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NOTES CONTINUED:

- 5. MECHANICALLY STAMP (NO INKS OR DYES) PART NUMBER, REVISION AND SERIAL NUMBER .020 DEEP WITH MINIMUM CHARACTER HEIGHT .156 APPROXIMATELY WHERE SHOWN. SERIAL NUMBER WILL START AT .001 AND PROCEED CONSECUTIVELY. EXAMPLE: D100XXXX-V1 S/N 001
- 6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPEC E0900364.
- 7. ALL MATERIAL IS TO BE VIRGIN MATERIAL (I.E. NO WELD REPAIRS OR PLUGS) UNLESS APPROVED IN ADVANCE, IN WRITING, BY LIGO PER SPECIFICATION E0900364.
- 8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES & GOUGES.
- 9. PART WILL BE PORCELAIN COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION. THE INDICATED HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING TO APPROXIMATELY 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF HOLE.
- 10. DIMENSIONS APPLY BEFORE PORCELAIN COATING UNLESS SPECIFIED.
- 11. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING. IN PARTICULAR IF SHEET METAL IS TO BE PORCELAIN COATED, THE BEND RADIUS SHALL BE A MINIMUM OF .12" OUTSIDE RADIUS OF BEND UNLESS OTHERWISE NOTED.

REV.	DATE	DCN #	DRAWING TREE #
v1	20 DEC 2010	E1000865	-
-	-	-	-
-	-	-	-

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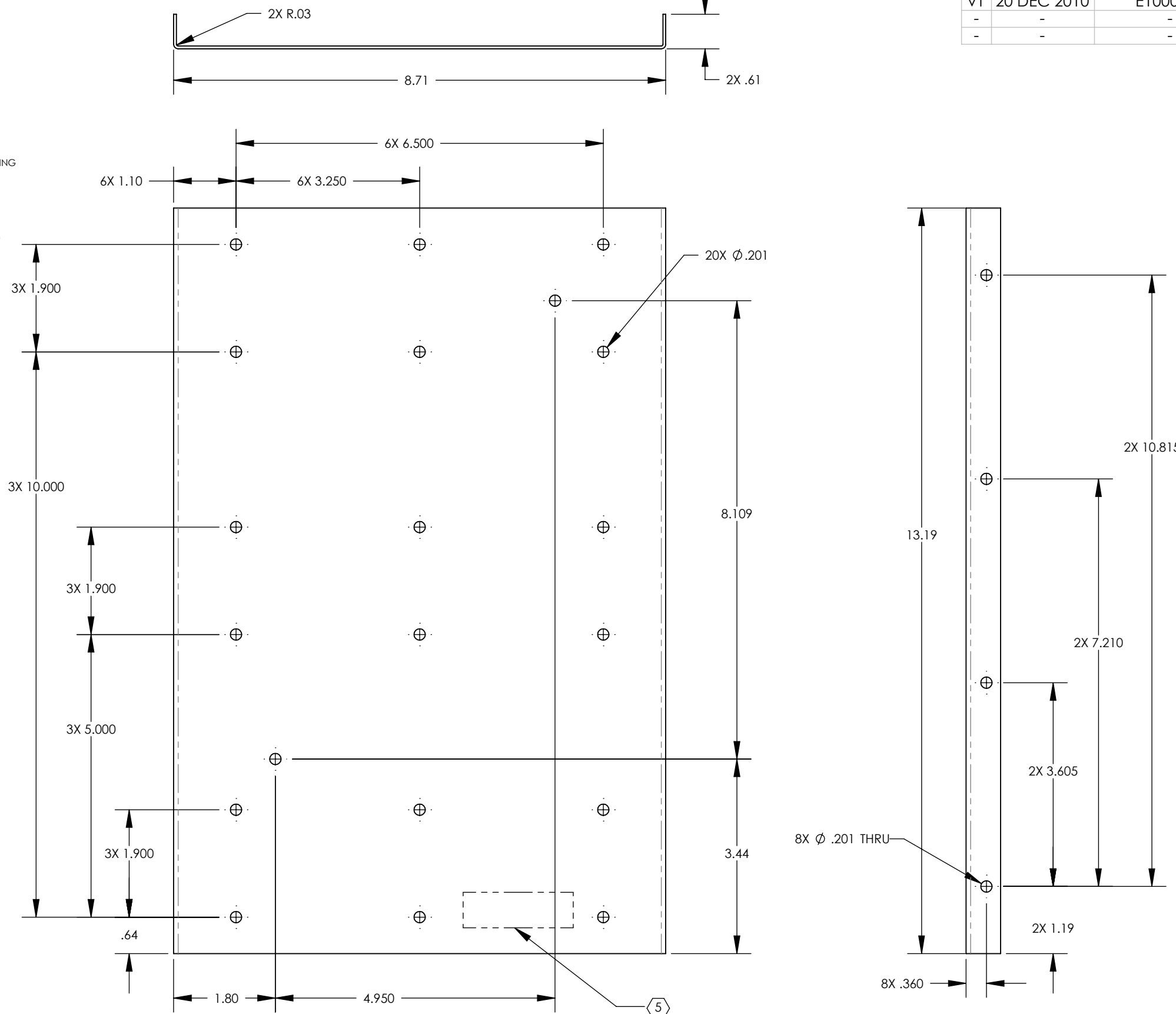
C

B

B

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A



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .02 .XXX ± .010	
ANGULAR ± 0.5°	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES AND BURRS AND ROUND EDGES APPROXIMATELY R.02. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE AND CHLORINE PER LIGO DOCUMENT E0900237.	
MATERIAL A424 TYPE I, 18GA, SSTL	FINISH SEE NOTE 7

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME SR2 Scraper Baffle Cap Skin	
SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS	DESIGNER DRAFTER CHECKER APPROVAL	N. KILPATRICK 20 DEC 2010 SIZE DWG. NO. B D1003302 SCALE: 1:2 PROJECTION:
NEXT ASSY D1003300	REV. v1	SHEET 1 OF 1	

D1003302_AdlIGO_AOS_SR2 Scraper Baffle Cap Skin, PART PDM REV: X-003, DRAWING PDM REV: X-015

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