

D:\101442\_d\UGO\_Monitord\Part\_Baffle\_Spoke\_8\_FEM.XT.PART.PDM.REV.X-017.DRAWING.PDM.REV.X-005

**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

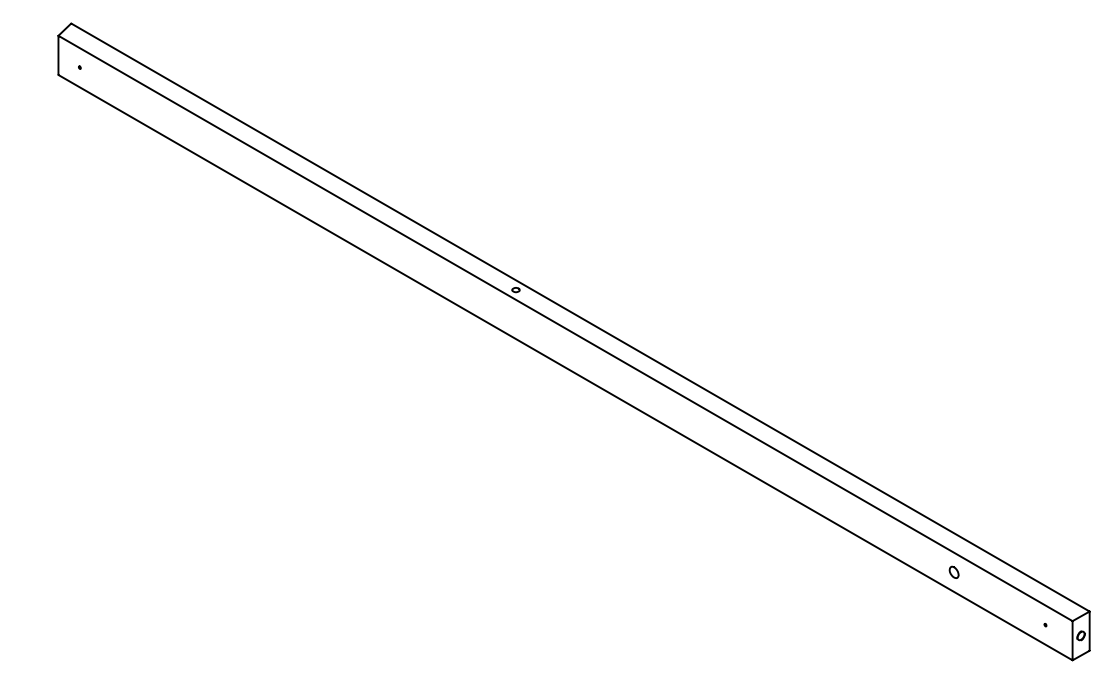
6. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-ED900364.

7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION ED900364.

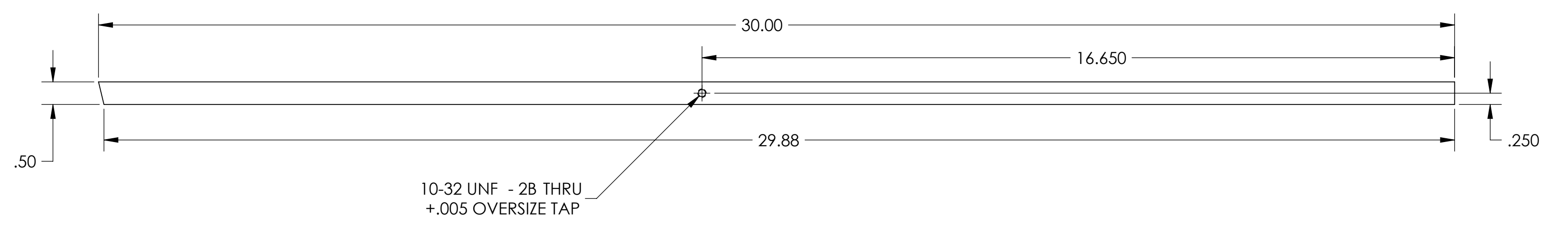
8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-ED900364.

9. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER. FREE FROM SCRATCHES OR GOUGES.

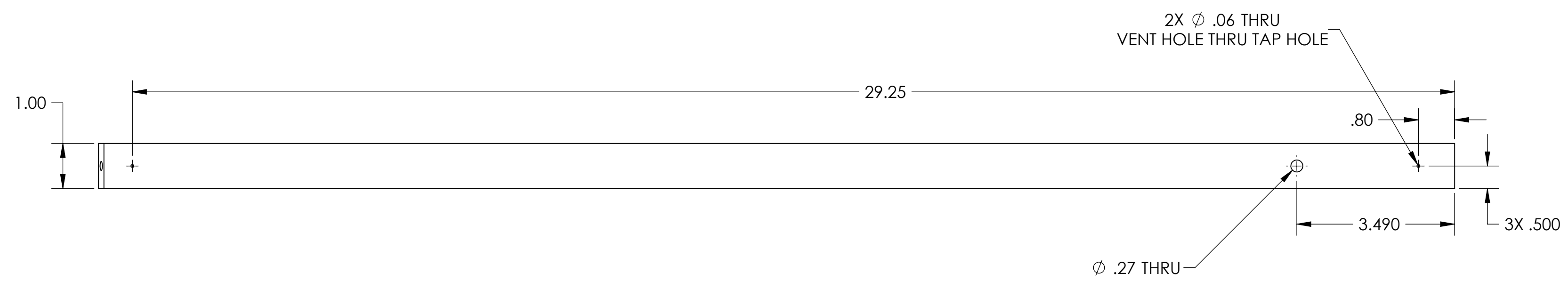
| REV. | DATE       | DCN #       | DRAWING TREE # |
|------|------------|-------------|----------------|
| v1   | 5 AUG 2011 | E1100088-v1 | -              |
| -    | -          | -           | -              |
| -    | -          | -           | -              |



GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE

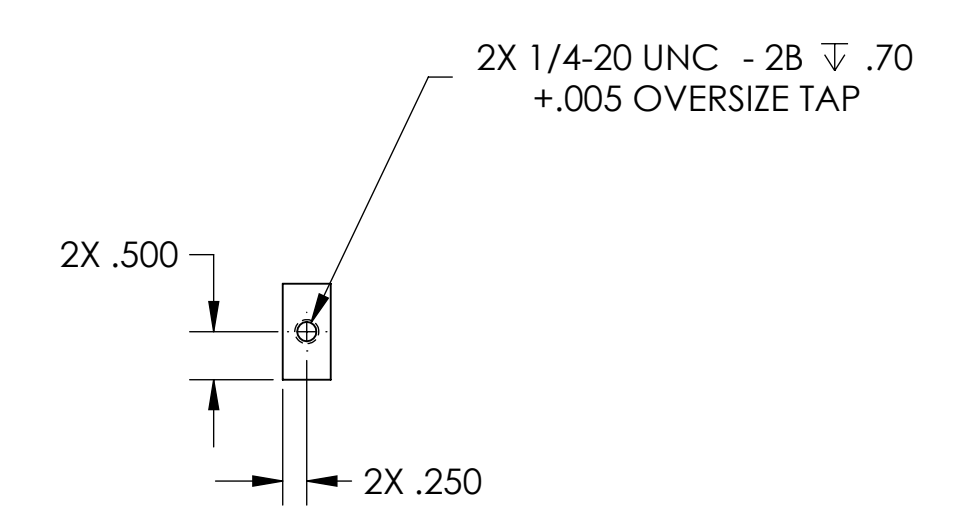


10-32 UNF - 2B THRU  
+.005 OVERSIZE TAP



2X Ø .06 THRU  
VENT HOLE THRU TAP HOLE

Ø .27 THRU



| NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)                                    |  |  |  | LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY<br>MASSACHUSETTS INSTITUTE OF TECHNOLOGY  |  | PART NAME                      |  |                           |  |                              |  |
|---|--|--|--|---|--|--------------------------------|--|---------------------------|--|------------------------------|--|
| DIMENSIONS ARE IN INCHES<br>TOLERANCES:<br>.XX ± .02<br>.XXX ± .005<br>ANGULAR ± 1.0° |  |  |  | 1. INTERPRET DRAWING PER ASME Y14.5-1994.<br>2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL 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<br><b>ADVANCED LIGO</b> |  | SUB-SYSTEM<br><b>AOS</b>  |  | <b>SPOKE 8</b>               |  |
|   |  |  |  |   |  | MATERIAL<br><b>6061-T6 Al</b>  |  | FINISH<br><b>63 μinch</b> |  | NEXT ASSY<br><b>D1003384</b> |  |
|   |  |  |  |   |  | CHECKER<br>M. SMITH            |  | APPROVAL<br>C. TORRIE     |  | REV.<br><b>v1</b>            |  |
|   |  |  |  |   |  | SCALE: 1:2                     |  | PROJECTION:               |  | SHEET 1 OF 1                 |  |