

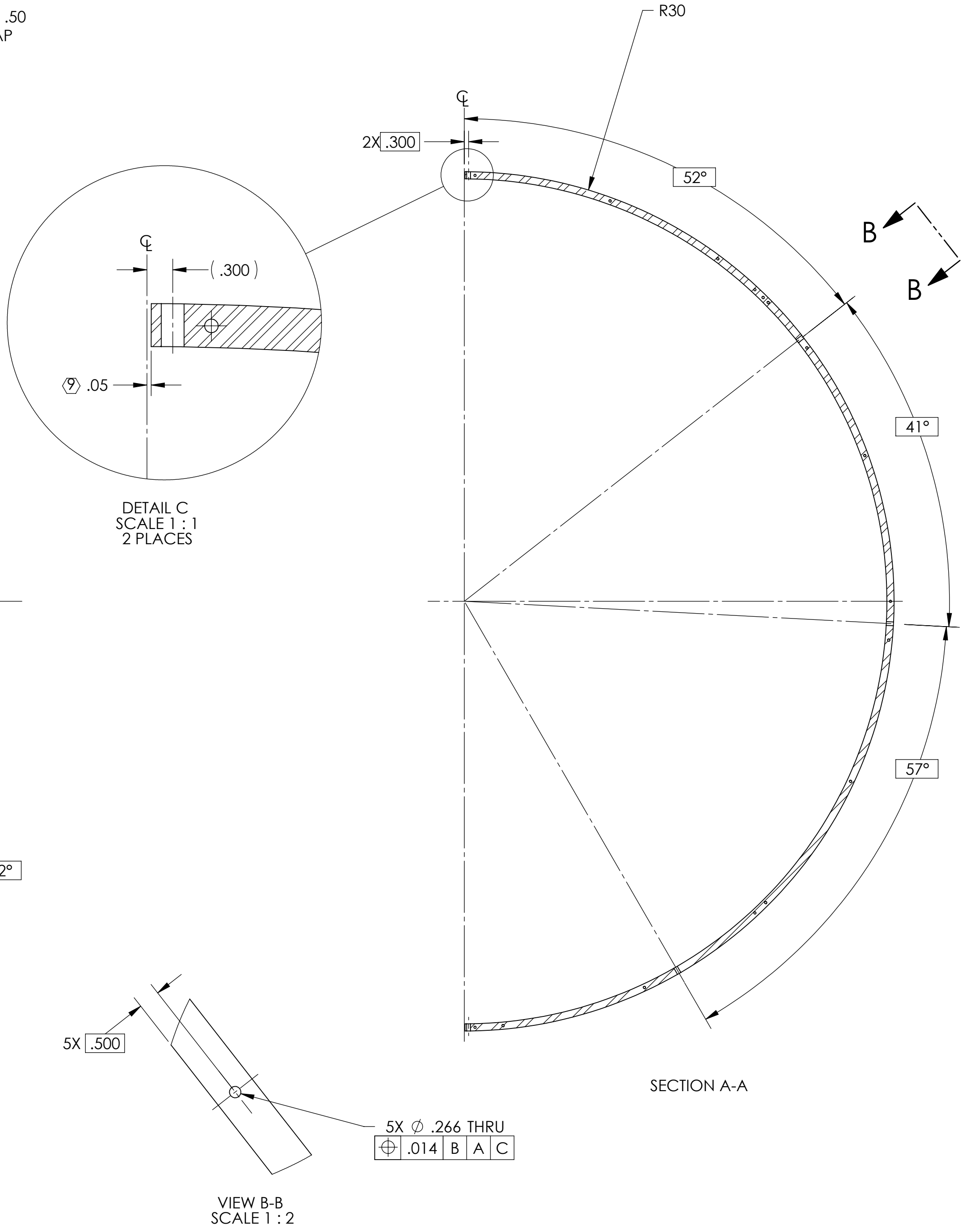
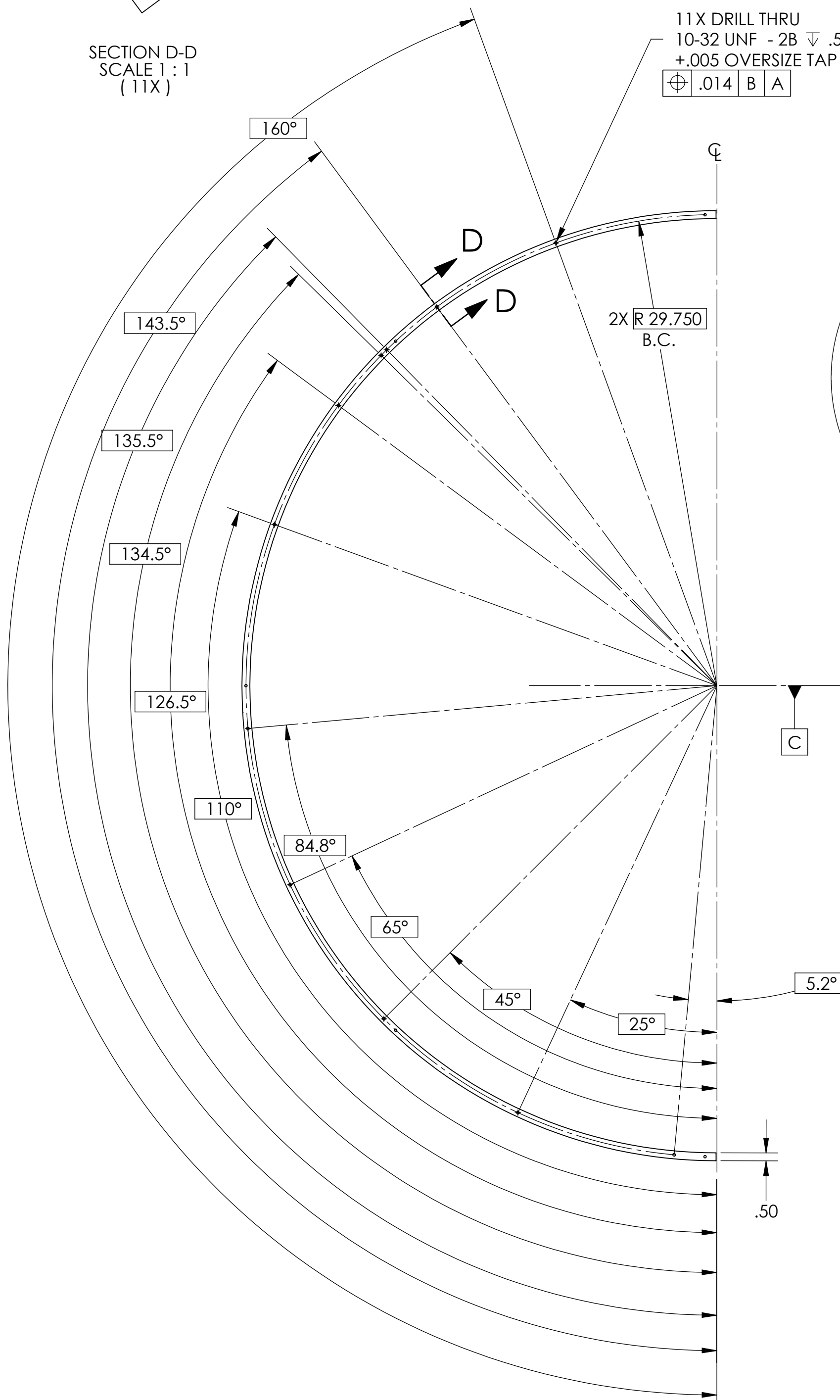
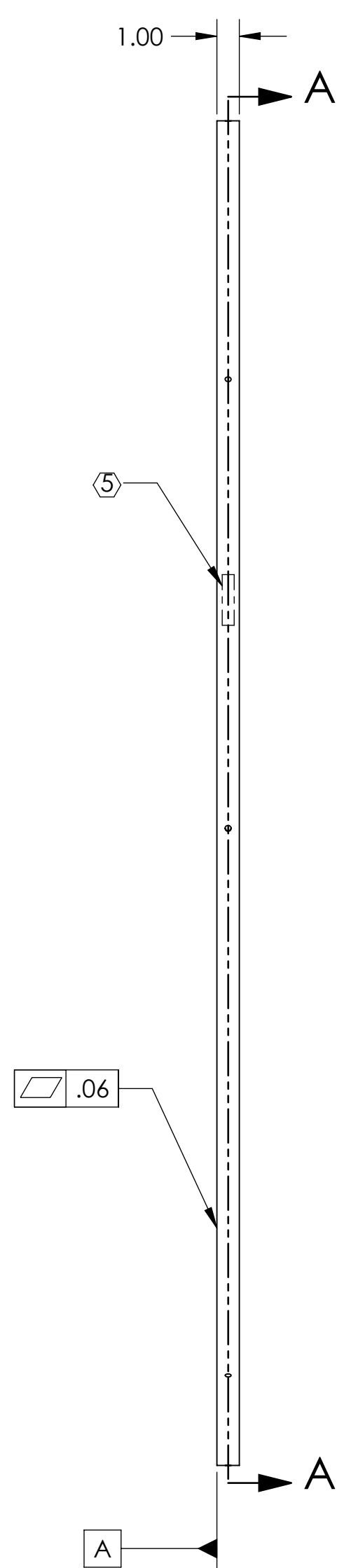
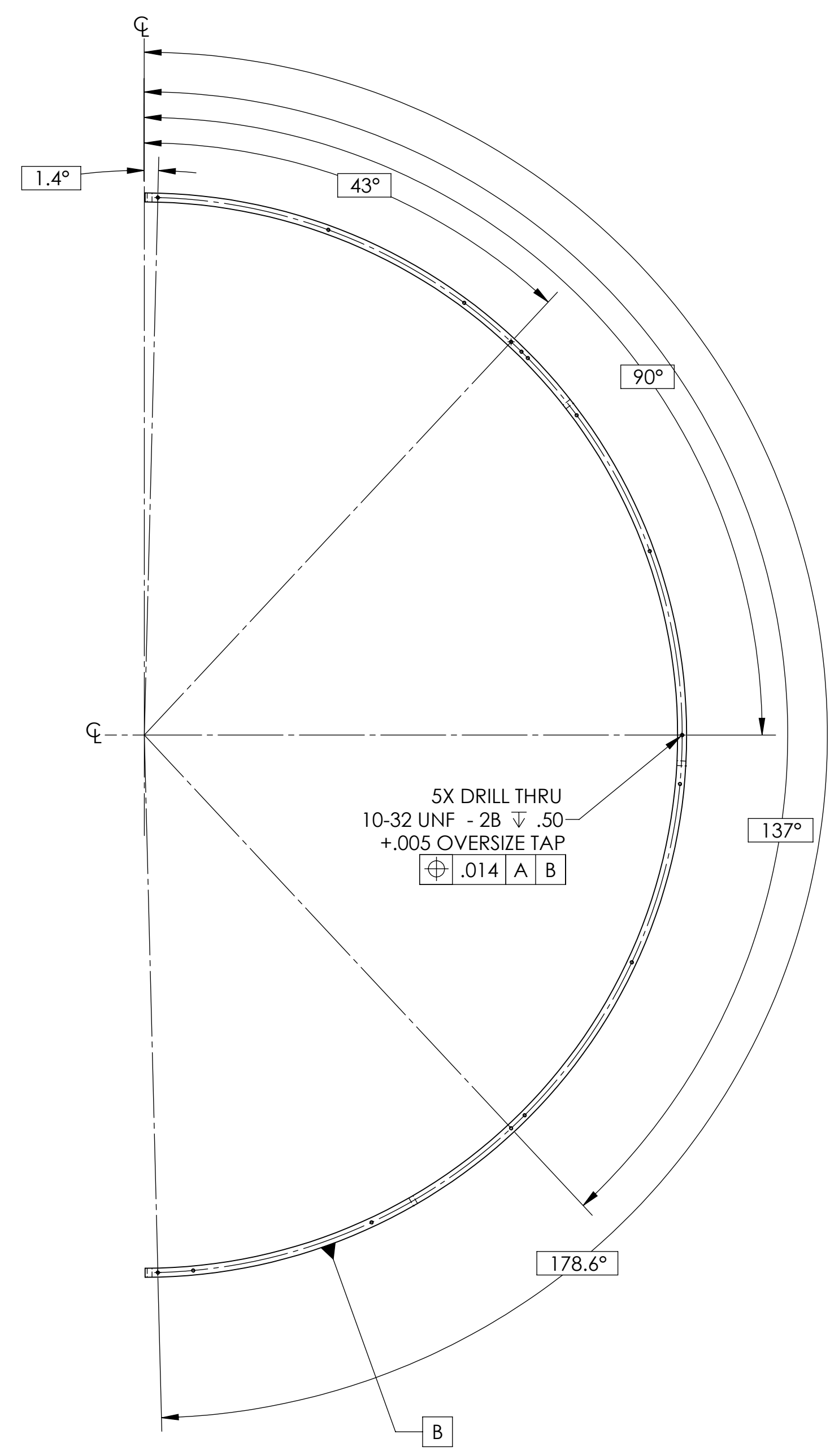
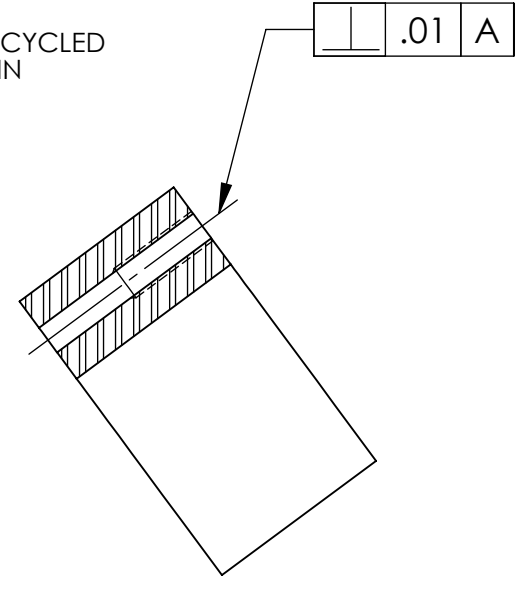
NOTES: UNLESS OTHERWISE SPECIFIED

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. ELECTRO POLISH TO REMOVE .0005-.001 PER SIDE
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.

Ⓢ PART NOT TRUE HALF CIRCLE.

REV.	DATE	DCN #	DRAWING TREE #
v1	19 MAY 2010	E1000822-v1	-
-	-	-	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
DIMENSIONS ARE IN INCHES						TUBE BAFFLE INNER RIGHT BRACE					
TOLERANCES: .XX ± .03 .XXX ± .010 ANGULAR ± 0.5°						SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS	DESIGNER TQ. NGUYEN	DATE 27 OCT 2010	SIZE D	DWG. NO. D1002868
MATERIAL 6061-T6 Al				FINISH 63 μinch		NEXT ASSY D1002864		CHECKER M. SMITH		APPROVAL D. COYNE	
						SCALE: 1:6		PROJECTION:		SHEET 1 OF 1	

D1002868.dwg, LIGO, IAC, Tube Baffle Inner Right Brace, PART PDM REV: X-026, DRAWING PDM REV: X-024