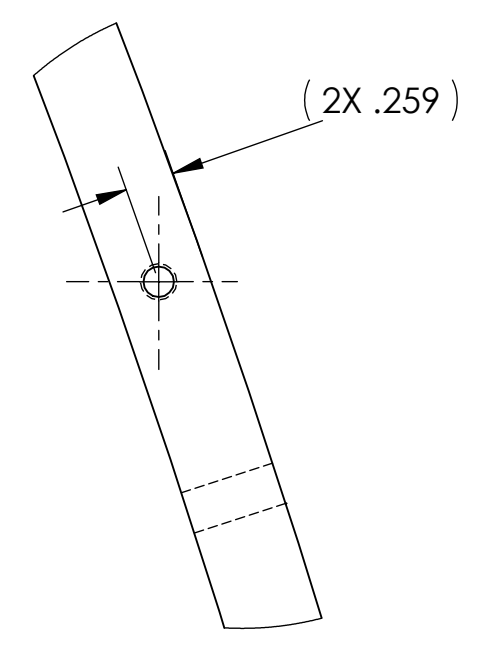


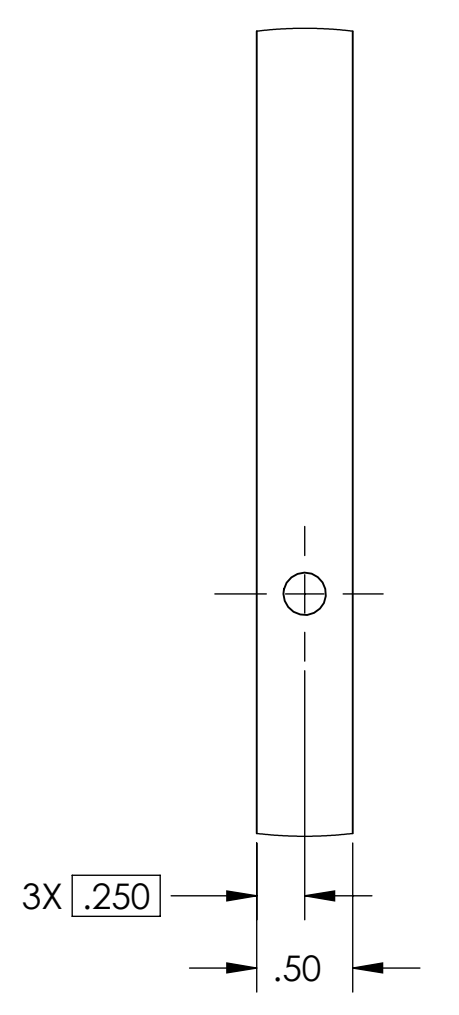
REV.	DATE	DCN #	DRAWING TREE #
v1	19 MAY 2011	E1000822-v1	-
v2	8 JUL 2011	-	-
v3	19 JUL 2011	-	-
v4	7 SEP 2011	-	-

**NOTES: UNLESS OTHERWISE SPECIFIED**

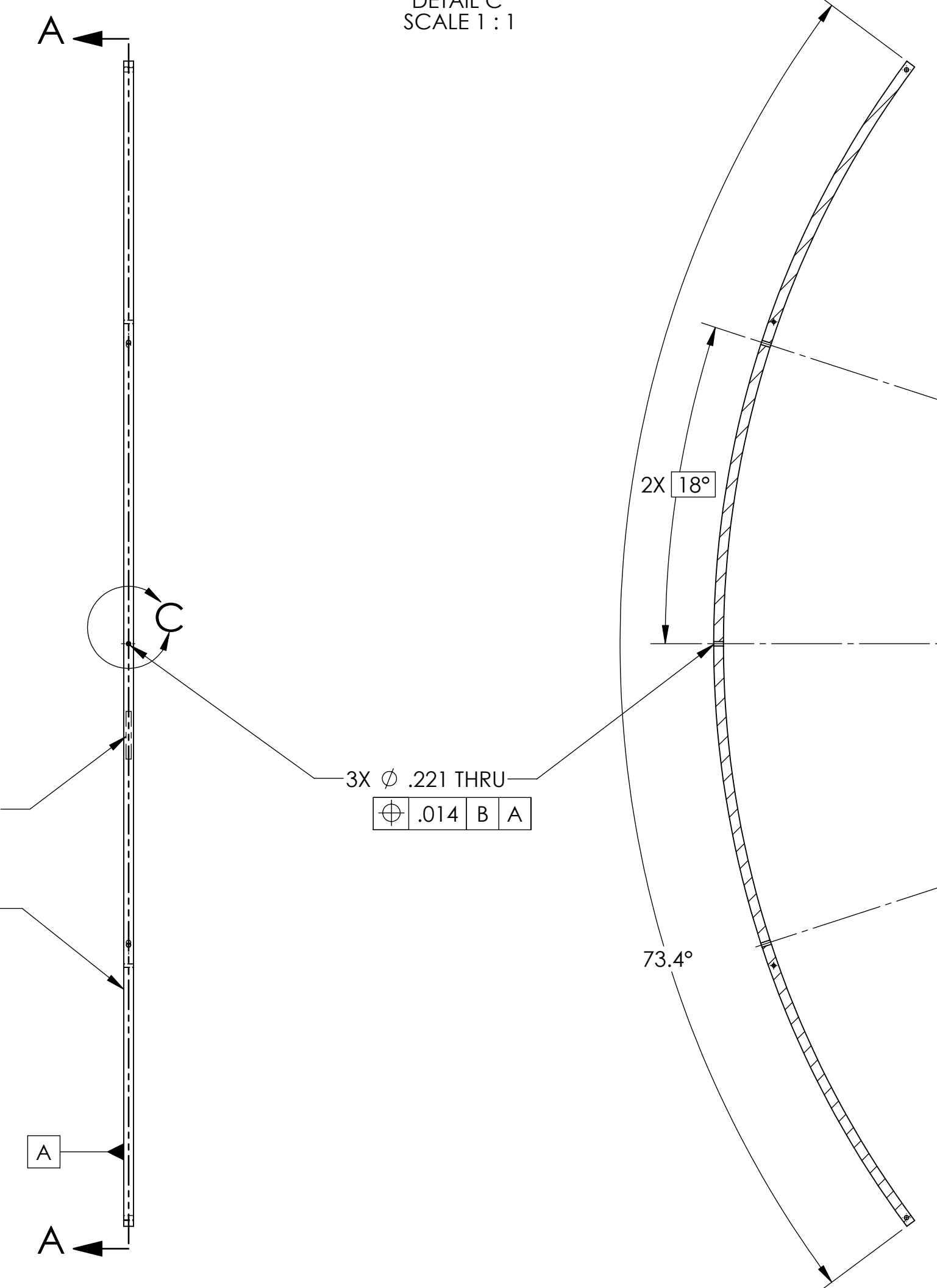
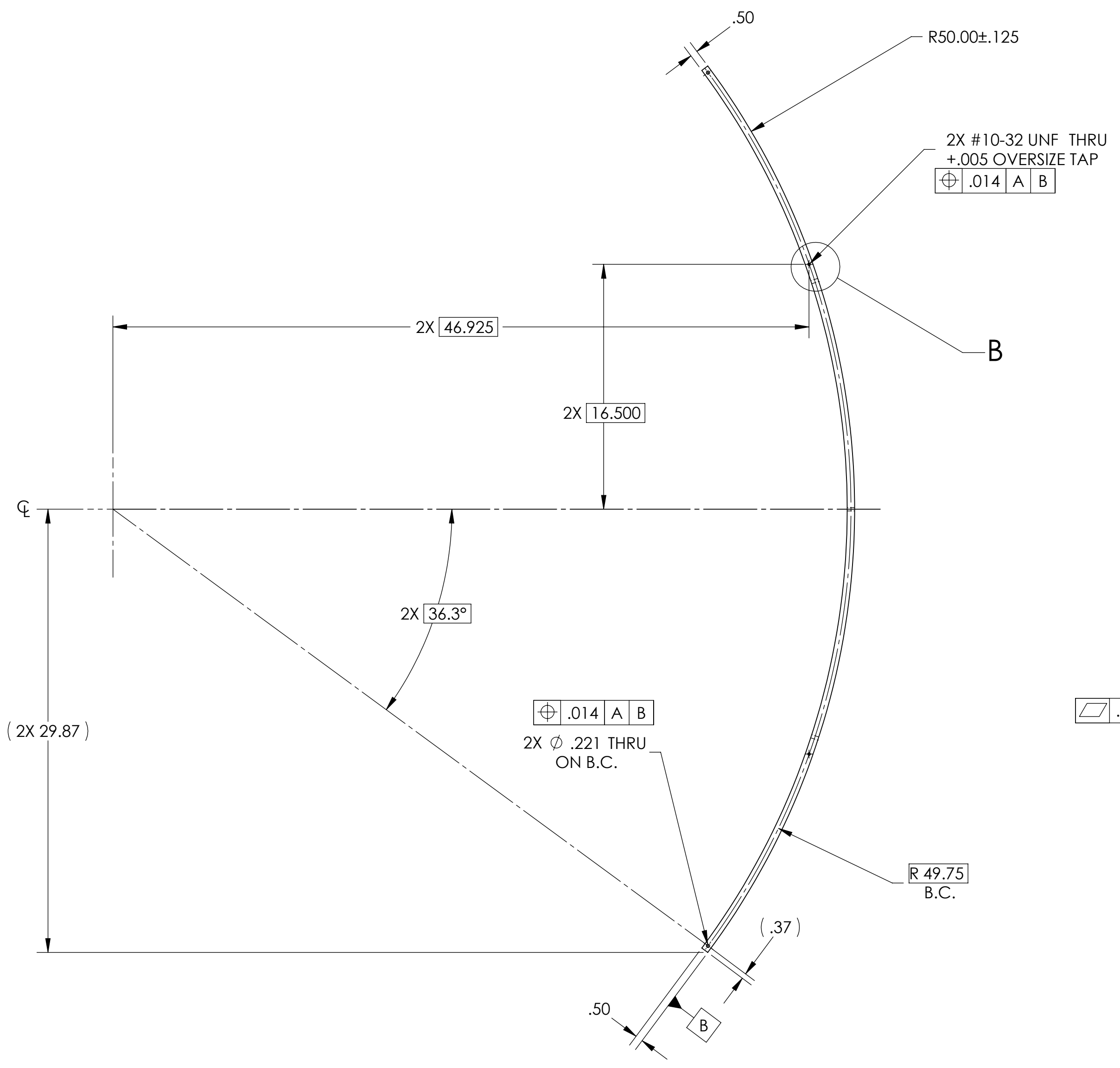
- INTERPRET DRAWING PER ASME Y14.5-1994.
- REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS.
- DO NOT SCALE FROM DRAWING.
- ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. REFER TO LIGO E0900237 FOR LIST OF APPROVED COOLANTS.
- 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
- ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
- DELETED
- 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.
- SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES AND GOUGES
- ELECTRO POLISH TO REMOVE .0005-.001" PER SIDE.



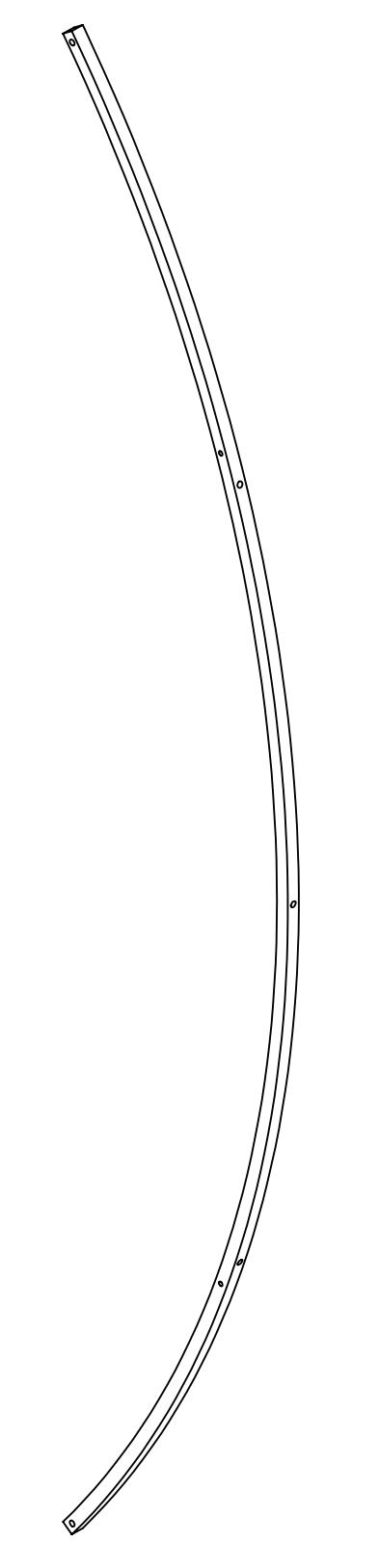
DETAIL B  
SCALE 1 : 1



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	63 μinch

**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. v4
APPROVAL	D. COYNE		SCALE: 1:6      PROJECTION:

D1002996.dwg LIGO\_MIT Tube\_Baffle\_Aperture\_Support\_LWAWC31.PART PDM REV: X014 DRAWING PDM REV: X039