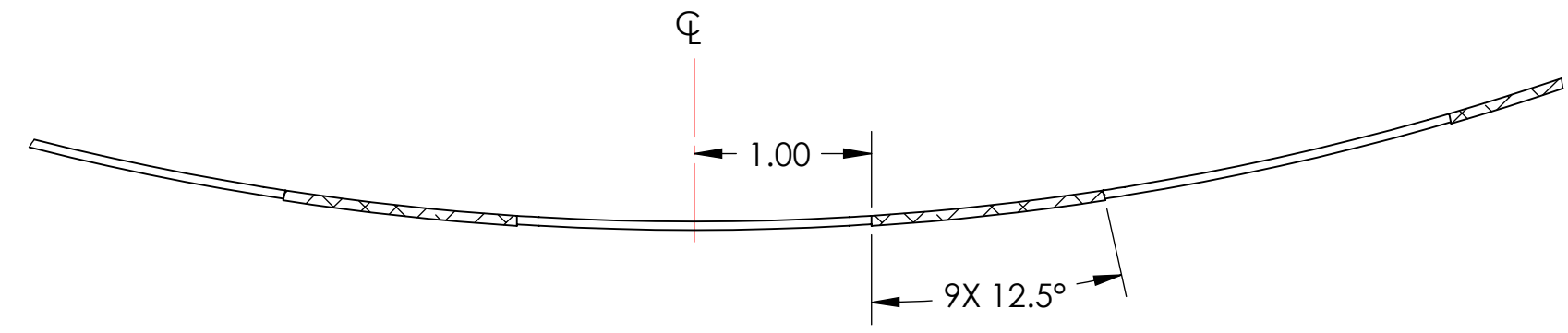
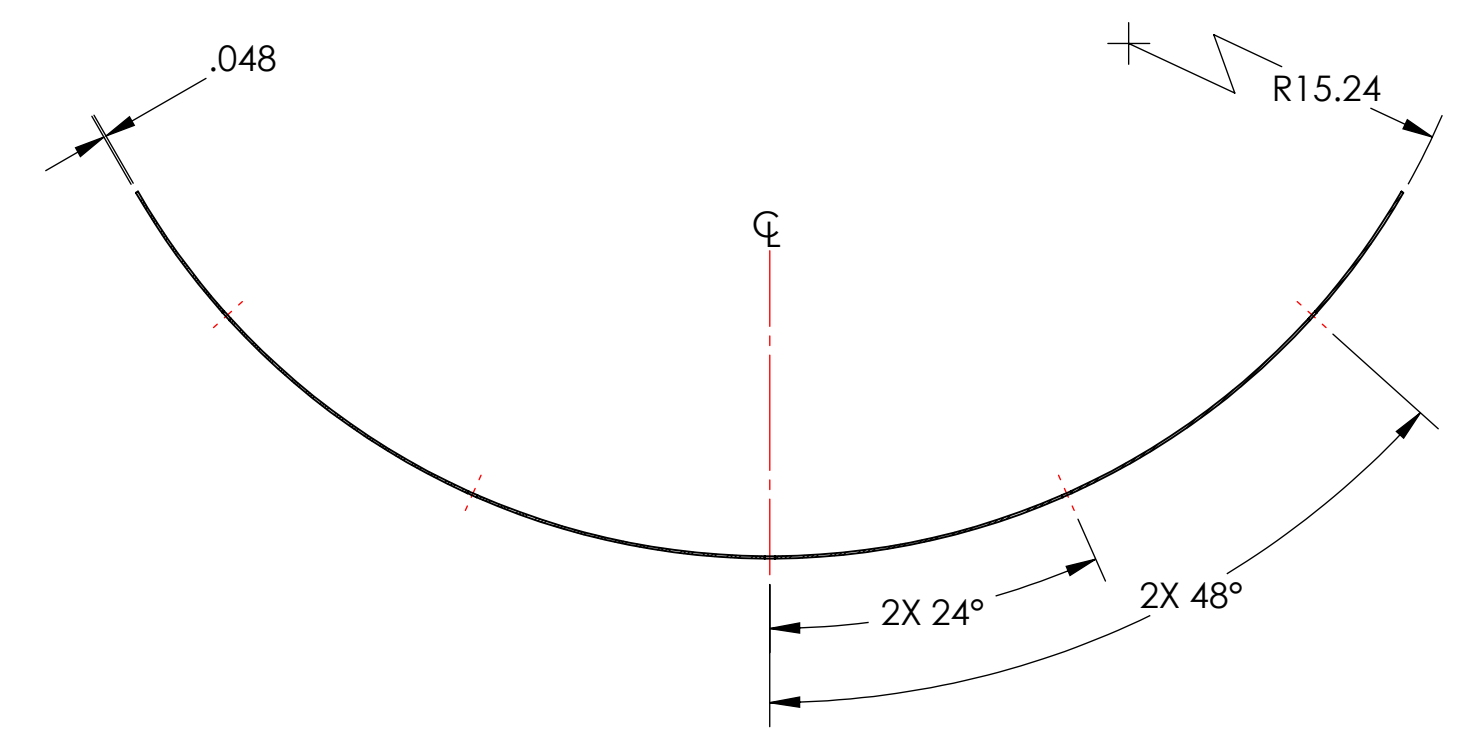


- NOTES CONTINUED:**
- ⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE 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 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.

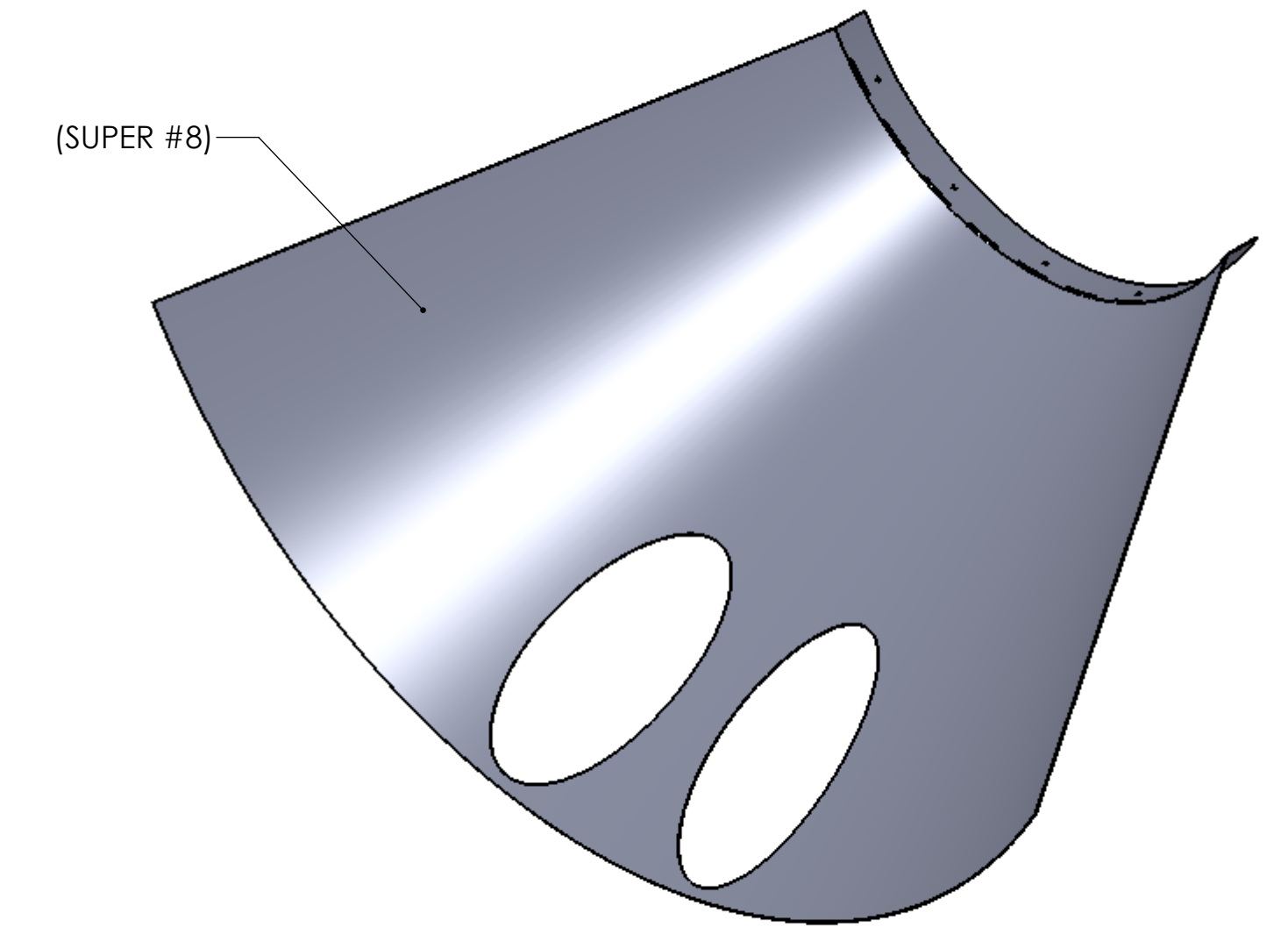
REV.	DATE	DCN #	DRAWING TREE #
v1	07 SEP 2010	E1000360	E1000090
v2	9 MAY 2011	E1000360-v2	-
v3	13 SEP 2011	E1000360-v3	-



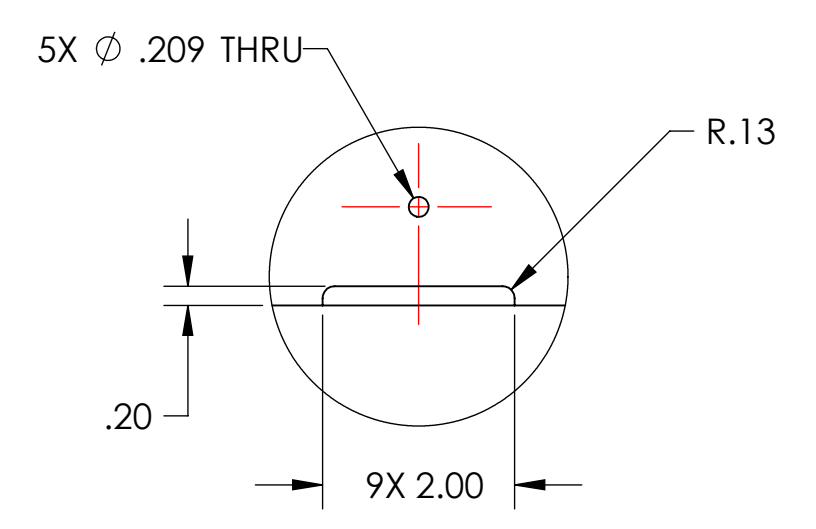
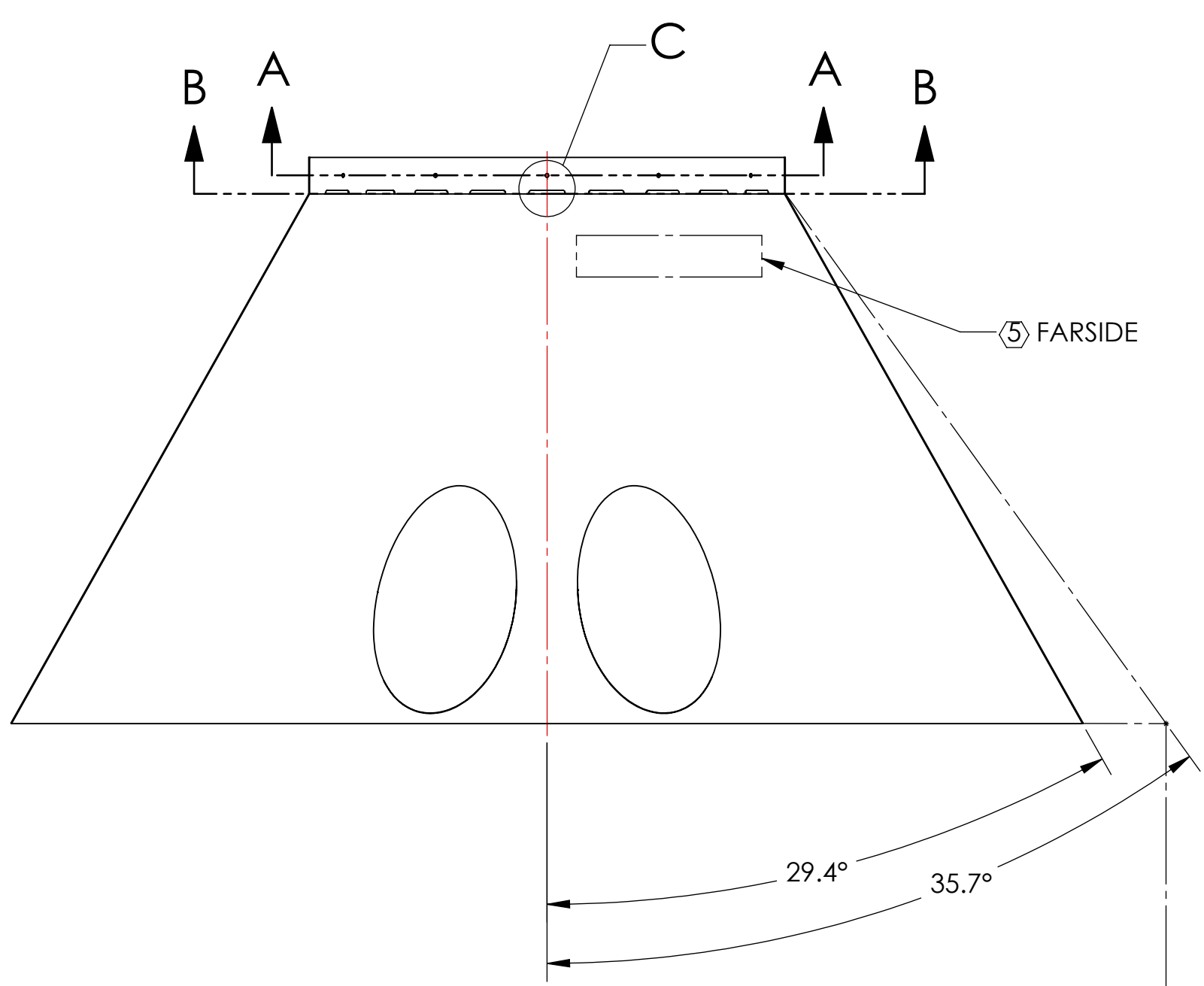
SECTION B-B  
WELD LOCATIONS  
SCALE 1 : 1



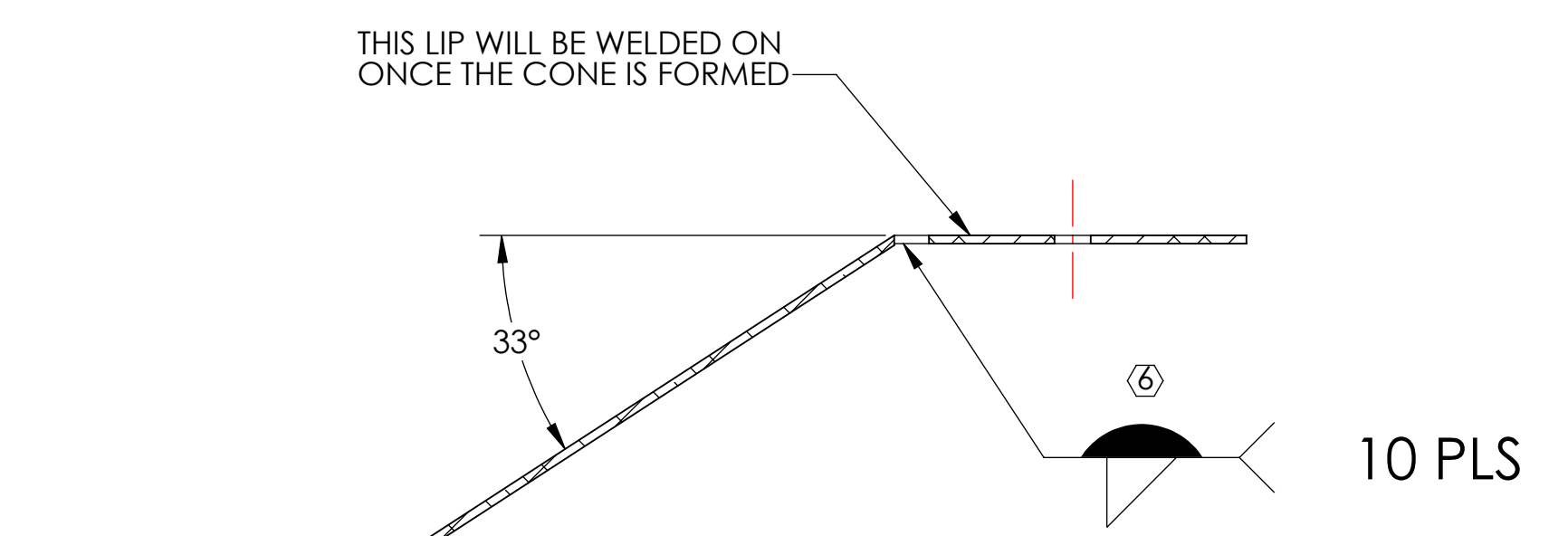
SECTION A-A  
DRILL LOCATIONS  
SCALE 1 : 4



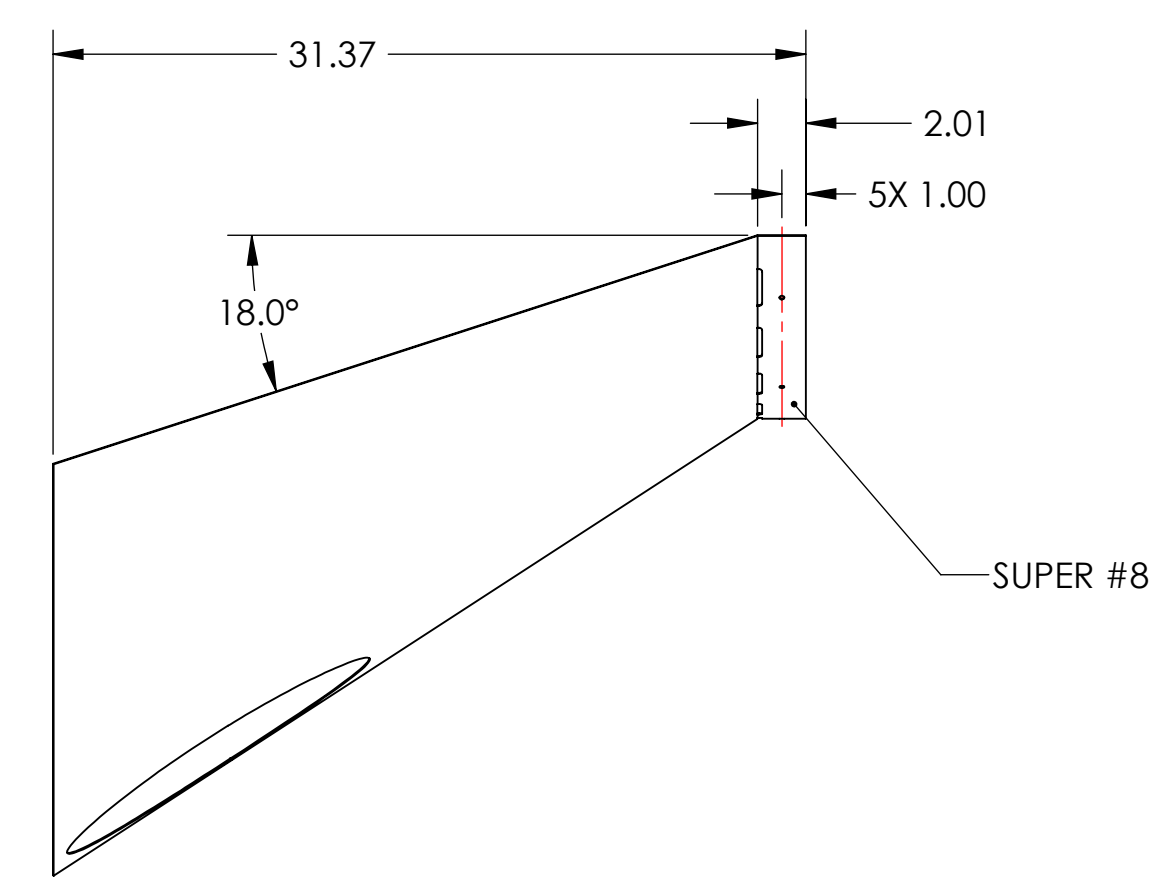
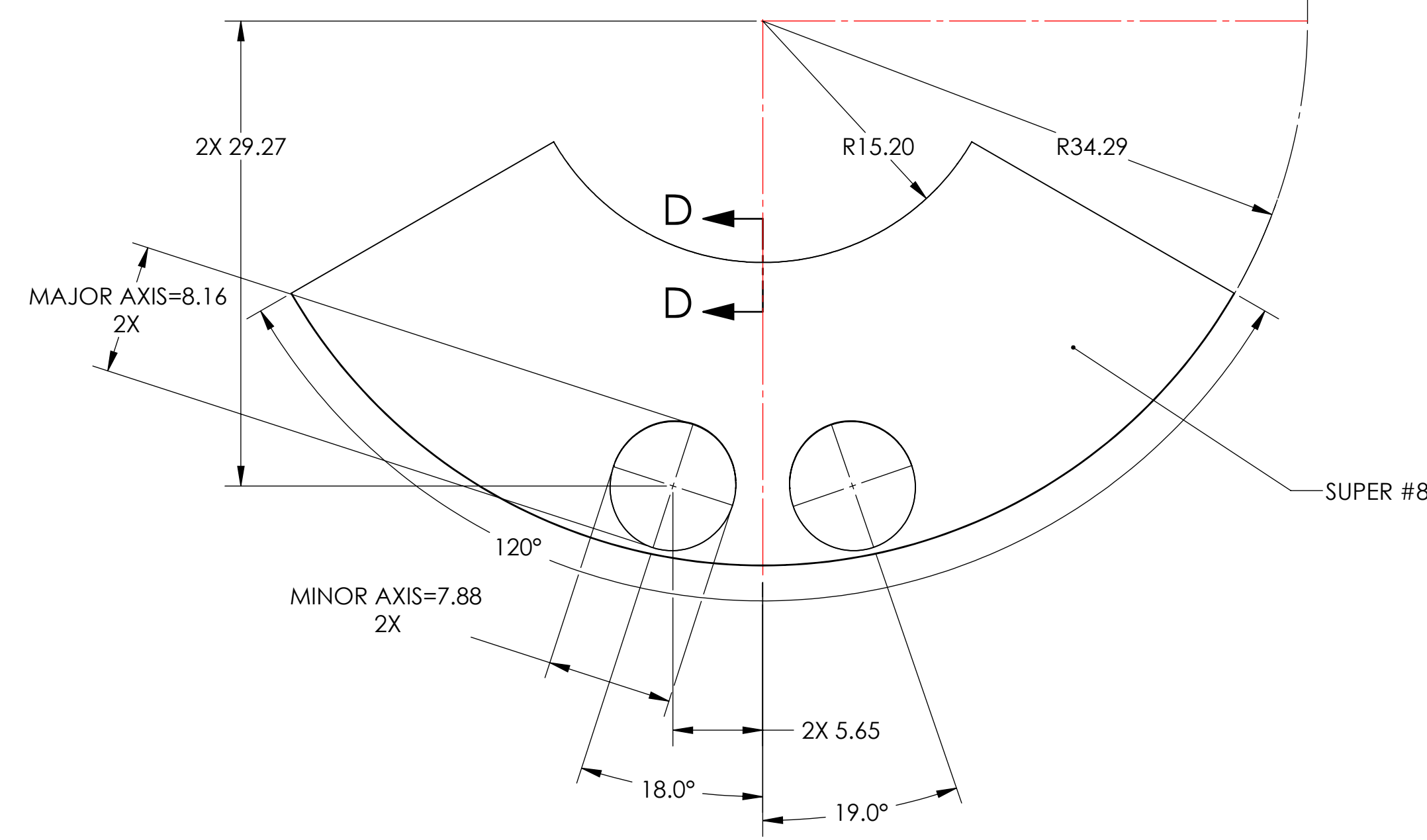
GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE



DETAIL C  
SCALE 1 : 2



SECTION D-D  
SCALE 1 : 1



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)	
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.	
DIMENSIONS ARE IN INCHES	
TOLERANCES:	
.XX ± .03	
.XXX ± .010	
ANGULAR ± 0.5°	
MATERIAL	FINISH
18 GAUGE 304 SSSL	⑩ SUPER #8

**LIGO** CALIFORNIA INSTITUTE OF TECHNOLOGY  
MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

NEXT ASSY: D0902655

PART NAME		MANIFOLD-CRYO BAFFLE INNER SEGMENT, ITM XY, BOTTOM	
DESIGNER	TQ. NGUYEN	16 DEC 2010	SIZE DWG. NO.
DRAFTER	TQ. NGUYEN	17 AUG 2010	D
CHECKER	M. SMITH	27 JUL 2010	D0902623
APPROVAL	D. COYNE	SCALE: 1:8	PROJECTION:
REV.	v3	SHEET 1 OF 1	

D0902623 at UCO\_Merfield\_Cryo\_Baffle\_Inner\_Segment1.ITM.X1.H2\_Bottom\_Pair\_PDM\_REV\_x031.DRAWING PDM\_REV\_x014