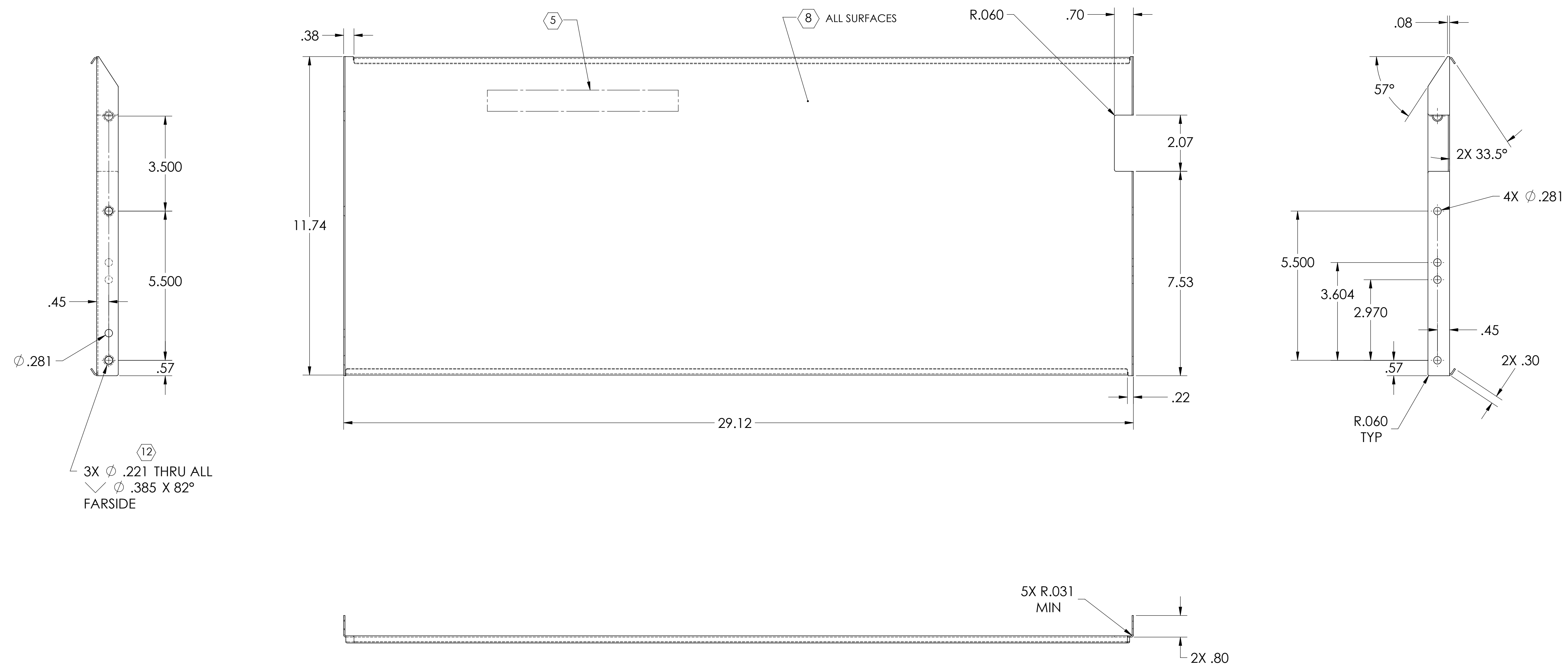


REV.	DATE	DCN #	DRAWING TREE #
v3	08 JUN 2010	E1000285	
v2	25 MAR 2011	E1100216	
v3	25 JUN 2011	E1100335	

- NOTES: UNLESS OTHERWISE SPECIFIED**
- INTERPRET DRAWING PER ASME Y14.5-1994.
  - REMOVE ALL SHARP EDGES. FULL RADIUS ON ALL EDGES AND HOLES.
  - DO NOT SCALE FROM DRAWING.
  - ALL MACHINE FLUIDS MUST BE FULLY SYNTHETIC, FULL WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE PER LIGO DOCUMENT E0900237.
  - 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
  - ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPEC E0900364.
  - ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NO WELD REPAIRS OR PLUGS) UNLESS APPROVED IN ADVANCE, IN WRITING, BY LIGO PER SPECIFICATION E0900364.
  - SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
  - PART WILL BE COMPLETELY PROCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION.
  - DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.
  - 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 MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.
  - COUNTERSUNK HOLES TO BE CLEANED OF FRIT PRIOR TO BAKING.



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES				SYSTEM		ARM CAVITY BAFFLE CTR SKIN					
TOLERANCES: .XX ± .03 .XXX ± .015				ADVANCED LIGO		SUB-SYSTEM		DESIGNER		N.Nguyen 02 Jun 2010	
ANGULAR ± 1.0°				MATERIAL		AOS		DRAFTER		TG. NGUYEN 28 MAY 2010	
				18GA Enamel Steel A424 type 1		NEXT ASSY		CHECKER		M. SMITH 10 AUG 2010	
				FINISH		D1000977		APPROVAL		D. COYNE 20 AUG 2010	
				8 9		SCALE: 1:2		PROJECTION:		SHEET 1 OF 2	
								DWG. NO.		REV.	
								D		D1000976	
								v3			

D1000976\_A03\_31C\_ARM\_Cavity\_Baffle\_Center\_Skin\_PART\_PDM\_REV\_X:007\_DRAWING\_PDM\_REV\_X:016

8

7

6

5

4

3

2

1

H

G

F

E

D

C

B

A

H

G

F

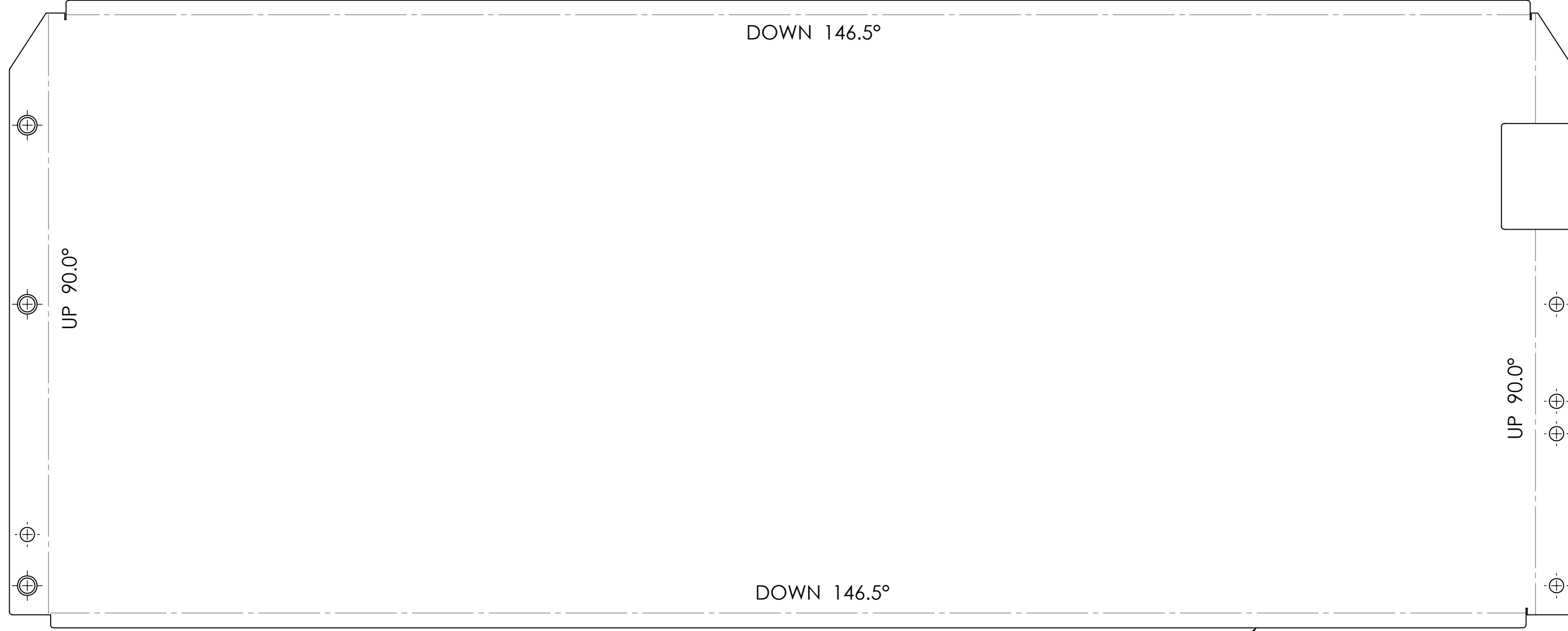
E

D

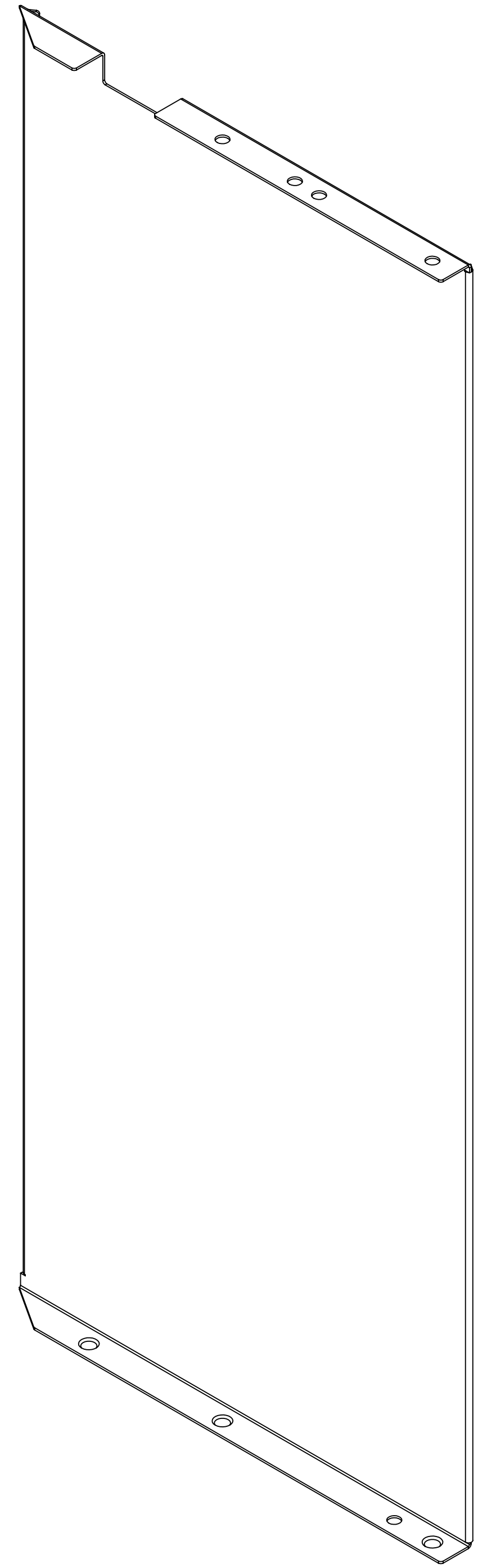
C

B

A



ALL EDGES TO BE SMOOTH AND FREE OF BURRS



<b>LIGO</b> CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		REV.
SIZE	DWG. NO.	REV.
D	D1000976	v3
SCALE: 1:2	PROJECTION:	SHEET 2 OF 2

D1000976\_AduIGO\_AOS\_SLC\_ARM\_Cavity\_Baffle\_Center\_Sin\_PART\_PDM\_REV\_X:007\_DRAWING\_PDM\_REV\_X:016