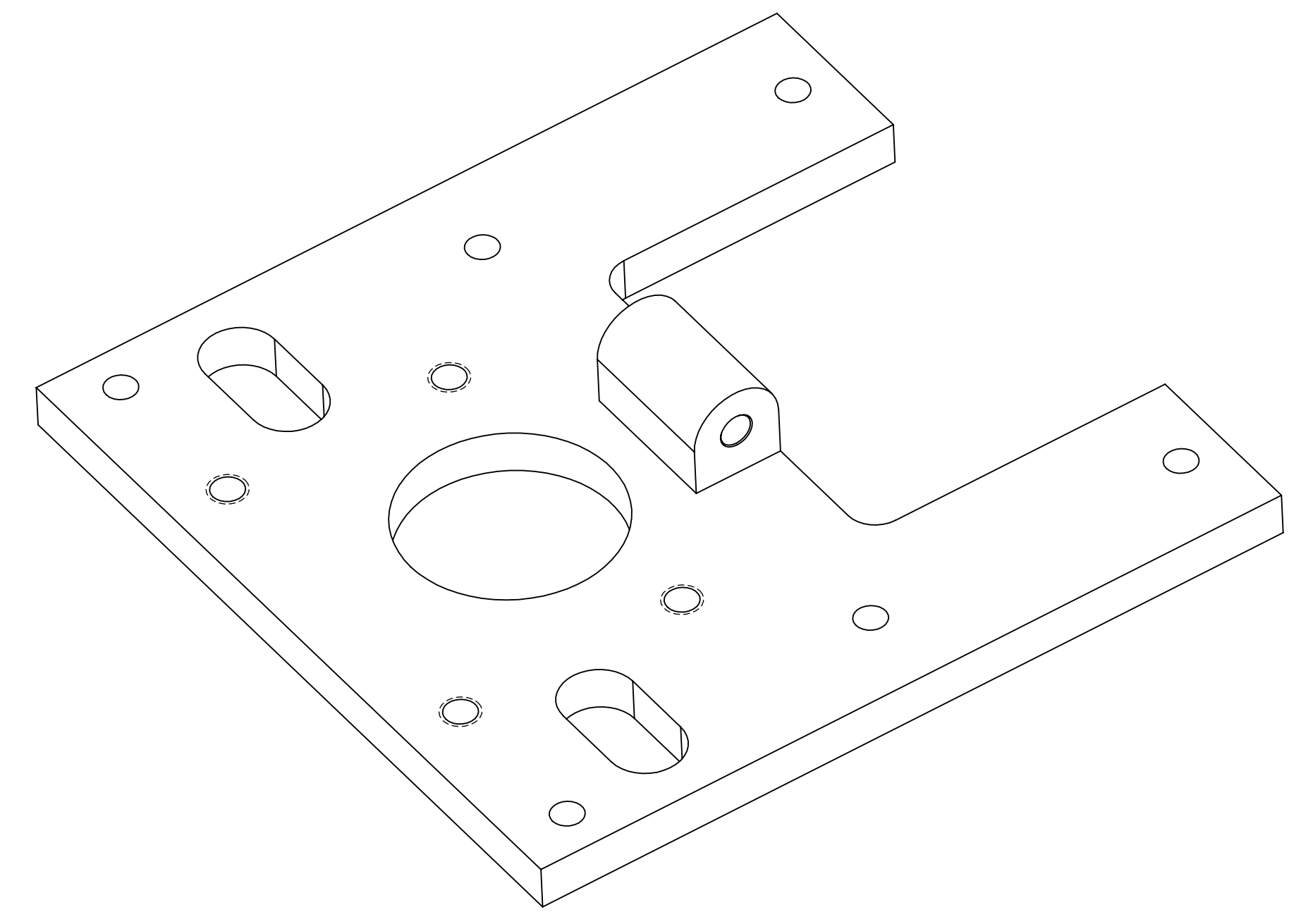
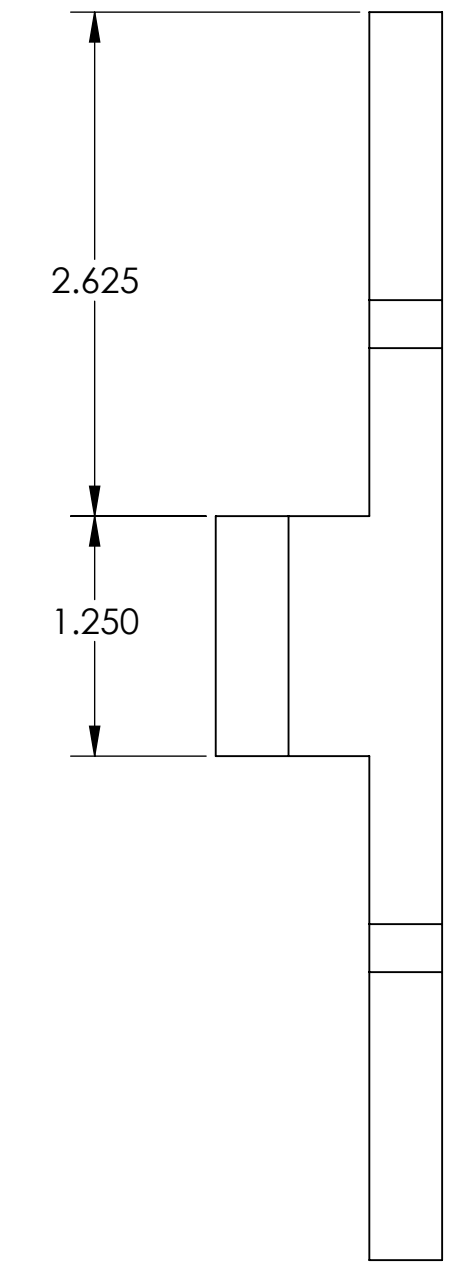
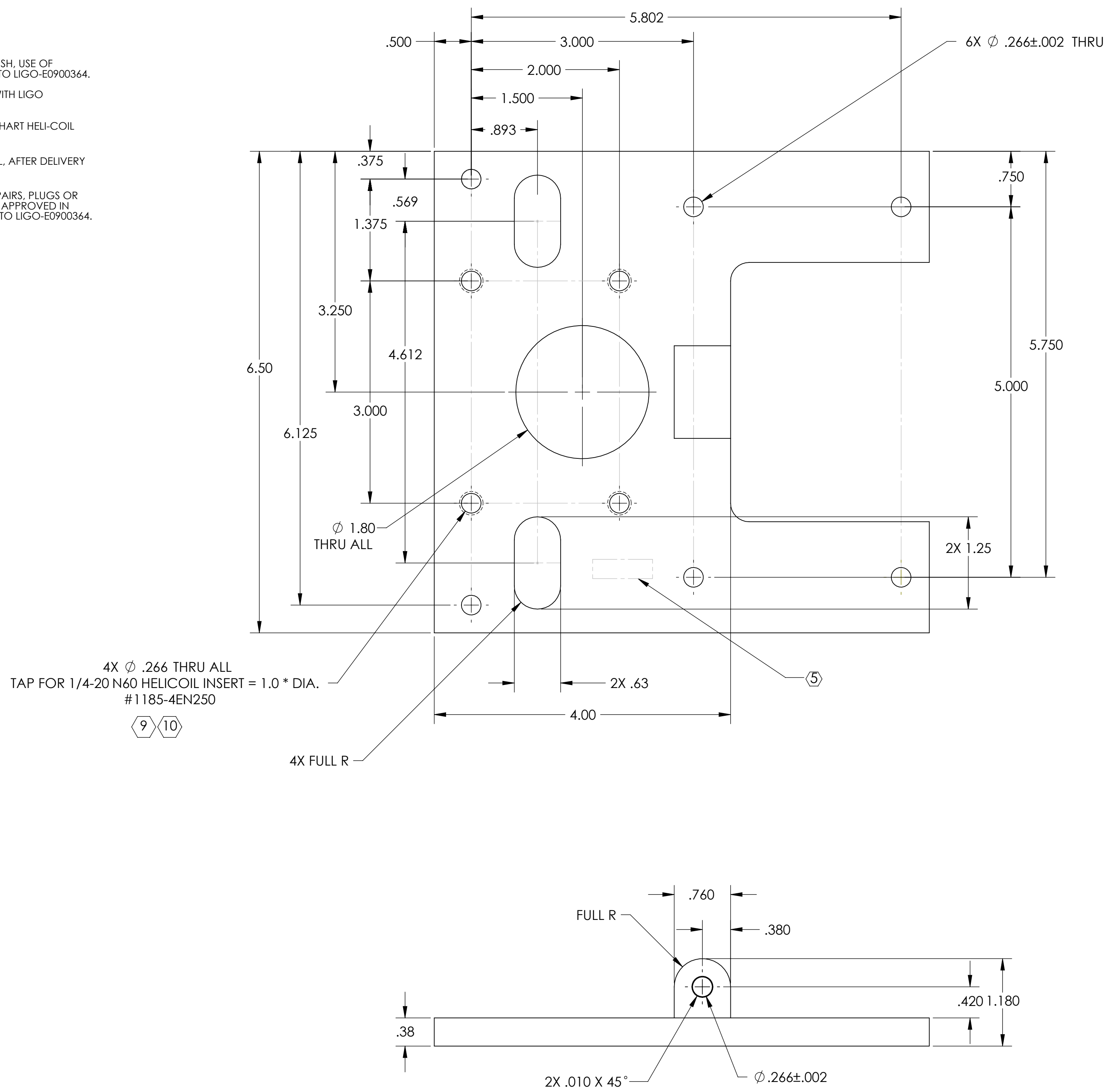


- NOTES: UNLESS OTHERWISE SPECIFIED**
1. INTERPRET DRAWING PER ASME Y14.5-1994.
  2. REMOVE ALL SHARP EDGES 0.005" TO 0.015".
  3. DO NOT SCALE FROM DRAWING.
  4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. REFER TO LIGO E0900237 FOR LIST OF APPROVED COOLANTS.
  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. APPROXIMATE WEIGHT = 0.883 LB.
  7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364.
  8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
  9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV.
  10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS. USE NITRONIC 60 THREADED INSERTS.
  11. 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	10 AUG 2010	E1000285	
v2	16 MAR 2011	E1100216	
v3	08 JUL 2011	E1100335	



ISO VIEW

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		ARM CAVITY BAFFLE LOWER MTG HINGE							
TOLERANCES: .XX ± .01 .XXX ± .005				MATERIAL 6061-T6 Al		FINISH 63 μinch		NEXT ASSY D1002173		DESIGNER N.Nguyen 02 Jul 2010	SIZE DWG. NO.	REV.	
ANGULAR ± 0.5°								ADVANCED LIGO AOS		D	D1001622	v3	
								CHECKER M. SMITH 10 NOV 2010		APPROVAL D. COYNE 20 NOV 2010	SCALE: 1:1	PROJECTION:	SHEET 1 OF 1

D1001622\_AdrLIGO\_AOS\_31C\_ARM\_Cavity\_Baffle\_Lower\_Mounting\_Hinge\_PDR\_PDM\_REV-X-023\_DRAWING\_PDM\_REV-X-027