

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 0.12" 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 = 3.619 LBS.

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.

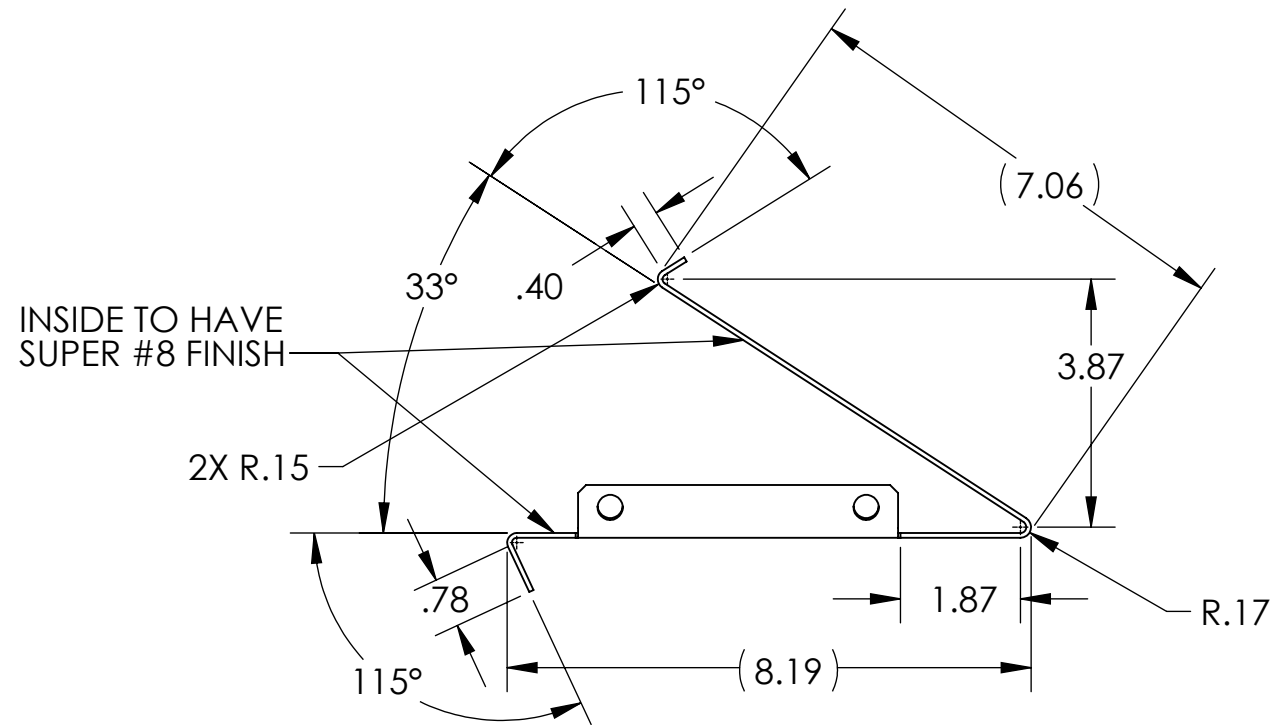
9. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

⑩ CAD FILE D1101605 MUST USED TO GENERATE ELLIPSE CURVE AND BEVEL ON OTHER SIDE OF SUPER #8 FINISH.

⑪ PART TO BE OXIDIZED PER LIGO SPEC E1100842.

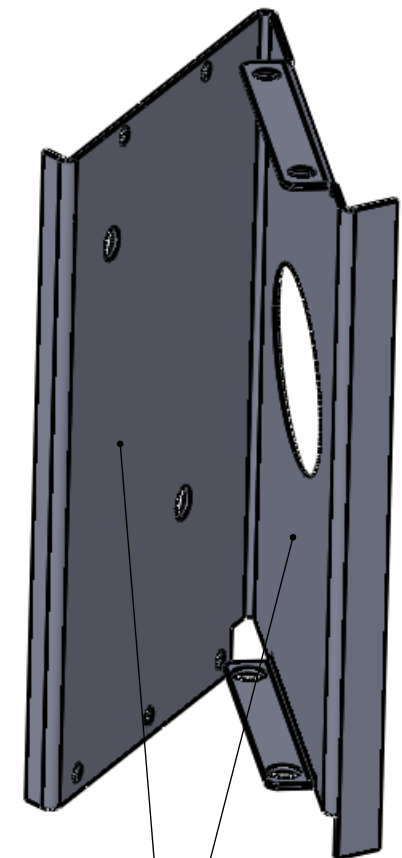
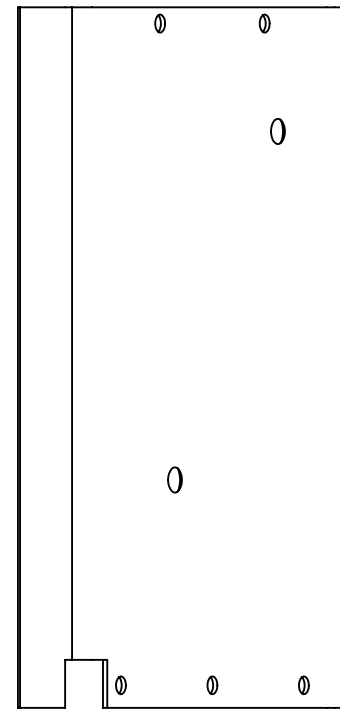
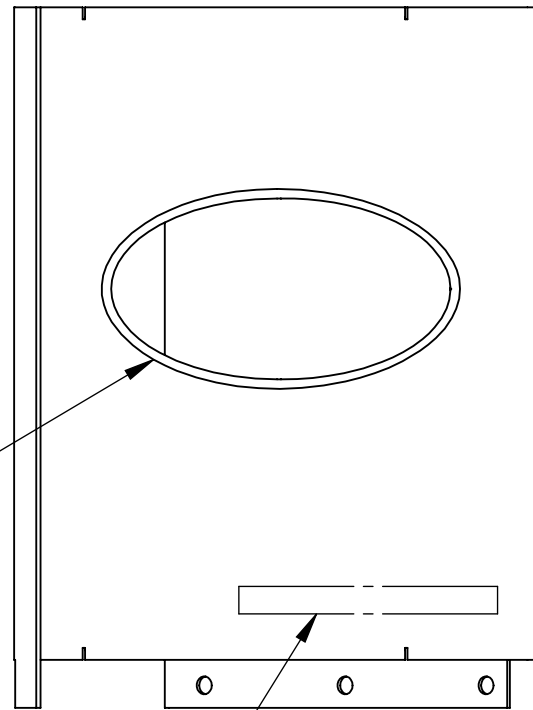
INSIDE TO HAVE SUPER #8 FINISH

2X R.15



SEE NOTE ⑩

⑤ NEARSIDE



SUPER #8 SIDE

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .02
.XXX ± .010

ANGULAR ± .5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. NO BURRS
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 14 GAUGE 304 SSTL

FINISH SUPER #8 ⑪

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM AOS

NEXT ASSY D1101599

PART NAME αLIGO AOS, HAM SCRAPER BAFFLE SKIN

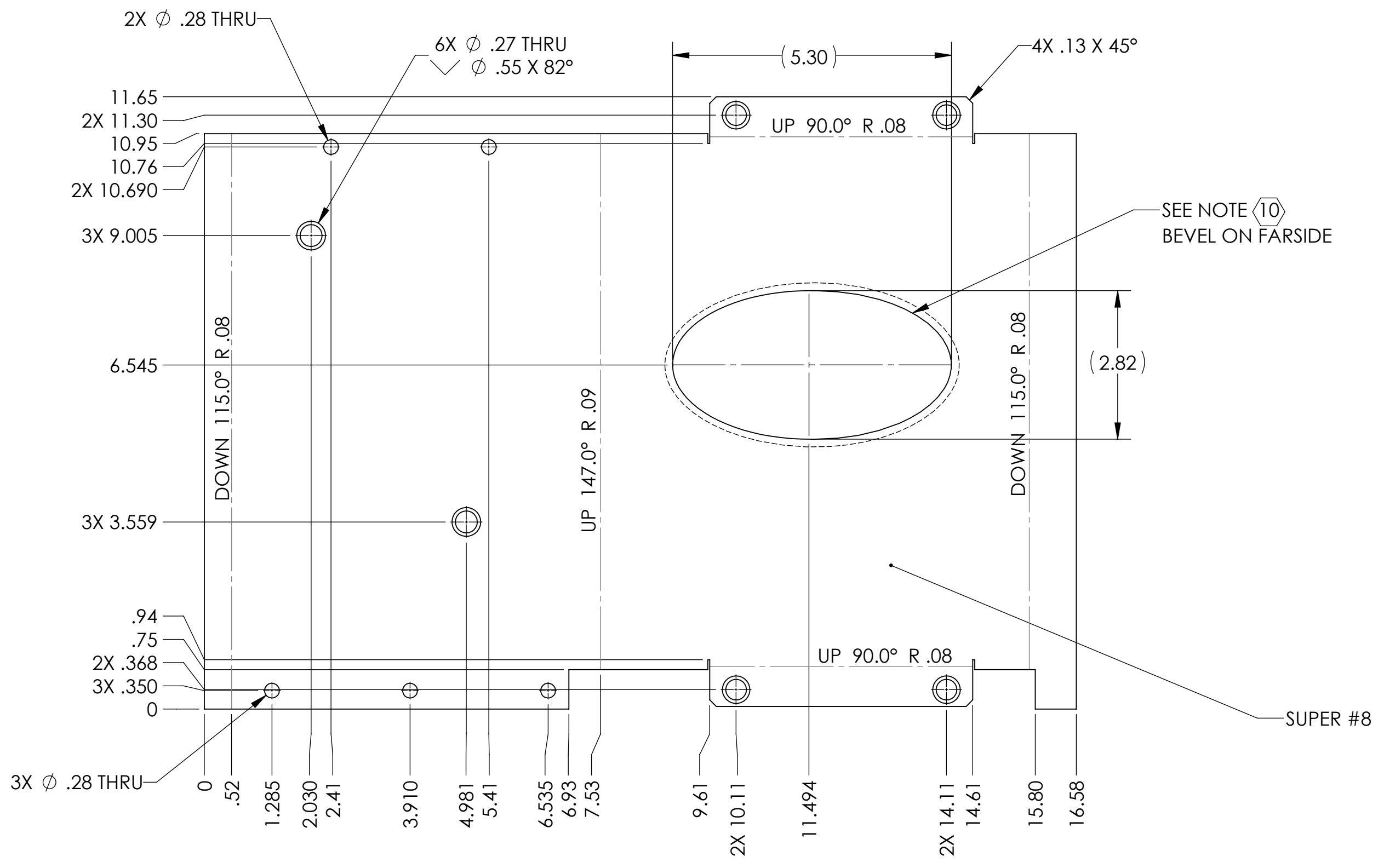
DESIGNER	M.HILLARD	16 Aug. 2011
DRAFTER	M.HILLARD	10 SETP 2011
CHECKER	L. AUSTIN	10 Sept. 2011
APPROVAL	M. SMITH	

SIZE DWG. NO. B D1101605

REV. v2

SCALE: 1:3 PROJECTION: SHEET 1 OF 2

D1101605, PART PDM REV: X-048, DRAWING PDM REV: X-040



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SIZE	DWG. NO.	REV.
B	D1101605	v2
SCALE: 1:2	PROJECTION:	SHEET 2 OF 2