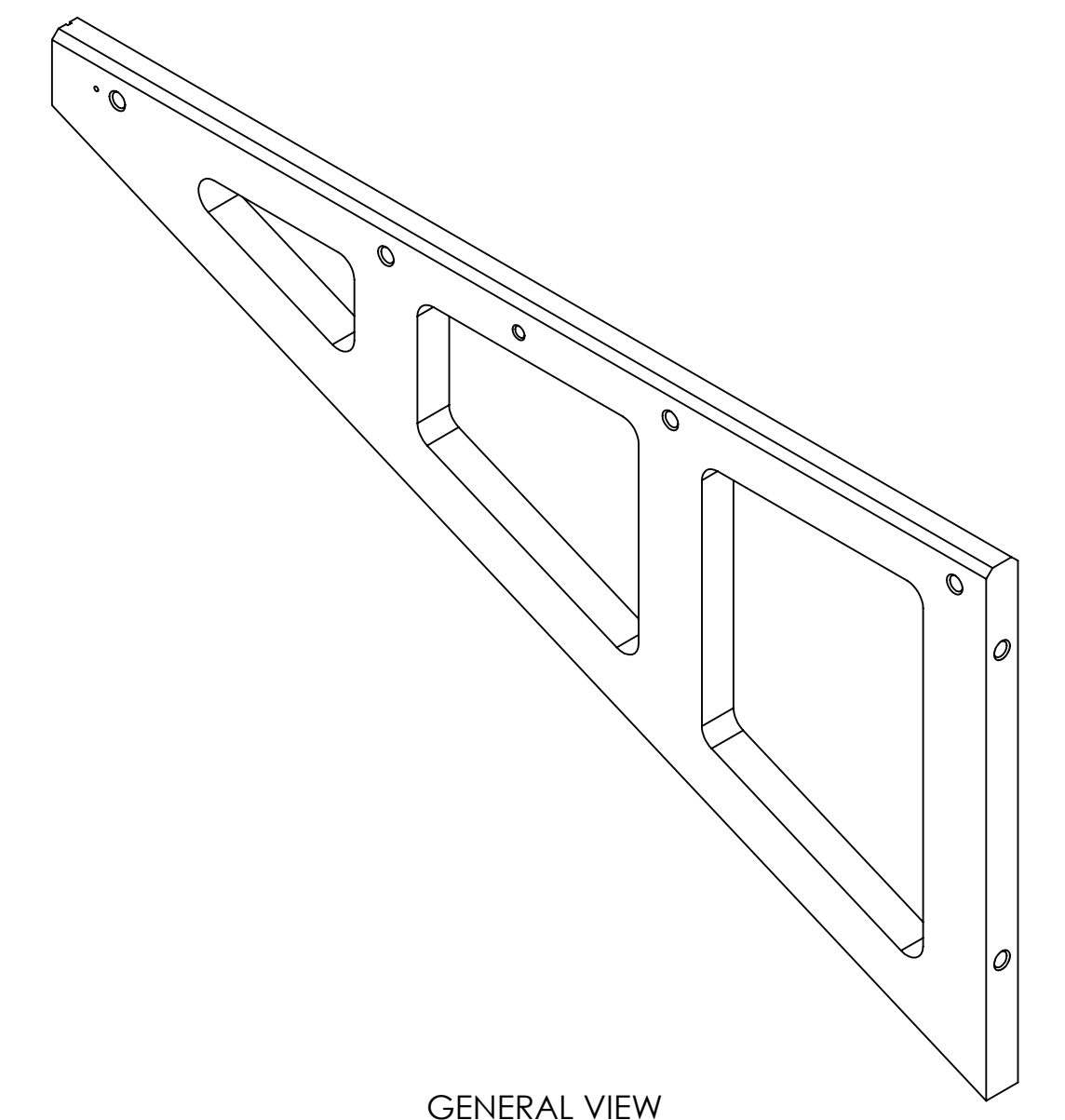
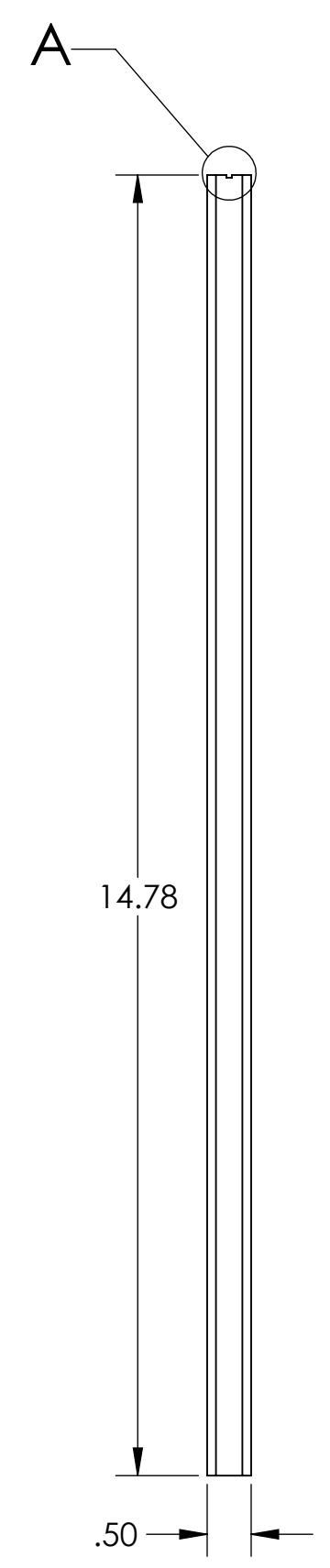
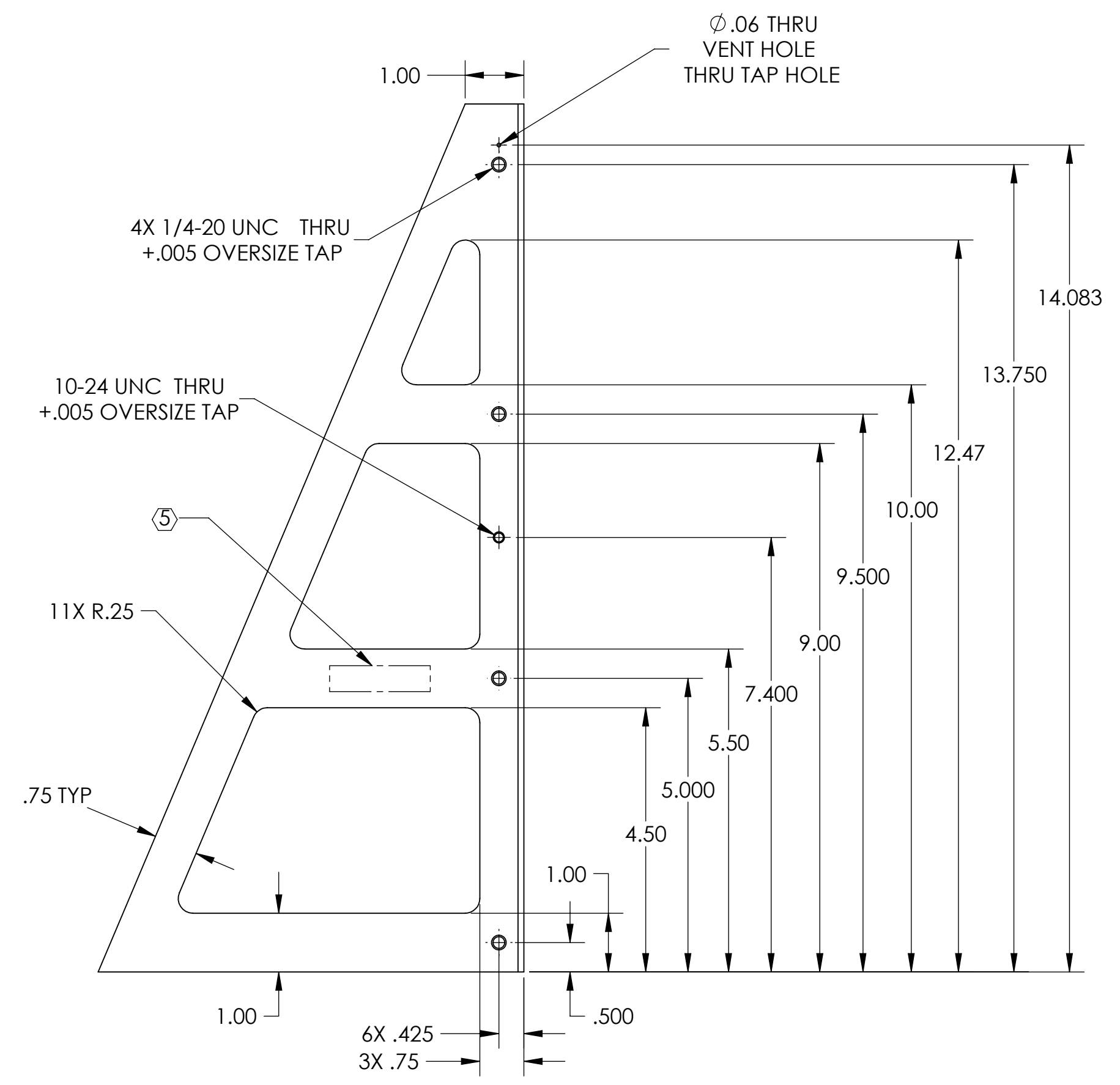
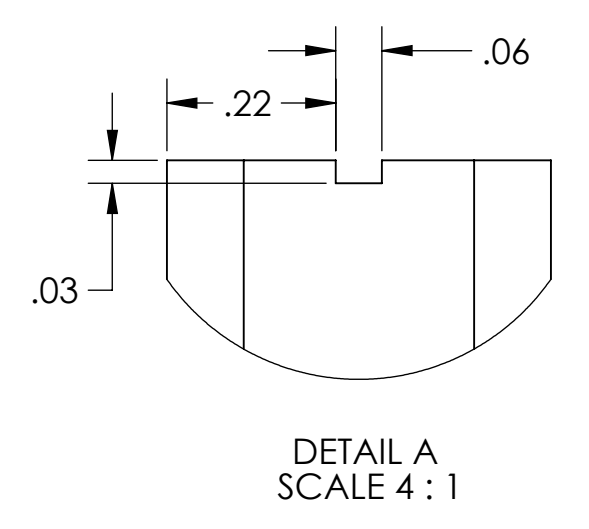
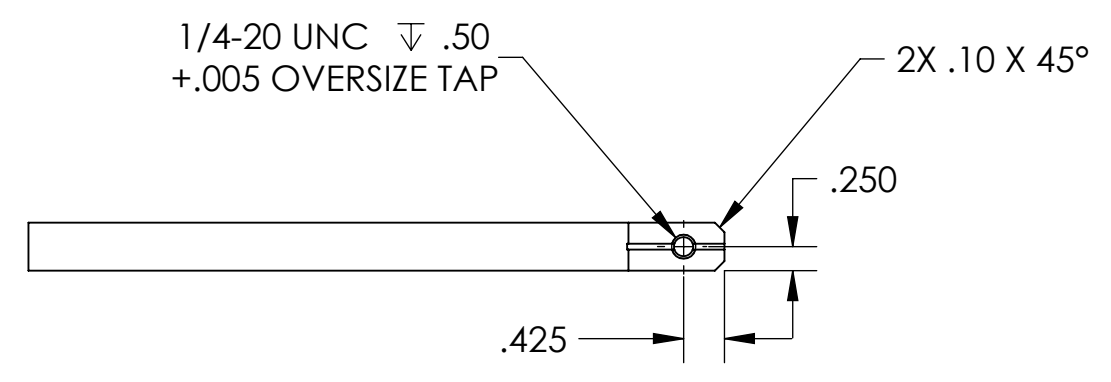
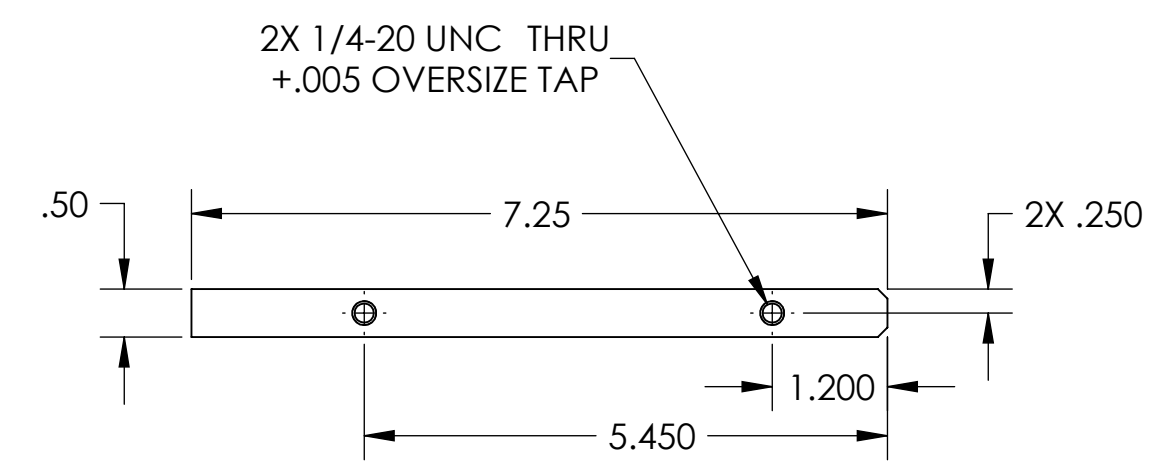


- NOTES CONTINUED:
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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=1.617 LB.
  7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
  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 UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364).



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± 1.0°	
MATERIAL	6061-T6
FINISH	63 μinch

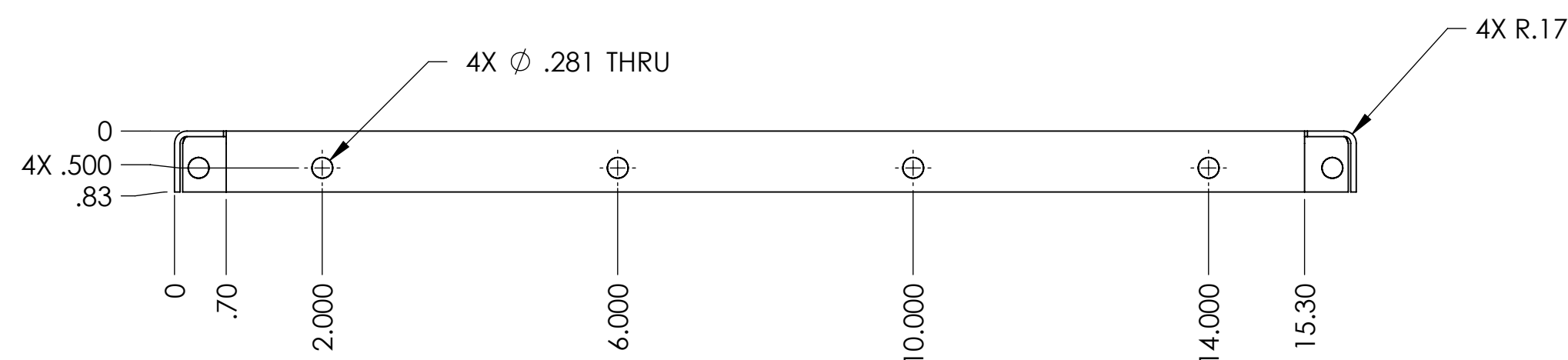
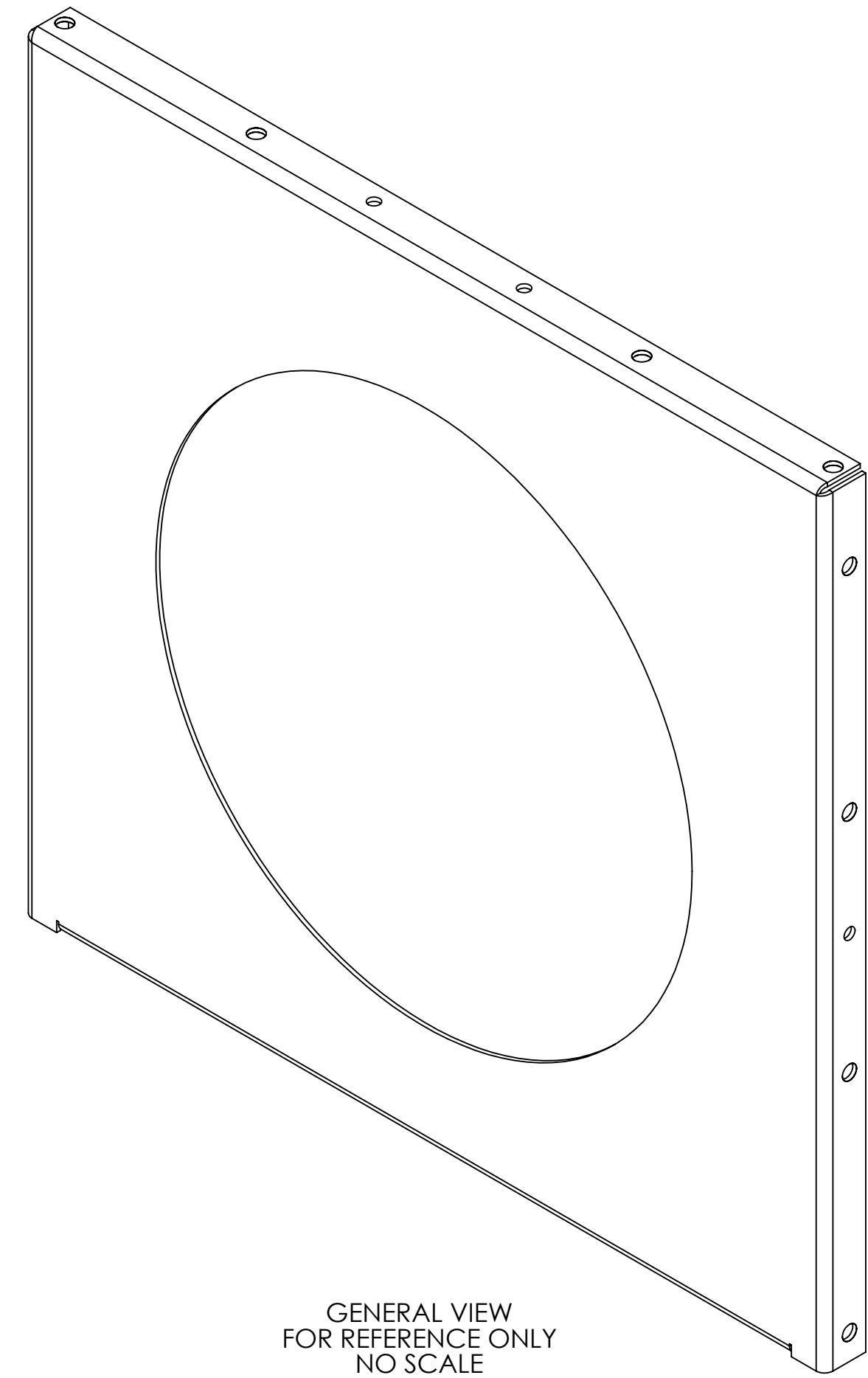
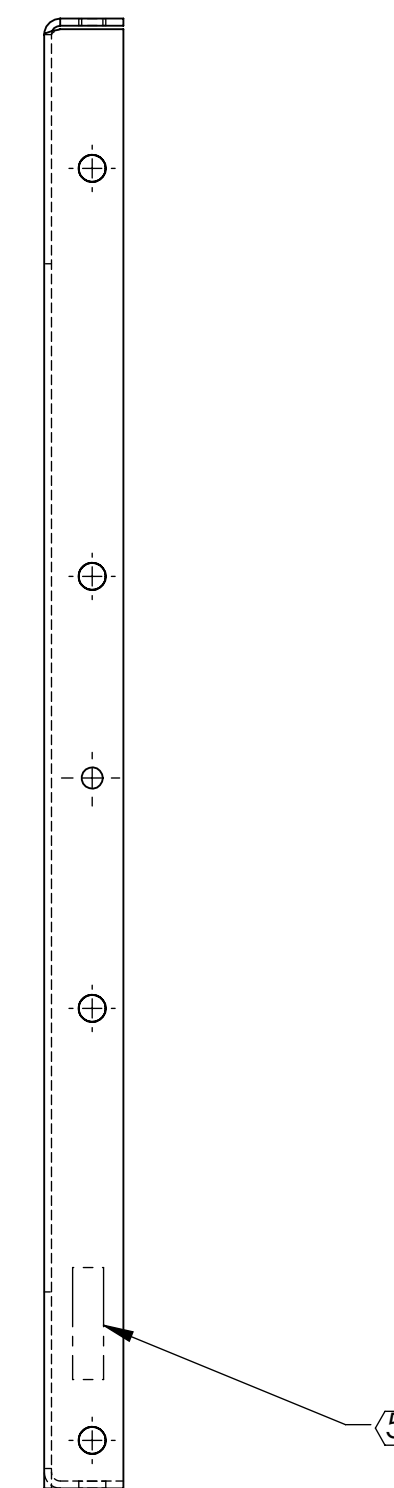
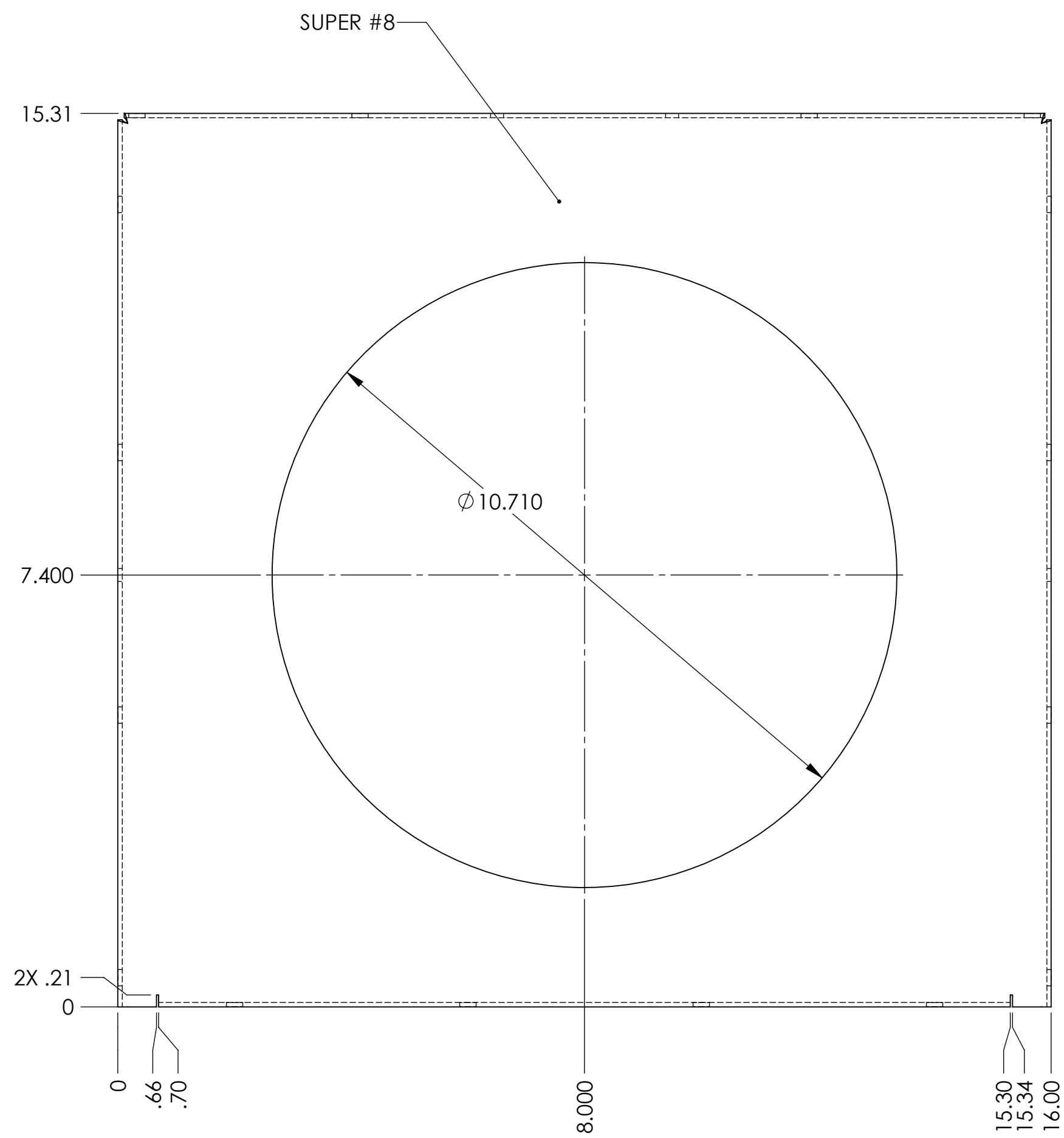
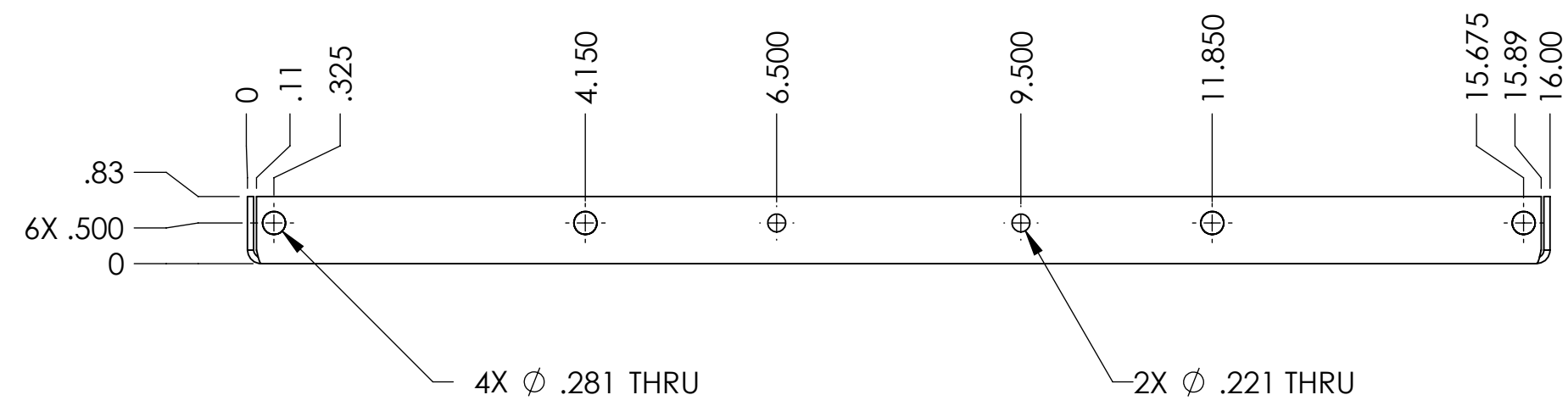
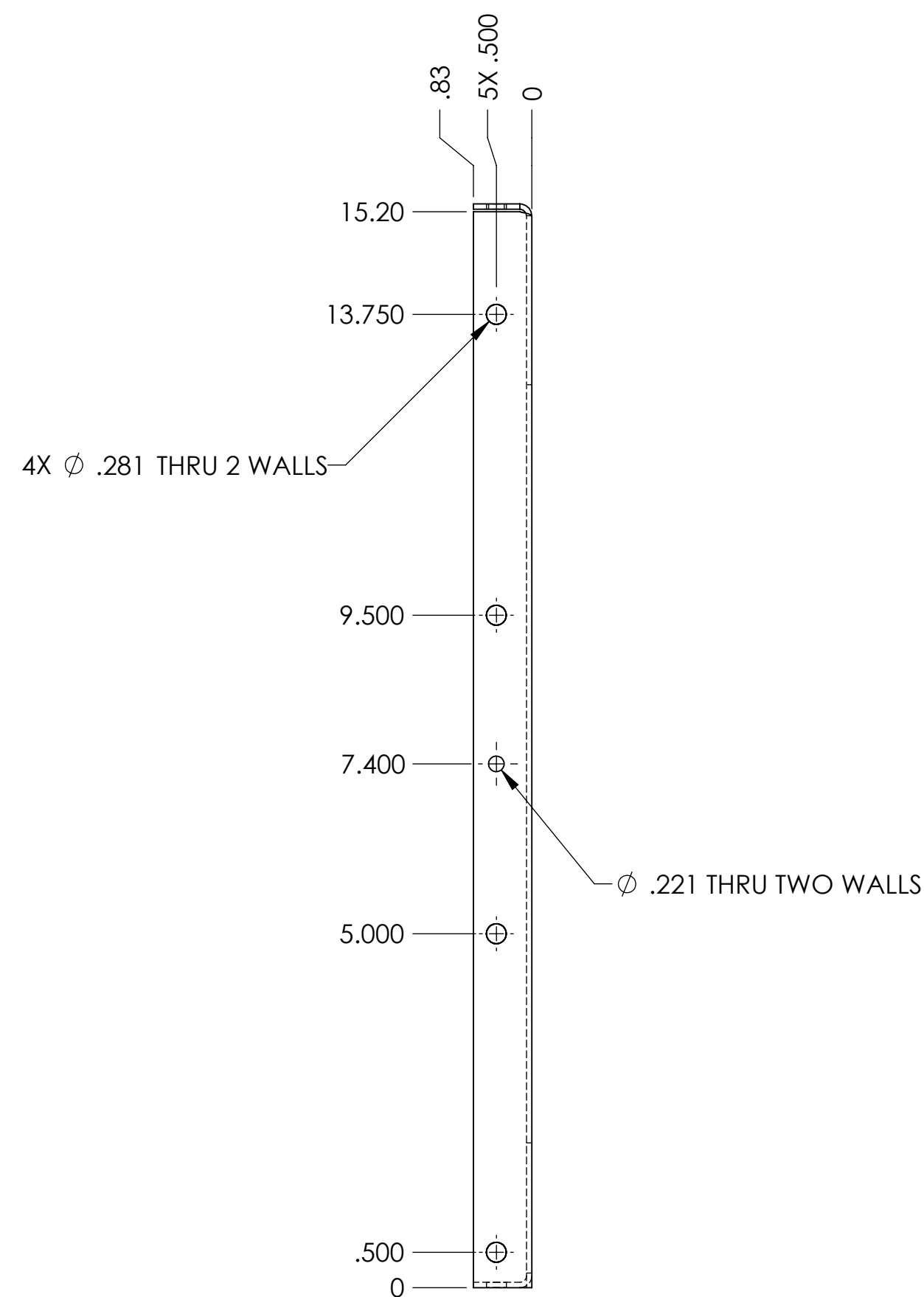
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	AOS
NEXT ASSY	D1003205

PART NAME		ALIGO SR3 BAFFLE VERTICAL SUPPORT	
DESIGNER	C. WILKERSON	18 DEC 2010	SIZE DWG. NO.
DRAFTER	TG. NGUYEN	3 OCT 2011	D D1003172
CHECKER	L. AUSTIN	4 NOV 2011	
APPROVAL	M. SMITH	4 NOV 2011	SCALE: 1:2
PROJECTION:		SHEET 1 OF 1	

D:\003172\ALIGO SR3 BAFFLE VERTICAL SUPPORT - PART PDM REV: X037 DRAWING PDM REV: X041

- NOTES CONTINUED:
- 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK (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 DIGITAL SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM .012" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS.  
EXAMPLE: DXXXXXXVY, TYPE-XX, S/N XXX  
DO NOT APPLY MARK ON SUPER # 8 SIDE.
  - 6. APPROXIMATE WEIGHT = 5.020 LB.
  - 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. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
  - 10. PART TO BE OXIDIZED PER LIGO SPECIFICATION E1100842.

REV.	DATE	DCN #	DRAWING TREE #
v1	4 APR 2011	E1100313	
v2	2 APR 2012	E1100313-v1	

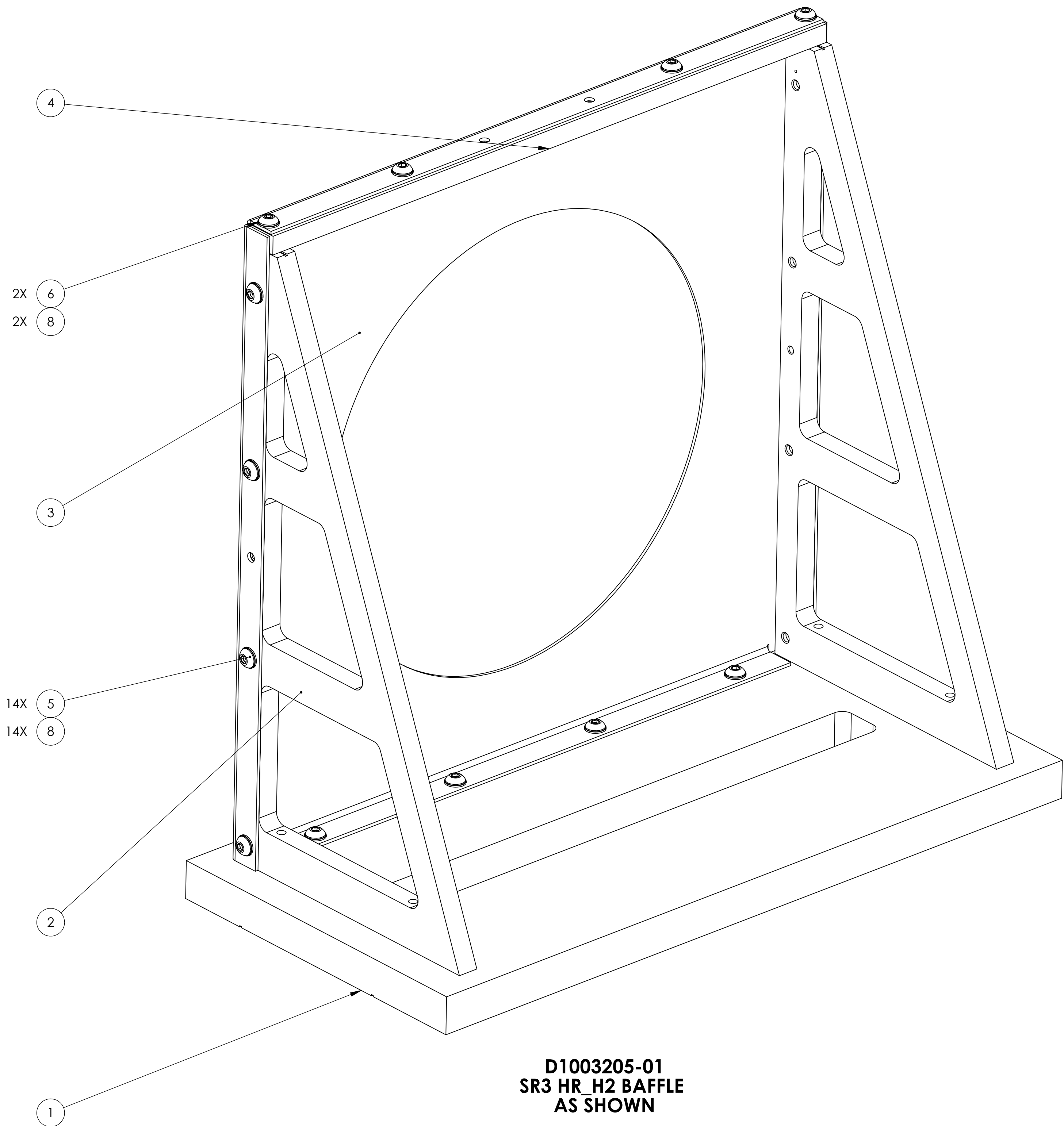


NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY LIGO MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .03 .XXX ± .010 ANGULAR ± 1.0°		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		<b>ALIGO SR3 HR BAFFLE PLATE</b>	
<b>MATERIAL</b> 14 GAUGE 304 SSSL		<b>FINISH</b> 9 SUPER #8		<b>SYSTEM</b> ADVANCED LIGO	
<b>NEXT ASSY</b> D1003205		<b>SUB-SYSTEM</b> AOS		<b>DESIGNER</b> C. WILKERSON 17 DEC 2010	
<b>SCALE</b> 1:2		<b>PROJECTION</b> 		<b>SIZE</b> D	
<b>DWG. NO.</b> D1003173		<b>CHECKER</b> L. AUSTIN 4 NOV 2011		<b>REV.</b> v2	
<b>APPROVAL</b> M. SMITH 4 NOV 2011		<b>SCALE</b> 1:2		<b>PROJECTION</b> 	
<b>SHEET 1 OF 1</b>		<b>SCALE</b> 1:2		<b>PROJECTION</b> 	

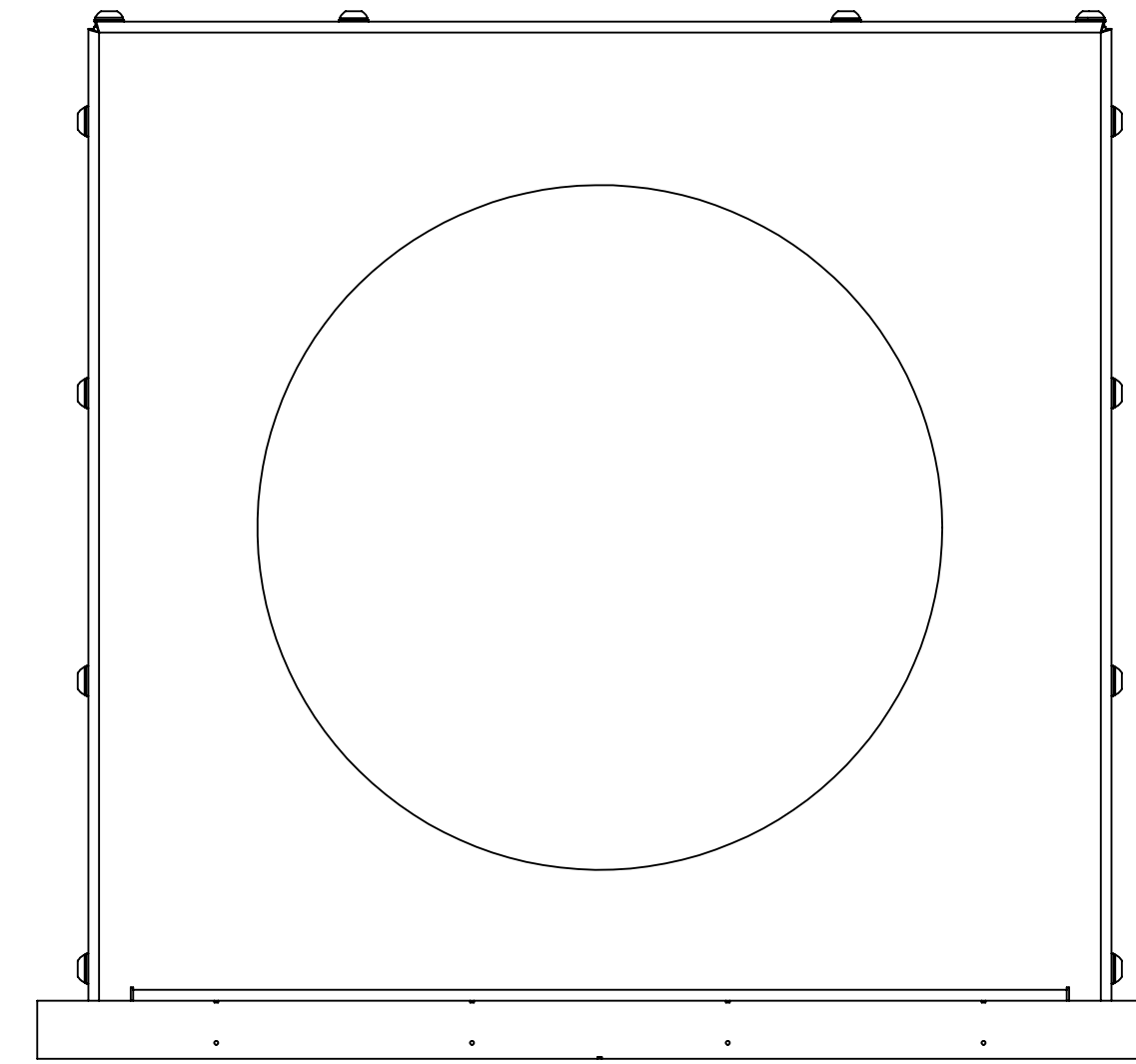
D1003173 ALIGO SR3 HR BAFFLE PLATE, PART PDM, REV: X-044, DRAWING PDM, REV: X-031

NOTES CONTINUED:  
 APPROXIMATE WEIGHT=19.92 LBS

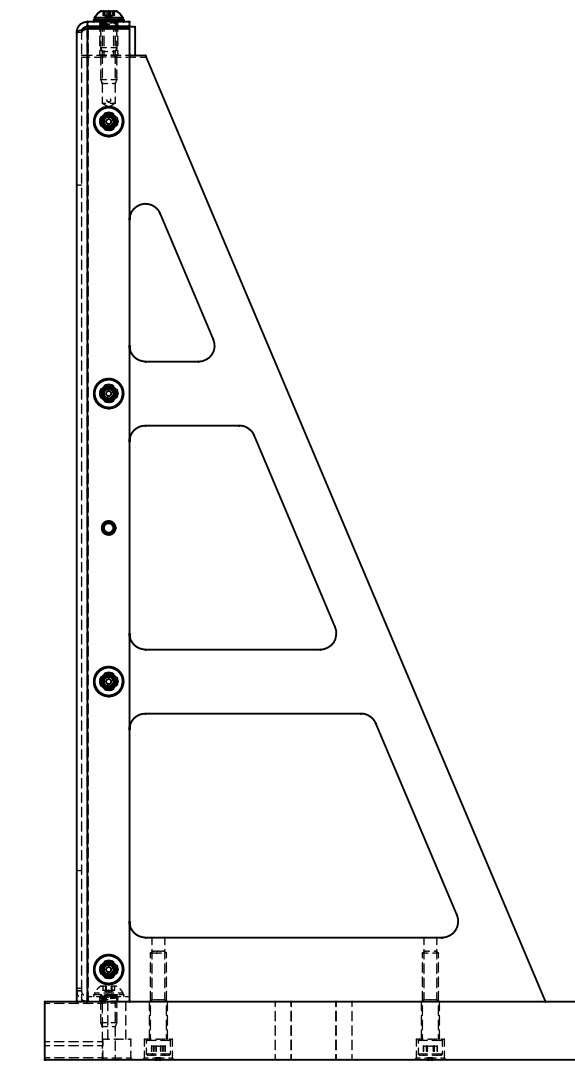
REV.	DATE	DCN #	DRAWING TREE #
v1	4 OCT 2011	E1100313	
v2	30 MAR 2012	E1100313-v1	



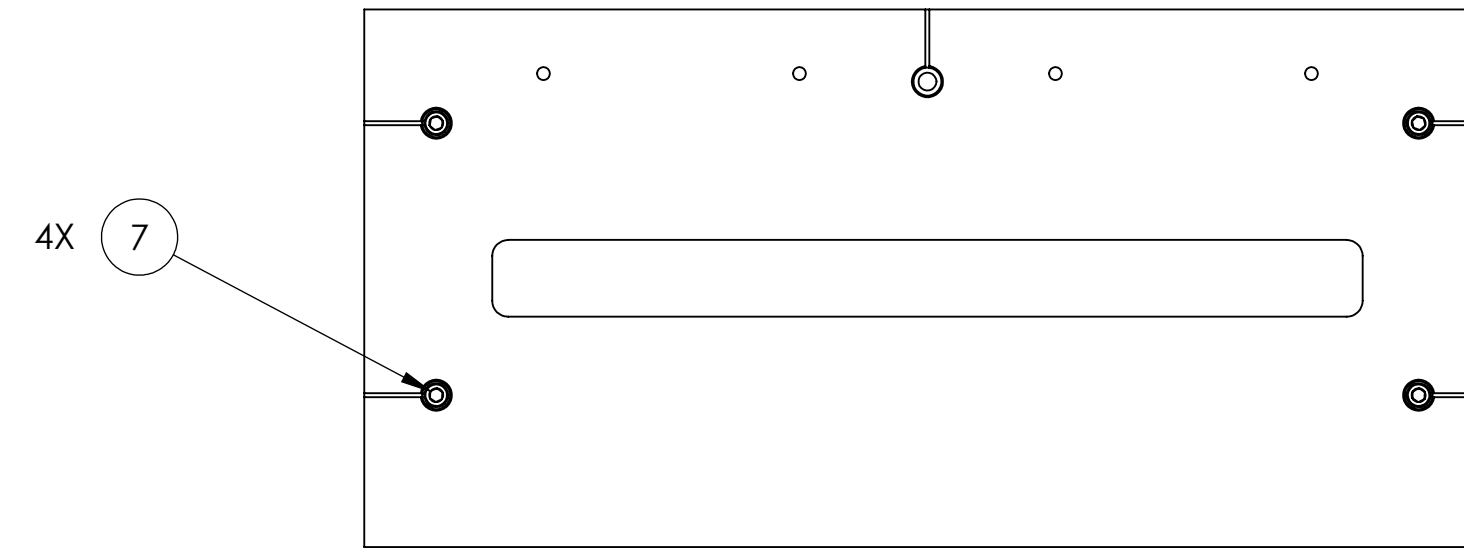
**D1003205-01  
 SR3 HR\_H2 BAFFLE  
 AS SHOWN**



**FRONT VIEW**



**SIDE VIEW**



**BOTTOM VIEW**

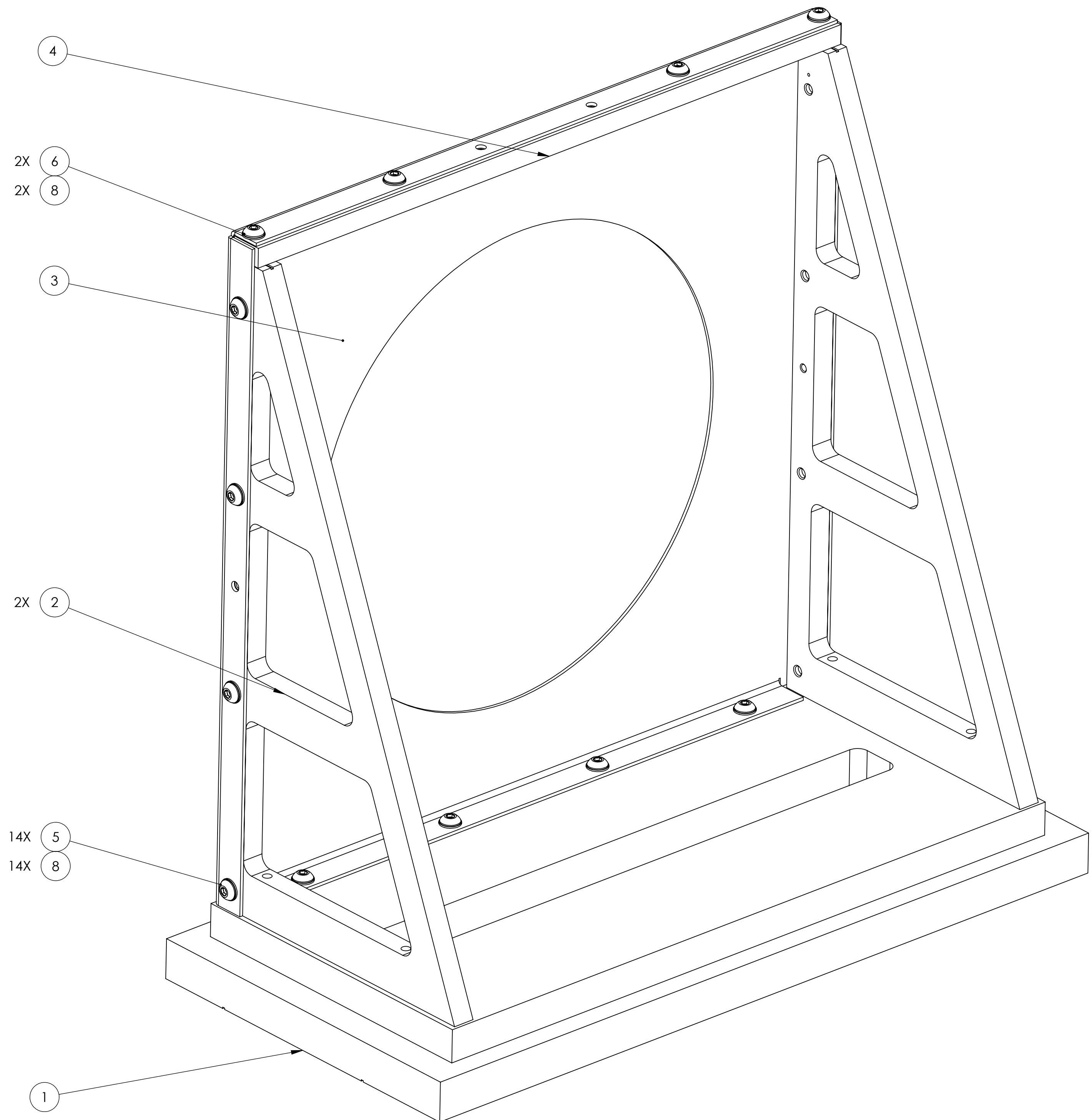
ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	D1003205-01 SR3 HR	SPARE	TOTAL
8	WF-25	FLAT WASHER 1/4 SCREW SIZE	18-8 SSTL	16		0
7	C-2022-N	SOCKET HEAD CAP SCREW, SHC, 1/4-20 x 1.375" L	18-8 SSTL	4		0
6	BU-2016-N	BUTTON HEAD SOCKET HEAD CAP SCREW, 1/4-20 x 1" L	18-8 SSTL	2		0
5	BU-2008-N	BUTTON HEAD SOCKET CAP SCREW, 1/4-20 x 1/2" L	18-8 SSTL	14		0
4	D1003240	ALIGO SR3 HR-AR TOP CROSS BAR	6061-T6 Al	1		0
3	D1003173	ALIGO SR3 BAFFLE PLATE	14 GAUGE 304 SSTL	1		0
2	D1003172	ALIGO SR3 BAFFLE VERTICAL SUPPORT	6061-T6 Al	2		0
1	D1100116	ALIGO SR3 HR-AR_H2 SPACER	6061-T6 Al	1		0

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .03 .XXX ± .010	
ANGULAR ± 1.0°	
MATERIAL	N/A
FINISH	N/A μinch

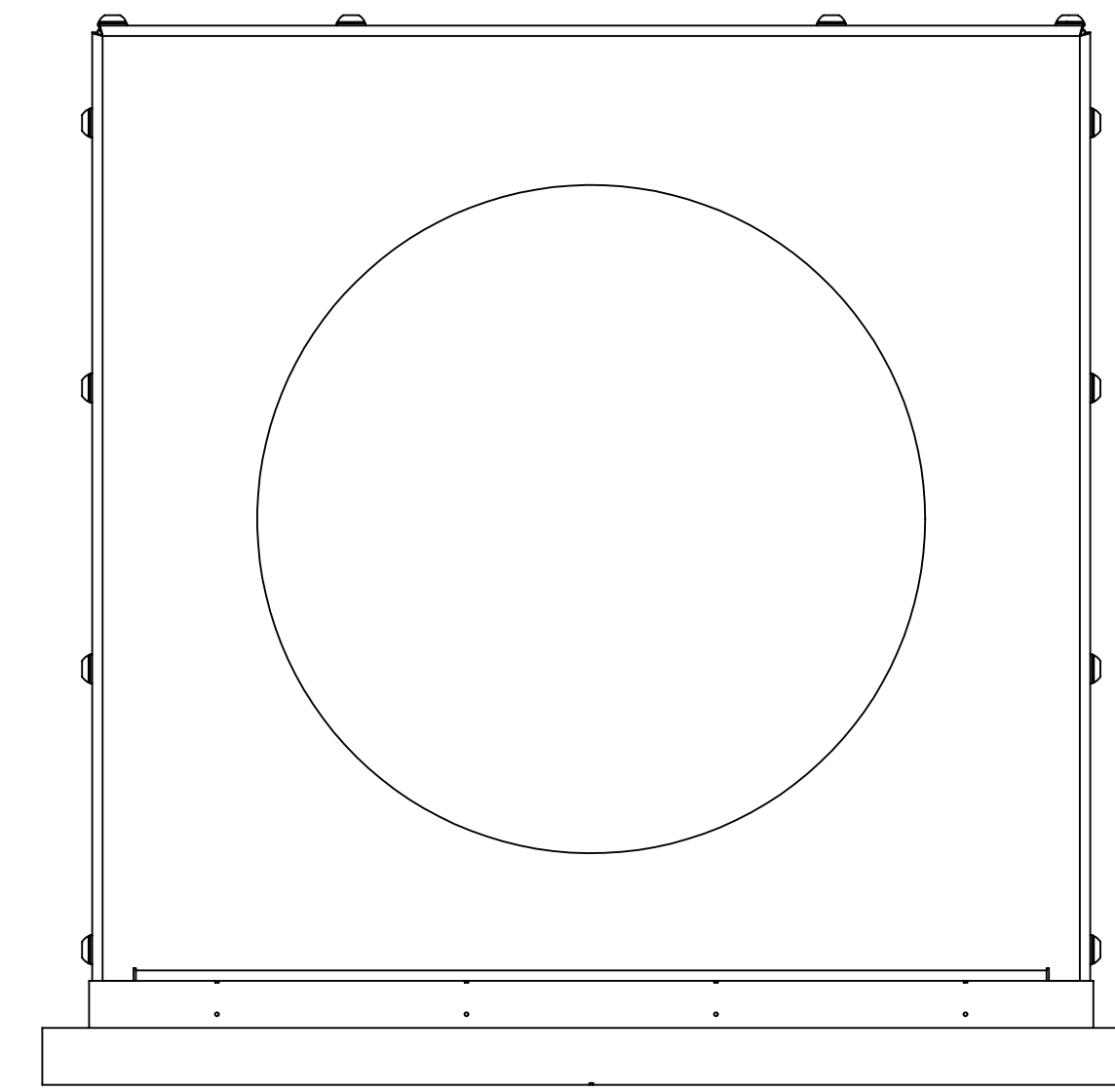
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY				PART NAME			
SYSTEM ADVANCED LIGO				SUB-SYSTEM AOS			
NEXT ASSY				PART NAME ALIGO SR3 HR-AR BAFFLE ASSY			
DESIGNER	C. WILKERSON	28 SEP 2011	SIZE	DWG. NO.		REV.	
DRAFTER	TG. NGUYEN	29 SEP 2011	D	D1003205		v2	
CHECKER	L. AUSTIN	4 NOV 2011	SCALE:	1:3	PROJECTION:	SHEET 1 OF 4	
APPROVAL	M. SMITH	4 NOV 2011					

D1003205-01 SR3 HR-AR BAFFLE ASSY PART PDM REV: X-091 DRAWING PDM REV: X-046

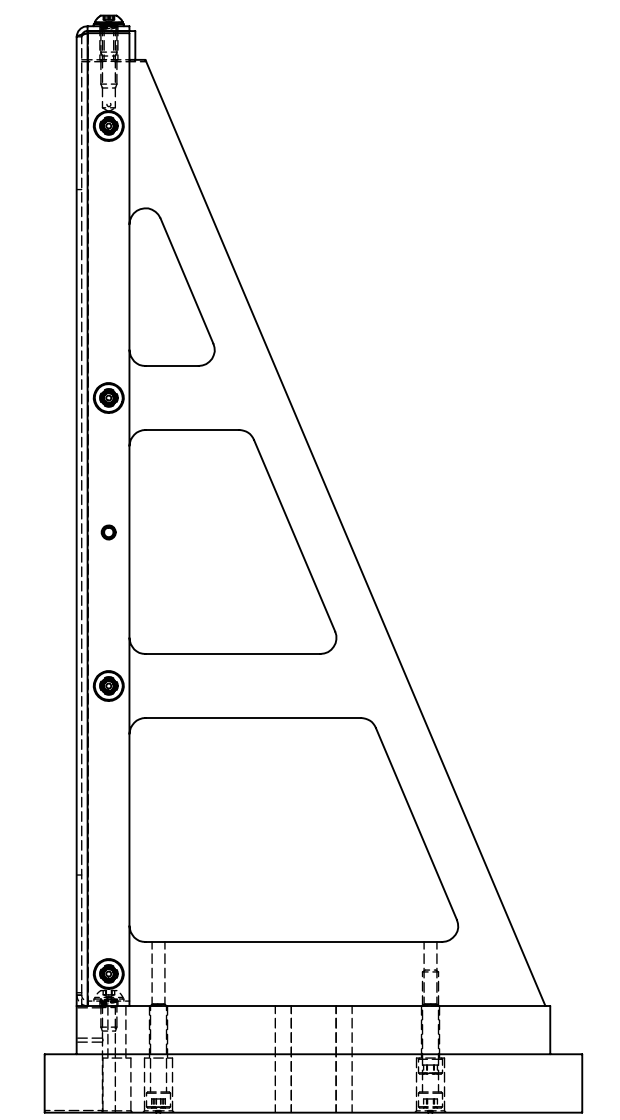
APPROXIMATE WEIGHT= 27.44 LBS.



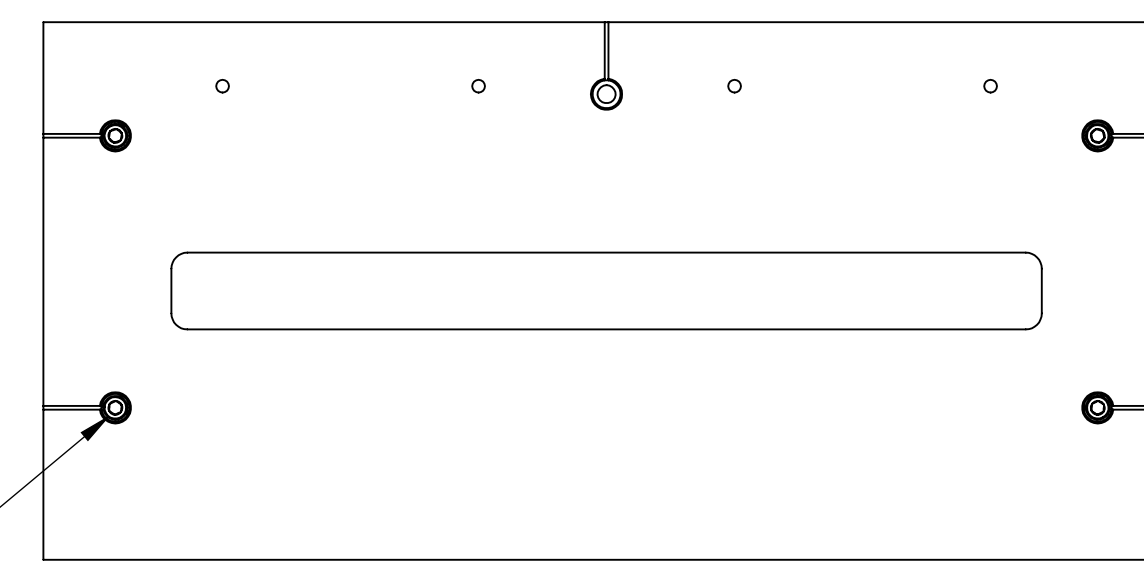
**D1003205-02  
SR3 HR\_H1-L1 BAFFLE  
AS SHOWN**



**FRONT VIEW**



**SIDE VIEW**



**BOTTOM VIEW**

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY	SPARE	TOTAL
8	WF-25	FLAT WASHER 1/4 SCREW SIZE	18-8 SSSL	16	0	0
7	C-2022-N	SOCKET HEAD CAP SCREW, SHC, 1/4-20 x 1.375" L	18-8 SSSL	4	0	0
6	BU-2016-N	BUTTON HEAD SOCKET HEAD CAP SCREW, 1/4-20 x 1" L	18-8 SSSL	2	0	0
5	BU-2008-N	BUTTON HEAD SOCKET CAP SCREW, 1/4-20 x 1/2" L	18-8 SSSL	14	0	0
4	D1003240	ALIGO SR3 HR-AR TOP CROSS BAR	6061-T6 Al	1	0	0
3	D1003173	ALIGO SR3 BAFFLE PLATE	14 GAUGE 304 SSSL	1	0	0
2	D1003172	ALIGO SR3 BAFFLE VERTICAL SUPPORT	6061-T6 Al	2	0	0
1	D1100423	ALIGO SR3 HR-AR_H1-L1 SPACER	6061-T6 Al	1	0	0
				<b>D1003205-02 SR3 HR_H1-L1</b>		

PARTS LIST

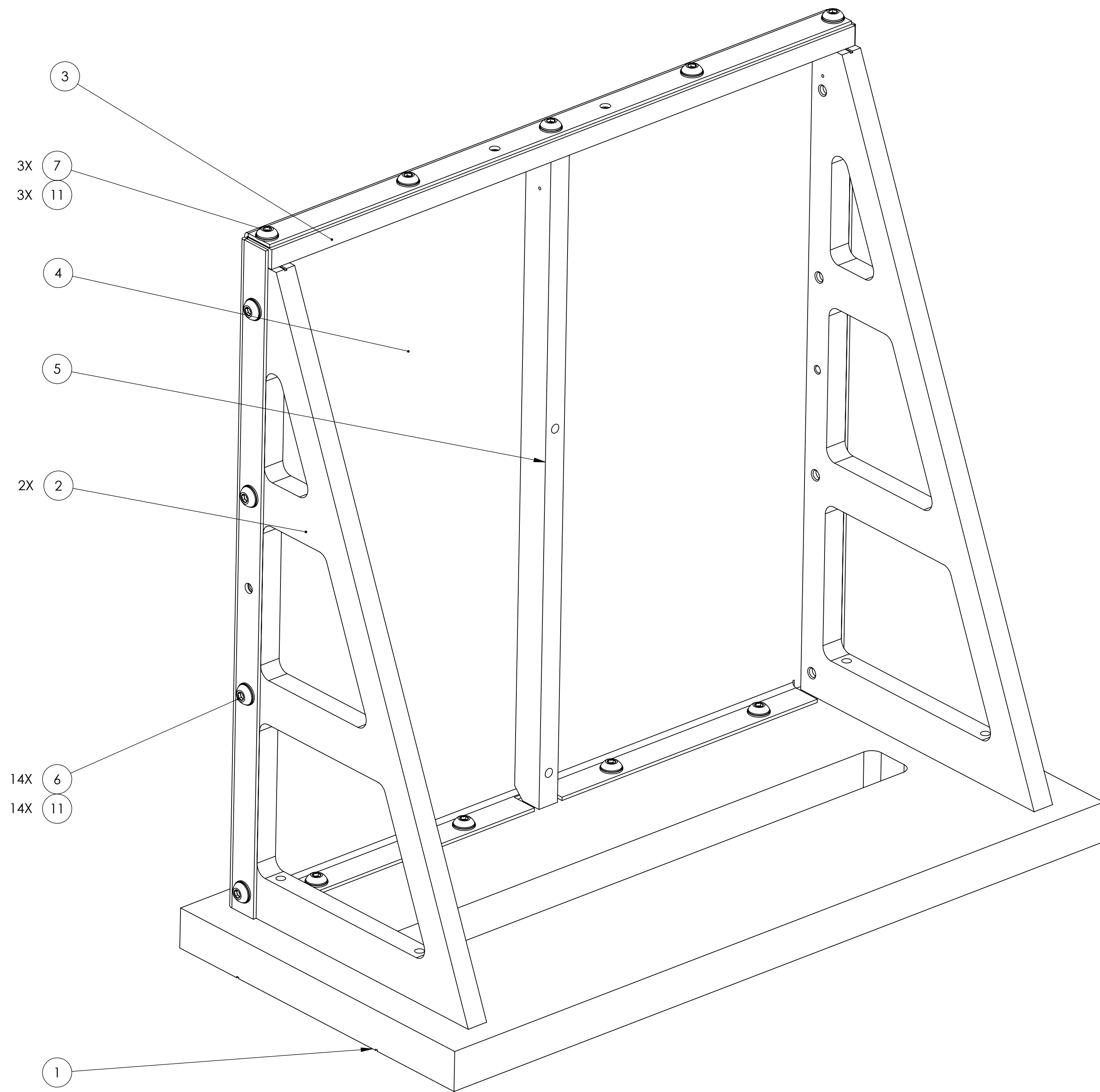
**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE DWG. NO. **D1003205** REV. **v2**

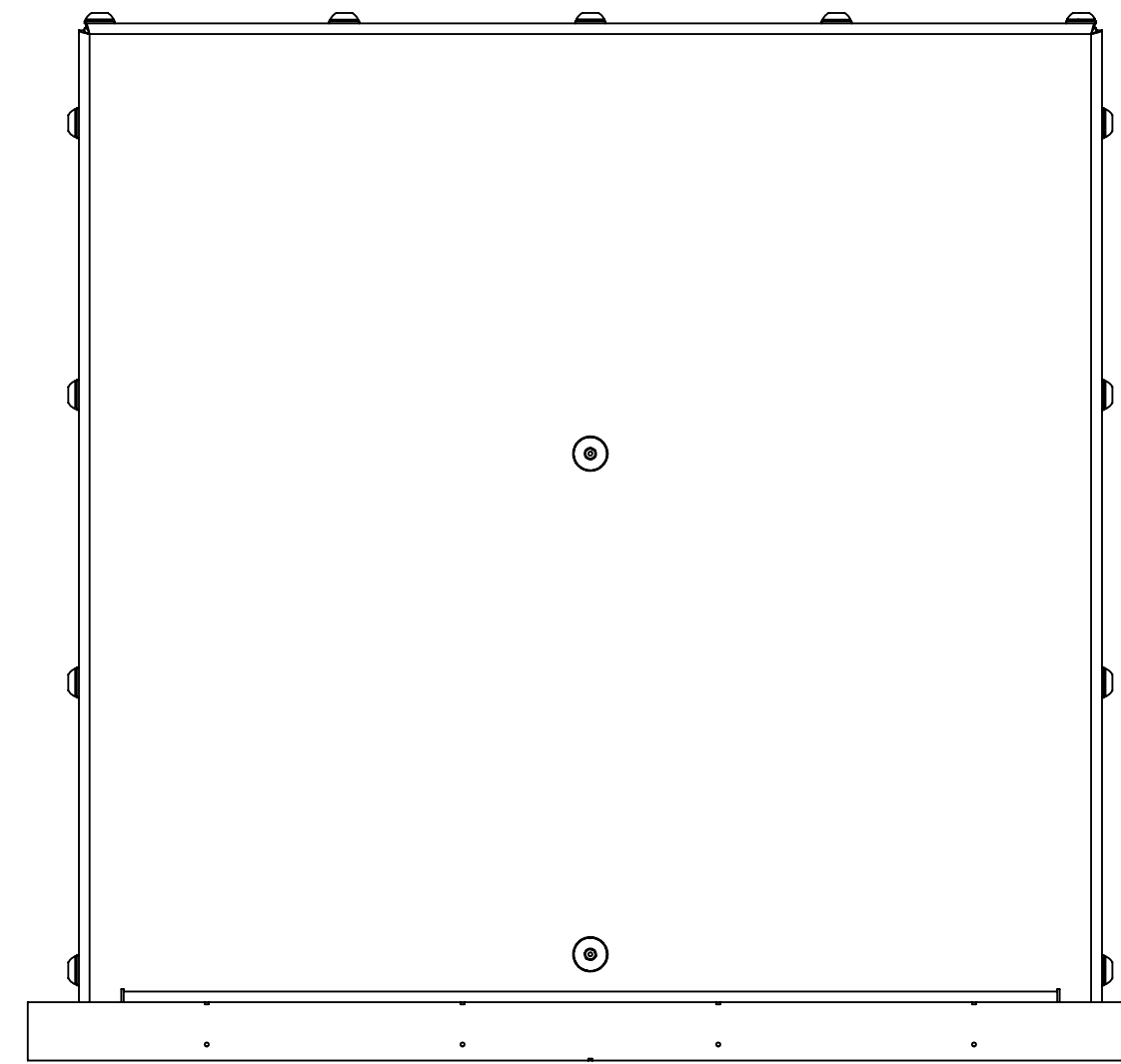
SCALE: 1:3 PROJECTION: SHEET 2 OF 4

D1003205 SR3 HR-AR BAFFLE ASSY PART PDM REV: X-091 DRAWING PDM REV: X-046

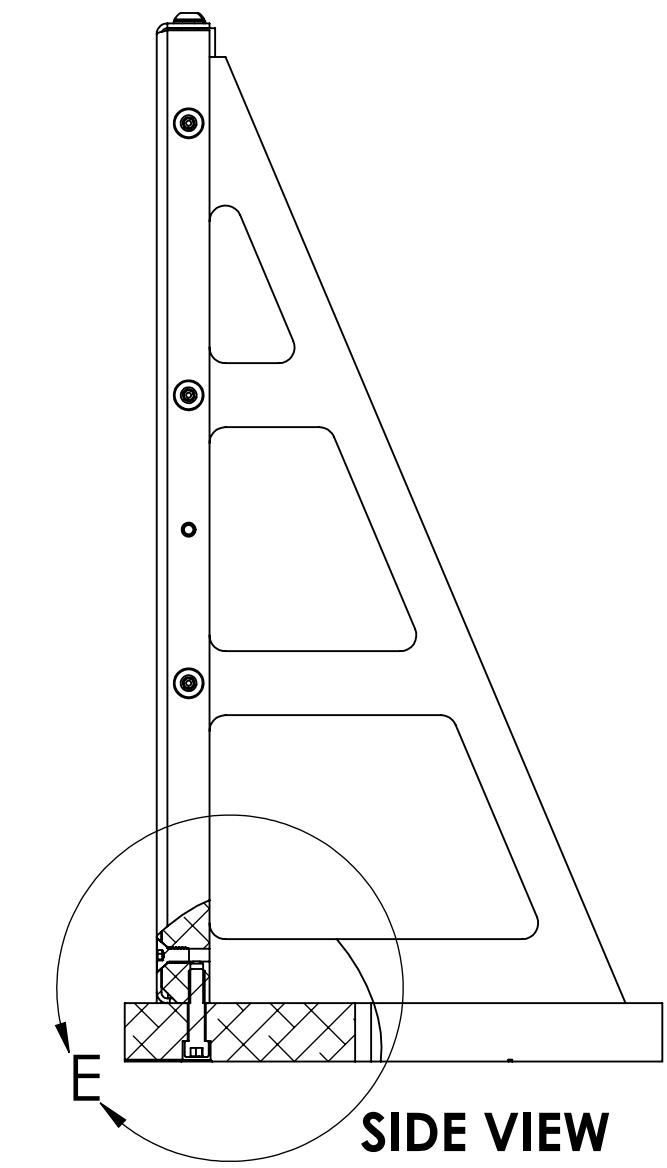
APPROXIMATE WEIGHT=22.45 LBS.



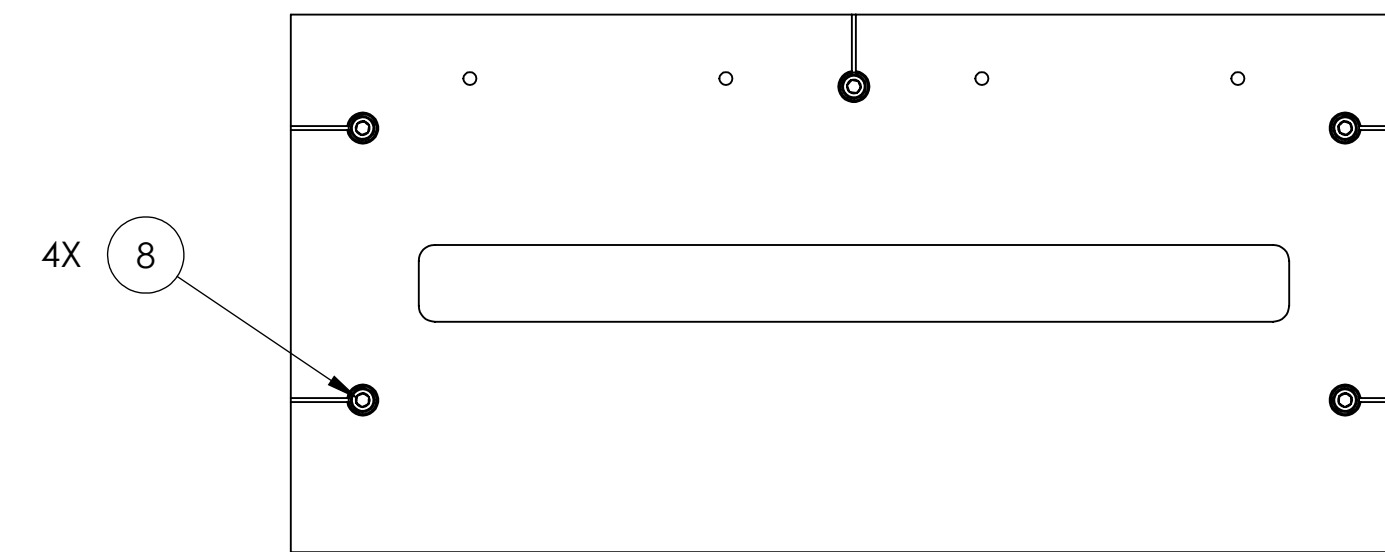
**D1003205-03  
SR3 AR\_H2 BAFFLE  
AS SHOWN**



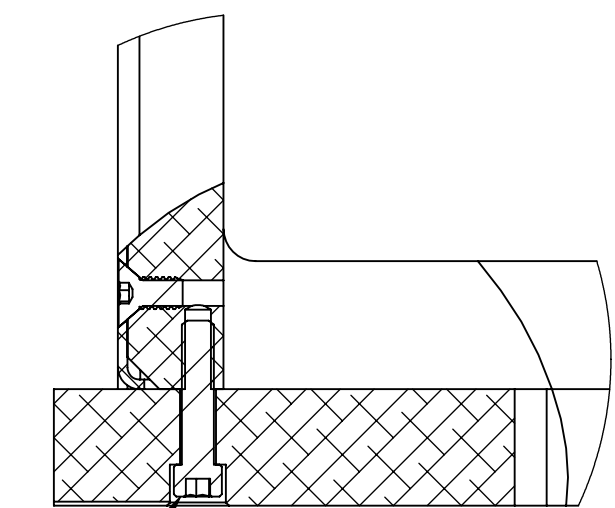
**FRONT VIEW**



**SIDE VIEW**



**BOTTOM VIEW**



**DETAIL E  
SCALE 2 : 3**

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	D1003205-02 SR3 AR	SPARE	TOTAL
11	WF-25	FLAT WASHER 1/4 SCREW SIZE	18-8 SSSL	17	0	0
10	FA-2008-N	FLAT HEAD SOCKET CAP SCREW, 1/4-20 x 1/2" L	18-8 SSSL	2	0	0
9	C-2018-N	SOCKET HEAD CAP SCREW, SHC, 1/4-20 x 1.125" L	18-8 SSSL	1	0	0
8	C-2022-N	SOCKET HEAD CAP SCREW, SHC, 1/4-20 x 1.375" L	18-8 SSSL	4	0	0
7	BU-2016-N	BUTTON HEAD SOCKET HEAD CAP SCREW, 1/4-20 x 1" L	18-8 SSSL	3	0	0
6	BU-2008-N	BUTTON HEAD SOCKET CAP SCREW, 1/4-20 x 1/2" L	18-8 SSSL	14	0	0
5	D1100021	ALIGO SR3 AR PLATE SUPPORT	6061-T6 AI	1	0	0
4	D1101826	ALIGO SR3 BAFFLE PLATE	14 GAUGE 304 SSSL	1	0	0
3	D1003240	ALIGO SR3 HR-AR TOP CROSS BAR	6061-T6 AI	1	0	0
2	D1003172	ALIGO SR3 BAFFLE VERTICAL SUPPORT	6061-T6 AI	2	0	0
1	D1100116	ALIGO SR3 HR-AR_H2 SPACER	6061-T6 AI	1	0	0
				<b>D1003205-02 SR3 AR</b>	<b>SPARE</b>	<b>TOTAL</b>

PARTS LIST

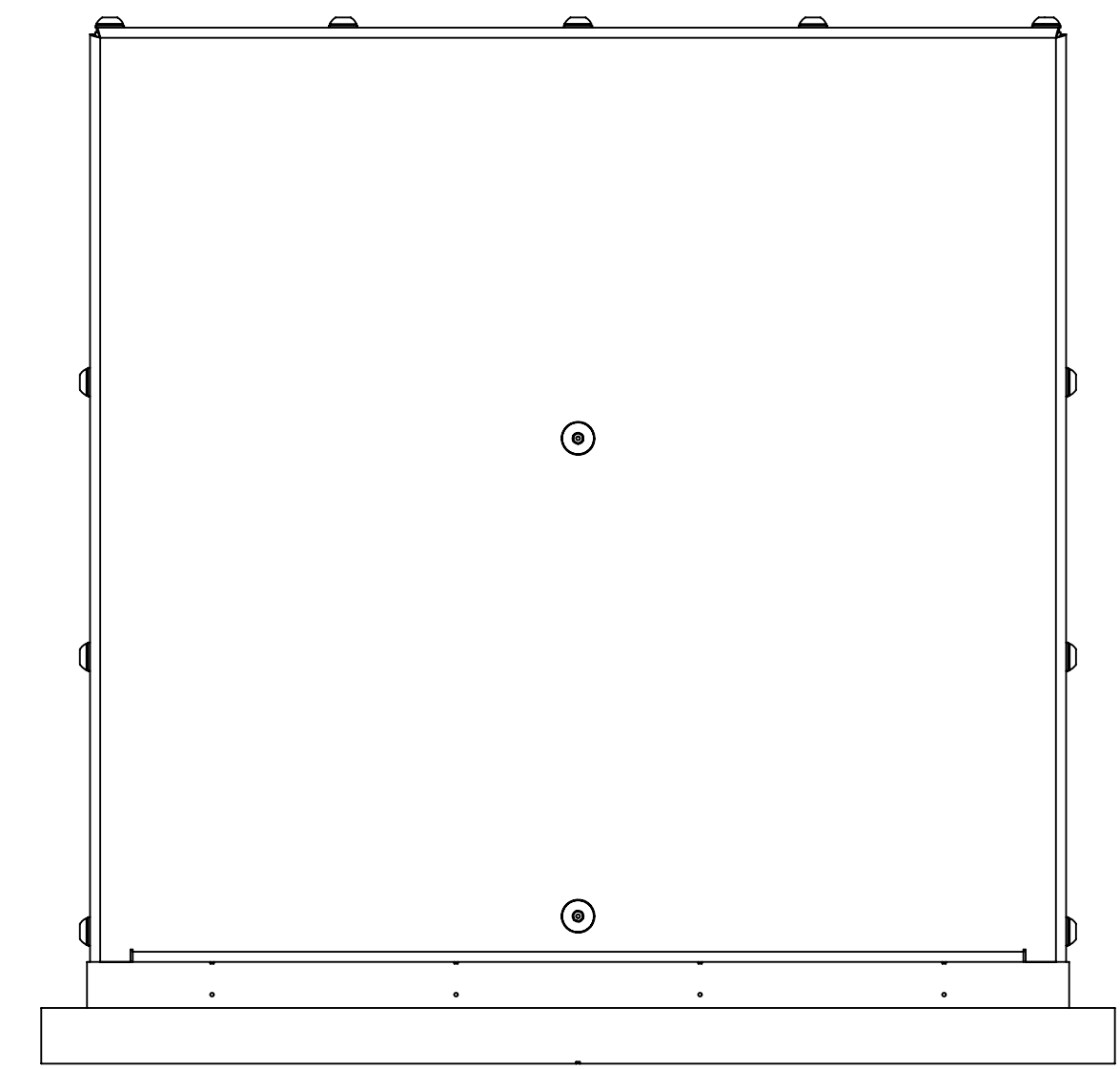
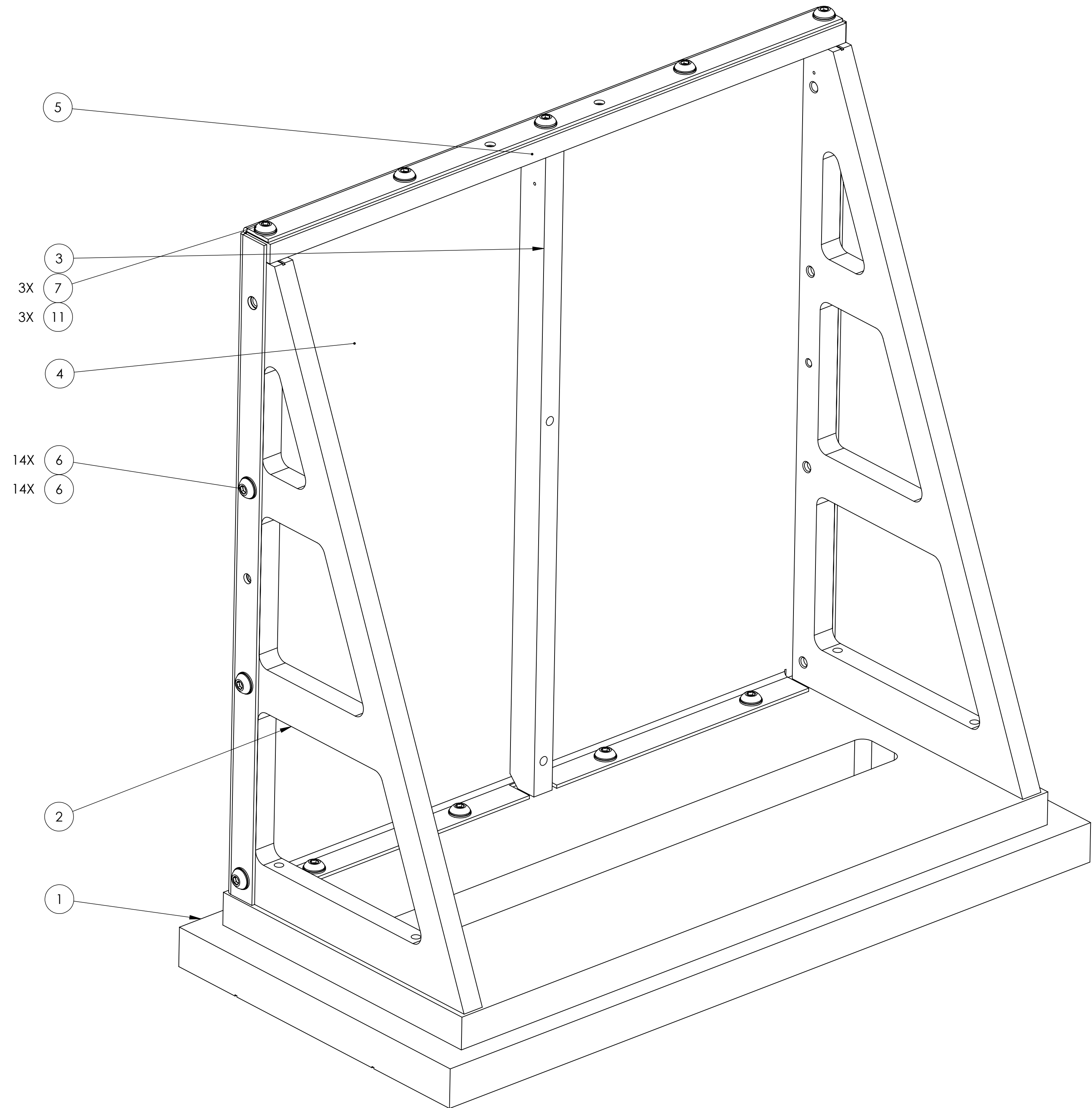
**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE DWG. NO. **D1003205** REV. **v2**

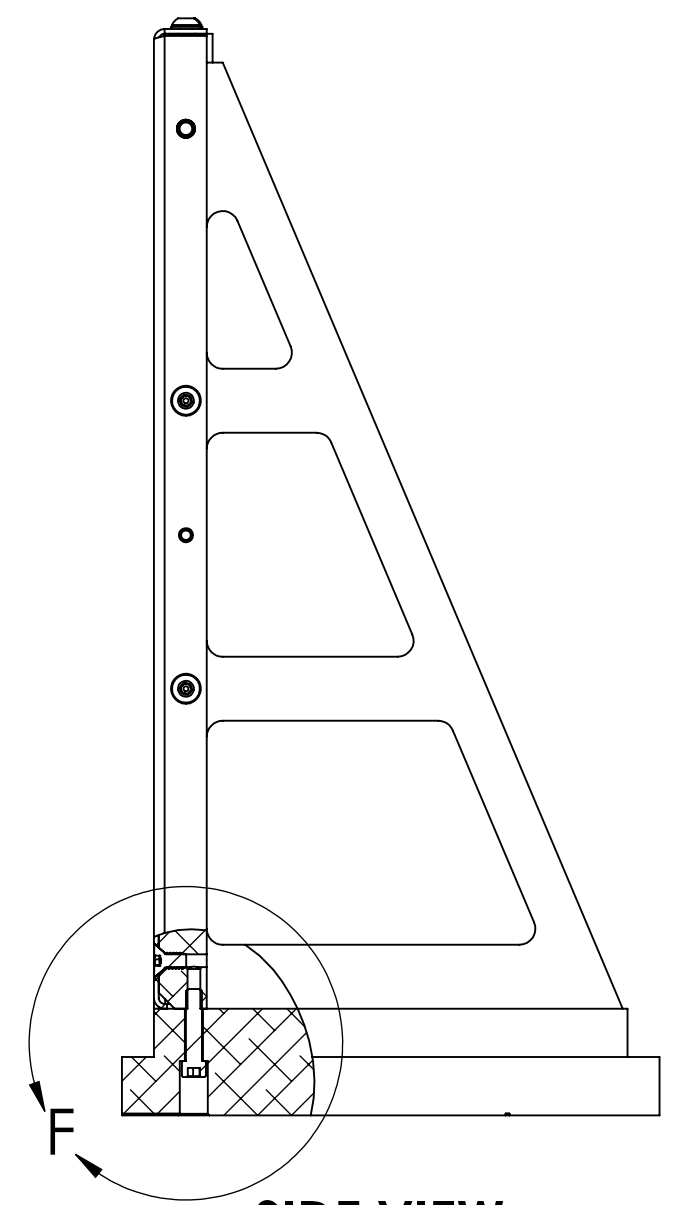
SCALE: 1:3 PROJECTION: SHEET 3 OF 4

D1003205 SR3 HR-AR BAFFLE ASSY PART PDM REV: X-091 DRAWING PDM REV: X-046

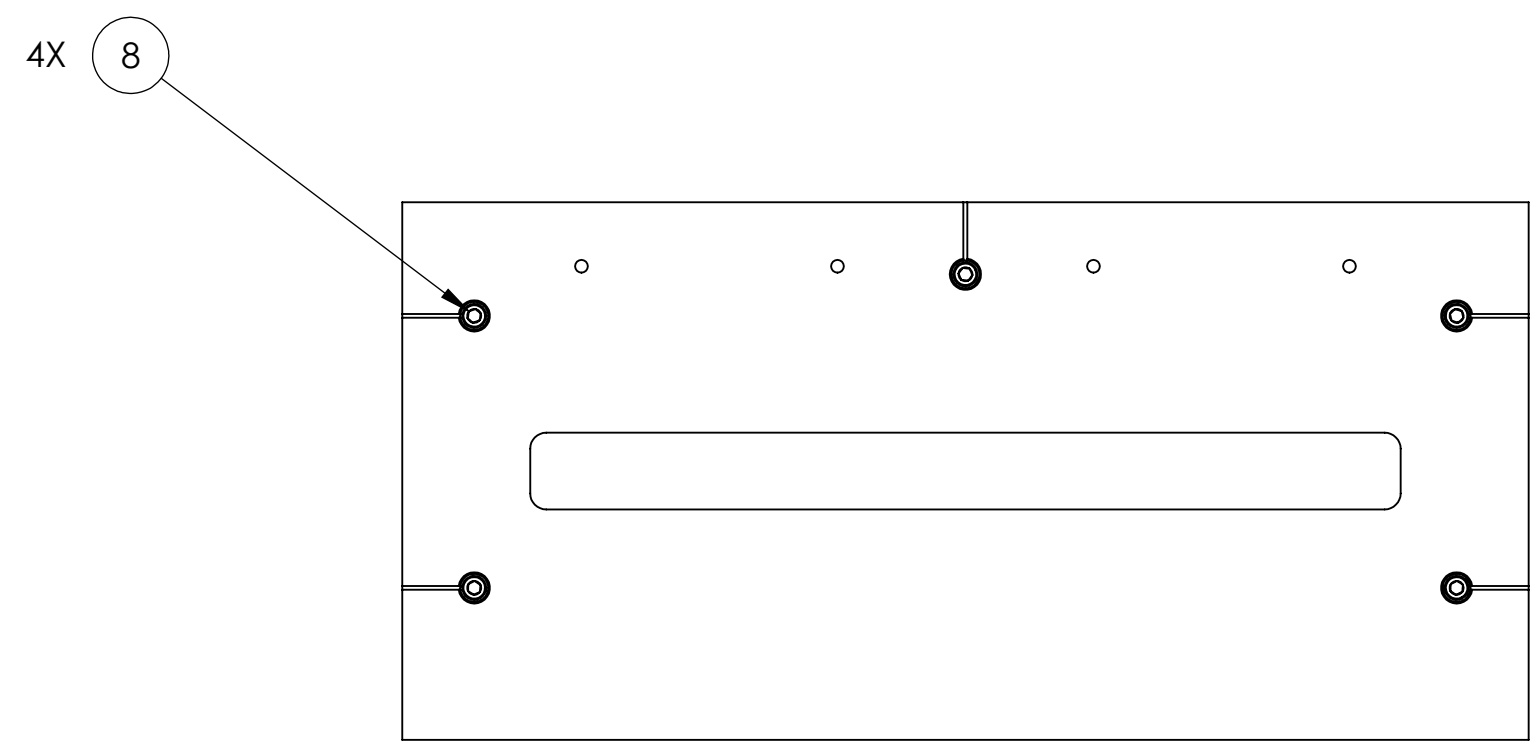
APPROXIMATE WEIGHT=29.97 LBS.



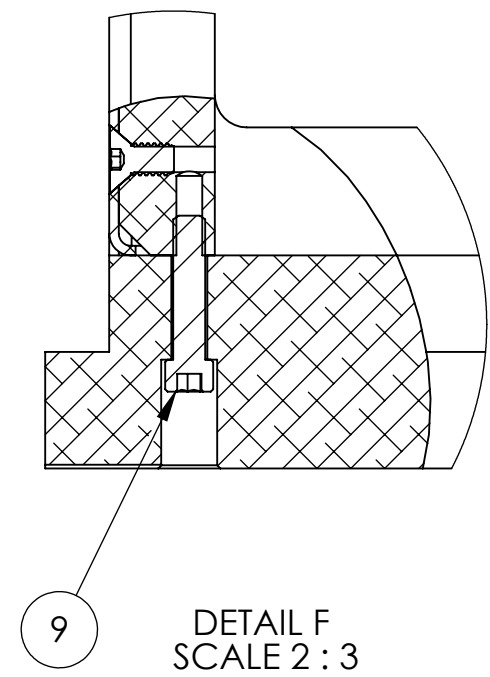
FRONT VIEW



SIDE VIEW



BOTTOM VIEW



DETAIL F  
SCALE 2 : 3

**D1003205-04  
SR3 AR\_H1-L1 BAFFLE  
AS SHOWN**

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	D1003205-04 SR3_AR_H1-L1	SPARE	TOTAL
11	WF-25	FLAT WASHER 1/4 SCREW SIZE	18-8 SSSL	17	0	0
10	FA-2008-N	FLAT HEAD SOCKET CAP SCREW, 1/4-20 x 1/2" L	18-8 SSSL	2	0	0
9	C-2018-N	SOCKET HEAD CAP SCREW, SHC, 1/4-20 x 1.125" L	18-8 SSSL	1	0	0
8	C-2022-N	SOCKET HEAD CAP SCREW, SHC, 1/4-20 x 1.375" L	18-8 SSSL	4	0	0
7	BU-2016-N	BUTTON HEAD SOCKET HEAD CAP SCREW, 1/4-20 x 1" L	18-8 SSSL	3	0	0
6	BU-2008-N	BUTTON HEAD SOCKET CAP SCREW, 1/4-20 x 1/2" L	18-8 SSSL	14	0	0
5	D1003240	ALIGO SR3 HR-AR TOP CROSS BAR	6061-T6 Al	1	0	0
4	D1101826	ALIGO SR3 BAFFLE PLATE	14 GAUGE 304 SSSL	1	0	0
3	D1100021	ALIGO SR3 AR PLATE SUPPORT	6061-T6 Al	1	0	0
2	D1003172	ALIGO SR3 BAFFLE VERTICAL SUPPORT	6061-T6 Al	2	0	0
1	D1100423	ALIGO SR3 HR-AR_H1-L1 SPACER	6061-T6 Al	1	0	0
PARTS LIST						

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

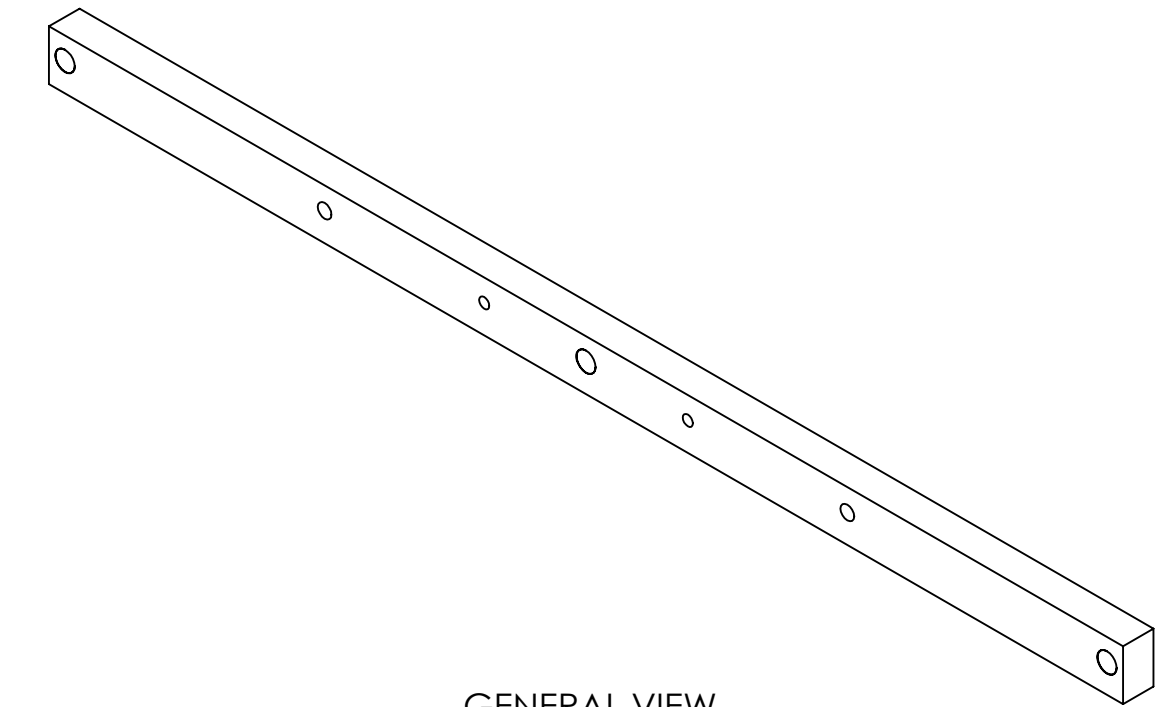
SIZE DWG. NO. **D1003205** REV. **v2**

SCALE: 1:3 PROJECTION: SHEET 4 OF 4

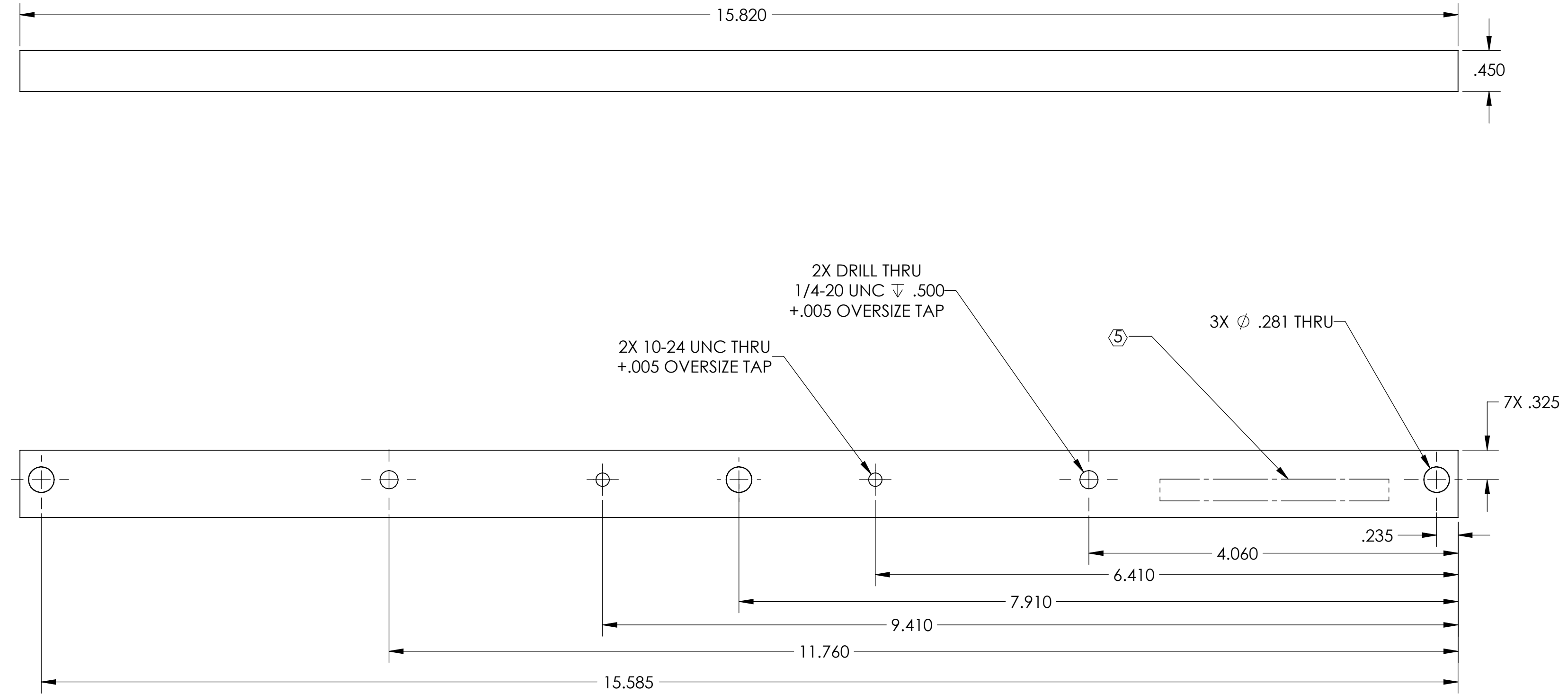
D1003205 SR3 HR-AR BAFFLE ASSY PART PDM REV: X-0911 DRAWING PDM REV: X-046

- 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 = 0.596 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	4 APR 2011	E1100313	
v2	30 MAR 2012	E1100313-v2	



GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE



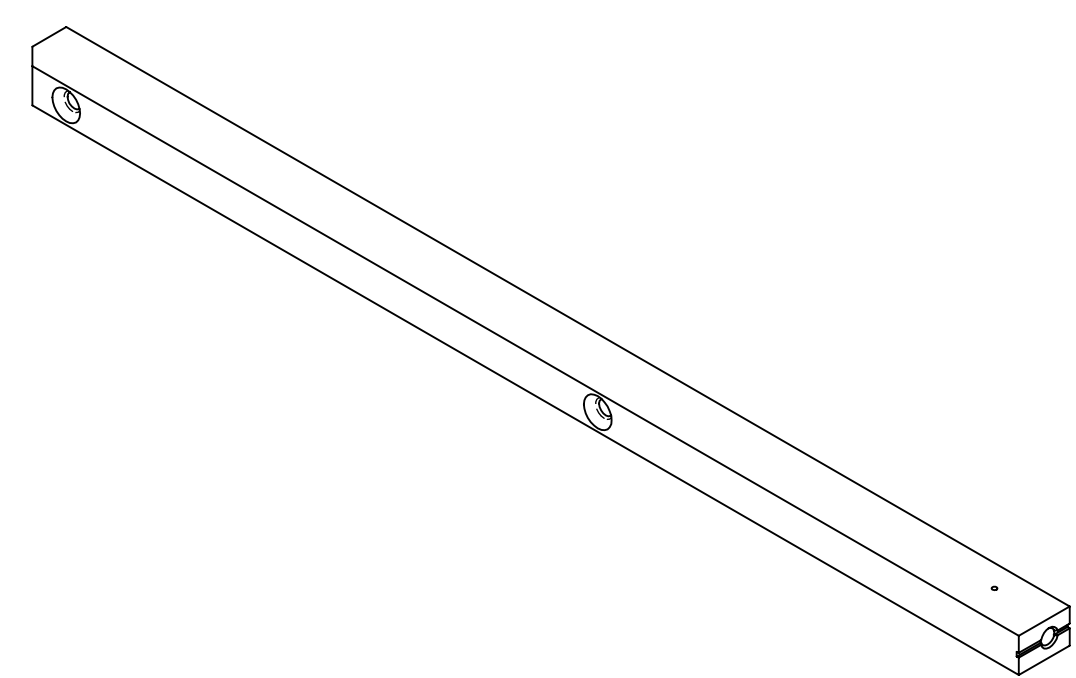
DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME <b>ALIGO SR3 HR-AR TOP CROSS BAR</b>							
TOLERANCES: .XX ± .02 .XXX ± .005		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM <b>ADVANCED LIGO</b>		SUB-SYSTEM <b>AOS</b>		DESIGNER	C. WILKERSON	1 APR 2011	SIZE	DWG. NO.	REV.
ANGULAR ± 1.0°		MATERIAL <b>6061-T6 Al</b>		FINISH <b>63 μinch</b>		NEXT ASSY <b>D1003205</b>		DRAFTER	C. WILKERSON	1 APR 2011	<b>D</b> <b>D1003240</b>	v2	
						APPROVAL		M. SMITH	4 NOV 2011	SCALE: 1:1			PROJECTION:

D1003240 ALIGO SR3 HR-AR TOP CROSS BAR, PART PDM REV: X-048, DRAWING PDM REV: X-023

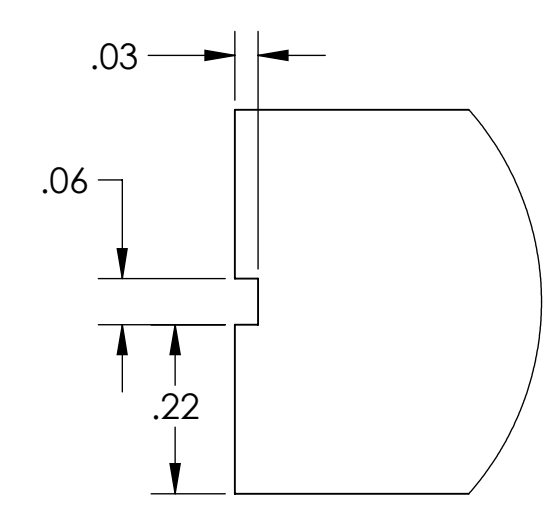
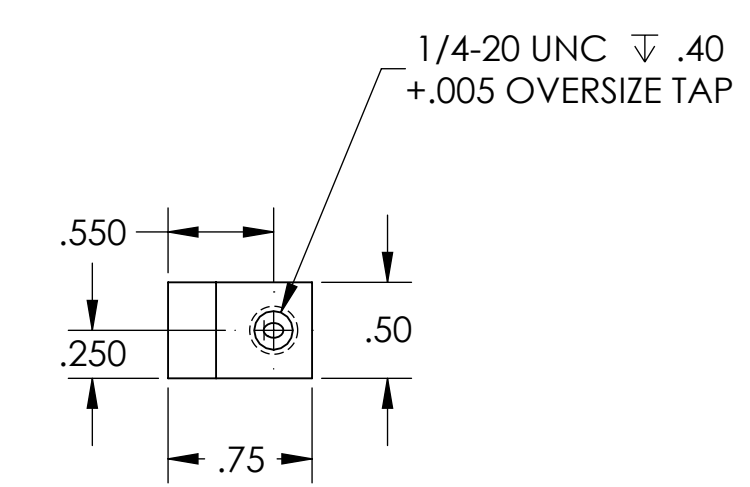
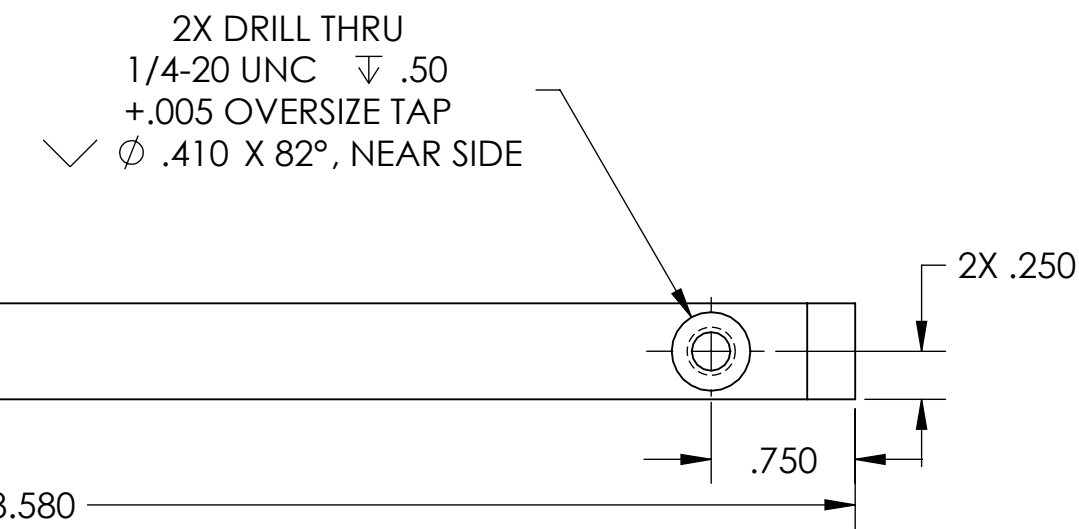
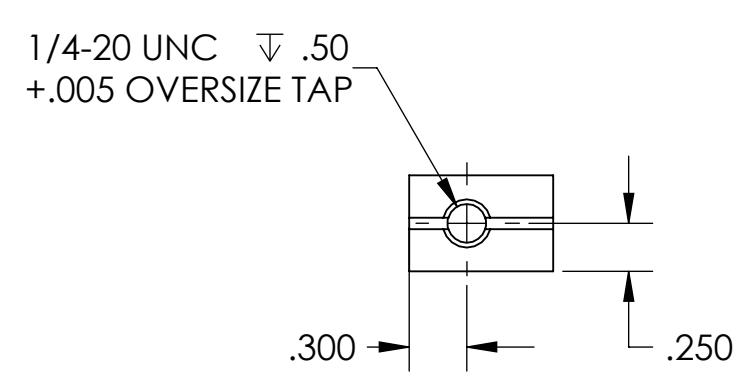
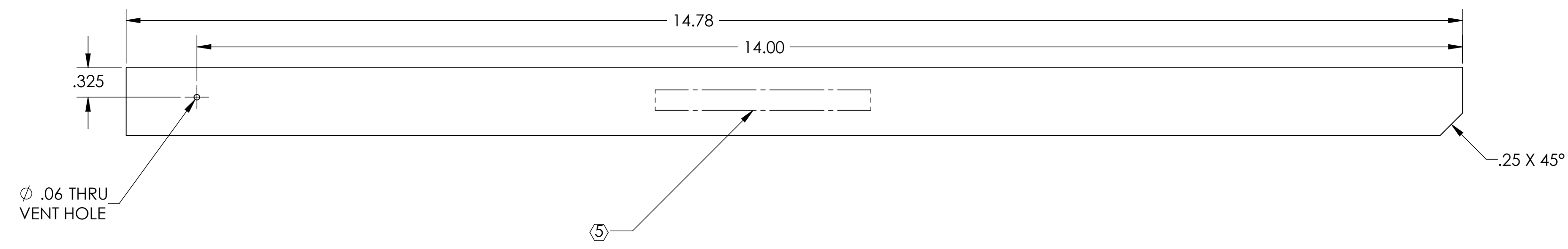
8  
7  
6  
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4  
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1  
H  
G  
F  
E  
D  
C  
B  
A  
 DT100021 ALIGO SR3 AR PLATE SUPPORT, PART PDM REV: X-037, DRAWING PDM REV: X-031

- 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 = .532 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.
  - 10. 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	3 OCT 2011	E1100313-v1	
v2	2 APR 2012		



GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE



DETAIL A  
SCALE 4 : 1

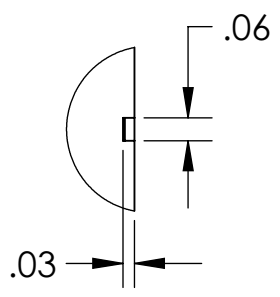
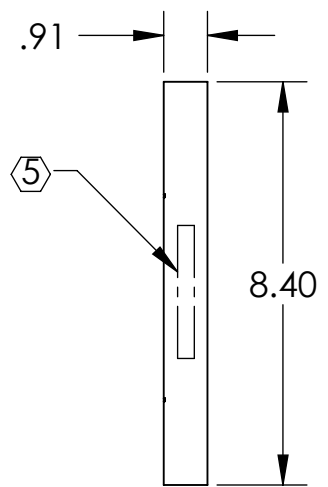
NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME						
DIMENSIONS ARE IN INCHES		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM <b>ADVANCED LIGO</b>		SUB-SYSTEM <b>AOS</b>		<b>ALIGO SR3 AR PLATE SUPPORT</b>				
TOLERANCES: .XX ± .01 .XXX ± .005		MATERIAL <b>6061-T6 Al</b>		FINISH <b>63 μinch</b>		NEXT ASSY <b>D1003205</b>		DESIGNER TQ. NGUYEN	29 SEP 2011	SIZE <b>D</b>	DWG. NO. <b>D1100021</b>	REV. <b>v2</b>
ANGULAR ± 1.0°						CHECKER L. AUSTIN		4 NOV 2011	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1	
						APPROVAL M. SMITH		4 NOV 2011				



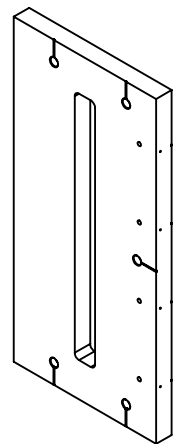
**NOTES CONTINUED:**  
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 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 = 8.618 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.

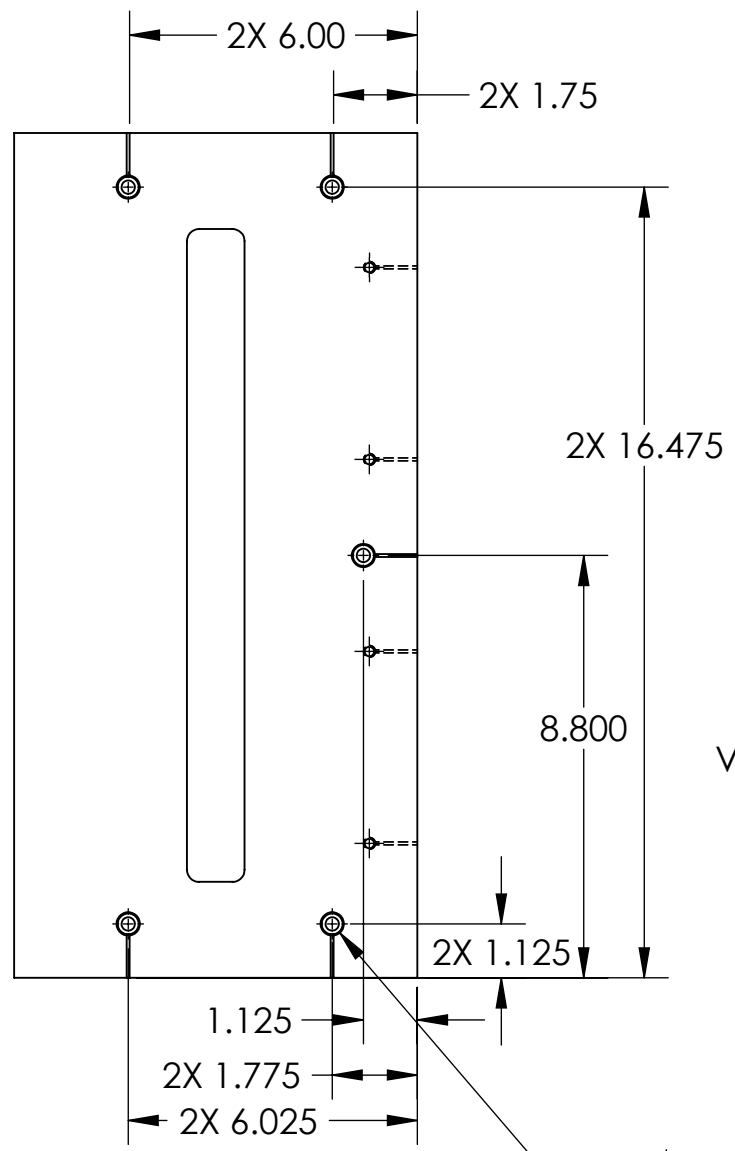
REV.	DATE	DCN #	DRAWING TREE #
v1	4 OCT 2011	E1100313-v1	
v2	30 MAR 2012	E1100313-v1	



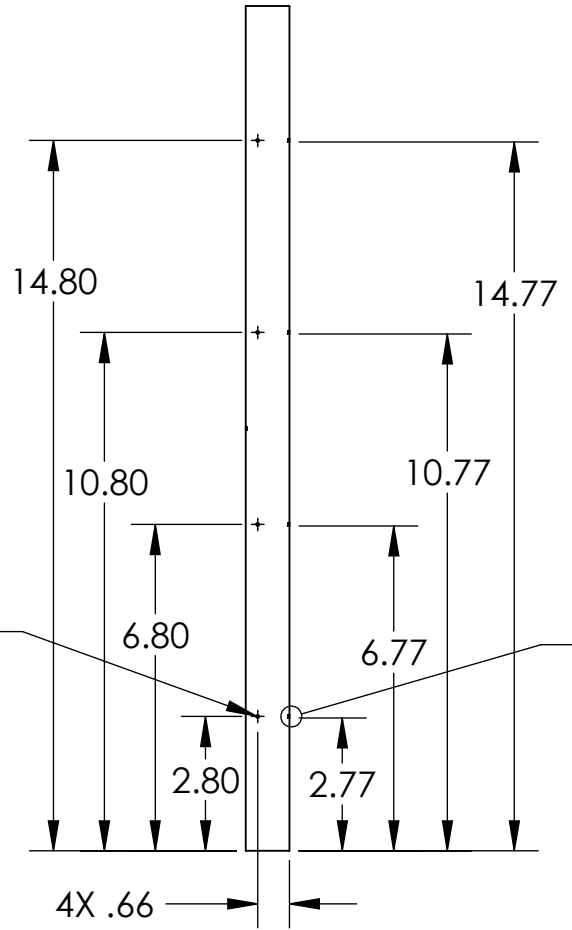
DETAIL A  
SCALE 2 : 1  
8X



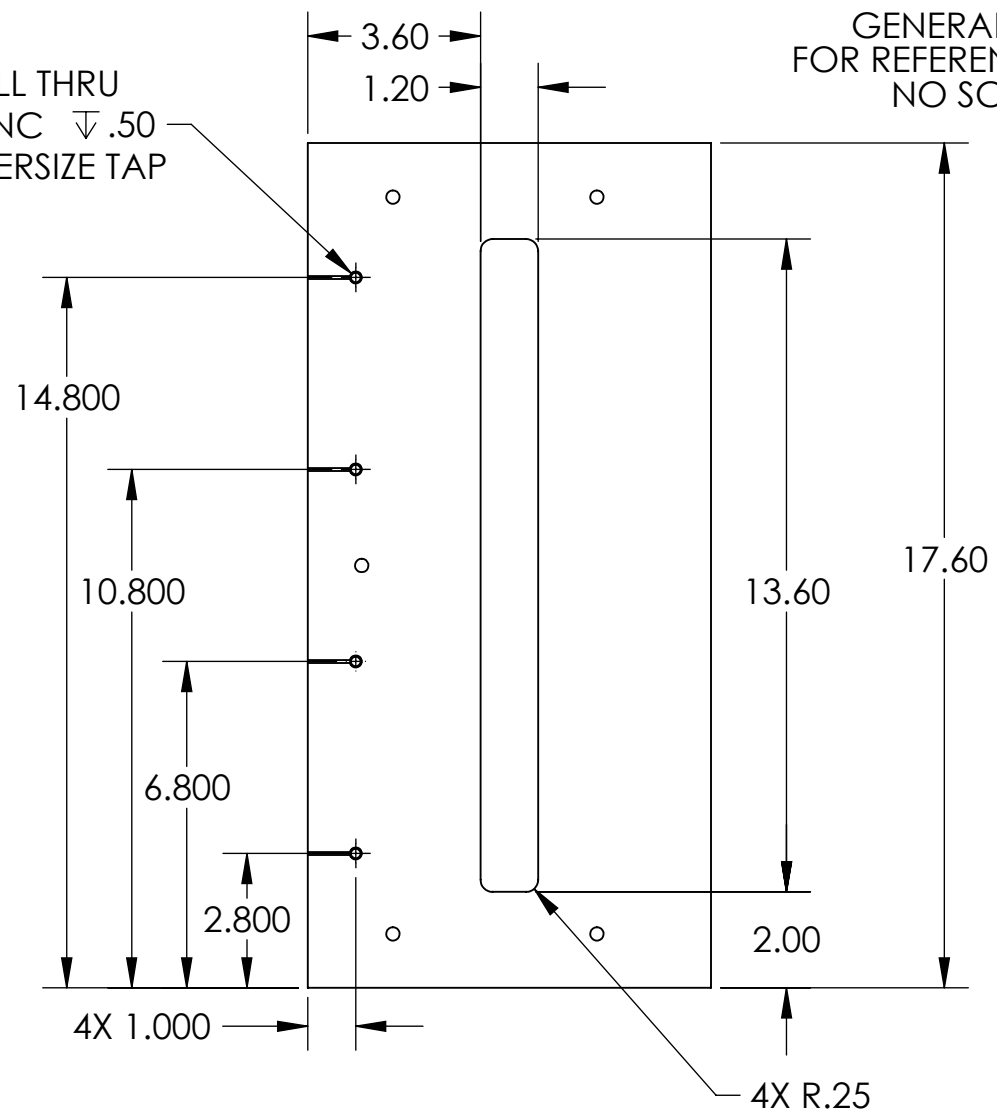
GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE



4X Ø .06  
VENT HOLE THRU  
TAP HOLE



4X DRILL THRU  
1/4-20 UNC  $\nabla$ .50  
+.005 OVERSIZE TAP



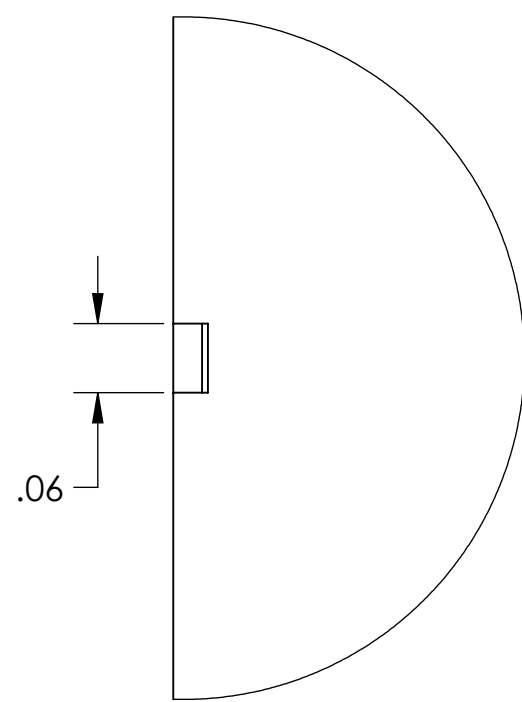
D1100116 ALIGO SR3 HR-AR\_H2 SPACER, PART PDM REV: X-044, DRAWING PDM REV: X-042

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± 1.0°	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
MATERIAL	6061-T6 Al
FINISH	63 μinch

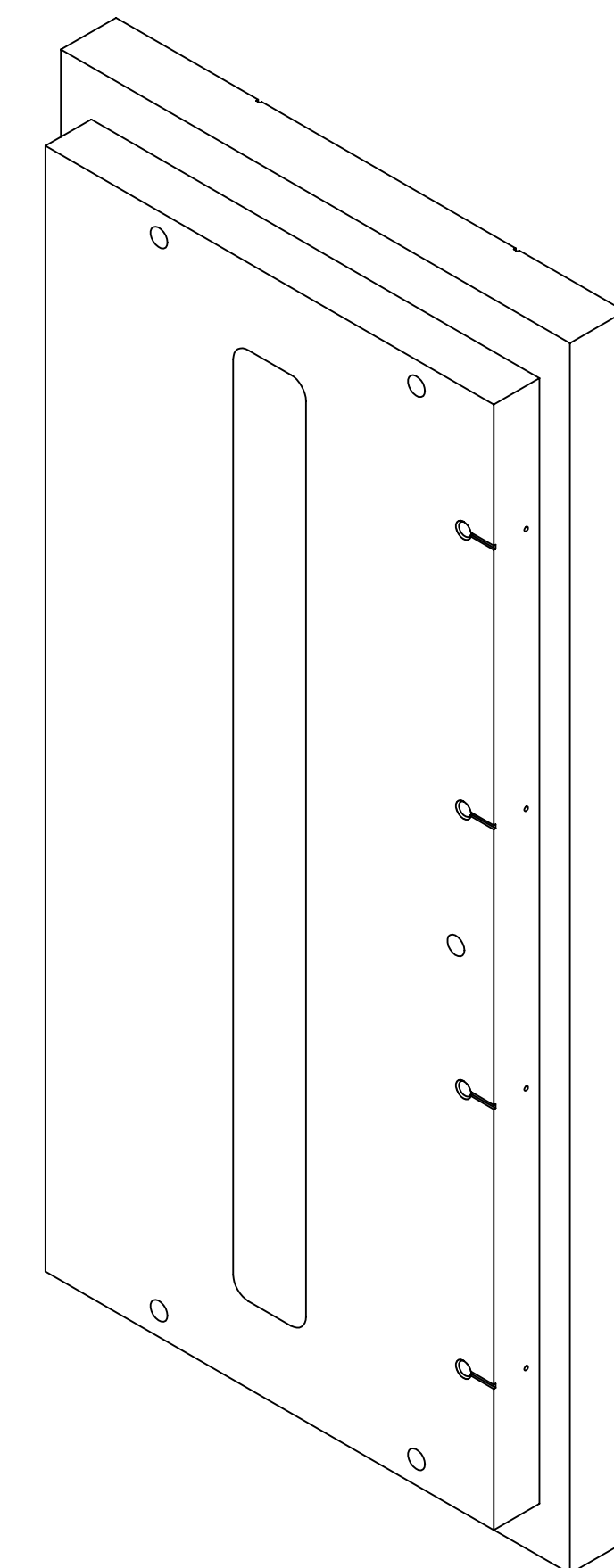
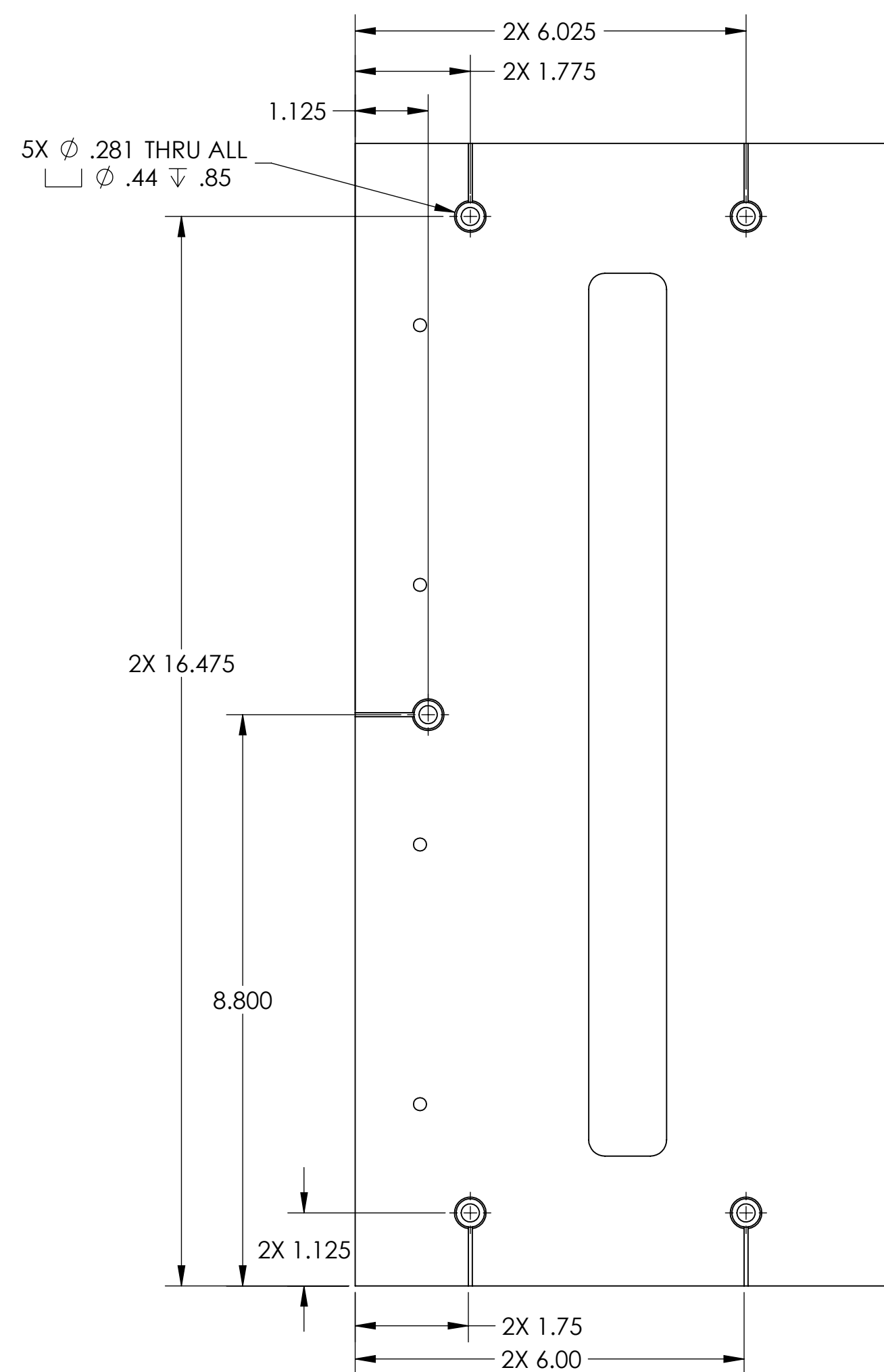
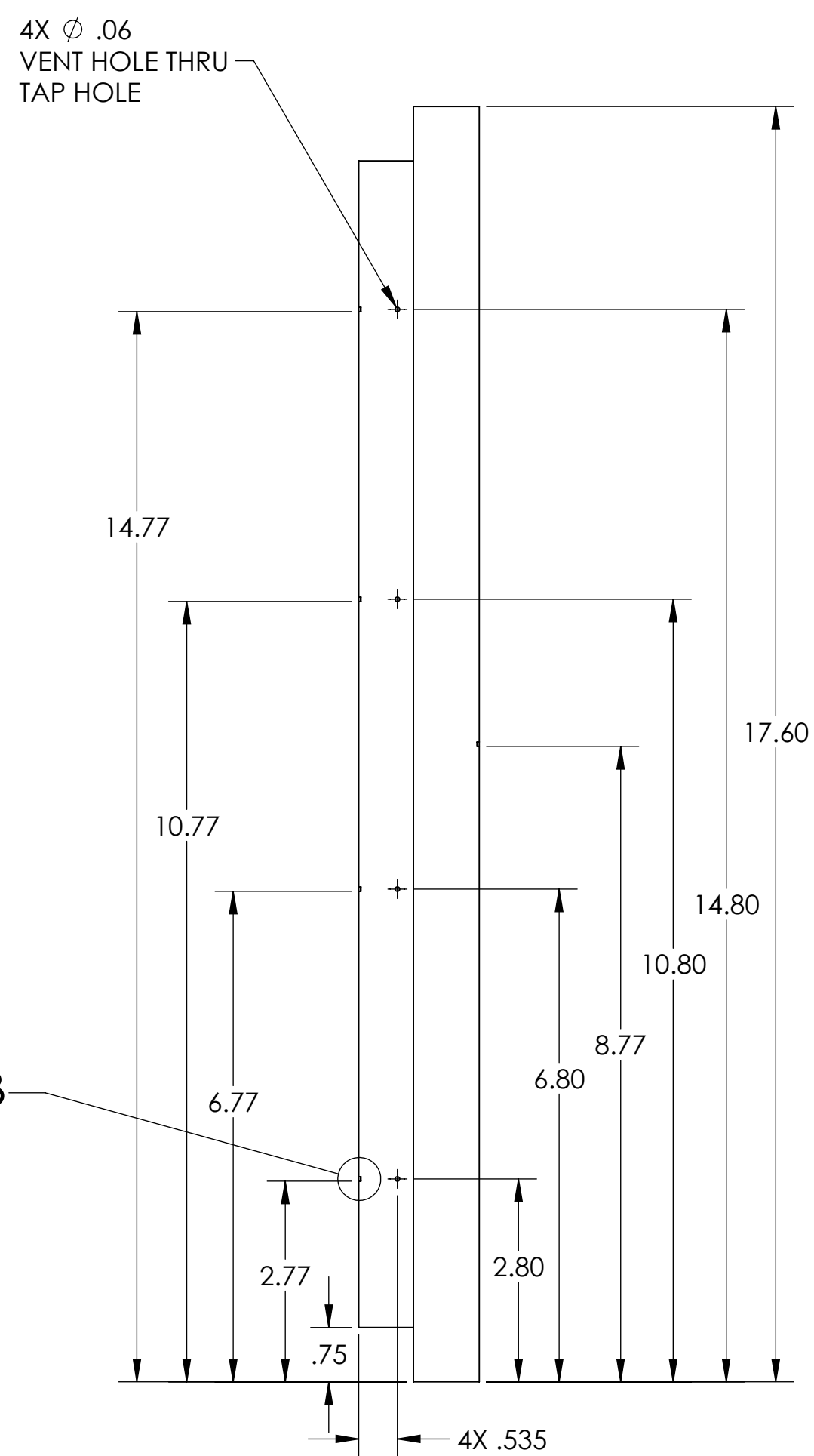
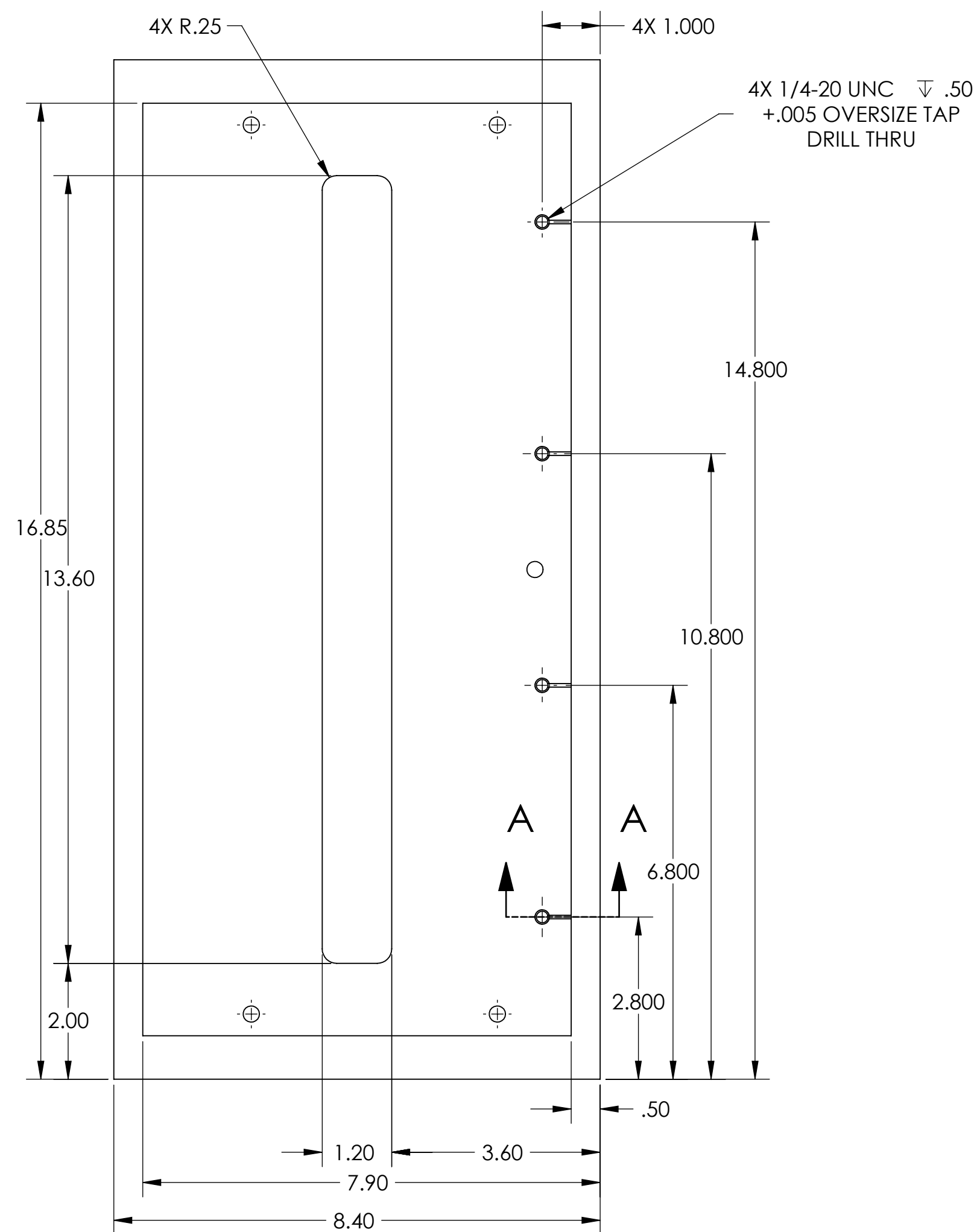
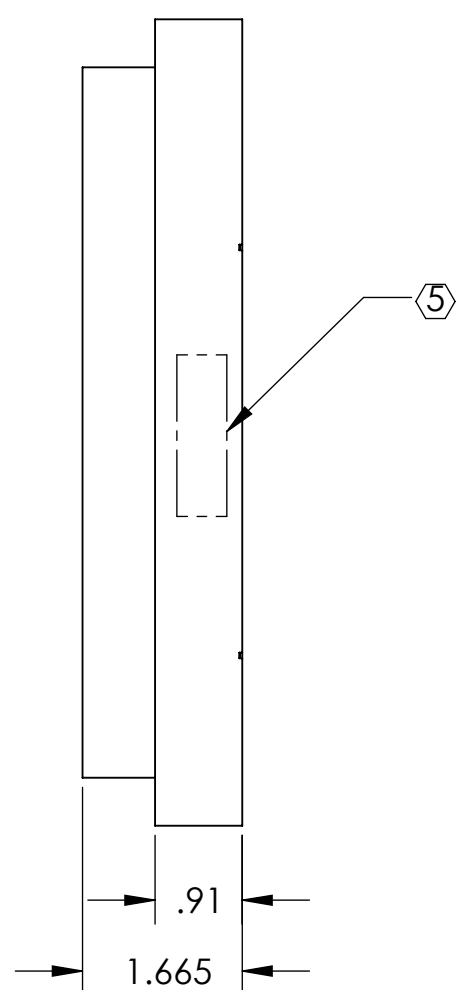
CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		ALIGO SR3 H2	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	AOS	DESIGNER	TQ. NGUYEN 28 SEP 2011
NEXT ASSY	D1003205	DRFTER	TQ. NGUYEN 26 JAN 2011	CHECKER	L. AUSTIN 4 NOV 2011
		APPROVAL	M. SMITH 4 NOV 2011	APPROVAL	M. SMITH 4 NOV 2011
				SIZE	DWG. NO.
				B	D1100116
				SCALE:	1:4
				PROJECTION:	
				SHEET	1 OF 1

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

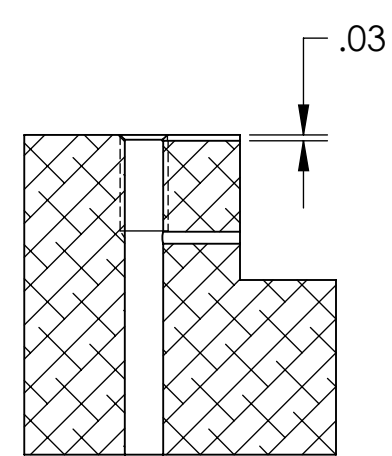
- 6. APPROXIMATE WEIGHT = 14.307 LB.
- 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
- 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- 9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NOT WELD REPAIRS OR PLUGS UNLESS APPROVED IN ADVANCE IN WRITING BY LIGO, REFER TO LIGO-E0900364.



DETAIL B  
SCALE 6 : 1  
8X



GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE



SECTION A-A  
SCALE 1 : 1  
8X

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± 1.0°	
MATERIAL	FINISH
6061-T6	63 μinch

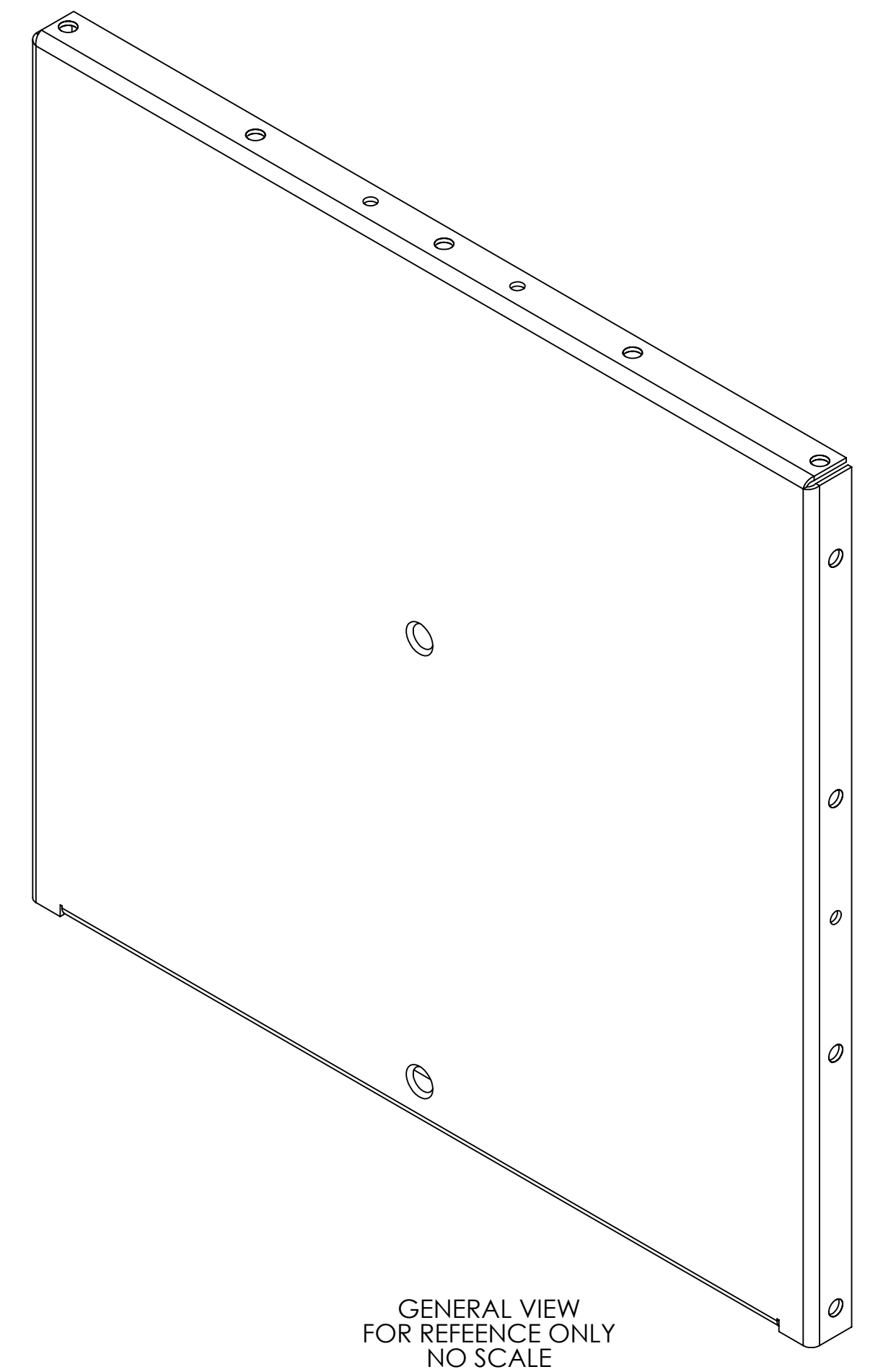
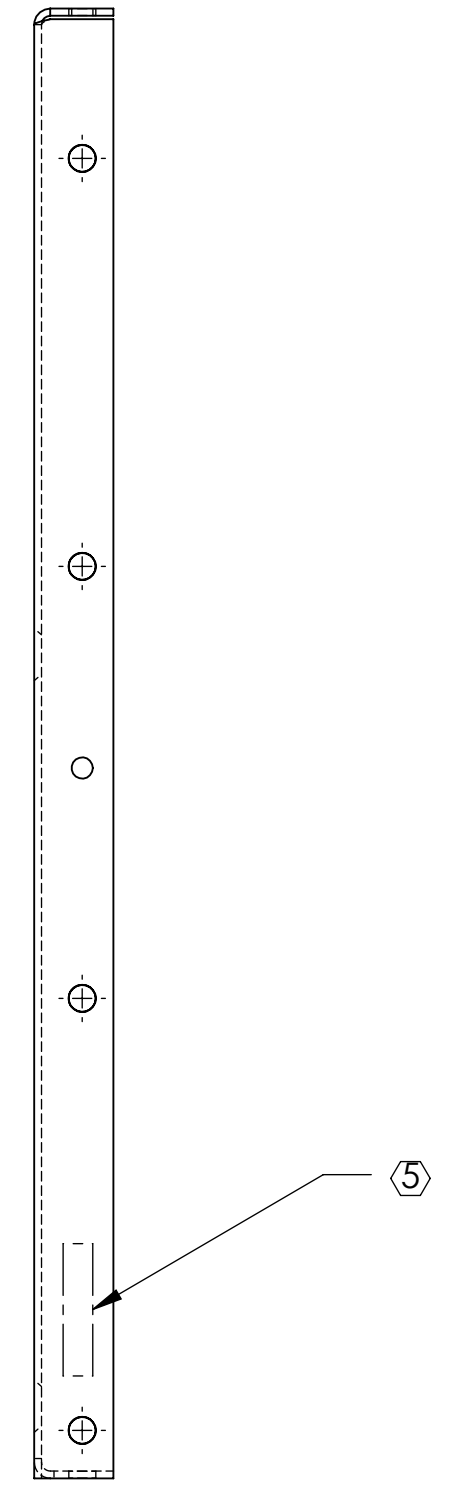
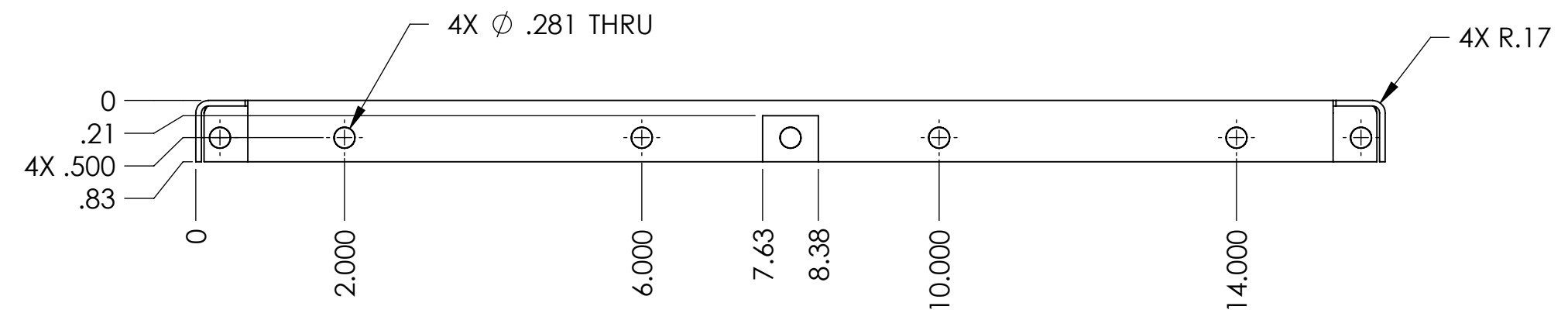
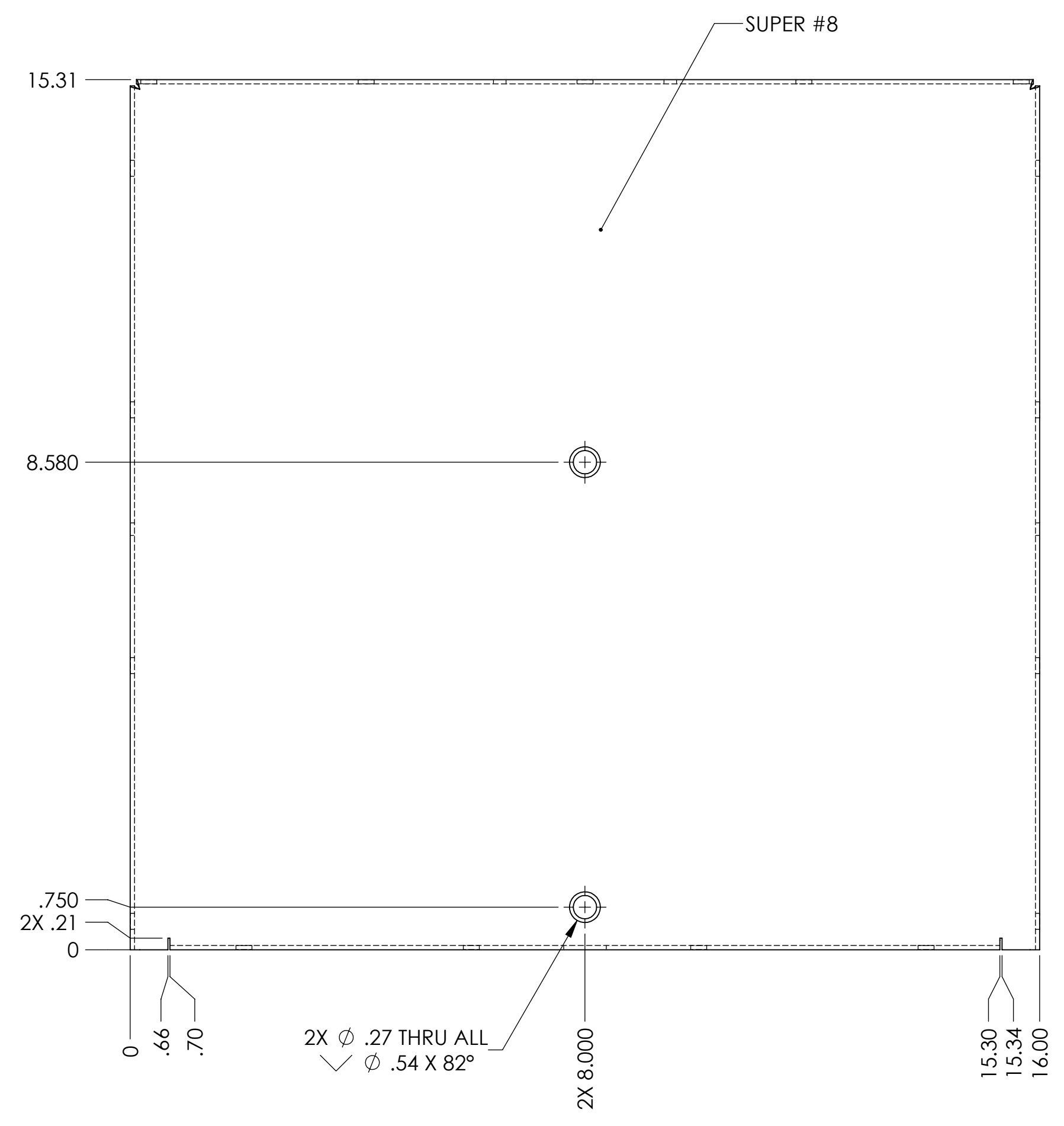
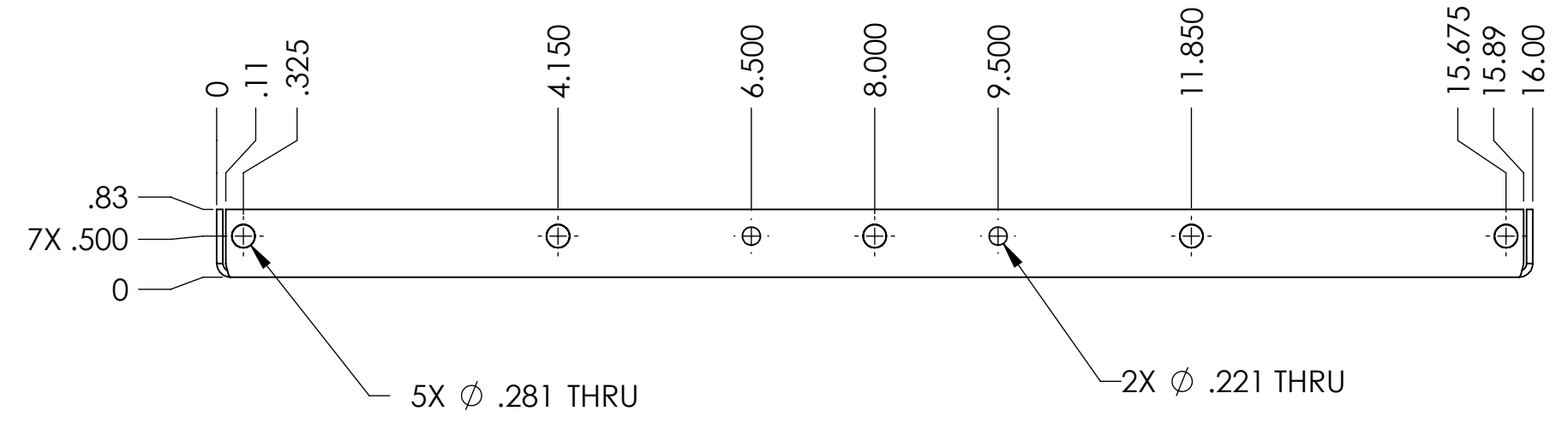
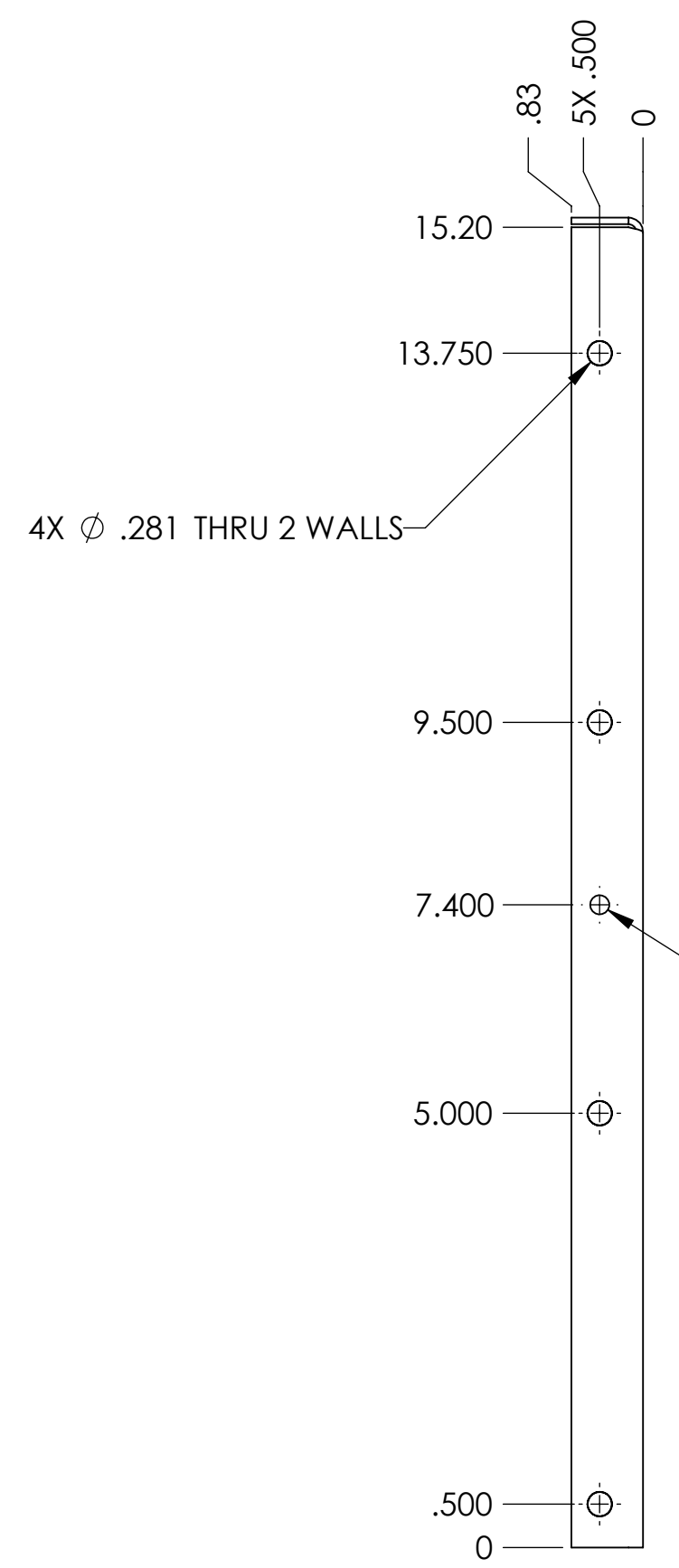
LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS
NEXT ASSY	
D1003205	

PART NAME		ALIGO SR3 HR-AR_H1-L1 SPACER	
DESIGNER	TQ. NGUYEN	29 SEP 2011	SIZE DWG. NO.
DRAFTER	TQ. NGUYEN	3 OCT 2011	D D1100423
CHECKER	L. AUSTIN	4 NOV 2011	REV. v2
APPROVAL	M. SMITH	4 NOV 2011	SCALE: 1:2 PROJECTION:
		SHEET 1 OF 1	

D1100423 ALIGO SR3 HR-AR\_H1-L1 SPACER PART PDM REV: X-033 DRAWING PDM REV: X-029

- NOTES CONTINUED:**
- ⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK (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 .012" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX DO NOT APPLY MARK ON SUPER # 8 SIDE.
  - 6. APPROXIMATE WEIGHT = 6.485 LB.
  - 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 SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
  - 10. PART TO BE OXIDIZED PER LIGO SPECIFICATION E1100842.

REV.	DATE	DCN #	DRAWING TREE #
v1	22 SEP 2011	E1100313-v1	-
v2	2 APR 2012	E1100313-v1	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
1. INTERPRET DRAWING PER ASME Y14.5-1994.	
2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.	
3. DO NOT SCALE FROM DRAWING.	
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
MATERIAL	FINISH
14 GAUGE 304 SSTL	⑨ SUPER #8

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS
NEXT ASSY	D1003205

PART NAME				SIZE		DWG. NO.		REV.	
SR3 AR BAFFLE PLATE				D		D1101826		v2	
DESIGNER	TQ, NGUYEN	21 SEP 2011	SCALE:	1:2	PROJECTION:			SHEET 1 OF 1	
DRAFTER	TQ, NGUYEN	22 SEP 2011							
CHECKER	L. AUSTIN	2 APR 2012							
APPROVAL	M. SMITH	2 APR 2012							

D1101826-LIGO-SR3-AR-BAFFLE-PLATE-PART-PDM-REV-K-032-DRAWING-PDM-REV-X-027