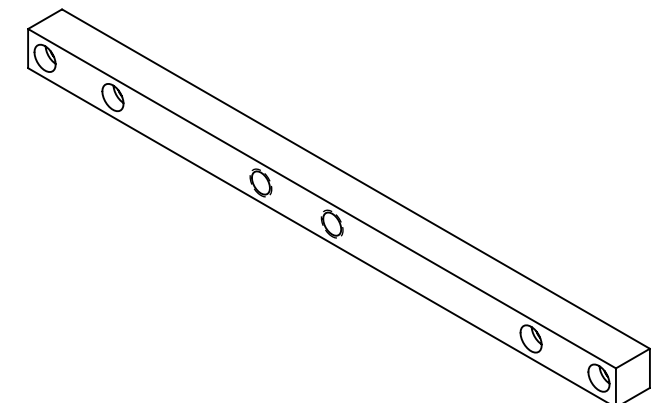


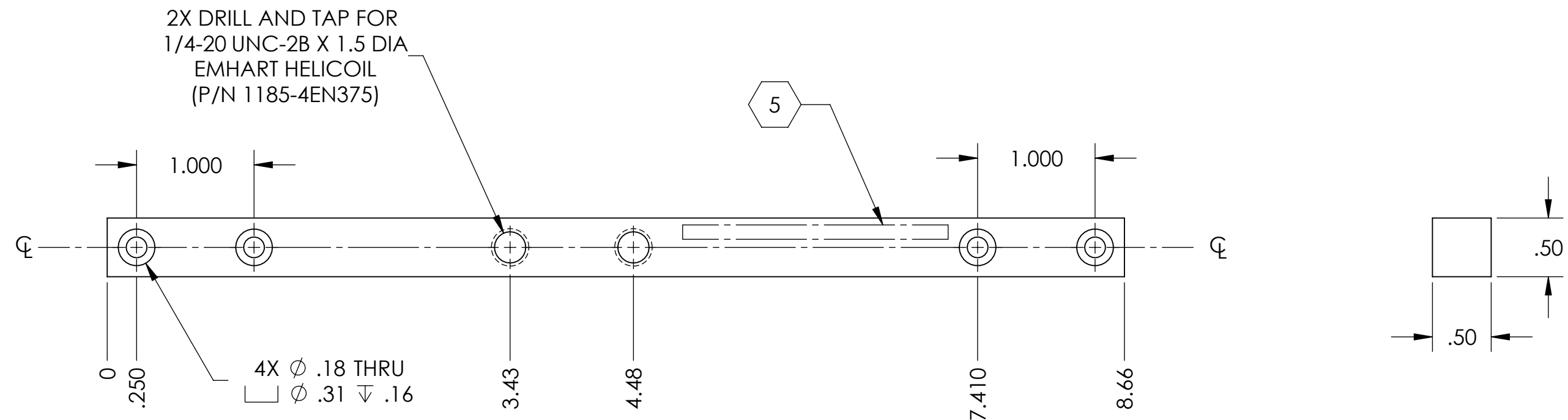
NOTES CONTINUED:

- 5. SCRIBE, ENGRAVE, 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 101 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS. UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.  
EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
- 6. APPROXIMATE WEIGHT = 0.198 LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
- 10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

REV.	DATE	DCN #	DRAWING TREE #
v1	09 JUN 2010	E0900498	E0900353
-	-	-	-
-	-	-	-



ISOMETRIC VIEW



2X DRILL AND TAP FOR  
1/4-20 UNC-2B X 1.5 DIA  
EMHART HELICOIL  
(P/N 1185-4EN375)

4X  $\phi$  .18 THRU  
 $\square$   $\phi$  .31  $\nabla$  .16

D0901935\_Blade\_Guard\_Crosspiece\_HSTS, PART PDM REV: X-004, DRAWING PDM REV: X-008

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX $\pm$ .03 .XXX $\pm$ .005 ANGULAR $\pm$ 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 MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		BLADE GUARD CROSSBEAM	
MATERIAL		FINISH		SYSTEM		SUB-SYSTEM	
6061-T6 Al		32 $\mu$ inch		ADVANCED LIGO		SUS	
NEXT ASSY				DESIGNER		SIZE DWG. NO.	
D0901934				W. RASCH		B	
				DRAFTER		REV.	
				B. MOORE		v1	
				CHECKER		SCALE: 1:1	
				M. MEYER		PROJECTION:	
				APPROVAL		SHEET 1 OF 1	