

REV.	DATE	DCN #	DRAWING TREE #
v1	10 Sept.2001	E1100836	E1100837

NOTES CONTINUED:

- 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE, PER LIGO SPECIFICATION E0900237.
- 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. A VIBRATORY TOOL MAY BE USED. EXAMPLE DXXXXXXX-VY, TYPE-XX, S/N XXX.
- 6. APPROXIMATE WEIGHT = 0.312 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. NOT WELD REPAIRS OR PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING BY LIGO LABORATORY. REFER TO LIGO-E0900364.

3X ϕ .20 ∇ 1.15
 1/4-20 UNC ∇ .60
 \checkmark ϕ .32 X 90°, NEAR SIDE
 USE .005" OVERSIZE TAP

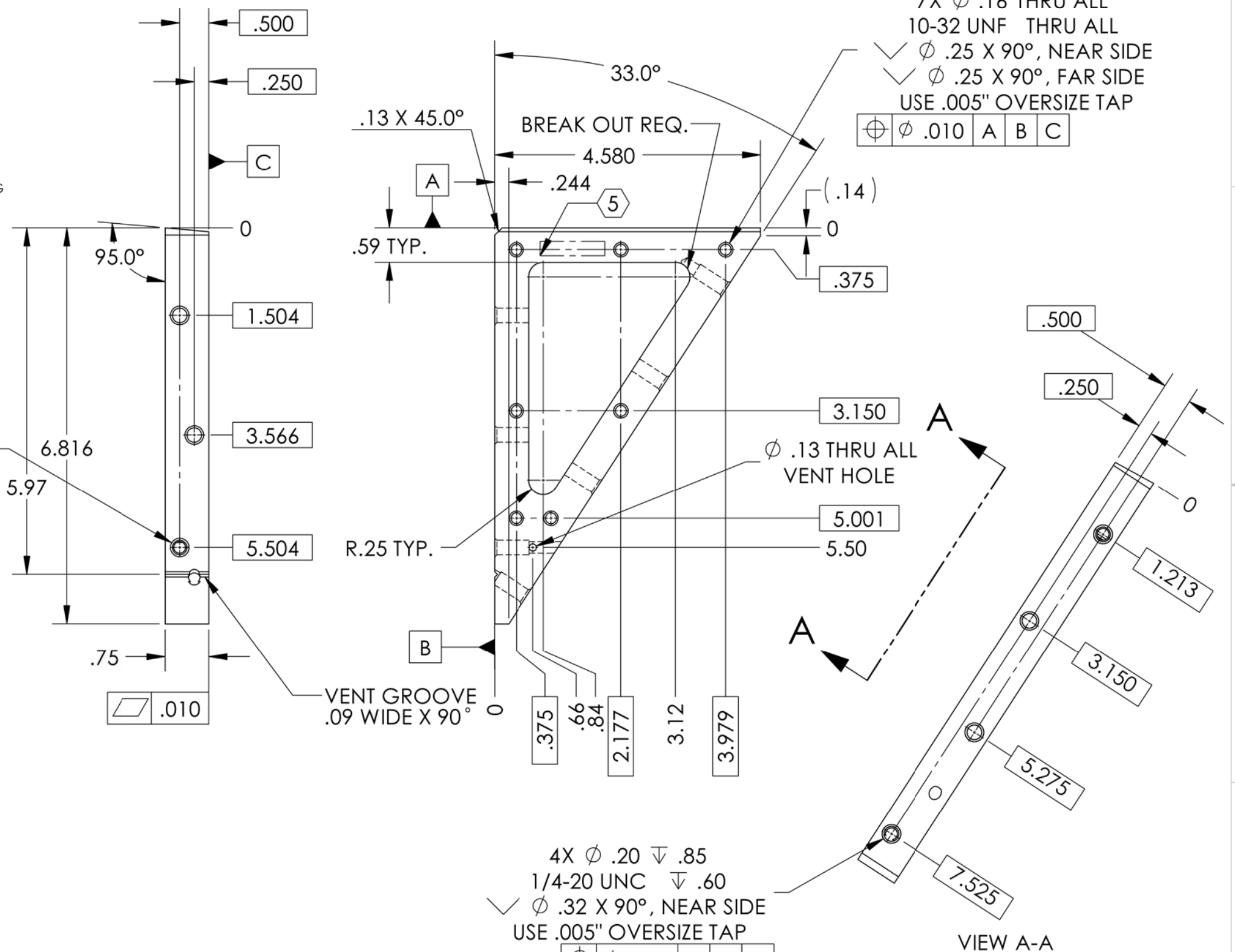
ϕ .010	A	B	C
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7X ϕ .16 THRU ALL
 10-32 UNF THRU ALL
 \checkmark ϕ .25 X 90°, NEAR SIDE
 \checkmark ϕ .25 X 90°, FAR SIDE
 USE .005" OVERSIZE TAP

ϕ .010	A	B	C
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4X ϕ .20 ∇ .85
 1/4-20 UNC ∇ .60
 \checkmark ϕ .32 X 90°, NEAR SIDE
 USE .005" OVERSIZE TAP

ϕ .010	A	B	C
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D1101603, PART PDM REV: X-016, DRAWING PDM REV: X-013

DIMENSIONS ARE IN INCHES		TOLERANCES: .XX ± .015 .XXX ± .005		ANGULAR ± 0.1°		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) 1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. ON ALL EDGES AND HOLES. 3. DO NOT SCALE FROM DRAWING.		MATERIAL 6061-T6 Al		FINISH 63 μinch		PART NAME αLIGO AOS, HAM SCRAPER BAFFLE BOTTOM		DESIGNER M.HILLARD		DRAFTER M.HILLARD		CHECKER -		APPROVAL -		DATE 16 Aug. 2011		SIZE B		DWG. NO. D1101603		REV. v1	
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY SYSTEM ADVANCED LIGO SUB-SYSTEM AOS NEXT ASSY D1101599												SCALE: 1:2		PROJECTION:		SHEET 1 OF 1													