

D1100365 AdLIGO AOS Spacer, Scraper Baffle (47.1 mm), PART PDM REV: X-008, DRAWING PDM REV: X-012

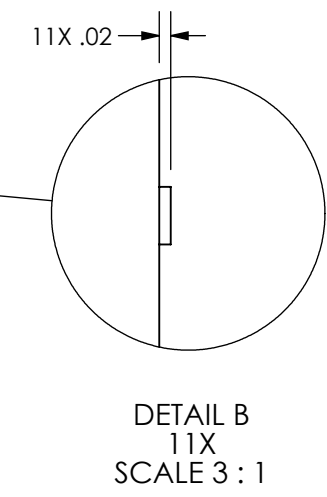
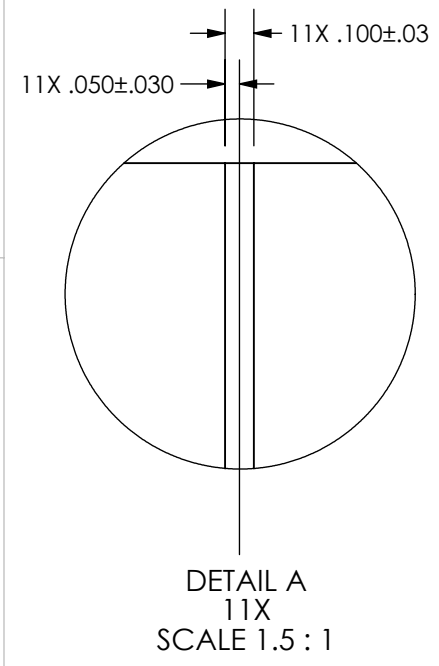
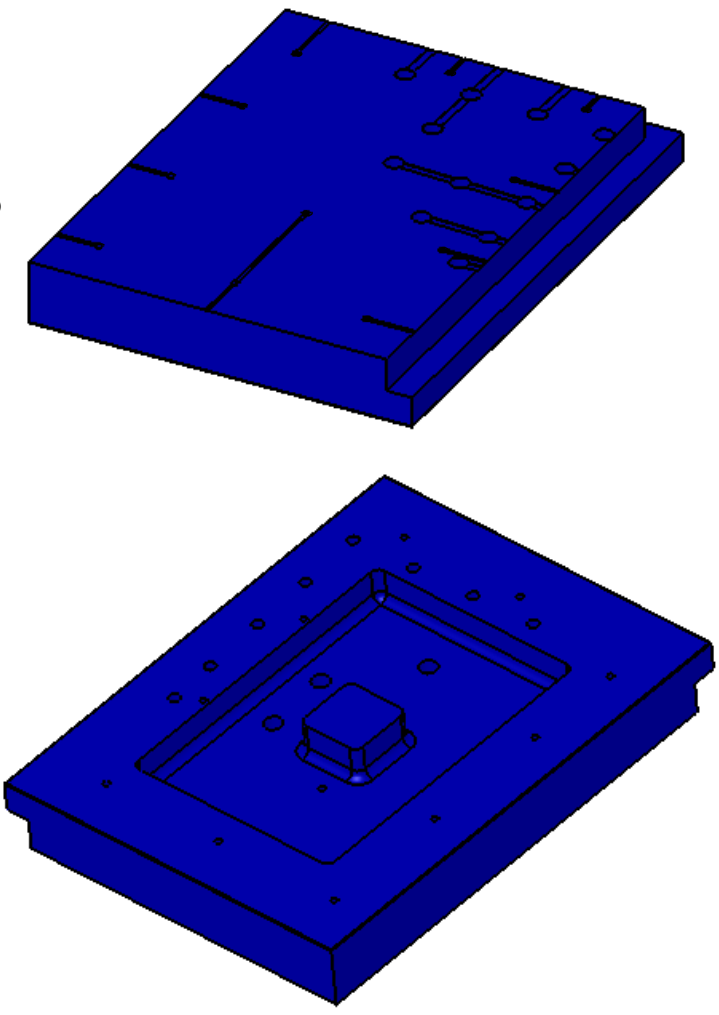
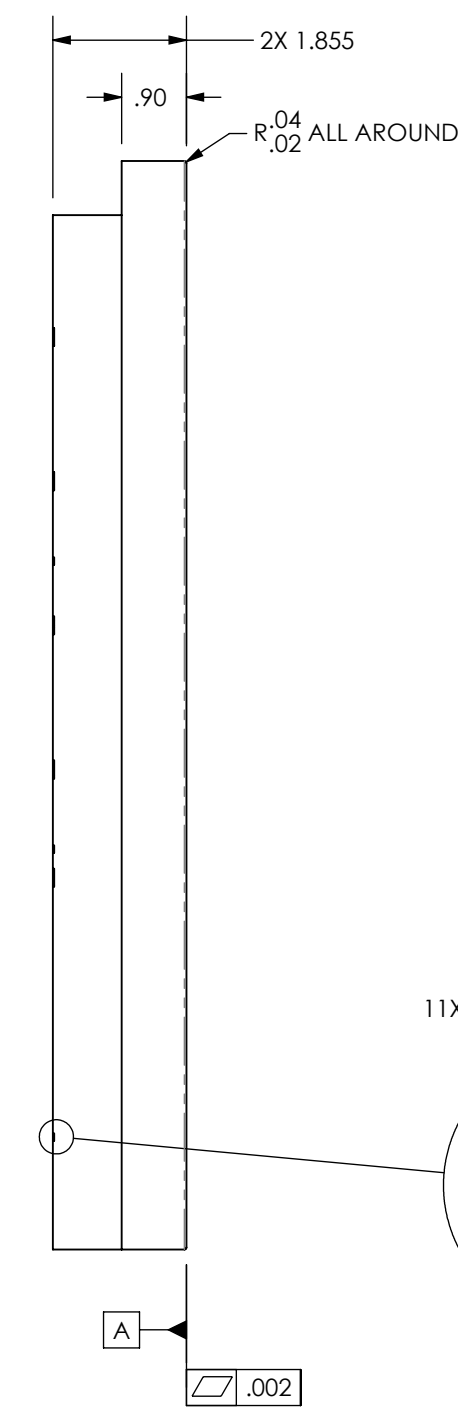
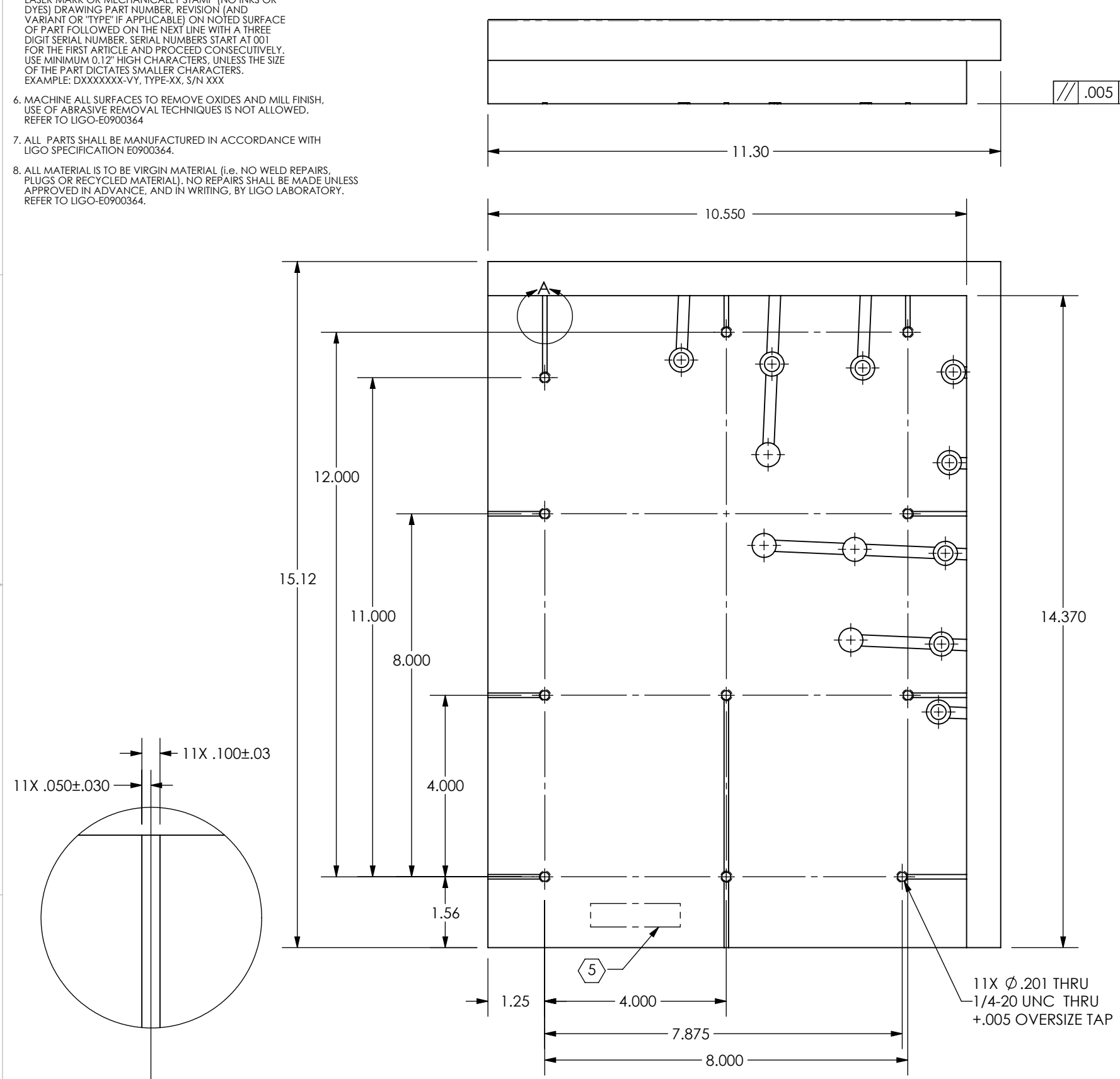
NOTES CONTINUED:
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 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. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
 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.

REV.	DATE	DCN #	DRAWING TREE #
v1	15 DEC 2011	E1000865	-
-	-	-	-
-	-	-	-

D
C
B
A

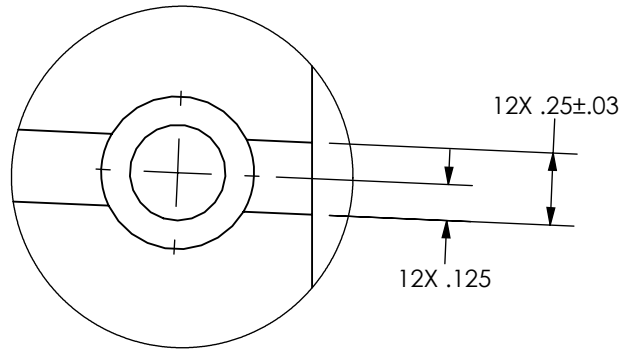
D
C
B
A



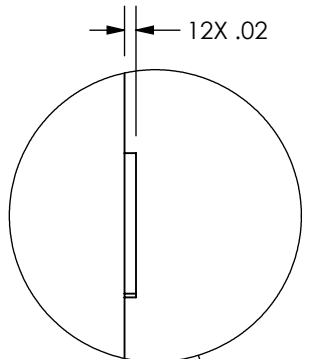
DIMENSIONS ARE IN		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .XX ± .01 .XXX ± .005		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO		SPACE, SCRAPER BAFFLE (47.1 mm)	
ANGULAR ± 1.0°		MATERIAL 6061-T6 Al		SYSTEM Advance LIGO		DESIGNER J. TERRAZAS	
		FINISH 63 μinch		SUB-SYSTEM AOS		DRAFTER	
				NEXT ASSY D1003349		CHECKER	
						APPROVAL	
						SIZE DWG. NO. B D1100365	
						REV. v1	
						SCALE: 1:4 PROJECTION: SHEET 1 OF 2	

8 7 6 5 4 3 2 1

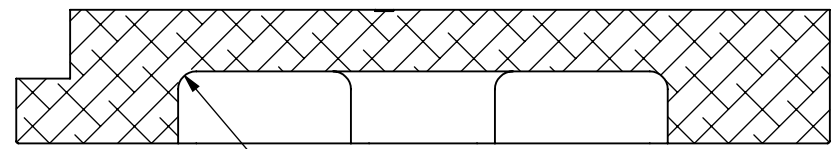
D1100365 AdLIGO AOS Spacer, Scraper Baffle (47.1 mm), PART PDM REV: X-008, DRAWING PDM REV: X-012



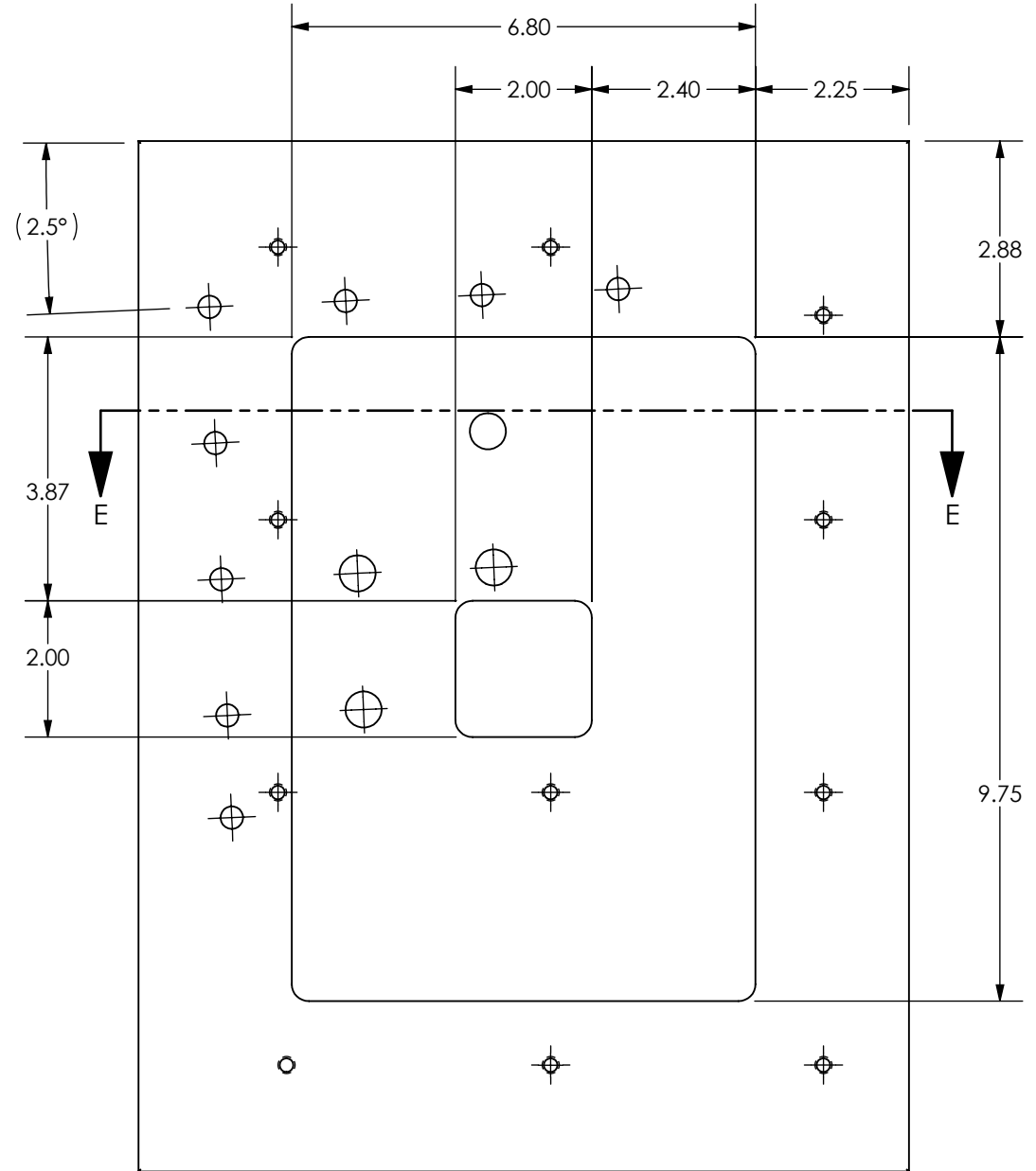
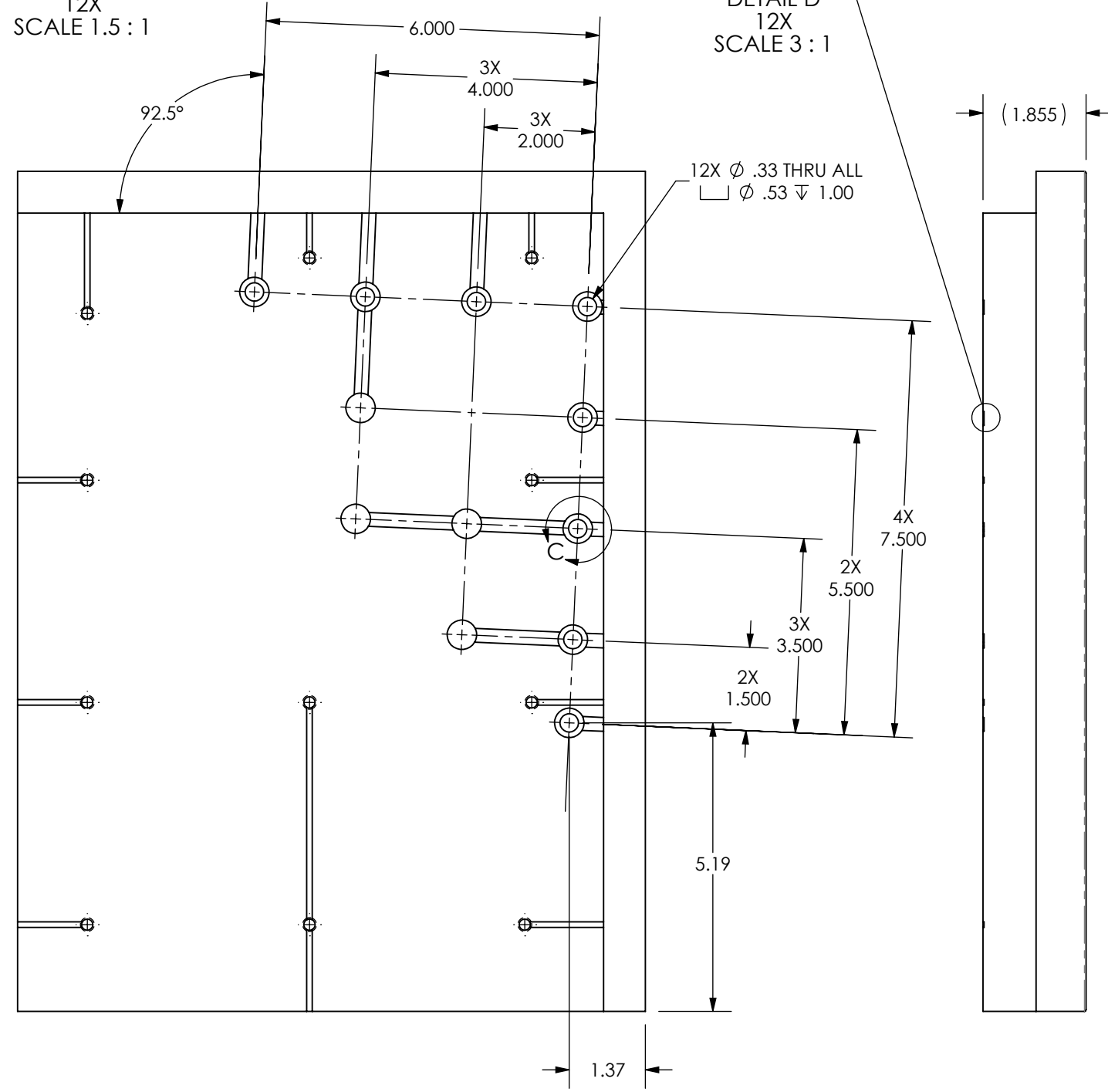
DETAIL C
12X
SCALE 1.5 : 1



DETAIL D
12X
SCALE 3 : 1



SECTION E-E
SCALE 3 : 8



LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SIZE	DWG. NO.	REV.
B	D1100365	v1
SCALE: 1:4	PROJECTION:	SHEET 2 OF 2