

D1100952_AdlIGO_AOS_SLC_ARM Cavity Baffle Skin-Left, PART PDM REV: X-001, DRAWING PDM REV: X-004

8 7 6 5 4 3 2 1

NOTES: UNLESS OTHERWISE SPECIFIED

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: D100XXXX=V1 S/N 001

- 6. DELETED
- 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 WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION. THE INDICATED HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING TO APPROXIMATELY 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF THE HOLE.

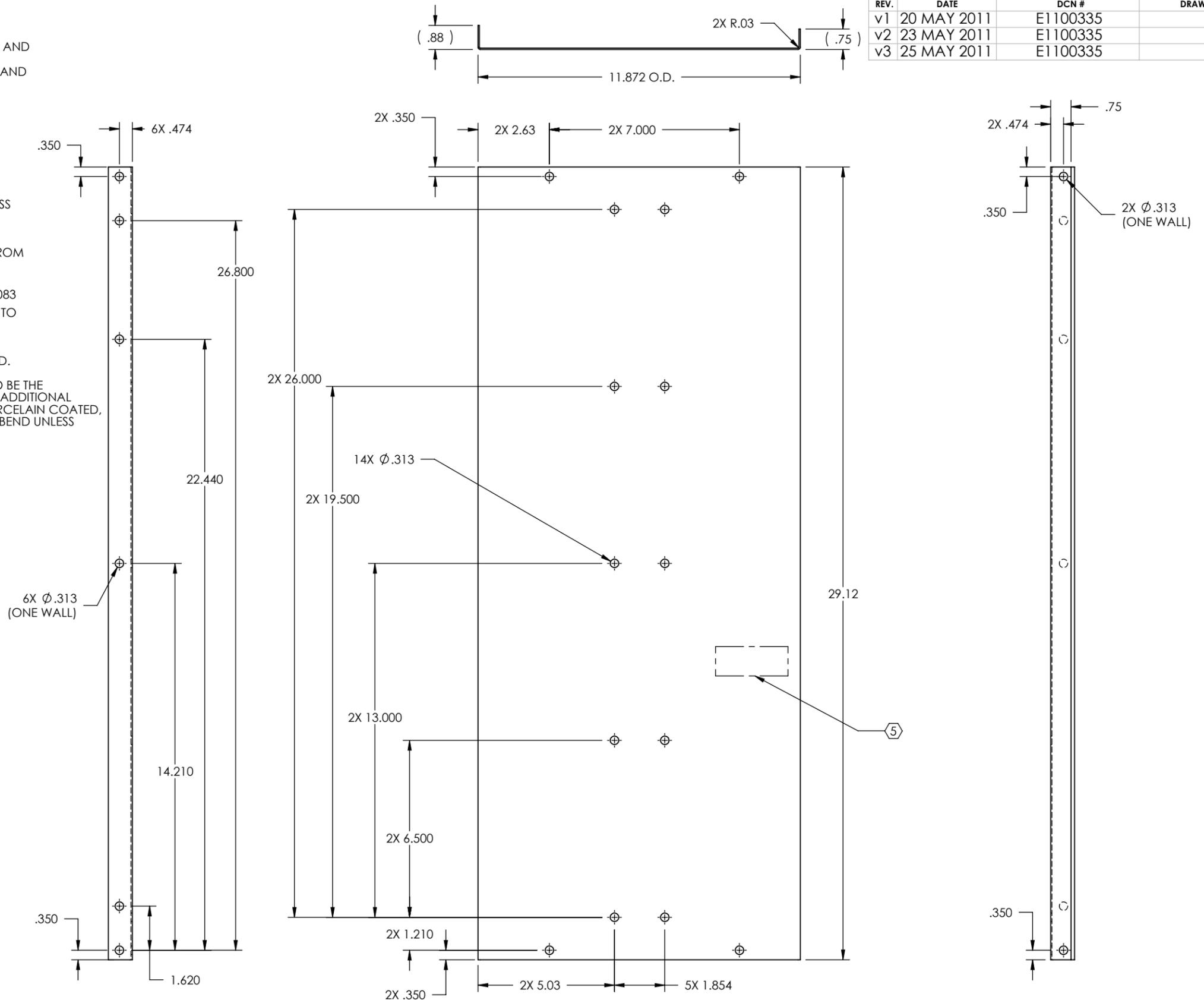
11. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.

12. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.

REV.	DATE	DCN #	DRAWING TREE #
v1	20 MAY 2011	E1100335	-
v2	23 MAY 2011	E1100335	-
v3	25 MAY 2011	E1100335	-

D C B A

D C B A



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN
 TOLERANCES:
 .XX ± .03
 .XXX ± .015
 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 18 GA Enamel Steel A424 Type I FINISH 10

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM AOS
 NEXT ASSY D1000977

PART NAME			REV.		
ARM CAVITY BAFFLE SKIN-LEFT			v3		
DESIGNER	M.RUIZ	20 May 2010	SIZE	DWG. NO.	
DRAFTER	M.RUIZ	20 MAY 2011	B	D1100952	
CHECKER			SCALE:	1:4	
APPROVAL			PROJECTION:	SHEET 1 OF 1	

8 7 6 5 4 3 2 1