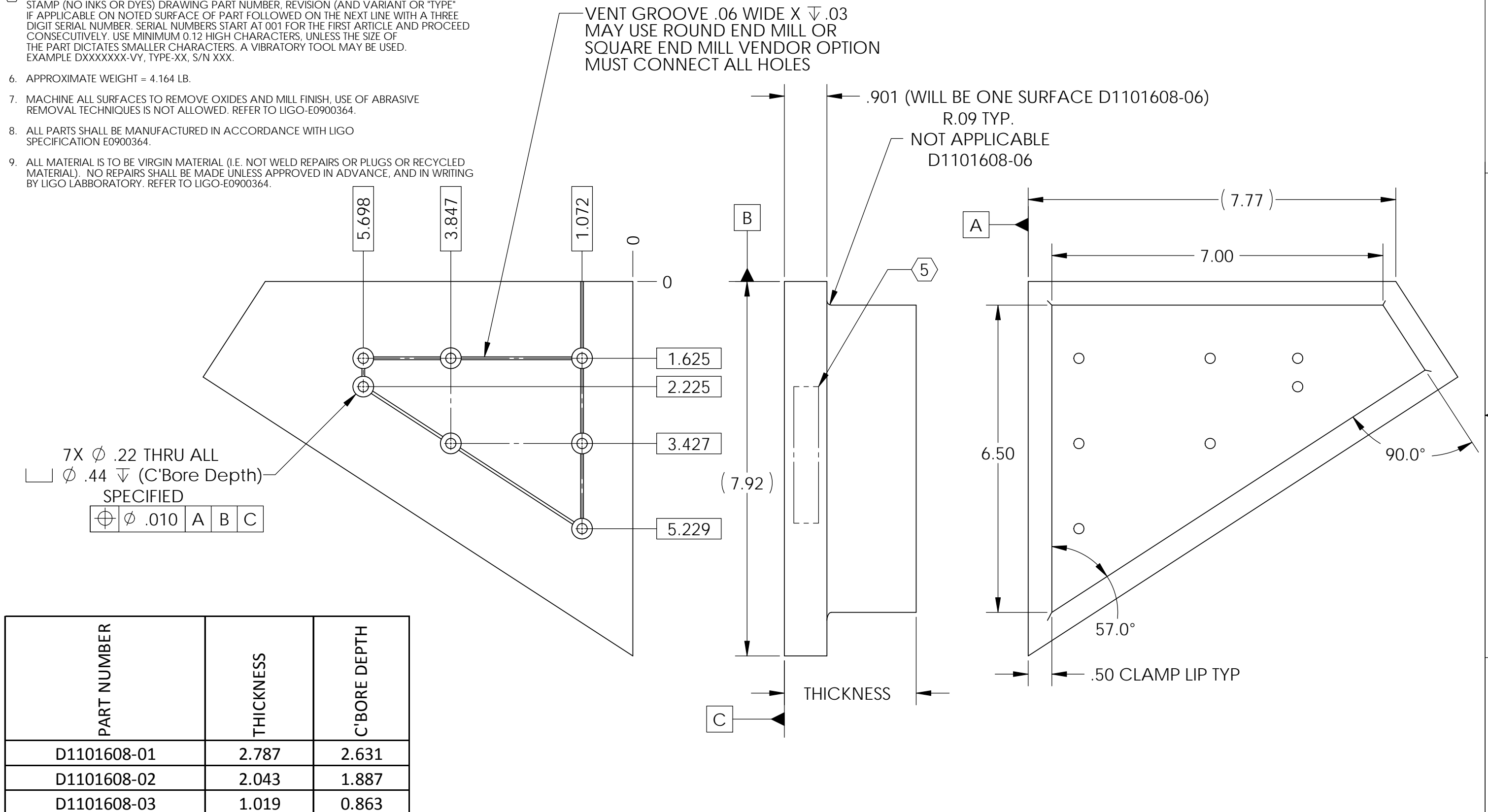


REV.	DATE	DCN #	DRAWING TREE #
v1	13 Sept. 2011	E1100836	E1100837

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 = 4.164 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.



PART NUMBER	THICKNESS	C'BORE DEPTH
D1101608-01	2.787	2.631
D1101608-02	2.043	1.887
D1101608-03	1.019	0.863
D1101608-04	2.684	2.528
D1101608-05	2.440	2.284
D1101608-06	0.901	0.745

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .015
.XXX ± .005

ANGULAR ± .5°

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 μ inch

CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

PART NAME: aLIGO AOS, HAM SCRAPER BAFFLE BASE

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

DESIGNER: M.HILLARD 16 Aug. 2011 SIZE: B DWG. NO.: D1101608 REV.: v1

DRAFTER: M.HILLARD 13 Sept. 2011

CHECKER: 13 Sept. 2011

APPROVAL: 13 Sept. 2011

SCALE: 1:2 PROJECTION: SHEET 1 OF 1

D1101608, PART PDM REV: X-018, DRAWING PDM REV: X-006