NOTES CONTINUED:

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

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. A VIBRATORY TOOL MAY BE USED.
EXAMPLE DXXXXXXX-VY, TYPE-XX, S/N XXX.

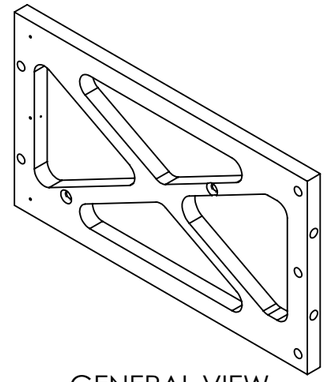
6. APPROXIMATE WEIGHT = 0.680 LB.

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

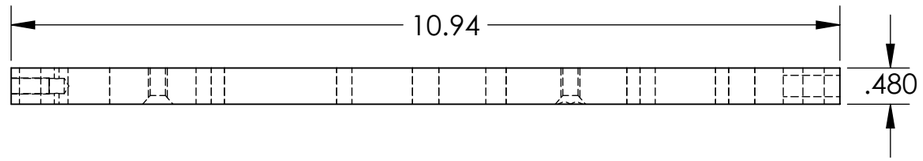
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

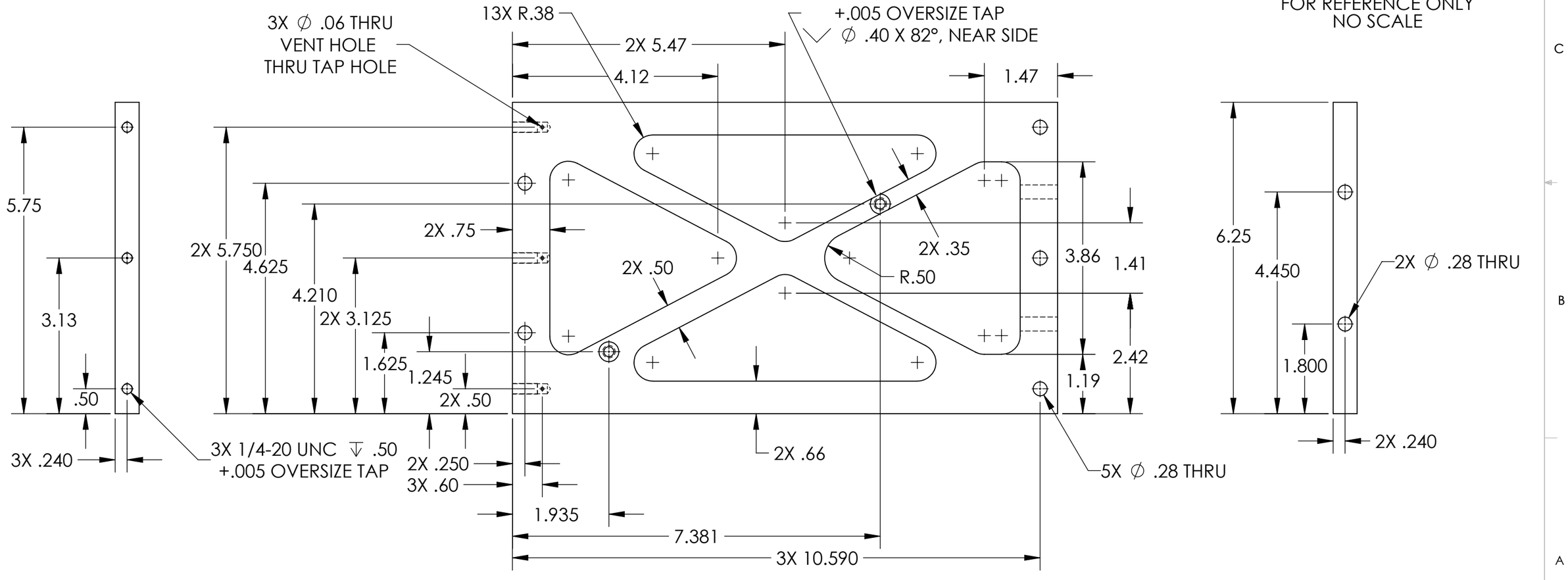
9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NOT WELD REPAIRS OR PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING BY LIGO LABBORATORY. REFER TO LIGO-E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	10 SETP 2011	E1100836	E1100837
v2	28 MAR 2012		



GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE





NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)			
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .015 .XXX ± .005 ANGULAR ± .5°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. ON ALL EDGES AND HOLES. 3. DO NOT SCALE FROM DRAWING.	MATERIAL: 6061-T6 Al	FINISH: 63 µinch

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM	ADVANCED LIGO
SUB-SYSTEM	AOS
NEXT ASSY	D1101599

PART NAME: aLIGO AOS, HAM SCRAPER BAFFLE, SUPPORT WALL

DESIGNER	M.HILLARD	16 Aug. 2011
DRAFTER	TQ. NGUYEN	14 MAR 2012
CHECKER	L. AUSTIN	
APPROVAL	M. SMITH	

SIZE: B | DWG. NO.: D1101602 | REV.: v2
SCALE: 1:2 | PROJECTION: | SHEET 1 OF 1

D1101602, PART PDM REV: X-022, DRAWING PDM REV: X-012