REV.	DATE	DCN #	DRAWING TREE #
v1	21 JUN 2011	E1000822-v1	-
v1	19 JUL 2011	-	-
-	-	-	-

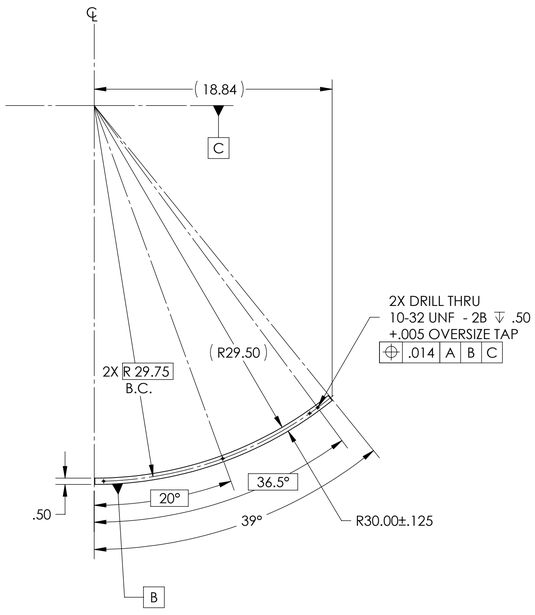
NOTES CONTINUED:

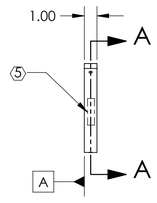
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR 'TYPE' IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE 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

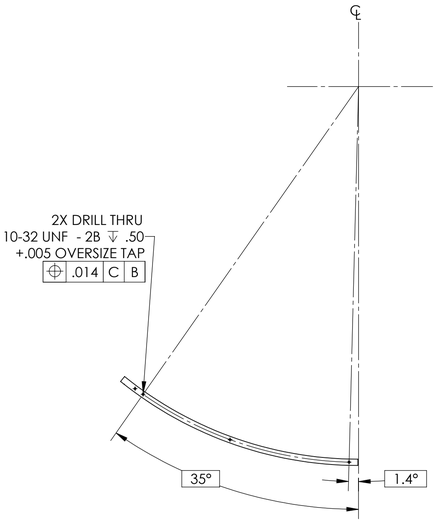
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

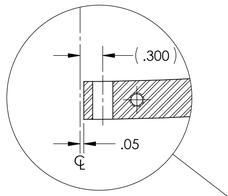
8. ELECTRO POLISH TO REMOVE .0005 TO .001 PER SIDE.

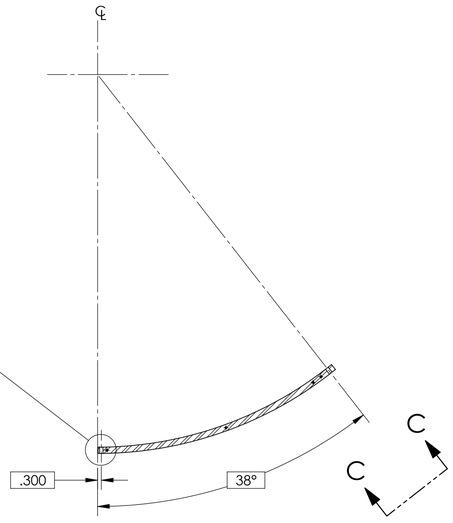
9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.



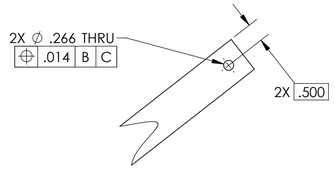








SECTION A-A



VIEW C-C
SCALE 1 : 2

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)							
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .02 .XXX ± .005 ANGULAR ± 0.5°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015. FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATLEY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME: INNER LOWER LEFT BRACE_MCA1		
	MATERIAL: 6061-T6 Al	FINISH: 63 µinch	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	DESIGNER: TQ. NGUYEN 17 JUN 2011	SIZE: D	DWG. NO.: D1100277 REV.: v2
			NEXT ASSY: D1002864		DRAFTER: TQ. NGUYEN 21 JUN 2011		
					CHECKER: M. SMITH		
					APPROVAL: D. COYNE	SCALE: 1:6	PROJECTION: SHEET 1 OF 1

D1100277_aLIGO_MC_Tube_Baffle_Inner_Lower_Left_Brace_MCA1, PART PDM REV-X-X06, DRAWING PDM REV-X-X02