

**NOTES: UNLESS OTHERWISE SPECIFIED**

1. INTERPRET DRAWING PER ASME Y14.5-1994.

2. REMOVE ALL SHARP EDGES AND BURRS AND ROUND EDGES. FULL RADIUS ON ALL EDGES AND HOLES.

3. DO NOT SCALE FROM DRAWING.

4. ALL MACHINE FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE PER LIGO DOCUMENT E0900237.

5. MECHANICALLY STAMP (NO INKS OR DYES) PART NUMBER, REVISION AND SERIAL NUMBER .020 DEEP WITH MINIMUM CHARACTER HEIGHT .156 APPROXIMATELY WHERE SHOWN. SERIAL NUMBER WILL START AT 001 AND PROCEED CONSECUTIVELY. EXAMPLE: D100XXX-V1  
S/N 001

6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPEC E0900364.

7. ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NO WELD REPAIRS OR PLUGS) UNLESS APPROVED IN ADVANCE, IN WRITING, BY LIGO PER SPECIFICATION E0900364.

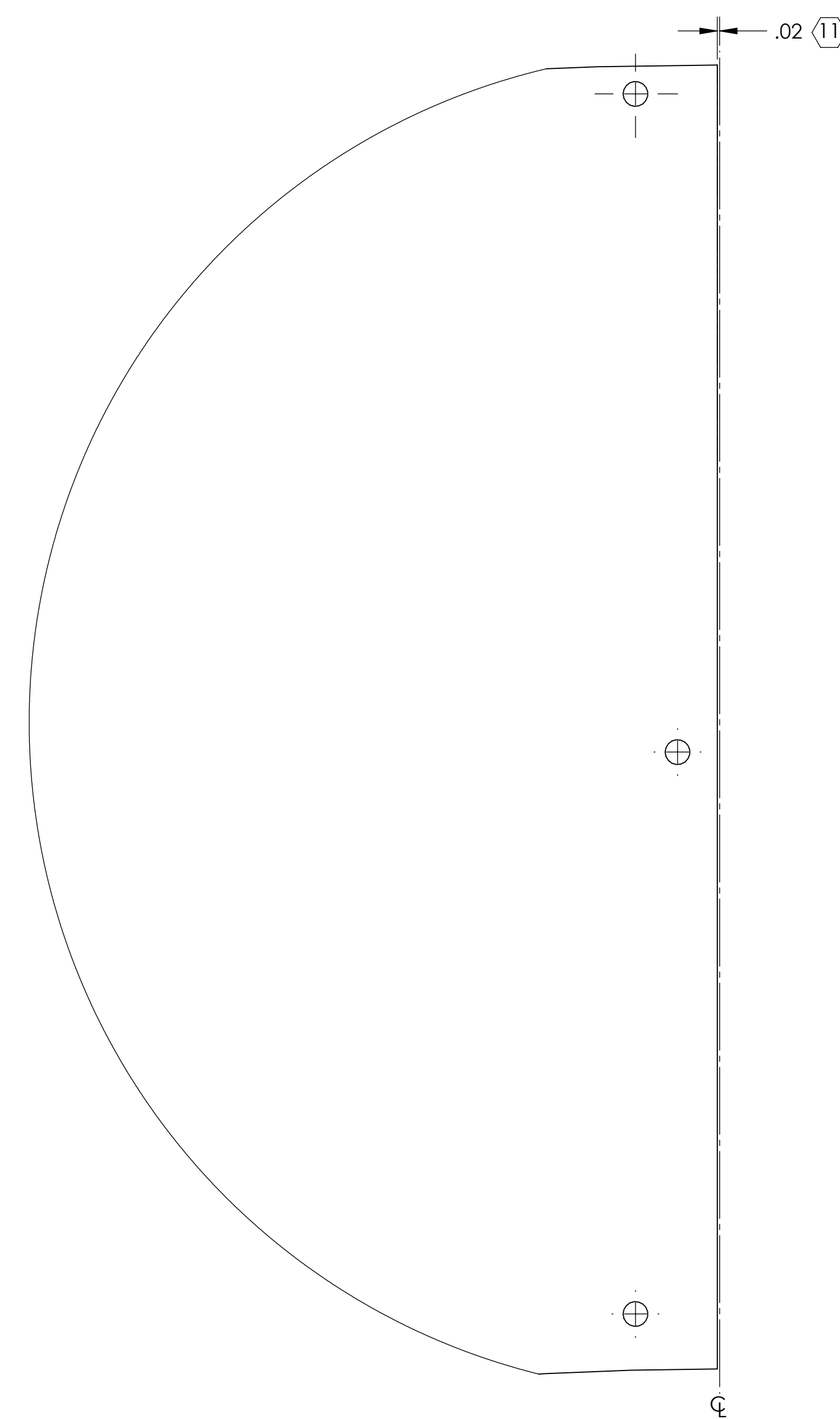
8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

9. PART WILL BE COMPLETELY PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION.

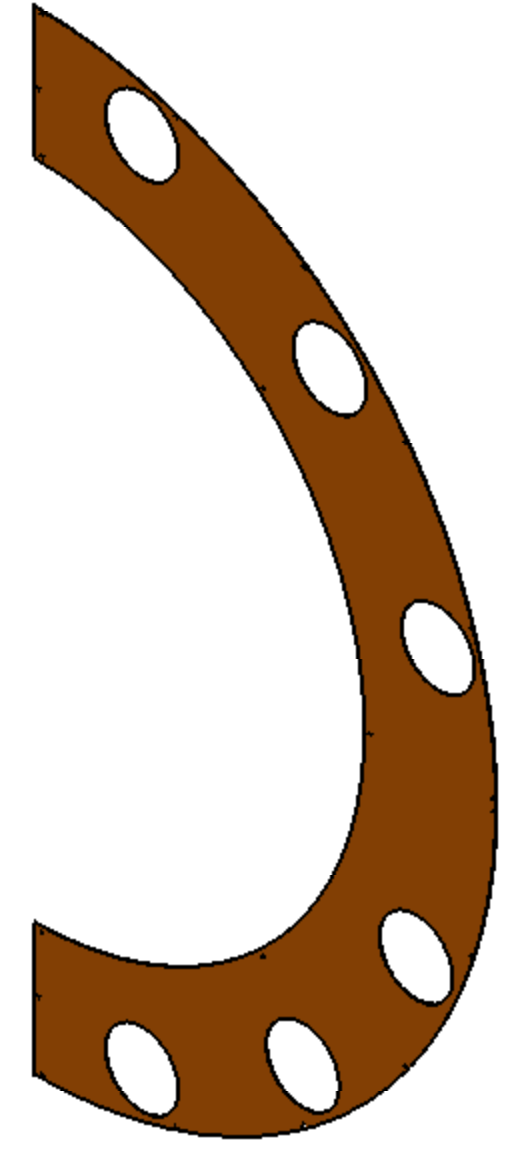
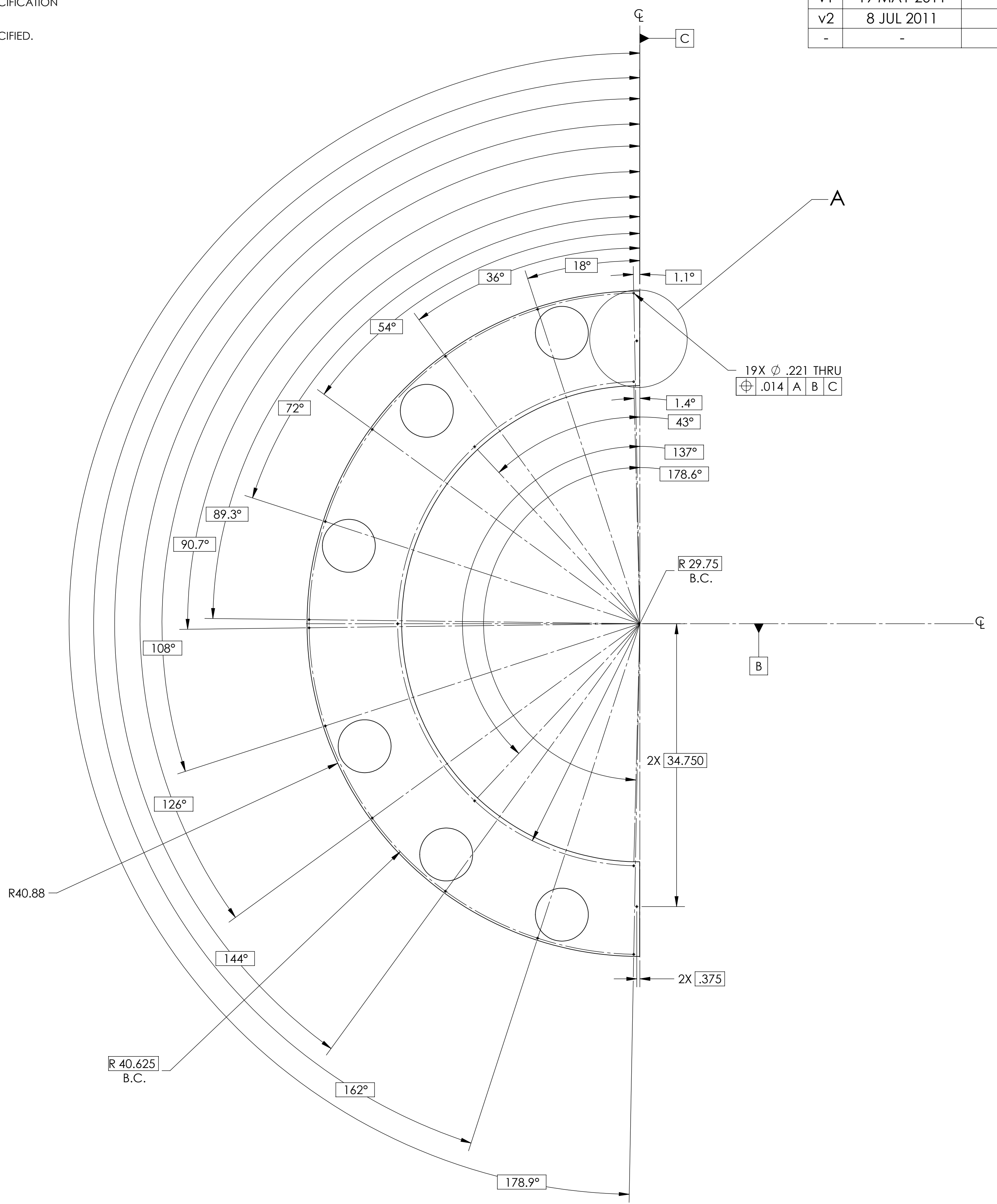
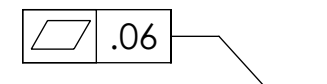
10. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.

11. PART IS NOT TRUE HALF CIRCLE.

REV.	DATE	DCN #	DRAWING TREE #
v1	19 MAY 2011	E1000822-v1	-
v2	8 JUL 2011	-	-
-	-	-	-



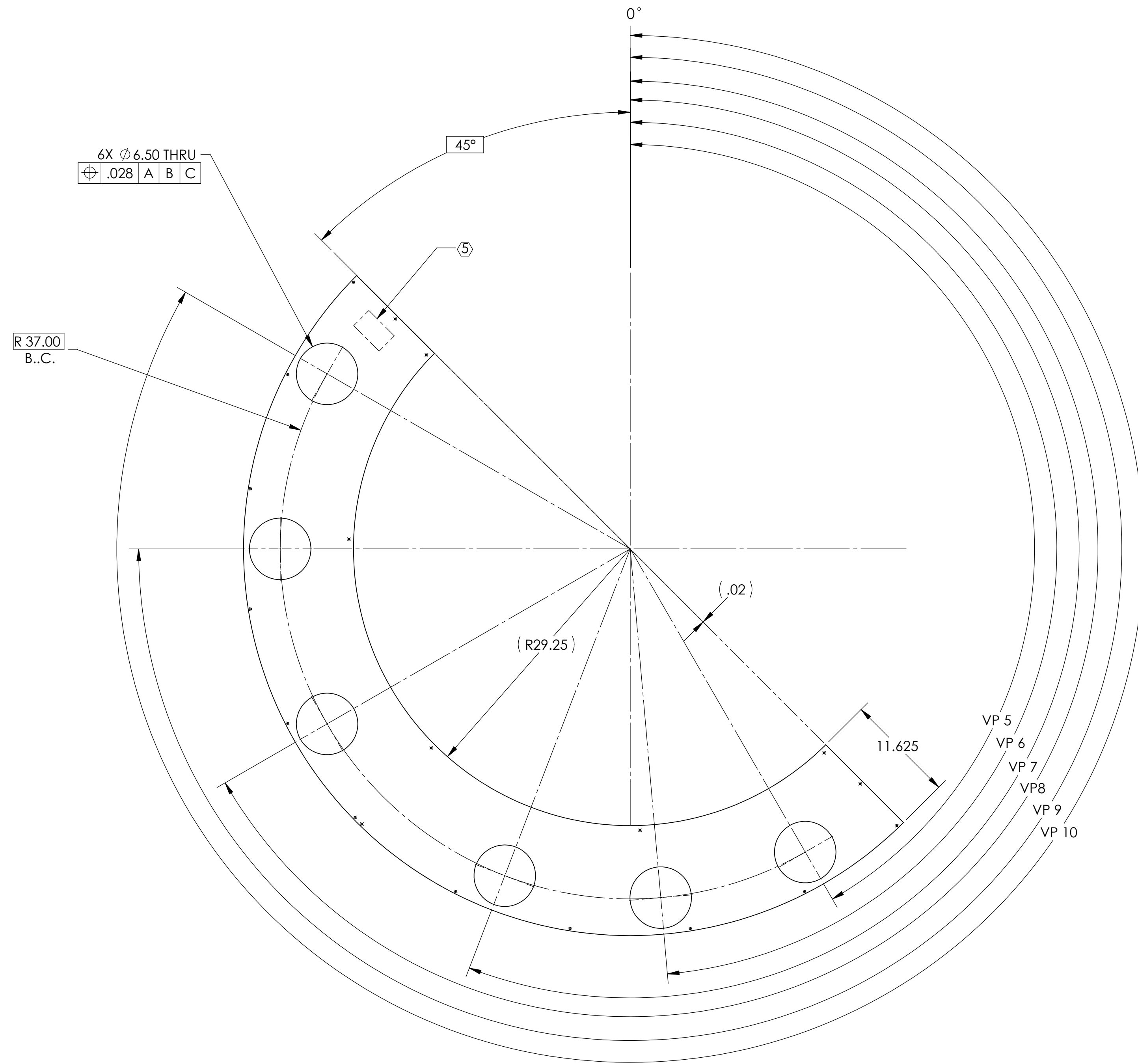
DETAIL A  
SCALE 1 : 1  
2 PLACES



GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES				SYSTEM		MODE CLEANER BAFFLE VIEWPORT PLATE, LOWER					
TOLERANCES: .XX ± .03 .XXX ± .005				ADVANCED LIGO		SUB-SYSTEM		DESIGNER		REV.	
ANGULAR ± 0.1°				MATERIAL		AOS		TQ. NGUYEN		v2	
18GA A424 TYPE 1 STEEL				FINISH		NEXT ASSY		28 OCT 2010		SIZE DWG. NO.	
				9		D1002864		29 NOV 2010		D D1003119	
								M. SMITH		SCALE: 1:8	
								D. COYNE		PROJECTION:	
										SHEET 1 OF 2	

D1003119\_dLIGO\_MC\_Tube\_Baffle\_Plate\_Lower\_PART PDM REV: X.015. DRAWING PDM REV: X.034



**TABLE I: VIEWPORT LOCATIONS**

VIEWPORT No.	MCA -00	MCB1 -01	MCB2 -02	MCB3 -03	MCB4 -04
VP 5	150°	150°	157°	150°	146°
VP 6	180°	175°	180°	190°	172°
VP 7	210°	201°	210°	215°	194°
VP 8	240°	240°	240°	240°	240°
VP 9	270°	270°	270°	270°	270°
VP 10	300°	300°	300°	300°	300°