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.

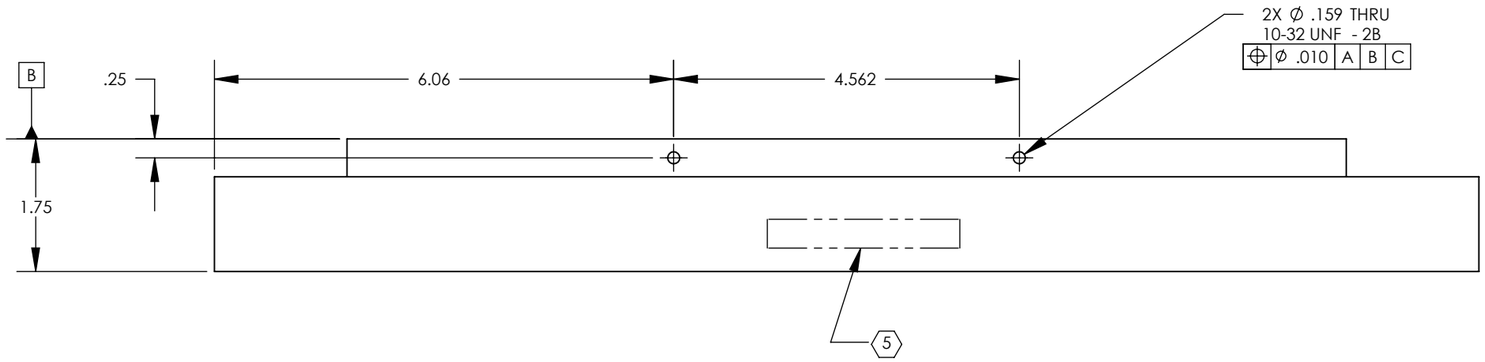
EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

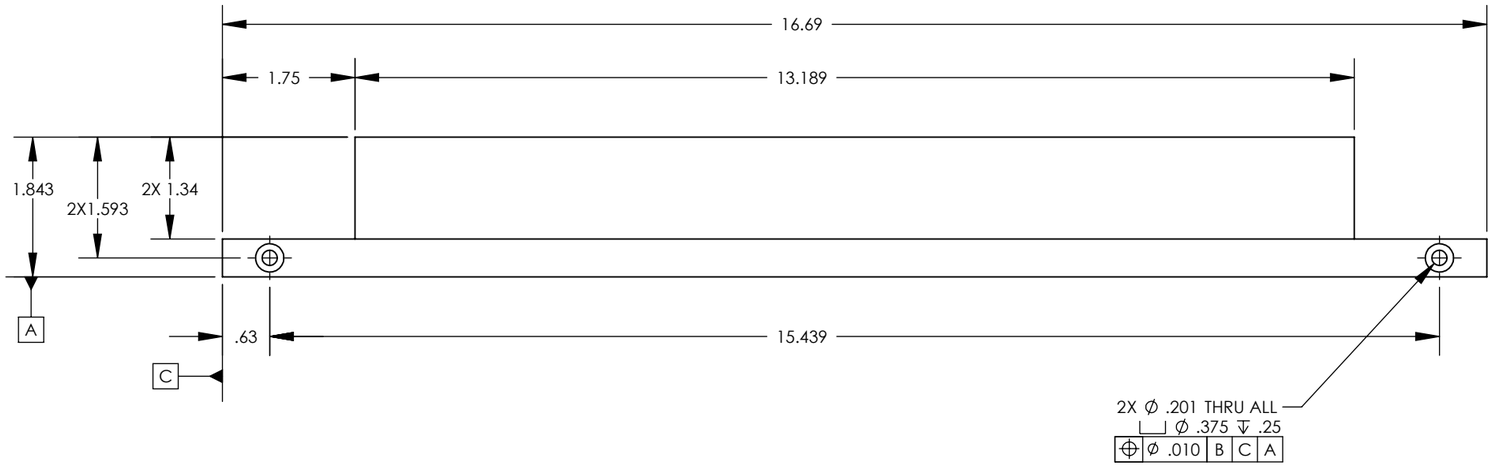
6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364

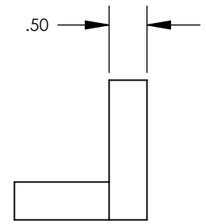
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATIONS E0900364.

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 IN WRITING BY LIGO LABORATORY, REFER TO LIGO-E0900364.

REV.	DATE	DCN #	DRAWING TREE #
v1	13 JAN 2011	E1000865	







NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)							
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 0.5°	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.			LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: SR2 Scraper Baffle Spacer 1, Side	
	MATERIAL: 6061-T6 Al	FINISH: µinch	NEXT ASSY	SYSTEM	SUB-SYSTEM	DESIGNER	
						DRAFTER: N. KILPATRICK 06 JAN 2011	SIZE: B DWG. NO.: D1003311 REV.: v1
						CHECKER	
						APPROVAL	SCALE: 1:4 PROJECTION: SHEET 1 OF 1

D1003311 AdLIGO AOS SR2 Scraper Baffle Spacer 1, Side, PART PDM REV: X-009, DRAWING PDM REV: X-005