

**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: DXXXXXX-VY, TYPE-XX, S/N XXX

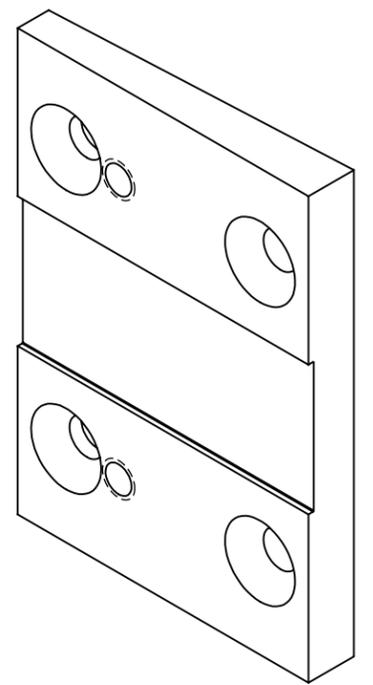
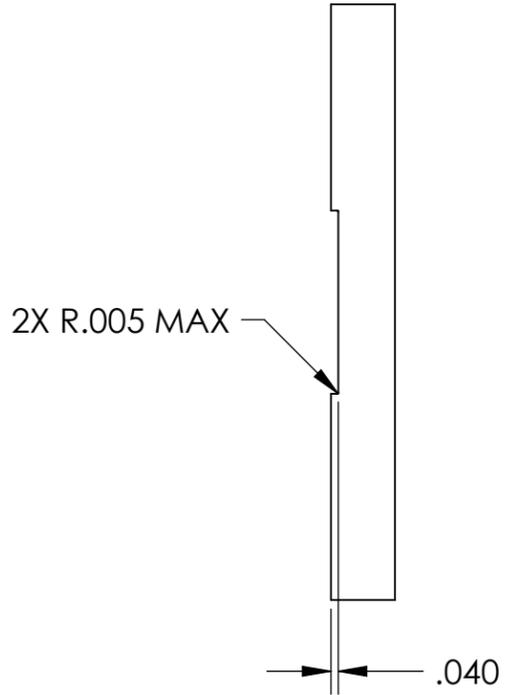
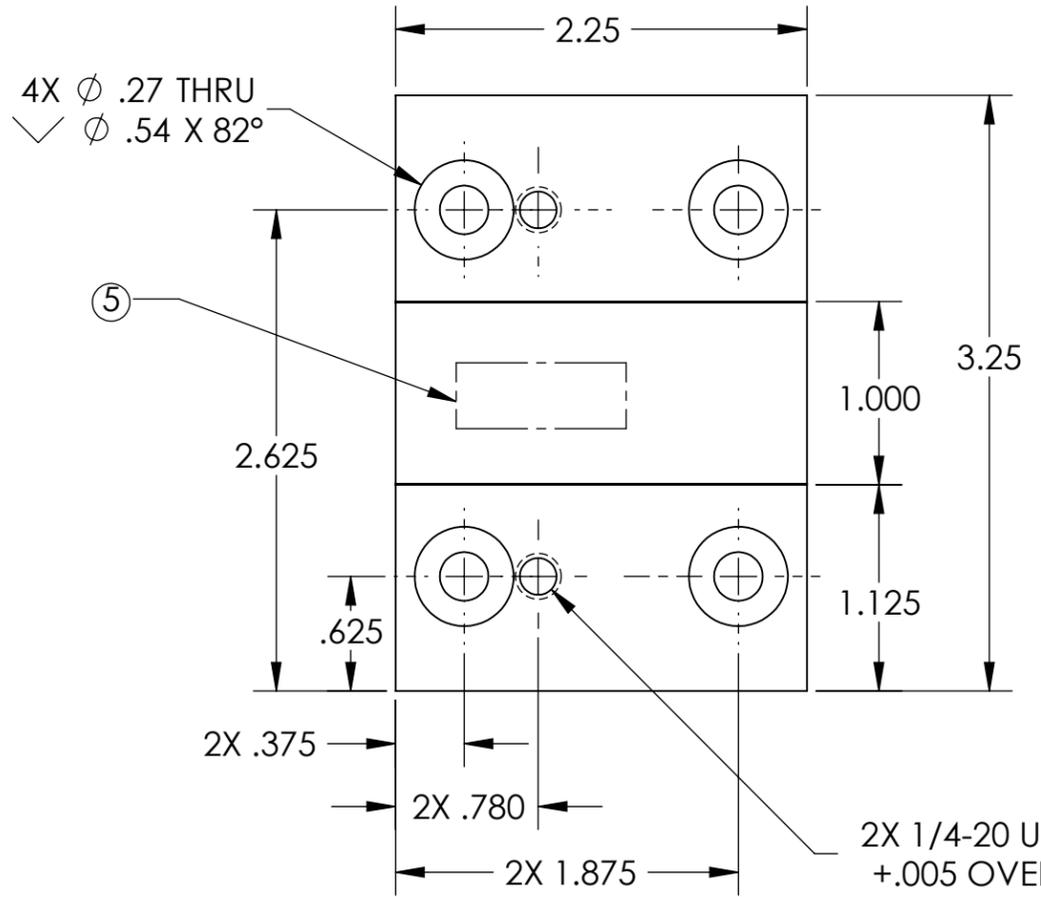
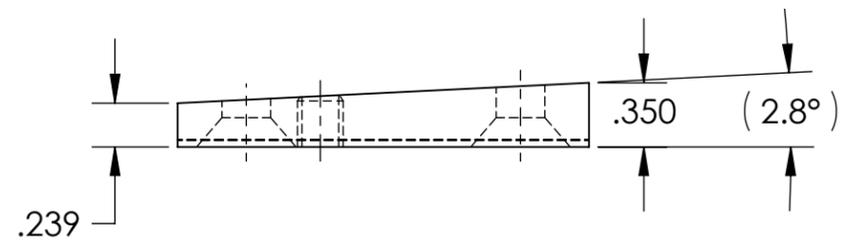
6. APPROXIMATE WEIGHT= 0.188 LB.

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 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   | 9 MAY 2011  | E1000360-v2 | -              |
| v2   | 29 DEC 2011 | -           | -              |
| v3   | 7 JUN 2012  | -           | -              |



GENERAL VIEW FOR REFERENCE ONLY NO SCALE

D1100822 aLIGO Manifold Cryo Baffle Lower CU Shim, PART PDM REV: X-012, DRAWING PDM REV: X-013

D C B A

D C B A

| NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED) |  |   |  | LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY |  | PART NAME                           |  |            |
|--|--|---|--|---|--|-------------------------------------|--|------------|
| DIMENSIONS ARE IN INCHES                           |  | 1. INTERPRET DRAWING PER ASME Y14.5-1994.<br>2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS.<br>3. DO NOT SCALE FROM DRAWING.<br>4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. |  | SYSTEM ADVANCED LIGO  |  | SUB-SYSTEM AOS                      |  | LOWER SHIM |
| TOLERANCES:<br>.XX ± .02<br>.XXX ± .005            |  | MATERIAL 6061-T6 Al   |  | FINISH 63 μinch   |  | NEXT ASSY D1002084                  |  |            |
| ANGULAR ± 1.0°                                     |  |   |  |   |  | DESIGNER H. KELMAN 20 APR 2011      |  |            |
|  |  |   |  |   |  | DRAFTER TQ. NGUYEN 4 MAY 2011       |  |            |
|  |  |   |  |   |  | CHECKER M. SMITH 07 OCT 2011        |  |            |
|  |  |   |  |   |  | APPROVAL D. COYNE 07 OCT 2011       |  |            |
|  |  |   |  |   |  | SIZE DWG. NO. B D1100822            |  |            |
|  |  |   |  |   |  | REV. v3                             |  |            |
|  |  |   |  |   |  | SCALE: 1:1 PROJECTION: SHEET 1 OF 1 |  |            |