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.

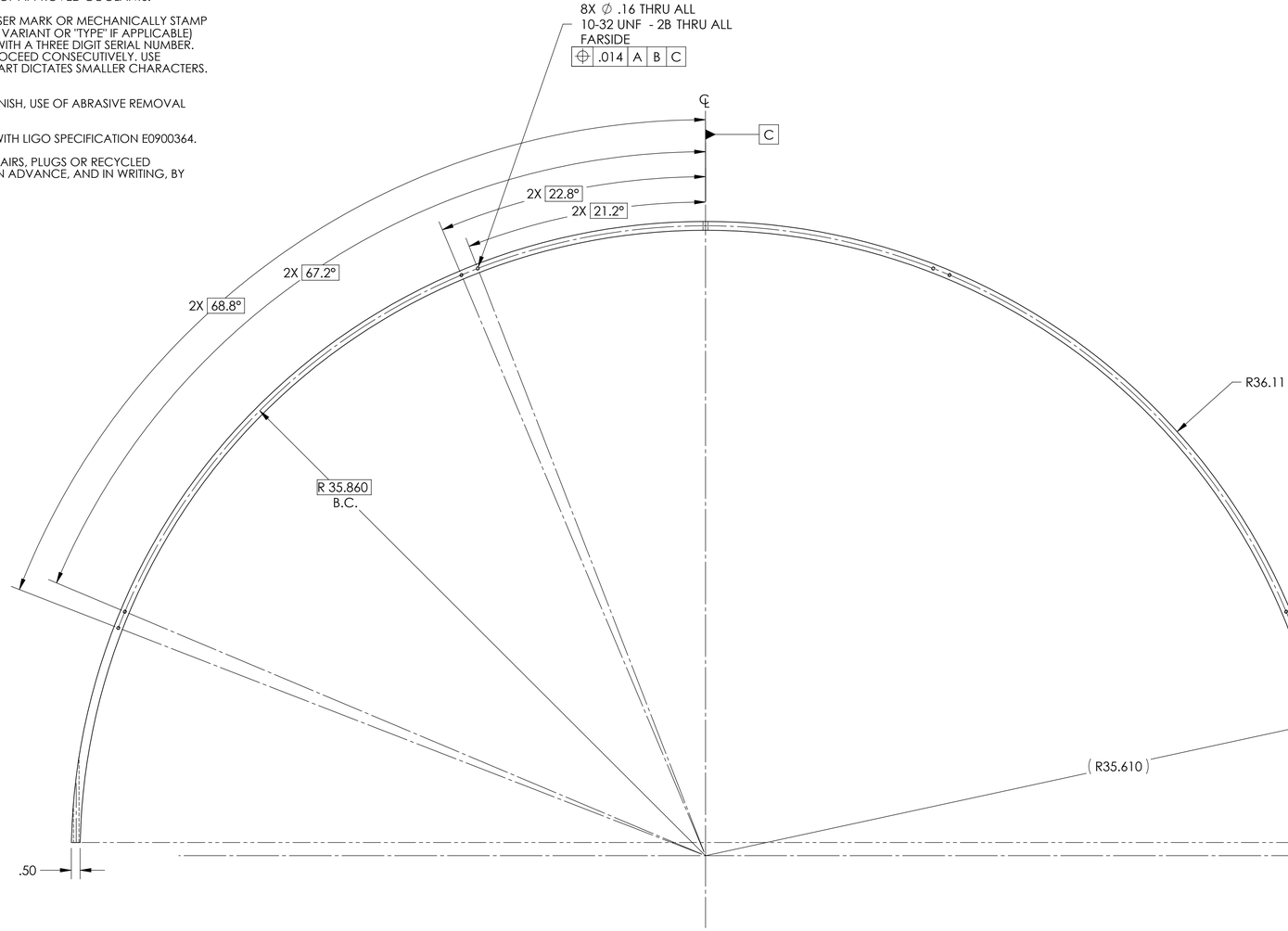
⟨5⟩ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

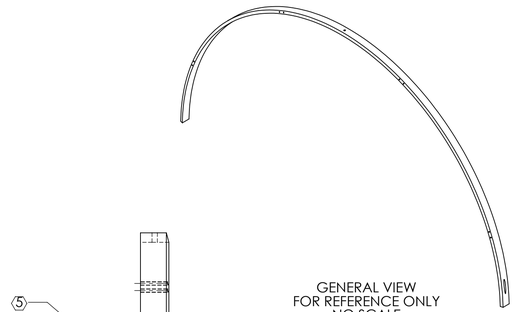
6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

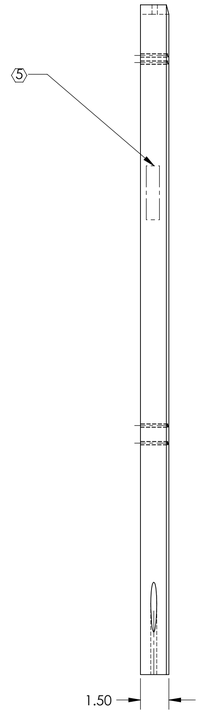
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

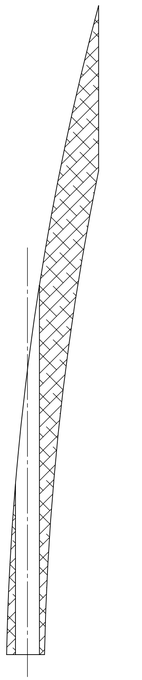
8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

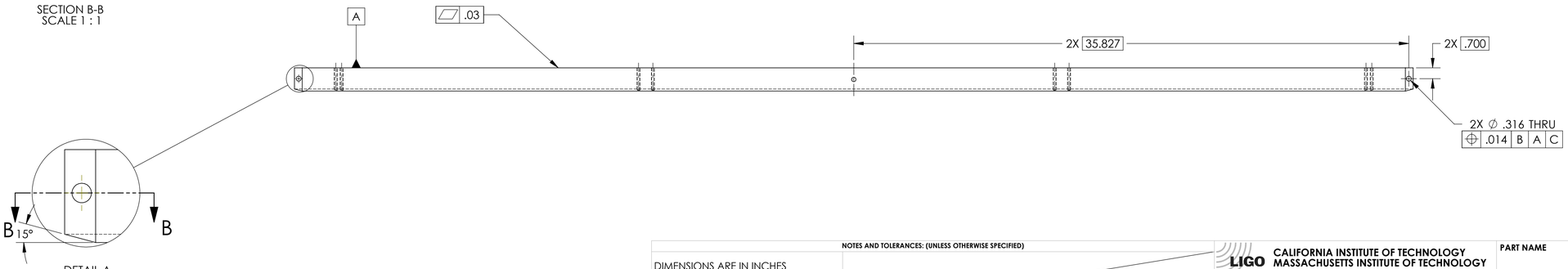
REV.	DATE	DCN #	DRAWING TREE #
v1	23 MAY 2011	E1100088-v1	-
-	-	-	-
-	-	-	-




GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE




SECTION B-B
SCALE 1 : 1



DETAIL A
SCALE 1 : 1

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

NEXT ASSY: D1003380

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO

SUB-SYSTEM: AOS

PART NAME: LOWER OUTER RING_F ETM XY

DESIGNER	TQ. NGUYEN	22 DEC 2010	
DRAFTER	TQ. NGUYEN	11 JAN 2011	
CHECKER	M. SMITH		
APPROVAL	D. COYNE		

SIZE: D

DWG. NO.: D1003382

REV.: v1

SCALE: 1:4

PROJECTION:

SHEET 1 OF 1

D1003382_aLIGO_Manifold_Flat_Baffle_Lower Outer Ring_F ETMX_PART PDM REV=.X-018, DRAWING PDM REV=.X-020