NOTES CONTINUED:

Ⓢ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIENT 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
DO NOT APPLY MARK ON SUPER #8 SIDE.

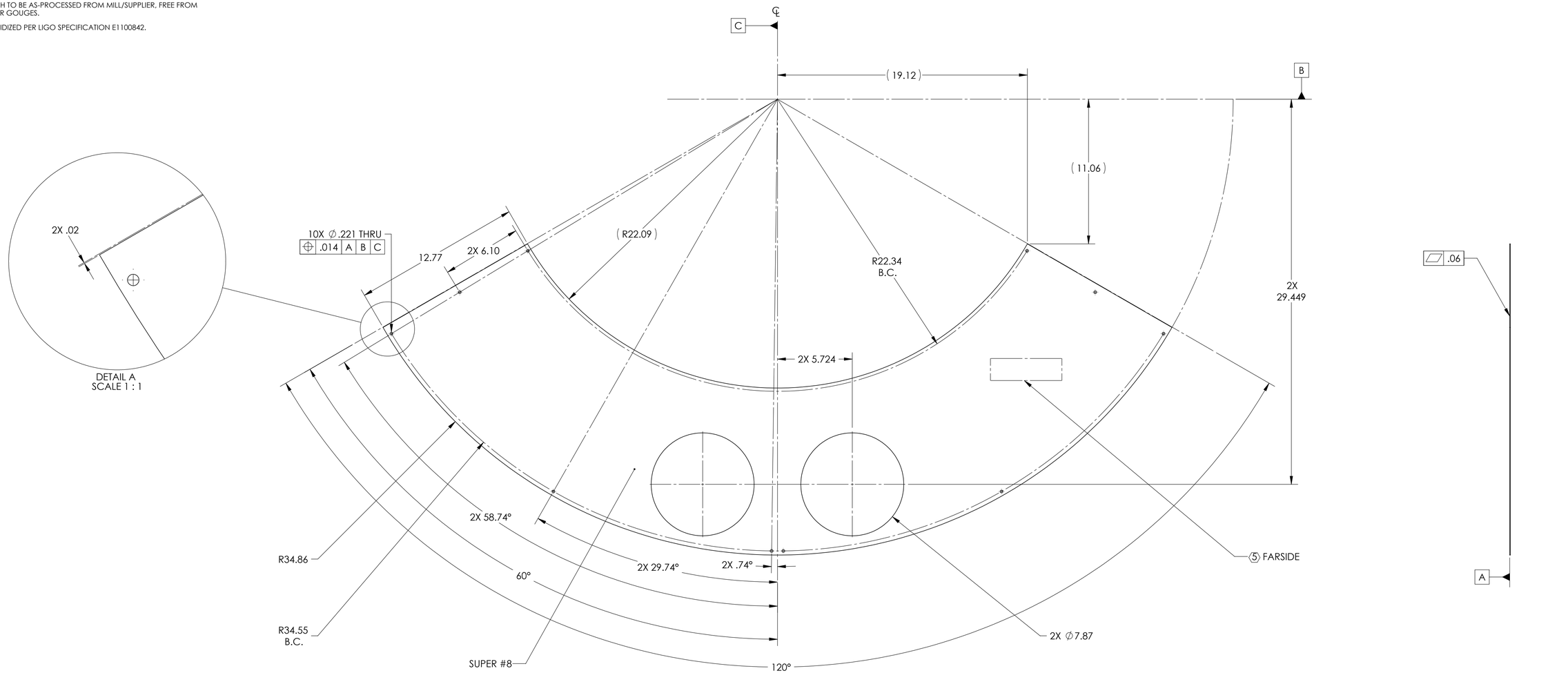
6. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

7. 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.

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

9. PART TO BE OXIDIZED PER LIGO SPECIFICATION E1100842.

REV.	DATE	DCN #	DRAWING TREE #
v1	4 OCT 2011	E1000360-v3	-
-	-	-	-
-	-	-	-



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .03
.XXX ± .010

ANGULAR ± 0.5°

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES .005-.015 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.

MATERIAL: 18 GAUGE 304 SSTL
FINISH: Ⓔ SUPER #8

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: AOS
NEXT ASSY: D1101398

PART NAME: LOWER FACE PLATE, ITM XY

DESIGNER	TQ. NGUYEN	26 JUL 2011
DRAFTER	TQ. NGUYEN	3 AUG 2011
CHECKER	M. SMITH	
APPROVAL	C. TORRIE	

SIZE: D | DWG. NO.: D1101501 | REV.: v1
SCALE: 1:4 | PROJECTION: | SHEET 1 OF 1

D1101501_aLIGO_Manifold_Cryo_Baffle_Lower Face Plate, ITM, PART FDM REV- X-007, DRAWING FDM REV- X-011