

**NOTES: UNLESS OTHERWISE SPECIFIED**

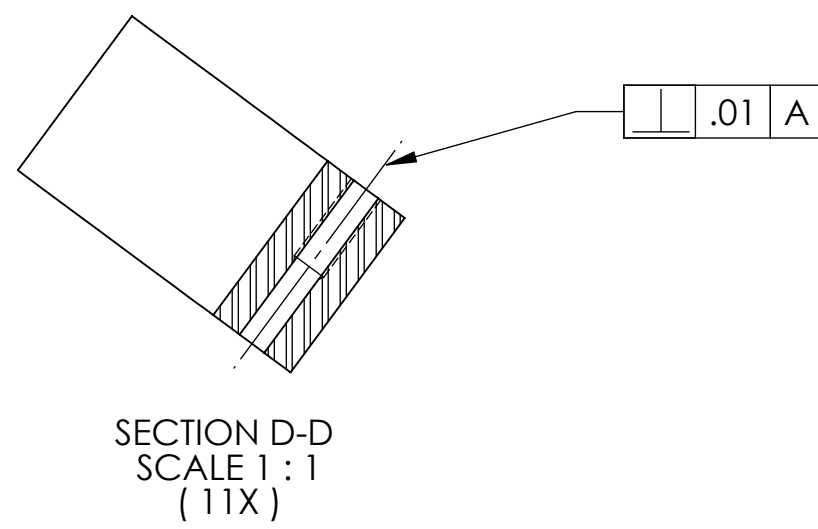
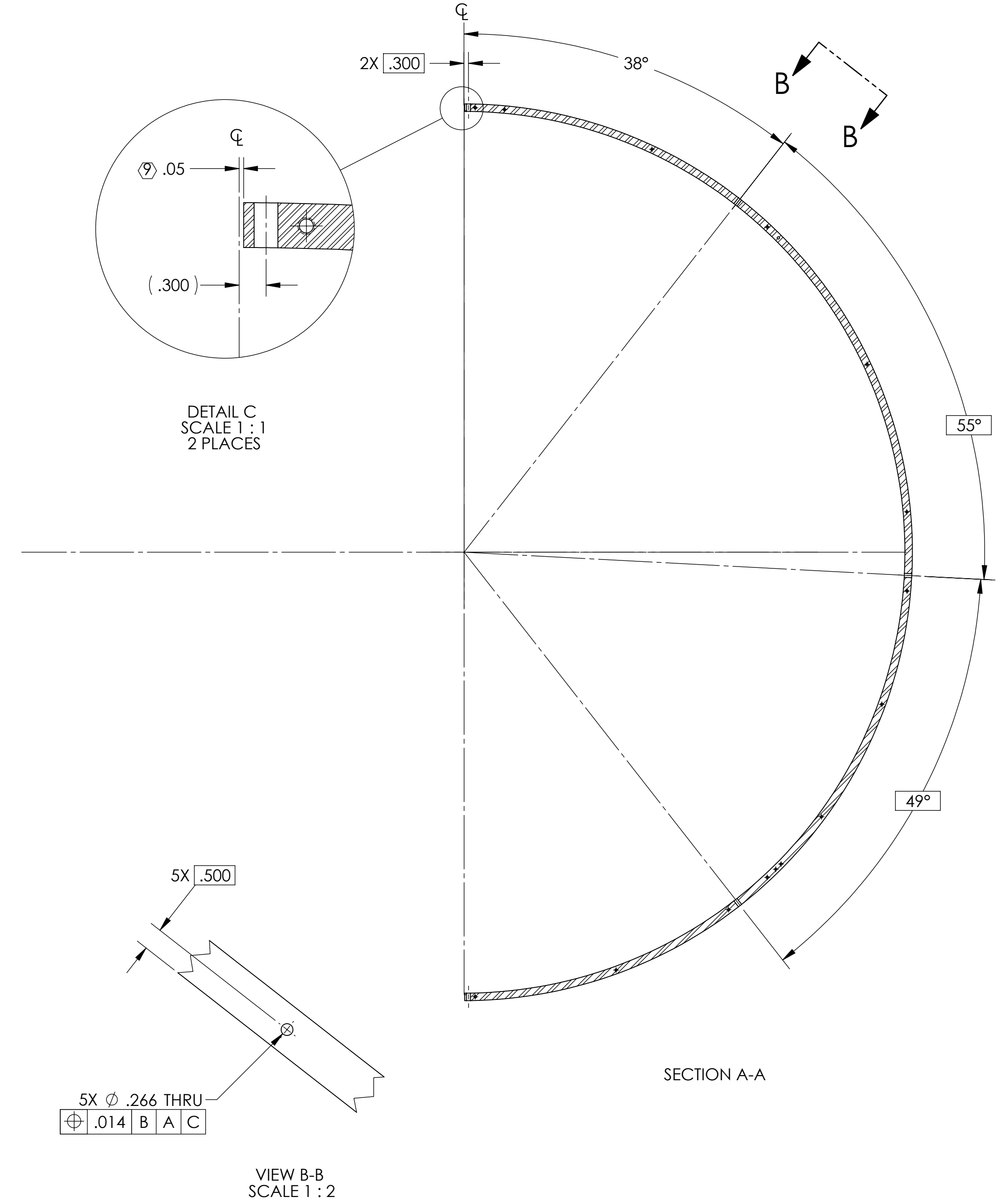
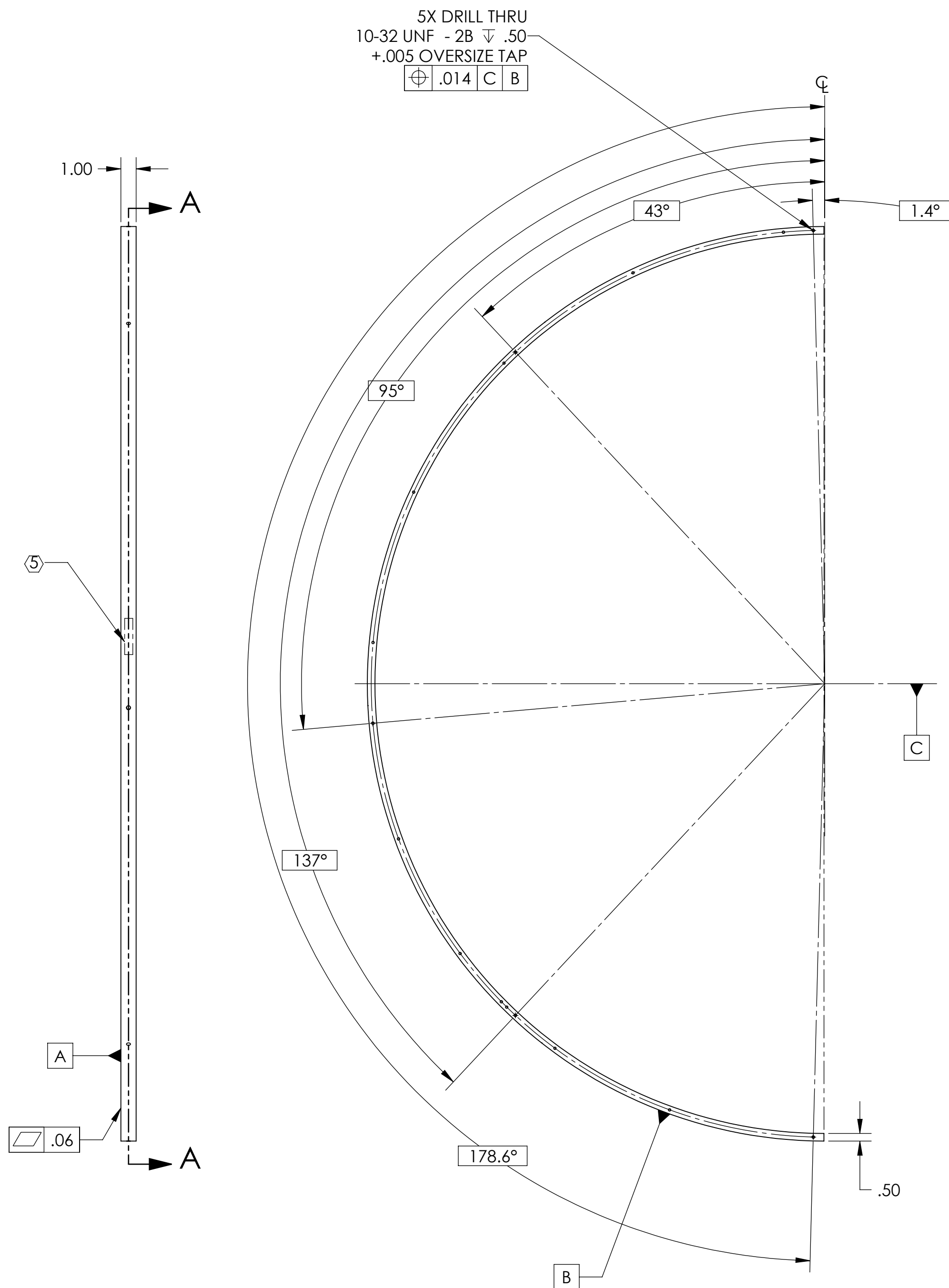
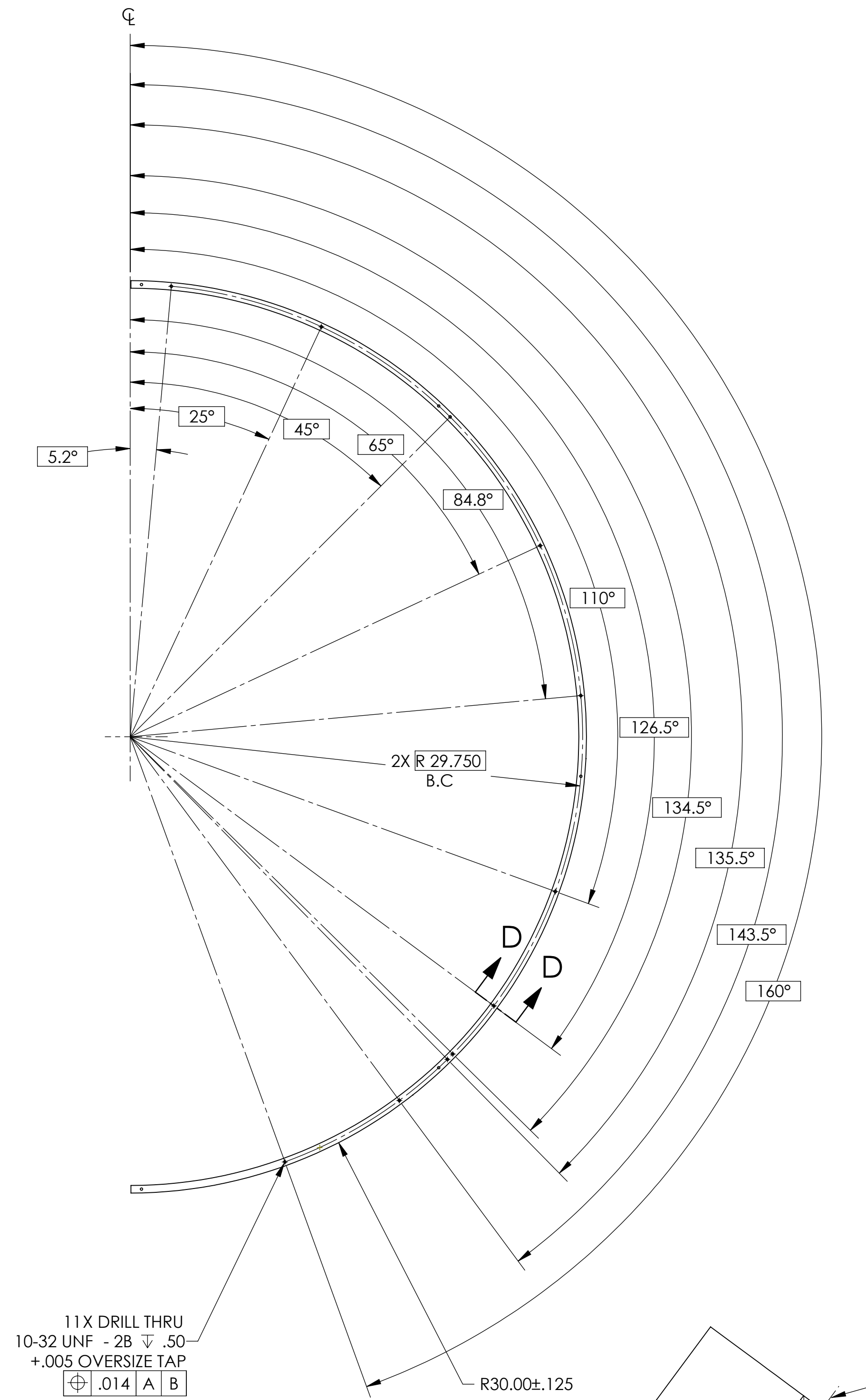
1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES 0.005" TO 0.015".
3. DO NOT SCALE FROM DRAWING.

4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. REFER TO LIGO E0900237 FOR LIST OF APPROVED COOLANTS.

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. ELECTRO POLISH TO REMOVE .0005 TO .001 PER SIDE.
  7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
  8. 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.
9. PART NOT TRUE HALF CIRCLE

REV.	DATE	DCN #	DRAWING TREE #
v1	19 MAY 2011	E1000822-v1	-
v2	18/JULY/2011	-	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .03 .XXX ± .010	
ANGULAR ± 0.5°	
MATERIAL	6061-T6 Al
FINISH	63 μinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
SYSTEM	ADVANCED LIGO	TUBE BAFFLE INNER LEFT BRACE	
SUB-SYSTEM	AOS	DESIGNER	TQ. NGUYEN 27 OCT 2010
NEXT ASSY	D1002864	DRAFTER	TQ. NGUYEN 16 NOV 2010
		CHECKER	M. SMITH
		APPROVAL	D. COYNE
		SIZE	D
		DWG. NO.	D1002869
		SCALE	1:6
		PROJECTION	ASME
		REV.	v2
		SHEET 1 OF 1	