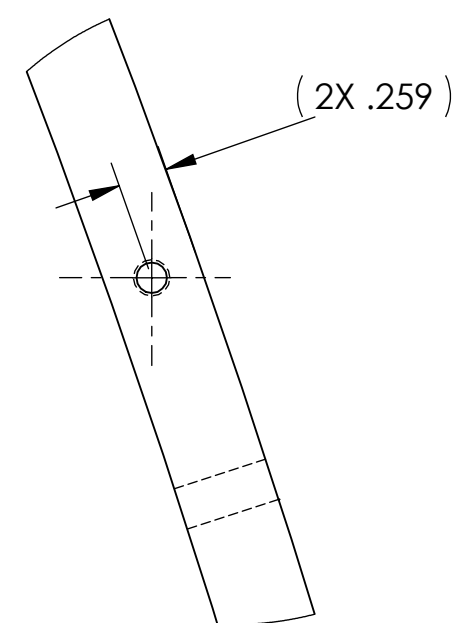


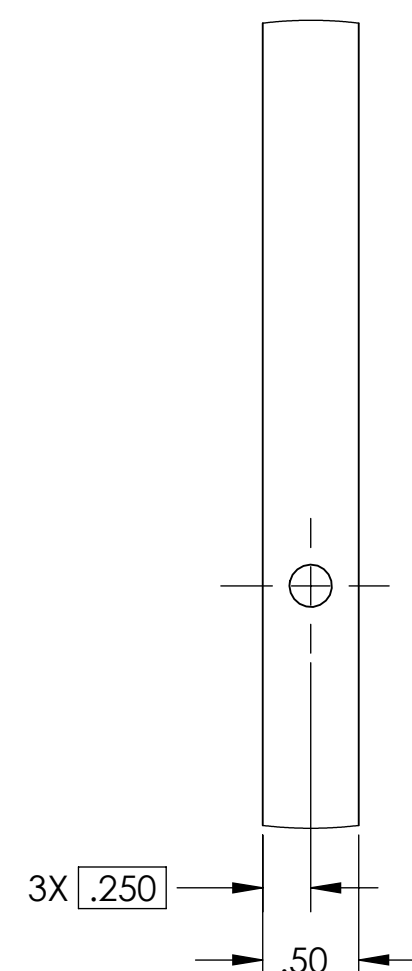
REV.	DATE	DCN #	DRAWING TREE #
v1	19 MAY 2011	E1000822-v1	-
v2	8 JUL 2011	-	-
v3	19 JUL 2011	-	-

**NOTES: UNLESS OTHERWISE SPECIFIED**

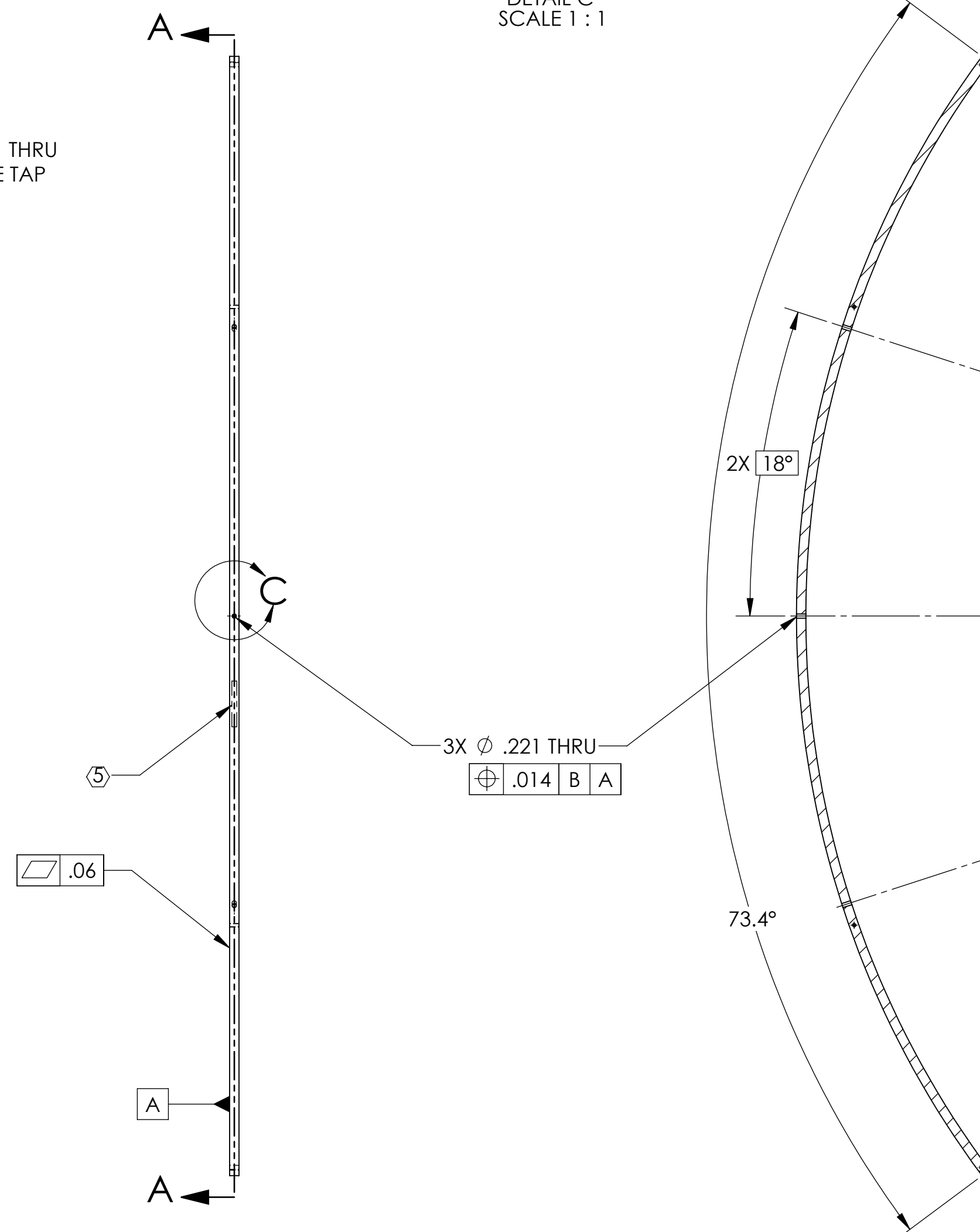
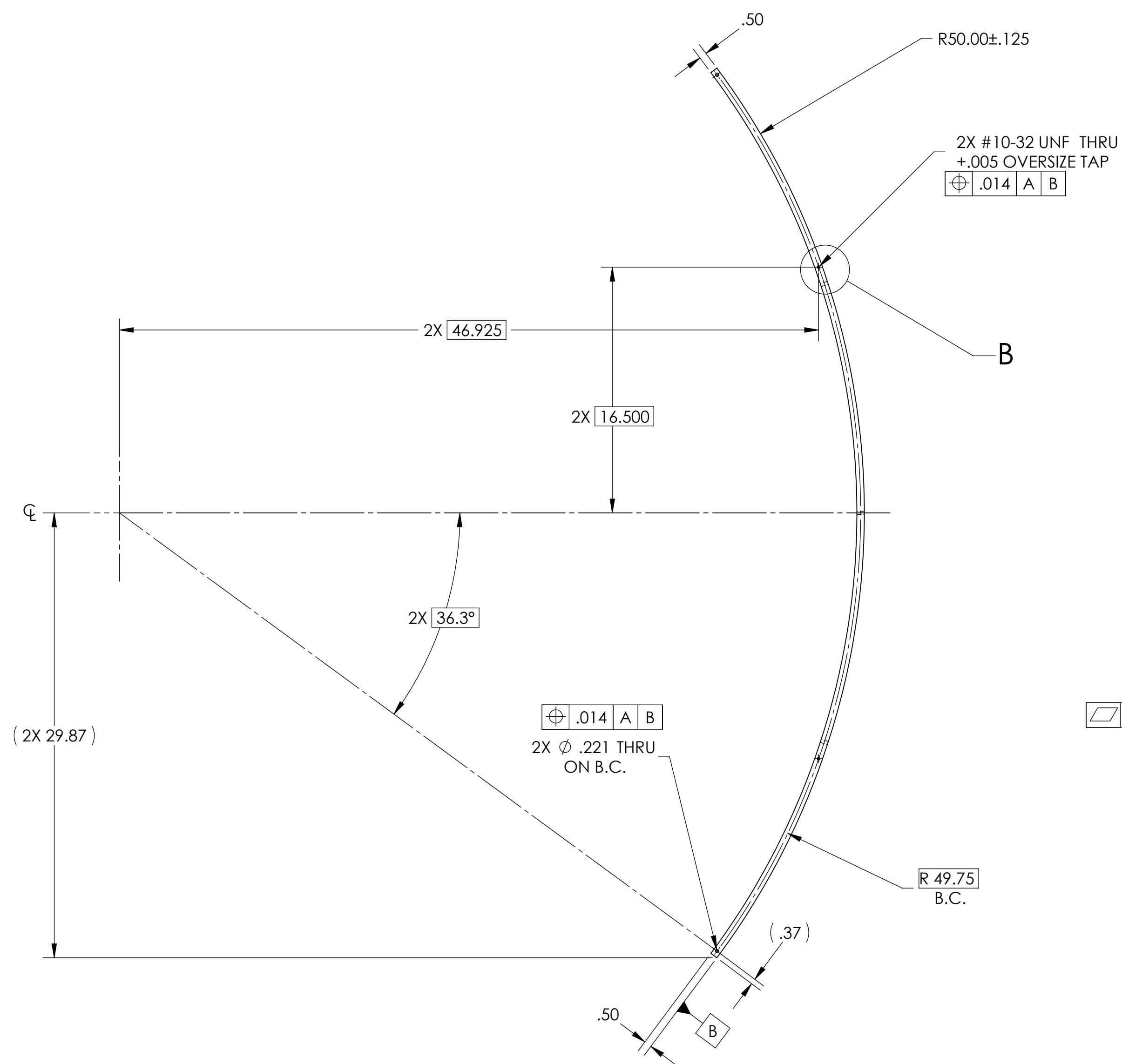
- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES.  
.030 RADIUS ON ALL EDGES AND HOLES.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. REFER TO LIGO E0900237 FOR LIST OF APPROVED COOLANTS.
- MACHINE OR STAMP DRAWING PART NUMBER, REVISION, AND SERIAL NUMBERS .020" DEPTH WITH MINIMUM .156" HIGH CHARACTERS, WHERE SHOWN.
- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER FREE FROM SCRATCHES OR GOUGES
- PART WILL BE COMPLETELY PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION.
- DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.
- 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.
- ALL HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING.



DETAIL B  
SCALE 1 : 1



DETAIL C  
SCALE 1 : 1



SECTION A-A



GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES  
TOLERANCES:  
.XX ± .03  
.XXX ± .010  
ANGULAR ± 0.5°

MATERIAL 304 SSSL

FINISH 7 8

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM AOS

NEXT ASSY D1002864

PART NAME		APERTURE SUPPORT	
DESIGNER	TQ. NGUYEN	15 NOV 2010	SIZE DWG. NO.
DRAFTER	TQ. NGUYEN	30 NOV 2010	D D1002996
CHECKER	M. SMITH		REV. v3
APPROVAL	D. COYNE		SCALE: 1:6 PROJECTION: SHEET 1 OF 1

D1002996.dwg LIGO\_MIT Tube\_Baffle\_Aperture\_Support\_WA10CB1.PART PDM REV: X013 DRAWING PDM REV: X032