

NOTES CONTINUED:

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. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

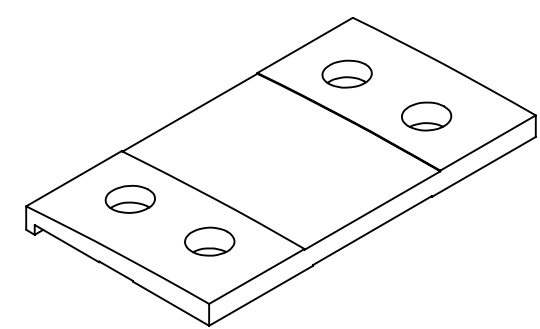
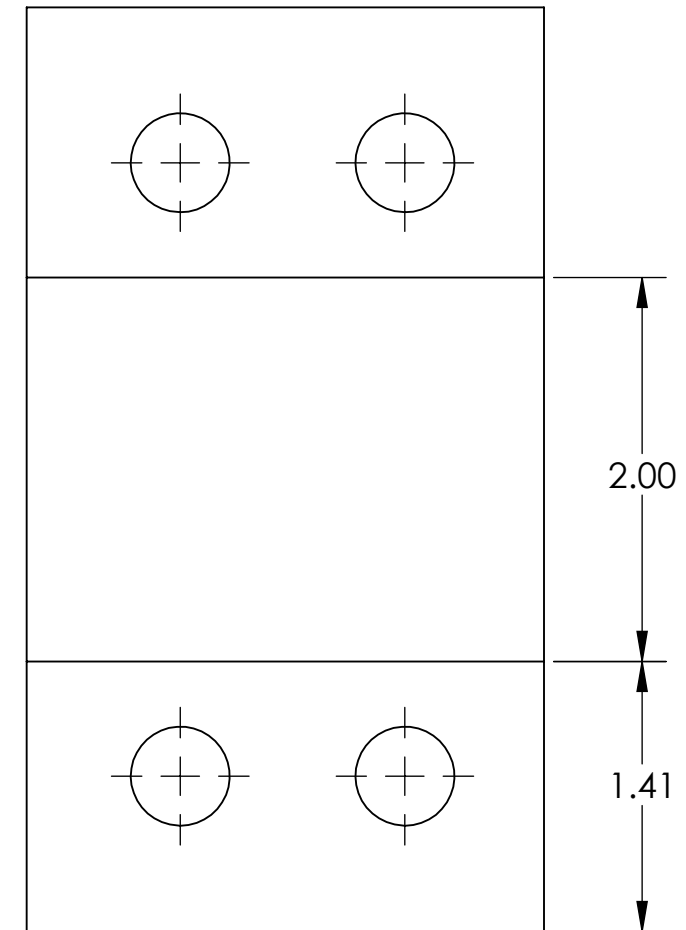
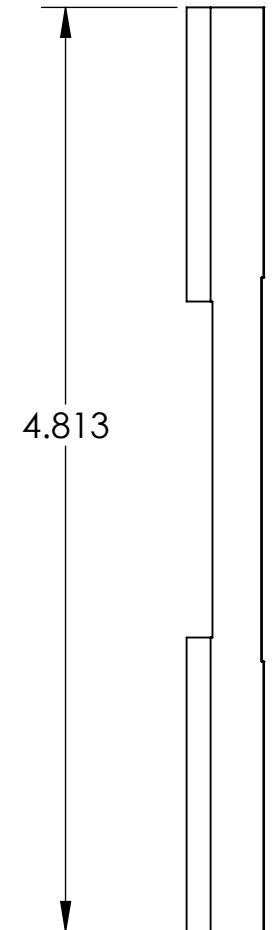
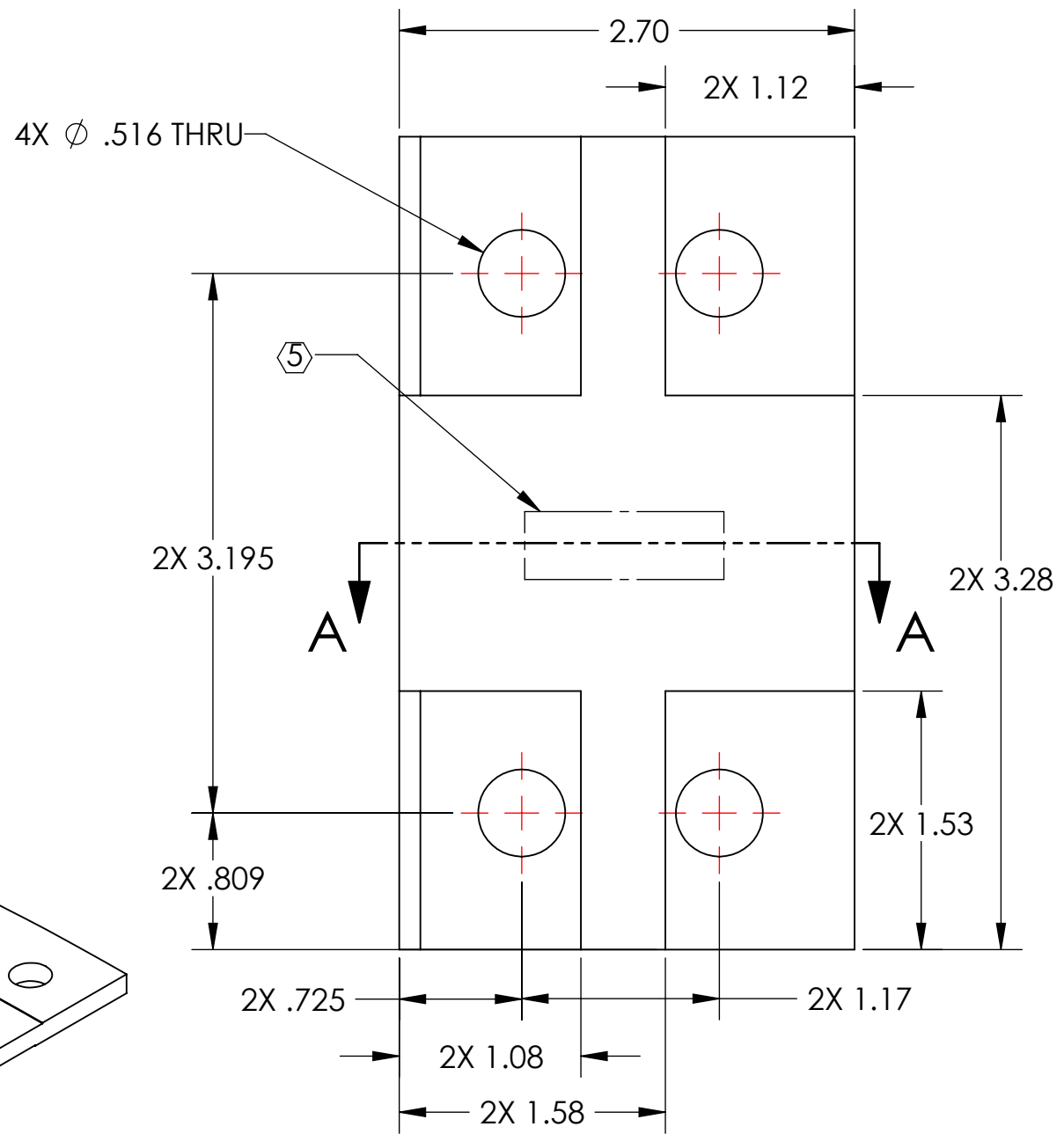
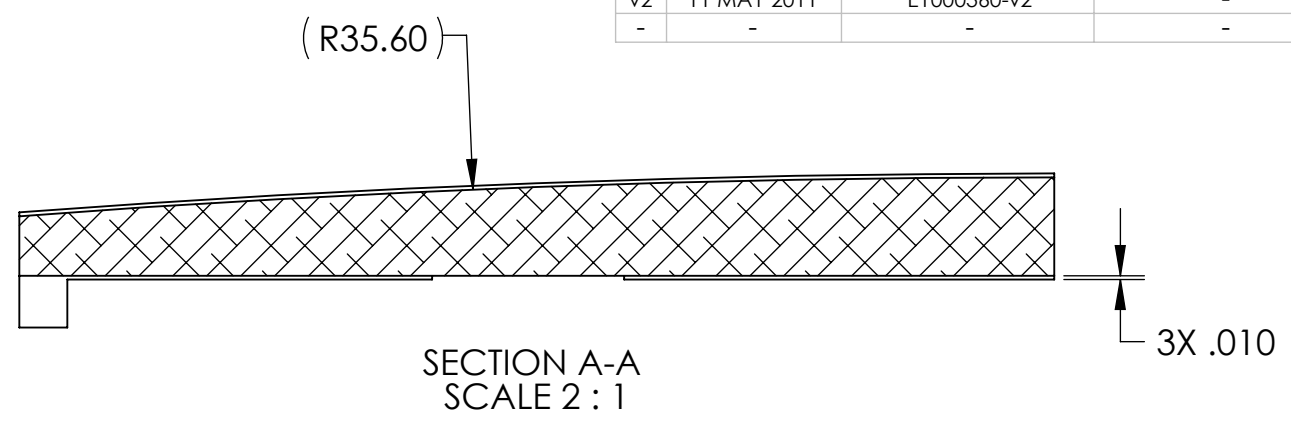
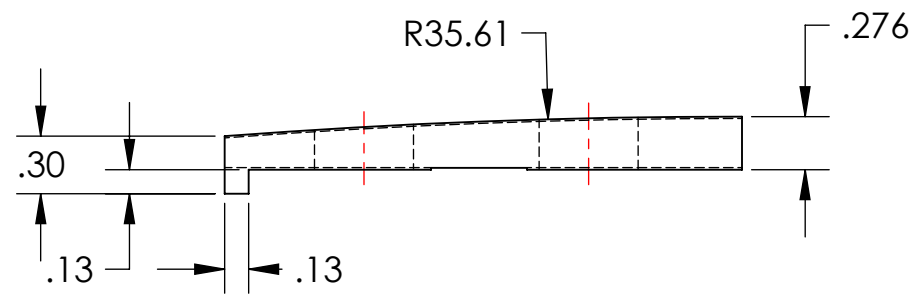
6. APPROXIMATE WEIGHT = 0.280 LB.

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. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	5 OCT 2010	E1000185	E1000358
v2	11 MAY 2011	E1000360-v2	-
-	-	-	-



GENERAL VIEW
NO SCALE
FOR REFERENCE ONLY

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES, R.02 MIN.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.

TOLERANCES:
.XX ± .01
.XXX ± .005
ANGULAR ± 0.5°

DIMENSIONS ARE IN INCHES

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
DESIGNER	TQ. NGUYEN	6 AUG 2010	SIZE DWG. NO.
DRAFTER	TQ. NGUYEN	13 JUL 2010	B
CHECKER	M. SMITH	27 SEP 2010	D0902820
APPROVAL	D. COYNE		REV. v2
MATERIAL		6061-T6 Al	
FINISH		63 μinch	
NEXT ASSY		D1002084	
SCALE: 1:1		PROJECTION:	
SHEET 1 OF 1			

D0902820_alIGO_Manifold_Cryo_Baffle_Spring_Shim, PART PDM REV: X-024, DRAWING PDM REV: X-015