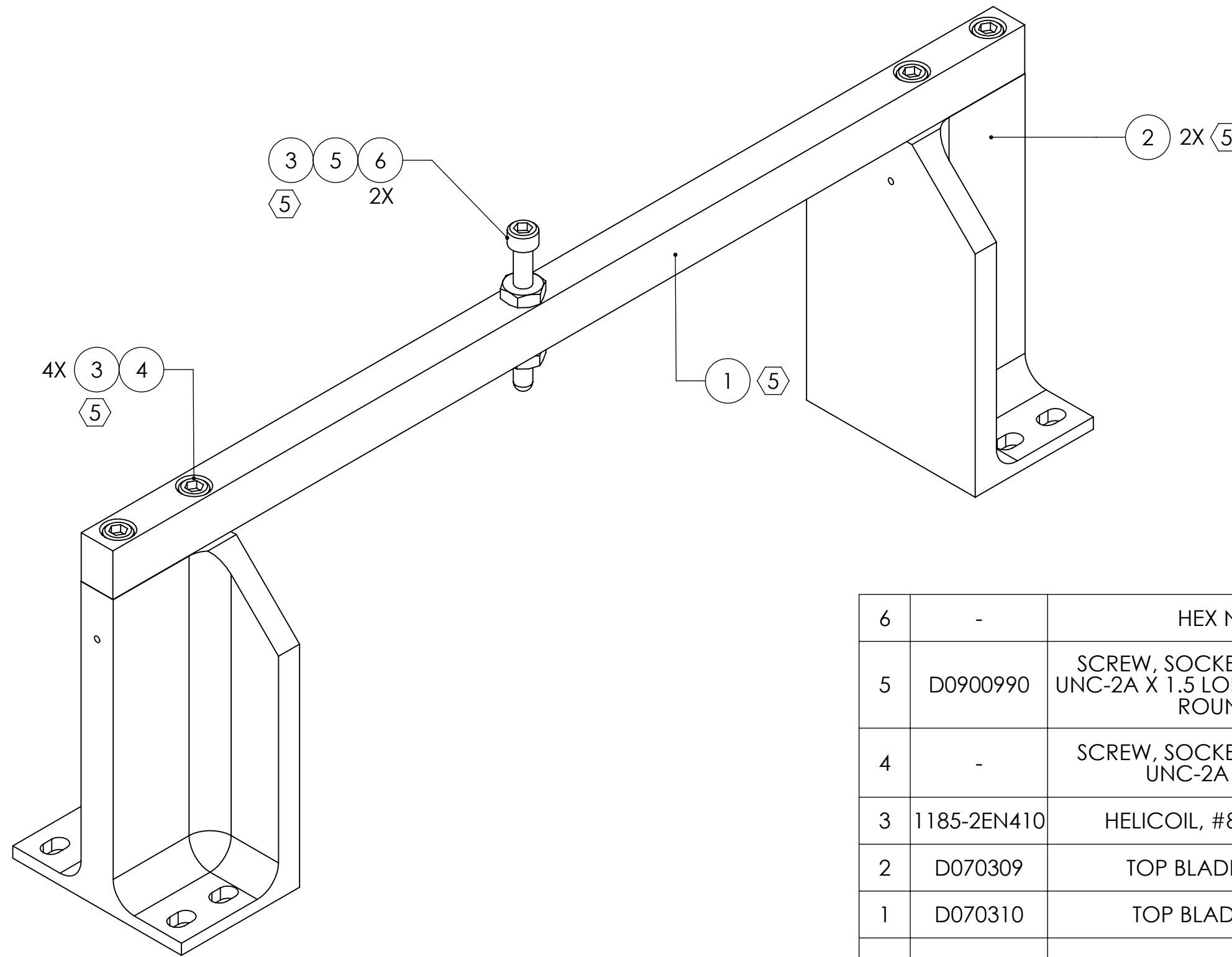


D070308_Advanced_LIGO_SUS_HLTS_Top_Blade_Guard_Assembly, PART PDM REV: X-004, DRAWING PDM REV: X-001

NOTES CONTINUED:
 ⑤ HELICOILS TO BE INSTALLED INTO ITEM NO. 1 AND ITEM NO. 2 BY LIGO PRIOR TO ASSEMBLY AND AFTER ALL PARTS ARE CLEANED AND BAKED.

REV.	DATE	DCN #	DRAWING TREE #
v1	26 MAY 2009	E0900159	E080191
-	-	-	-
-	-	-	-



6	-	HEX NUT, #8-32	300 SSTL	2	0	2
5	D0900990	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 1.5 LONG, FULLY THREADED, ROUNDED END	300 SSTL	1	0	1
4	-	SCREW, SOCKET HEAD CAP, #8-32 UNC-2A X 0.75 LONG	300 SSTL	4	1	5
3	1185-2EN410	HELICOIL, #8-32 X 0.41 LONG ⑤	NITRONIC 60	5	3	8
2	D070309	TOP BLADE GUARD RISER ⑤	6061-T6 Al	2	0	2
1	D070310	TOP BLADE GUARD BAR ⑤	6061-T6 Al	1	0	1
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL

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, R.02 MIN.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.

MATERIAL N/A FINISH N/A μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY
 SYSTEM ADVANCED LIGO SUB-SYSTEM SUS
 NEXT ASSY HLTS OVERALL ASSY

PART NAME TOP BLADE GUARD ASSY
 DESIGNER G. SCARBOROUGH 28 APR 2008 SIZE DWG. NO. B D070308 REV. v1
 DRAFTER D. BRIDGES 03 JUN 2009
 CHECKER M. MEYER 04 JUN 2009
 APPROVAL
 SCALE: 1:1 PROJECTION: SHEET 1 OF 1