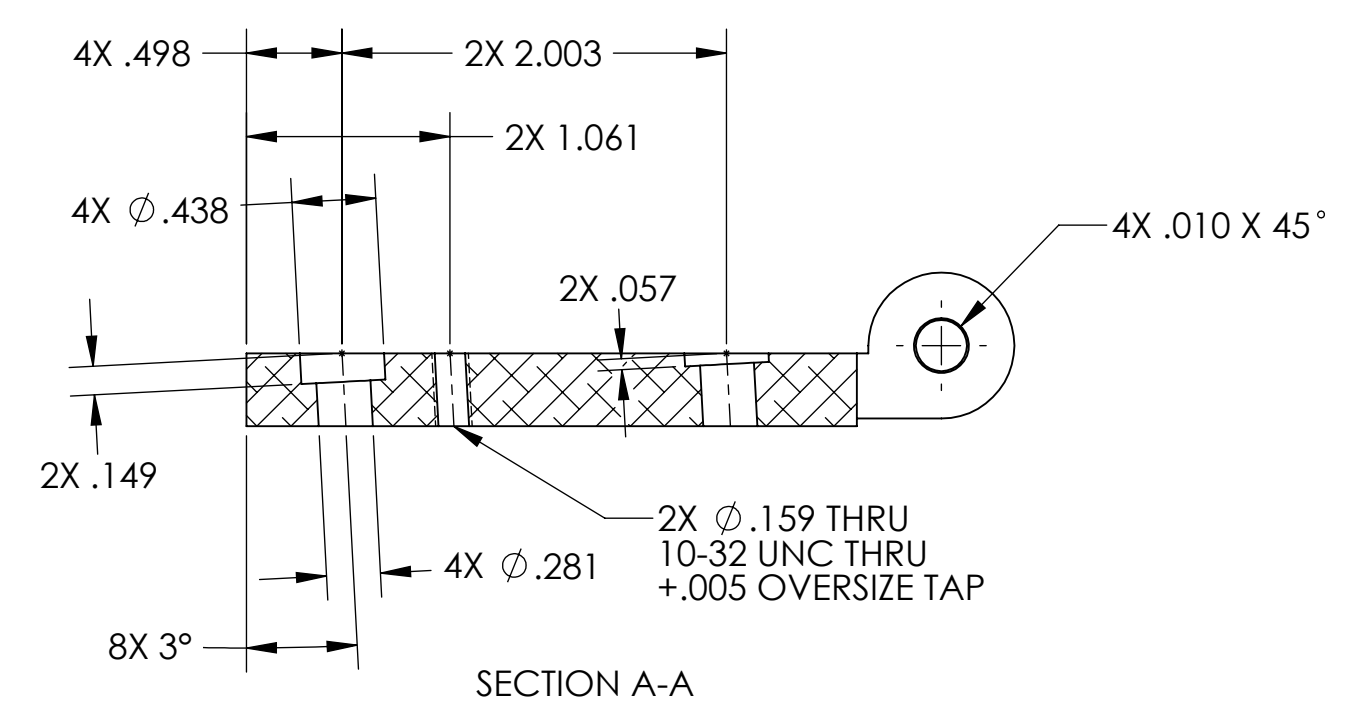
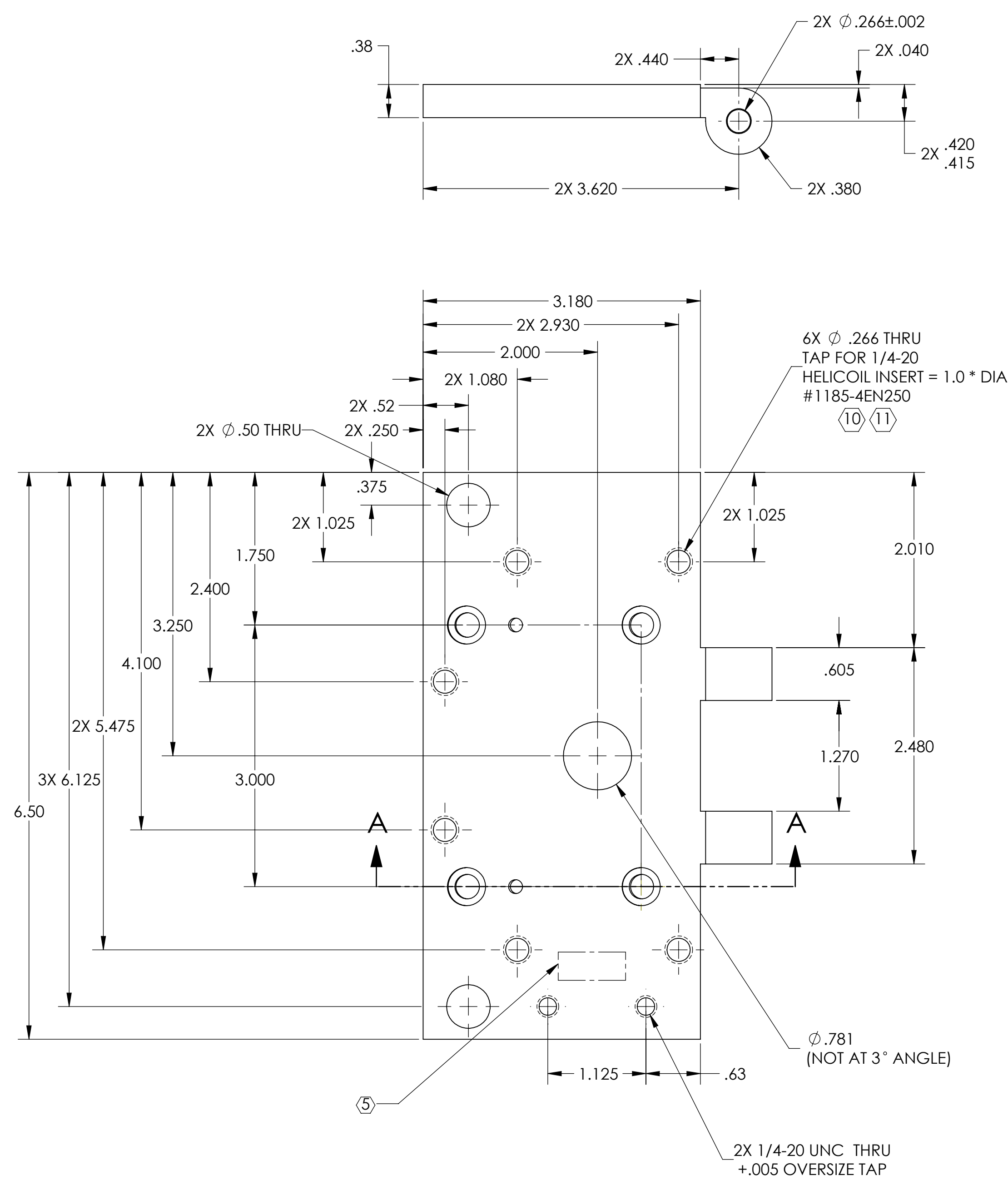
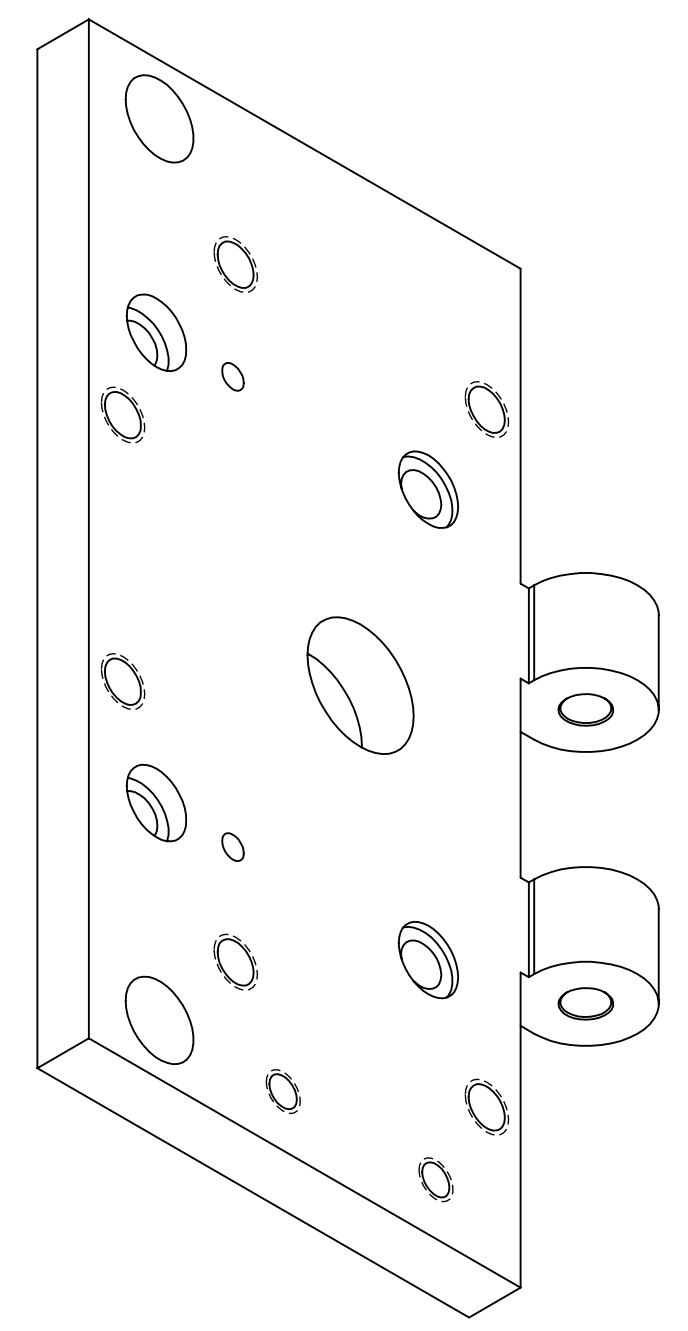


- NOTES: UNLESS OTHERWISE SPECIFIED**
- INTERPRET DRAWING PER ASME Y14.5-1994.
 - REMOVE ALL SHARP EDGES 0.005" TO 0.015".
 - DO NOT SCALE FROM DRAWING.
 - ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. REFER TO LIGO E0900237 FOR LIST OF 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
 - APPROXIMATE WEIGHT = 0.784 LB.
 - MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364.
 - ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
 - 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 HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
 - ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.



REV.	DATE	DCN #	DRAWING TREE #
v1	10 AUG 2010	E1000285	-
v2	07 APR 2011	E1100216	-
v3	08 JUL 2011	E1100335	-
v4	10 NOV 2011	E1100335	-
v5	5 JUL 2012	E1100335	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME										
DIMENSIONS ARE IN INCHES		SEE TOP LEFT FOR NOTES		SYSTEM		SUB-SYSTEM		ARM CAVITY BAFFLE UPPER MOUNTING HINGE								
TOLERANCES: .XX ± .01 .XXX ± .005		MATERIAL		NEXT ASSY		ADVANCED LIGO		AOS		DESIGNER	N.Nguyen	12 AUG 2010	SIZE	DWG. NO.	REV.	
ANGULAR ± 0.5°		6061-T6 Al		63 μinch		D1002173				CHECKER	M. SMITH	10 NOV 2010	D		D1001621	v5
										APPROVAL	D. COYNE	20 NOV 2010	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1	