NOTES CONTINUED:

⑤ 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: DXXXXXX-VY, TYPE-XX, S/N XXX
DO NOT APPLY MARK ON SUPER #8 SIDE

⑥ CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.

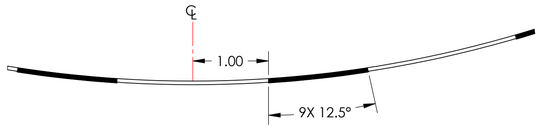
7. DELETED

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

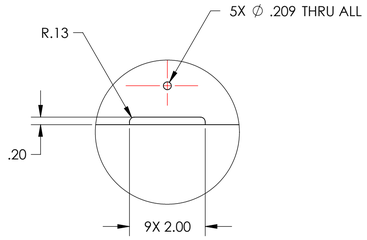
9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

⑩ SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

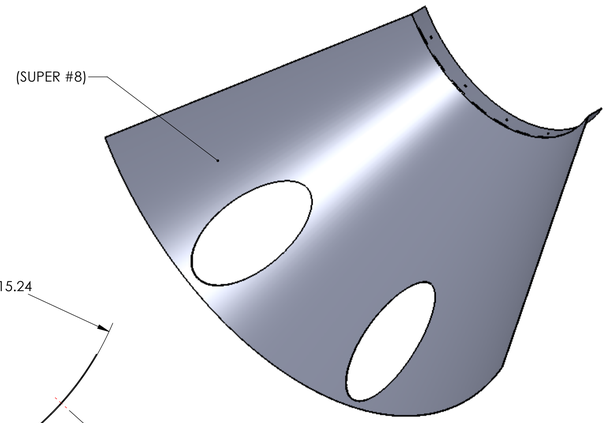
REV.	DATE	DCN #	DRAWING TREE #
v1	1 SEP 2010	E1000360	E1000091
v2	12 MAY 2011	E1000360-v2	-
v3	13 SEP 2011	E1000360-v3	-



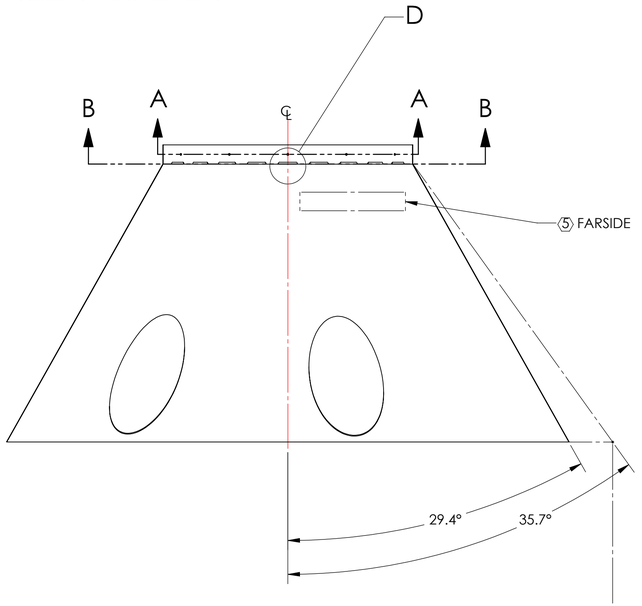
SECTION B-B
WELD LOCATIONS
SCALE 1 : 1

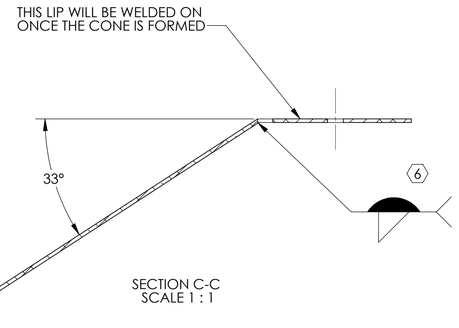


DETAIL D
SCALE 1 : 2



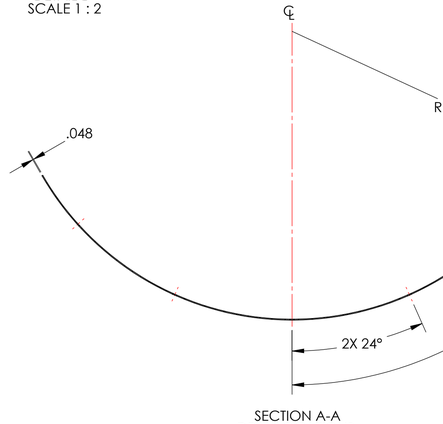
GENERAL VIEW
FOR REFERENCE
NO SCALE



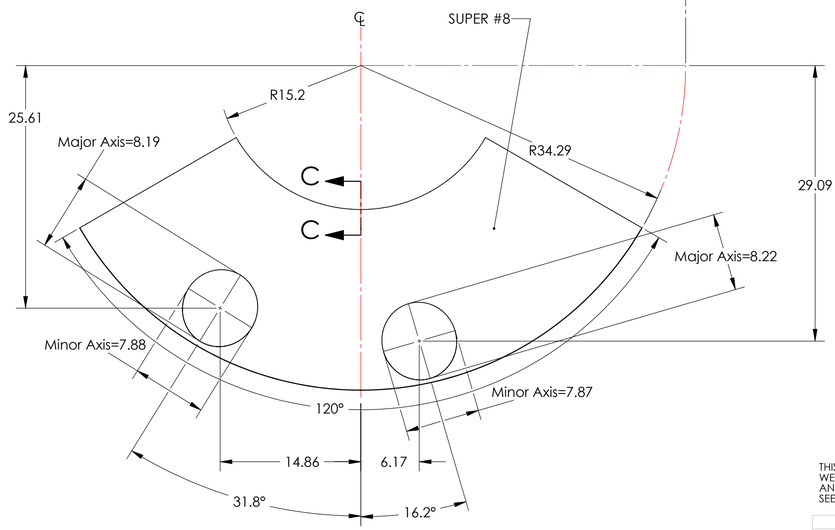


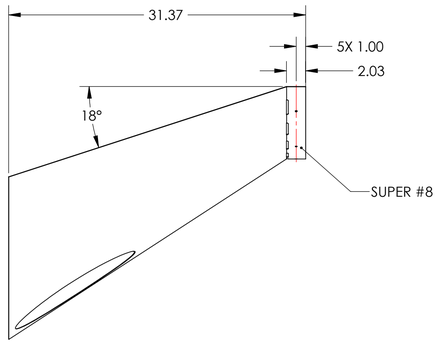
10 PLS

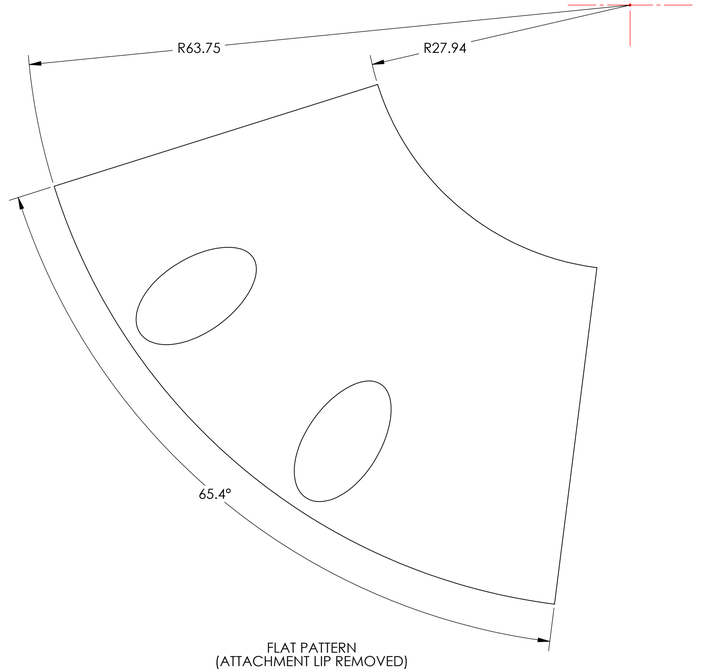
SECTION C-C
SCALE 1 : 1



SECTION A-A
DRILL LOCATIONS
SCALE 1 : 4







FLAT PATTERN
(ATTACHMENT LIP REMOVED)

THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902654 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)

DIMENSIONS ARE IN INCHES

TOLERANCES:
.XX ± .06
.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: ⑩ SUPER #8

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO
SUB-SYSTEM: AOS
NEXT ASSY: D0902654

PART NAME: MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ITM XY, RIGHT

DESIGNER	H. KELMAN	12 MAY 2010
DRAFTER	TQ. NGUYEN	17 AUG 2010
CHECKER	M. SMITH	27 SEP 2011
APPROVAL	D. COYNE	

SIZE: D
DWG. NO.: D0902619
REV.: v3
SCALE: 1:8
PROJECTION:
SHEET 1 OF 1

D0902619 aLIGO_Manifold_Cryo_Baffle_Inner_Segment.ITMX H1-H2, RIGHT, PART PDM REV: X-041, DRAWING PDM REV: X-025