

8

7

6

5

4

3

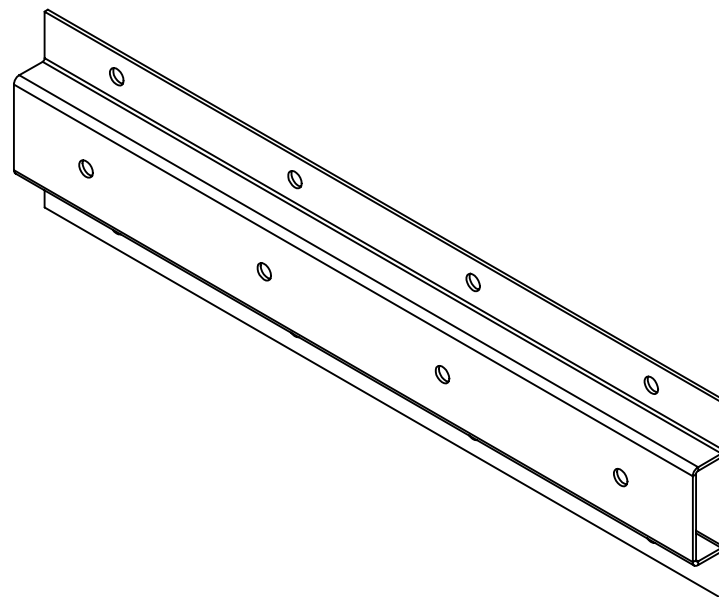
2

1

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: D100XXX-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	05 JAN 2011	E1000865	-
-	-	-	-
-	-	-	-



D

D

C

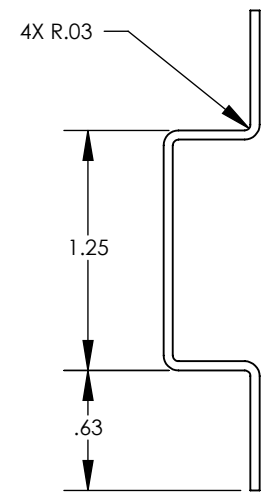
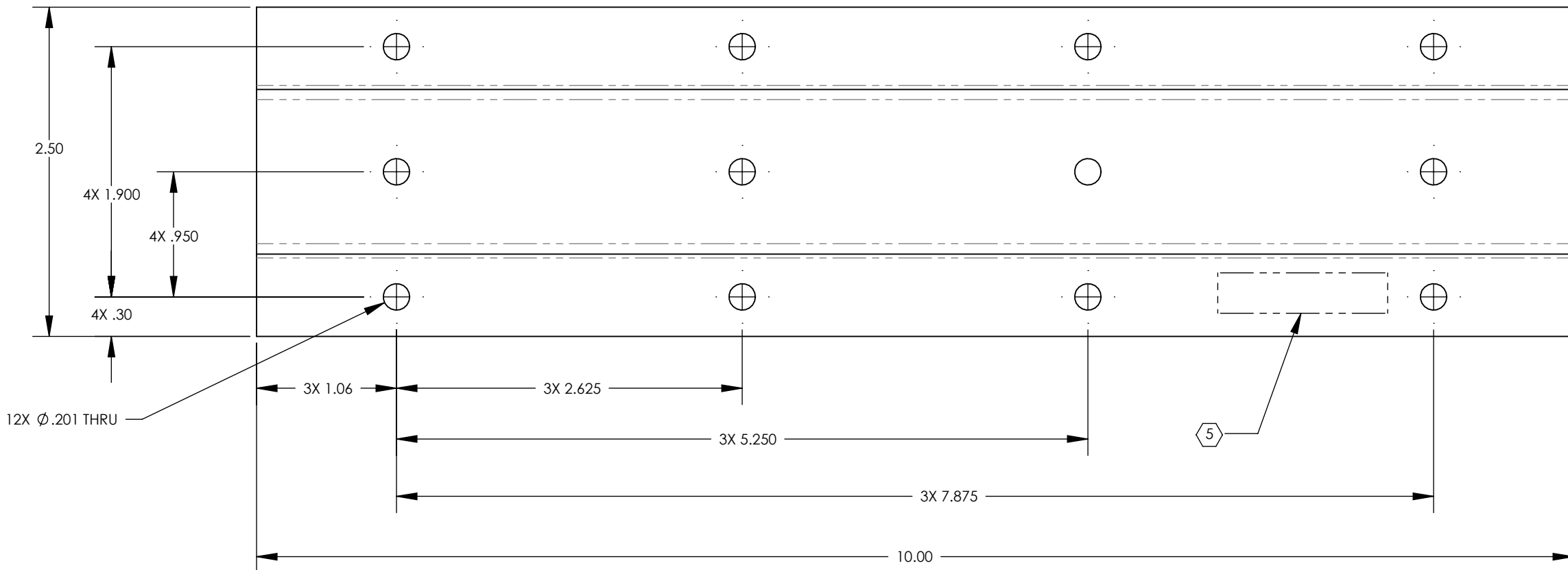
C

B

B

A

A



D1003299_AdlIGO_AOS_SR2 Scraper Baffle Hatsection, PART PDM REV: X-010, DRAWING PDM REV: X-012

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .015 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.		SR2 Scraper Baffle Hatsection	
MATERIAL A424 TYPE I, 18GA, SSSL		FINISH SEE NOTE 7		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
NEXT ASSY D1003300				DESIGNER M.RUIZ		DATE 06 NOV 2010	
APPROVAL				DRAFTER N. KILPATRICK		DATE 05 JAN 2011	
SCALE: 1:4				PROJECTION:		SIZE DWG. NO. B D1003299	
REVISION v1				SHEET 1 OF 1			

8

7

6

5

4

3

2

1