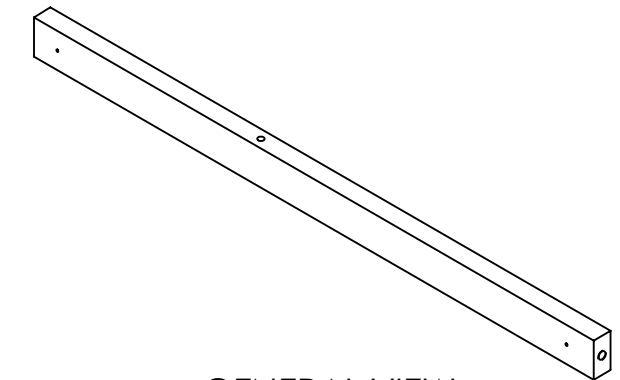


D1101444\_cdlIGO\_Manifold\_Flat\_Baffle\_Spoke\_5, F EIM XY, PART PDM REV: X-014, DRAWING PDM REV: X-006

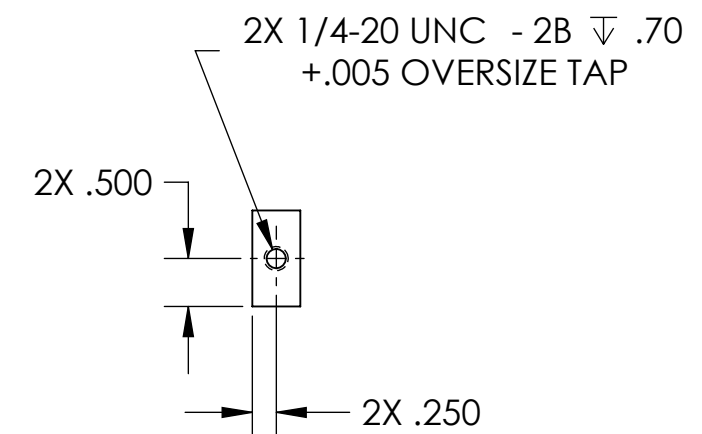
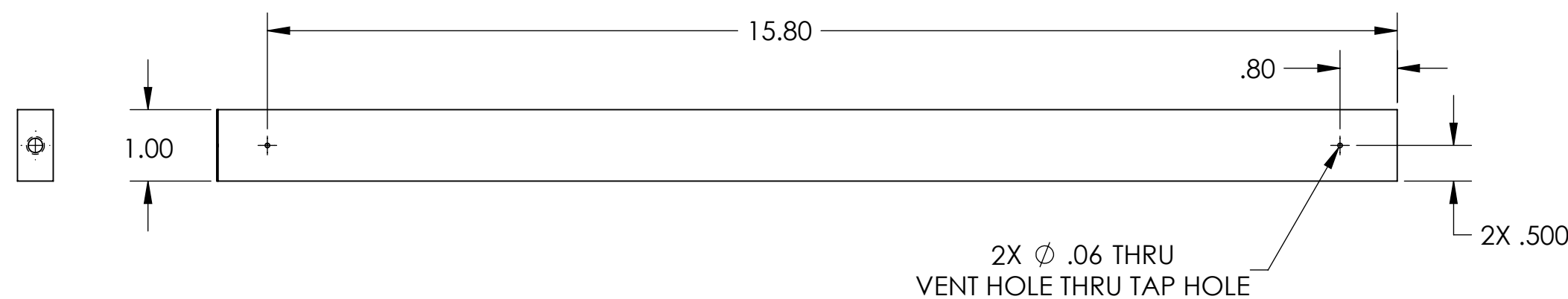
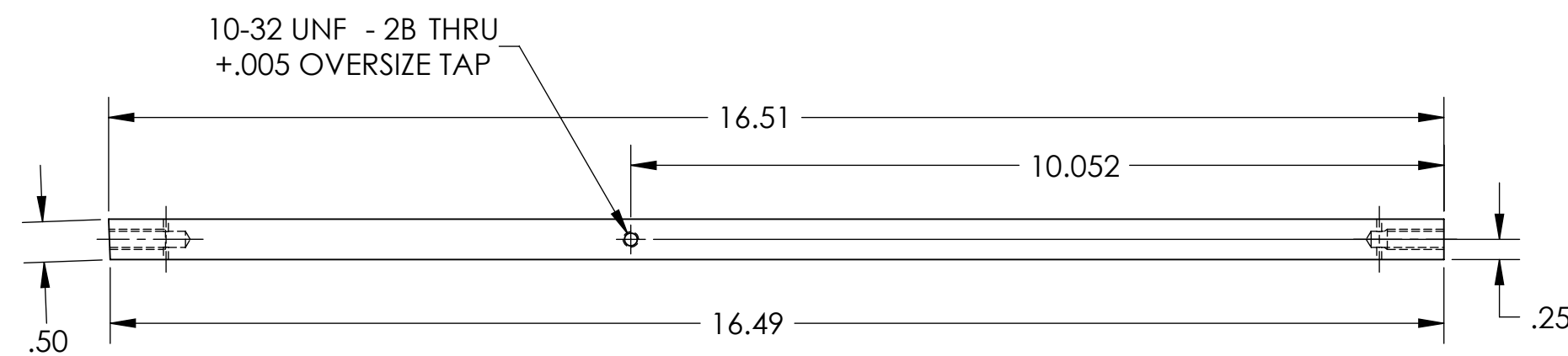
**NOTES CONTINUED:**  
 5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT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



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

DIMENSIONS ARE IN INCHES

TOLERANCES:  
 .XX ± .02  
 .XXX ± .005  
 ANGULAR ± 1.0°

1. INTERPRET DRAWING PER ASME Y14.5-1994.  
 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY 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.

MATERIAL	6061-T6 Al	FINISH	63 μinch
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CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		SPOKE 5	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	AOS	DESIGNER	TQ. NGUYEN 24 JUL 2011
NEXT ASSY	D1003384	DRFTER	TQ. NGUYEN 5 AUG 2011	SIZE	DWG. NO.
		CHECKER	M. SMITH	B	D1101444
		APPROVAL	C. TORRIE	SCALE	1:2
				PROJECTION:	
				REV.	v1
				SHEET 1 OF 1	