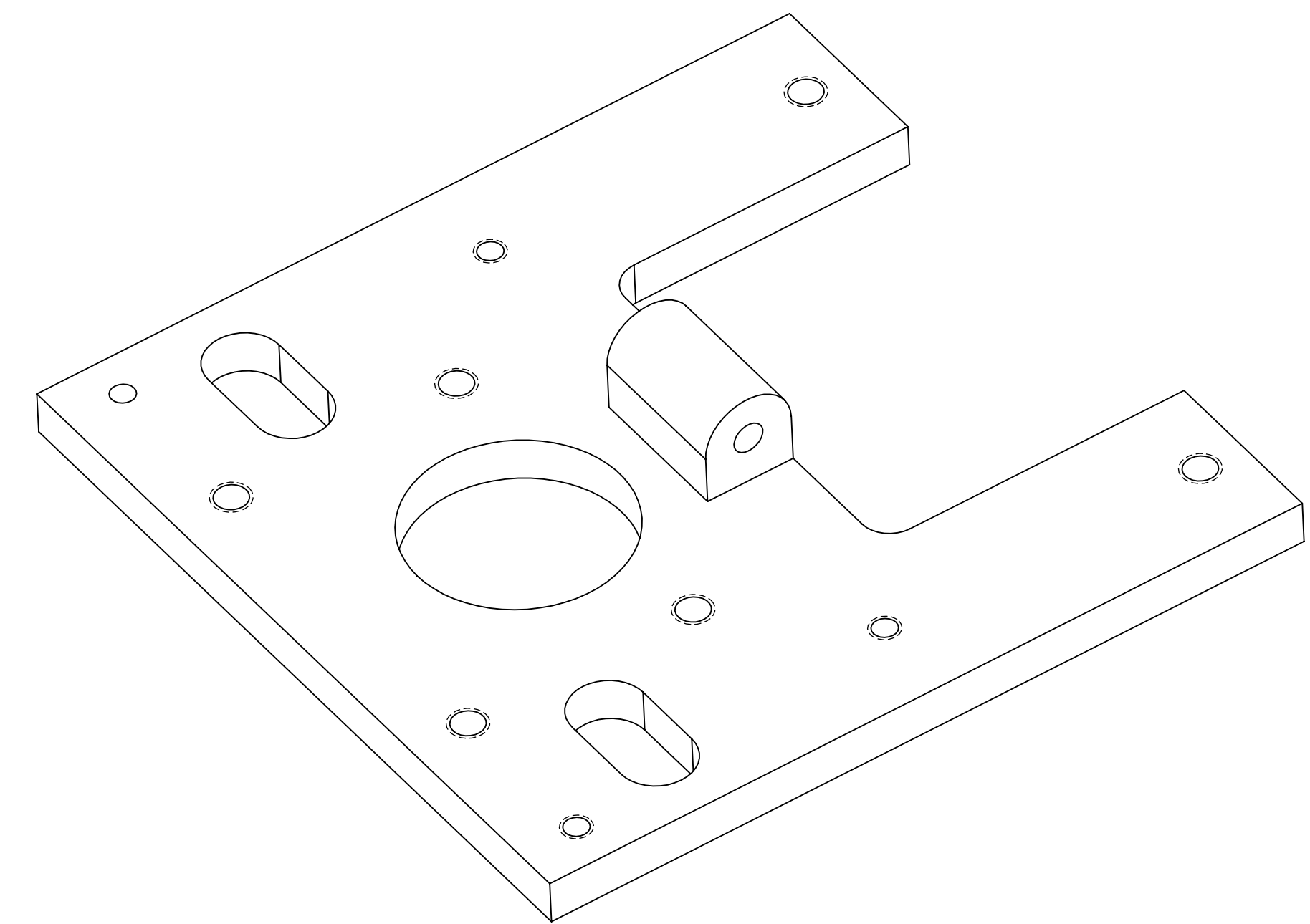
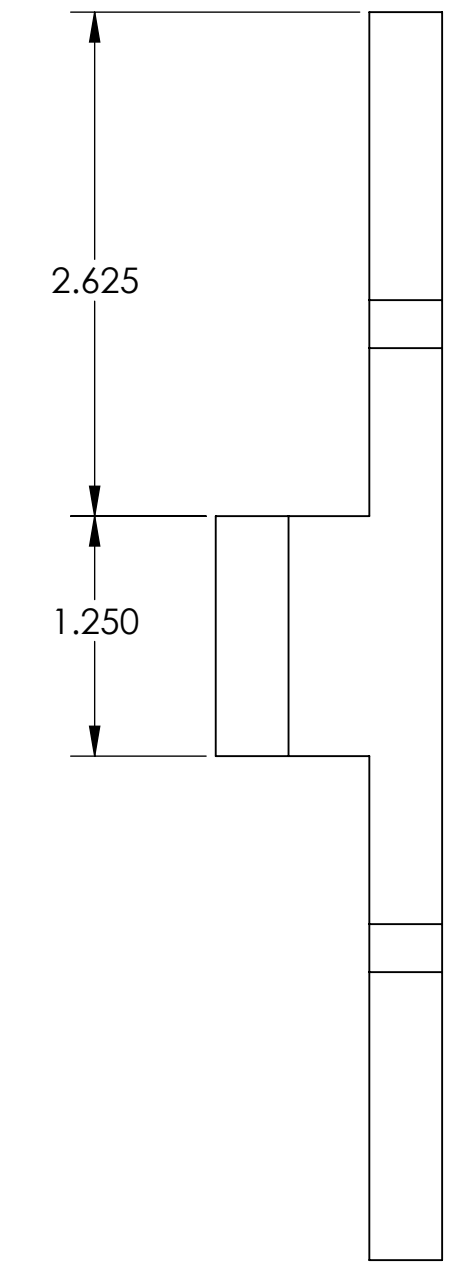
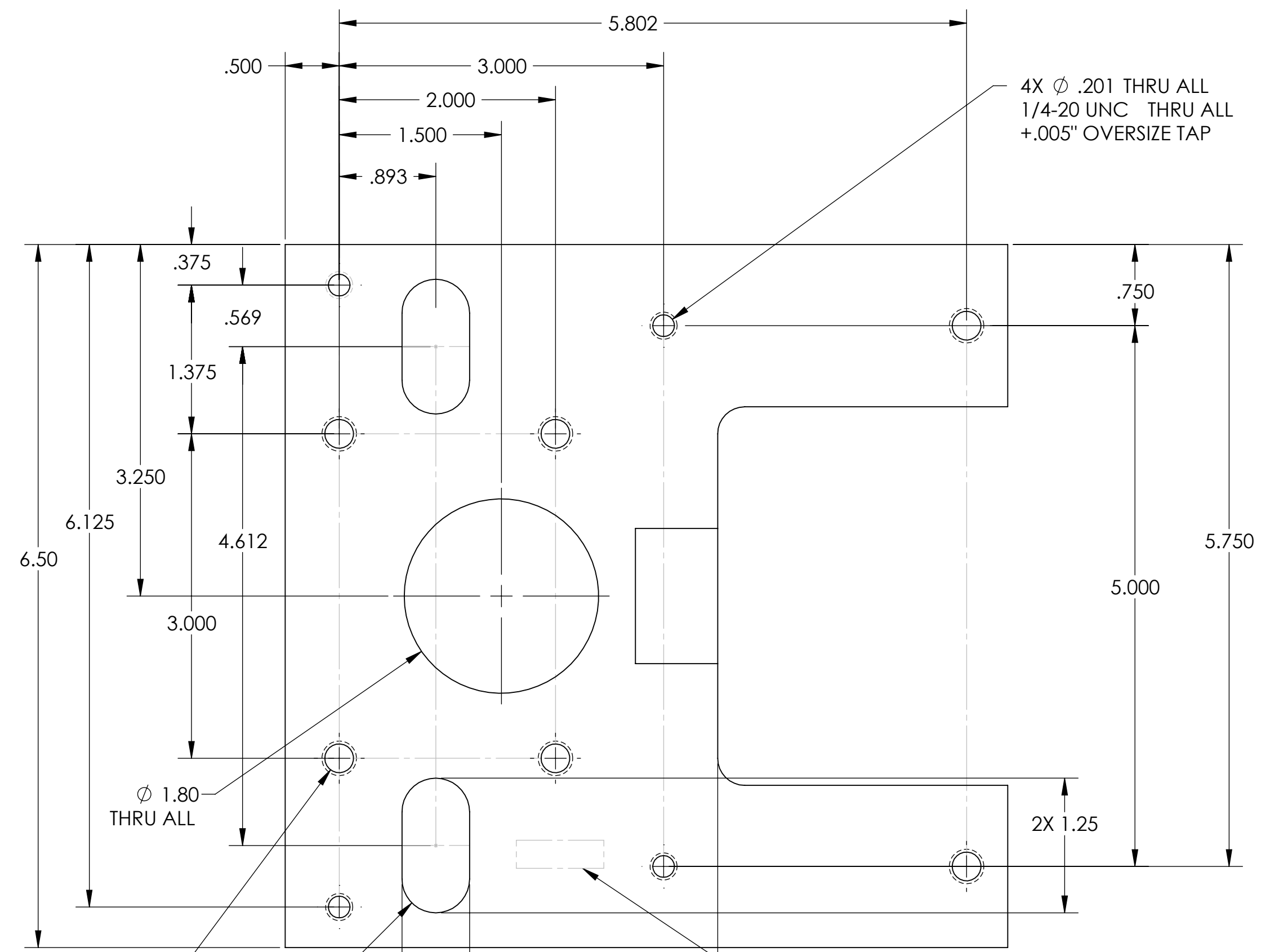


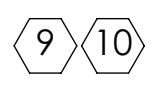
- NOTES: UNLESS OTHERWISE SPECIFIED**
1. INTERPRET DRAWING PER ASME Y14.5-1994.
 2. REMOVE ALL SHARP EDGES 0.005" TO 0.015".
 3. DO NOT SCALE FROM DRAWING.
 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. REFER TO LIGO E0900237 FOR LIST OF APPROVED COOLANTS.
 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 = 0.883 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 HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV.
 10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.
 11. 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	10 AUG 2010	E1000285	
v2	16 MAR 2011	E1100216	

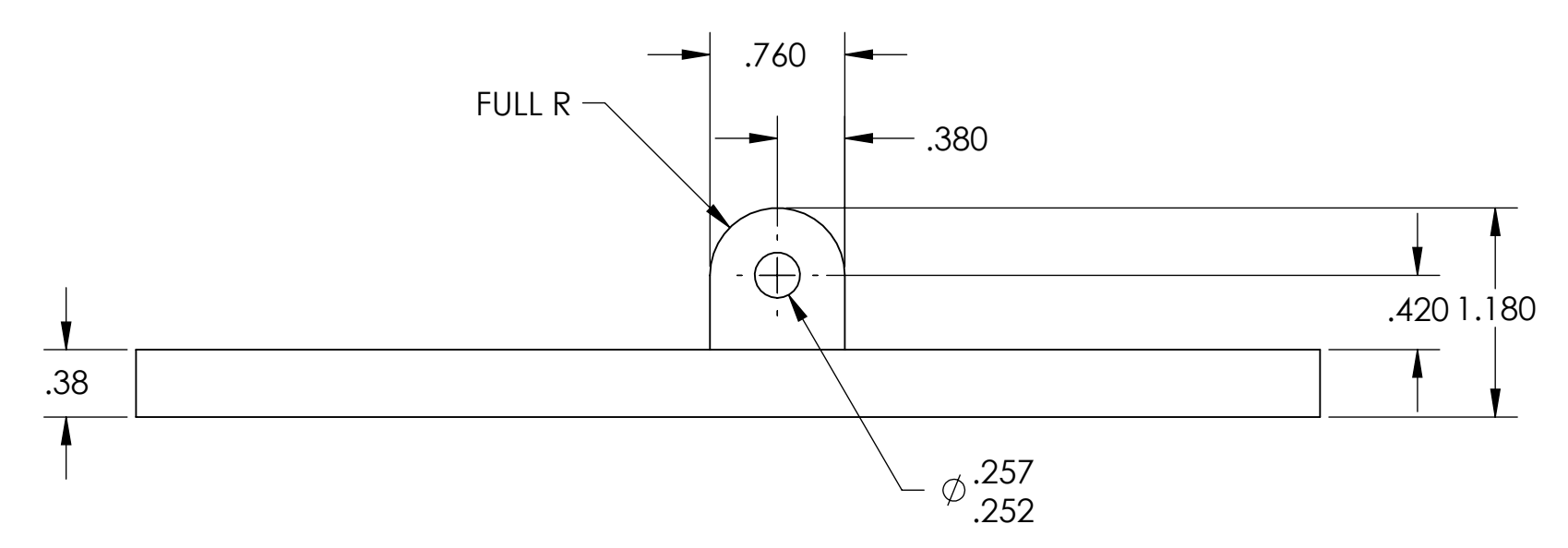


ISO VIEW

6X Ø .266 THRU ALL
TAP FOR 1/4-20 N60 HELICOIL INSERT = 1.0 * DIA.
#1185-4EN250



4X FULL R



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES
TOLERANCES:
.XX ± .01
.XXX ± .005
ANGULAR ± 0.5°

MATERIAL		FINISH		NEXT ASSY	
6061-T6 Al		63 µinch		D1002173	



PART NAME		DESIGNER		DATE		SIZE		DWG. NO.		REV.	
ARM CAVITY BAFFLE LOWER MTG HINGE		N.Nguyen		02 Jul 2010		D		D1001622		v2	
DRAFTER		CHECKER		APPROVAL		SCALE		PROJECTION		SHEET 1 OF 1	
TQ. NGUYEN		M. SMITH		D. COYNE		1:1		FIRST ANGLE		1	

D1001622_AdrLIGO_AOS_31C_ARM_Cavity_Baffle_Lower_Mounting_Hinge_PDR_PDM_REV-X-020_DRAWING_PDM_REV-X-024