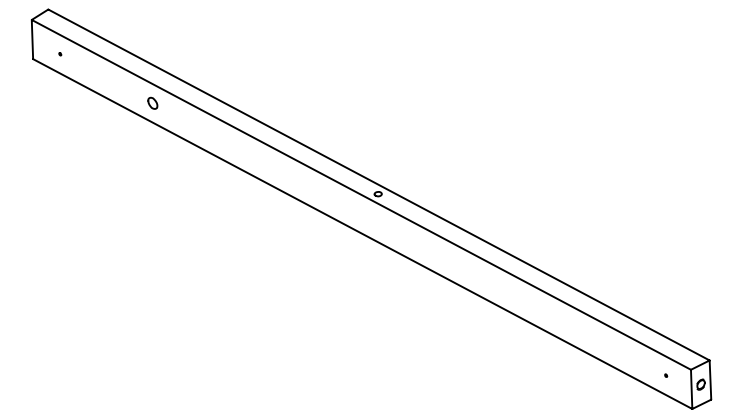


**NOTES: UNLESS OTHERWISE SPECIFIED**

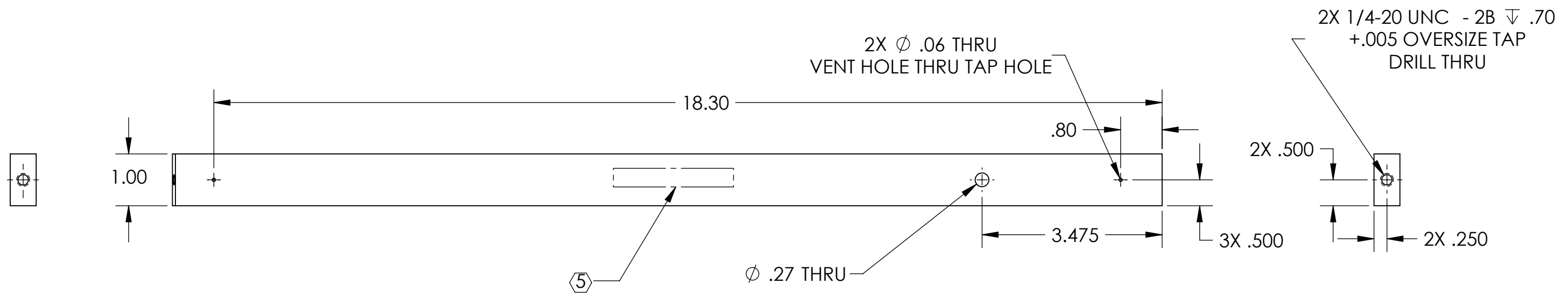
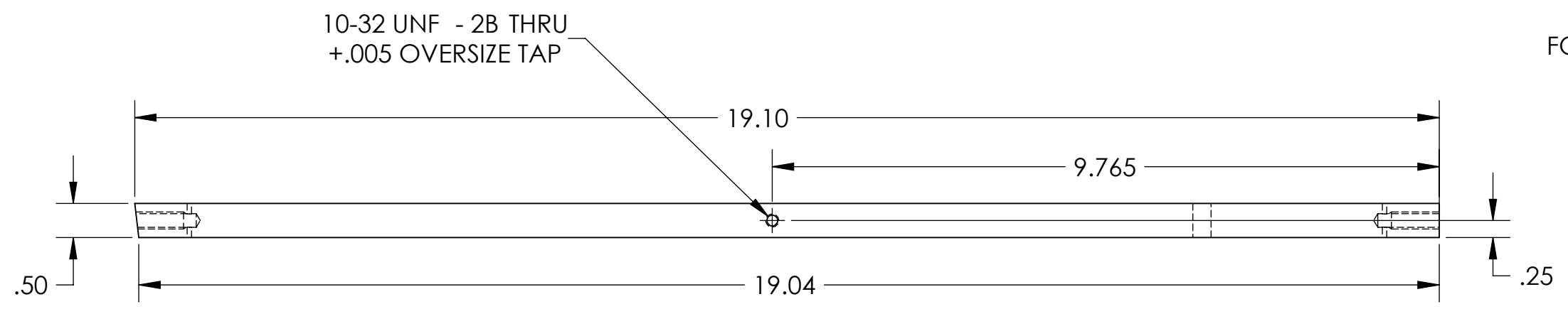
1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES. FULL RADIUS ON ALL EDGES AND HOLES.
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. REFER TO LIGO E0900237 FOR LIST OF APPROVED COOLANTS.
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. 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   | 5 AUG 2011 | E1100088-v1 | -              |
| -    | -          | -           | -              |
| -    | -          | -           | -              |



GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE



D1100010\_alIGO\_Manifold\_Flat\_Baffle\_Spoke\_3\_PART PDM REV: X-027, DRAWING PDM REV: X-012

**NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)**

DIMENSIONS ARE IN INCHES

TOLERANCES:  
 .XX ± .01  
 .XXX ± .005  
 ANGULAR ± 1.0°

MATERIAL 6061-T6 Al FINISH 8

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM ADVANCED LIGO SUB-SYSTEM AOS

NEXT ASSY D1003384

PART NAME SPOKE 3

|          |            |             |        |          |              |
|----------|------------|-------------|--------|----------|--------------|
| DESIGNER | TQ. NGUYEN | 3 JAN 2011  | SIZE   | DWG. NO. | REV.         |
| DRAFTER  | TQ. NGUYEN | 12 JAN 2011 | B      | D1100010 | v1           |
| CHECKER  | M. SMITH   |             | SCALE: | 1:2      | PROJECTION:  |
| APPROVAL | D. COYNE   |             |        |          | SHEET 1 OF 1 |