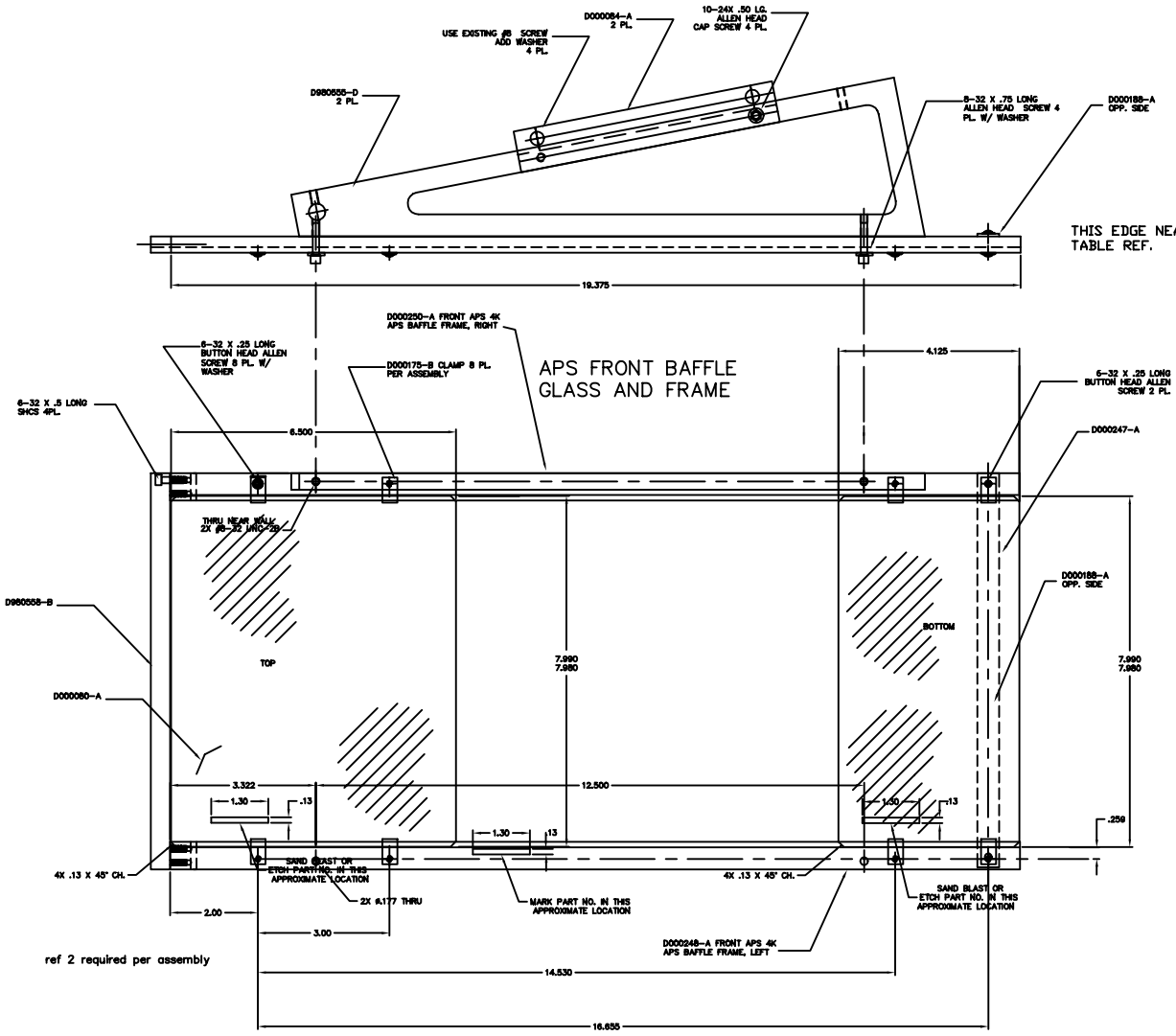
NOTES: (UNLESS OTHERWISE SPECIFIED)

~~Vacuum compatible per LIGO-C950001~~ lubricants
Liquids containing hydrocarbons or other contaminants, other than the machining fluids sprayed herein, shall not be allowed to come into contact with suspension material at any time. All machining fluids shall be water soluble and free of sulfur, chlorine and silicones such as Cincinnati Milacron's Cimtech 410 (stainless steel).

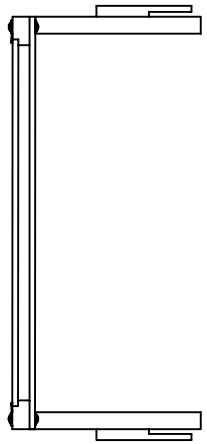
~~Vendor to mark~~
A serial number shall be etched, or scribed on the part see note drawing note.

~~Serial number format~~
The Serial number shall be of the format D99xxxx-x ~~S/N~~

Example: D990021-A-001
The drawing number. The revision number. The sequential part number



ref 2 required per assembly



APS 4K BAFFLE

SEE D000189 FOR 2K BAFFLE

REF. MAKE 1 PER ASSEMBLY

PARTS and MATERIAL LIST

REF	QTY	PART or DRWG No.	DESCRIPTION	MATERIAL

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCES:
FRACTIONAL ±1/16
ANGULAR ± .25°
~~ANGULARMACH ± BEND ±~~
TWO PLACE DECIMAL ± .01
THREE PLACE DECIMAL ± .005
FINISHED SURFACE RMS 63
BREAK CORNERS IN .015 OUT .015
REMOVE ALL BURRS

MATERIAL: ALUMINUM TOOLING PLATE
HEAT TREAT:
FINISH:

REV	DESCRIPTION	DCN NUMBER		APPR'D	CHECK	DRWN	DATE
A	NEW RELEASE	LIGO-E000390-00-D				kenm	8-2-2000
00	PRE-RELEASE		-	-	-	KENM	8-2-2000

ISSUE DESCRIPTION

DWG NO.	DESCRIPTION
REFERENCE DRAWINGS	

USED ON: XXX
NEXT ASS'Y: XXX

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

ASSEMBLY 4K
APS FRONT BAFFLE

D000246-A | SIZE E | D000246-A

SCALE 1 : 1 | SHEET 1 OF 1