

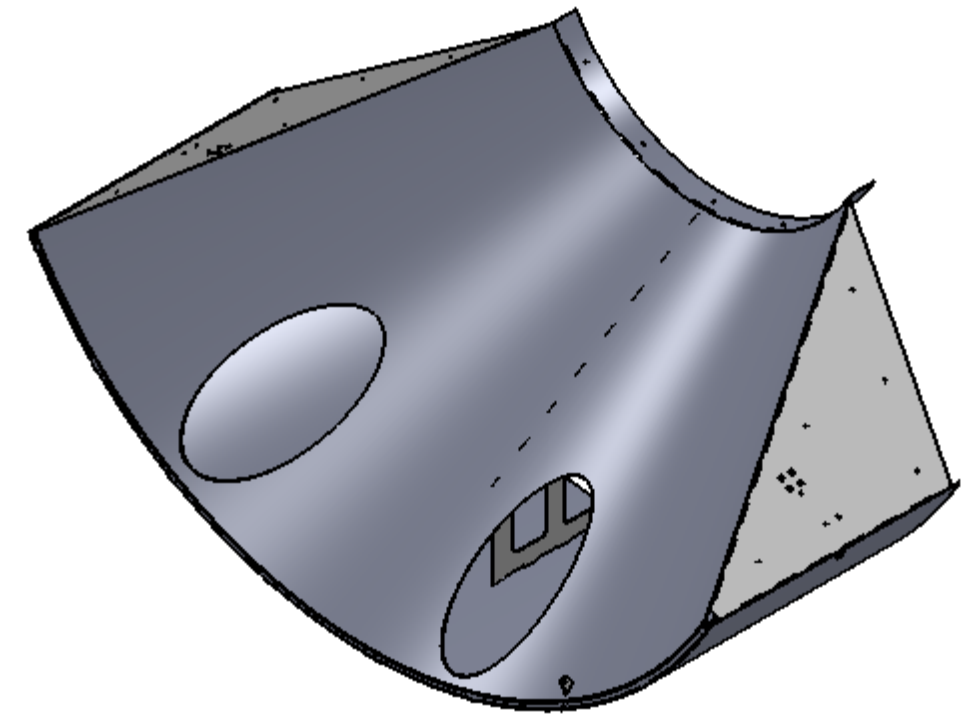
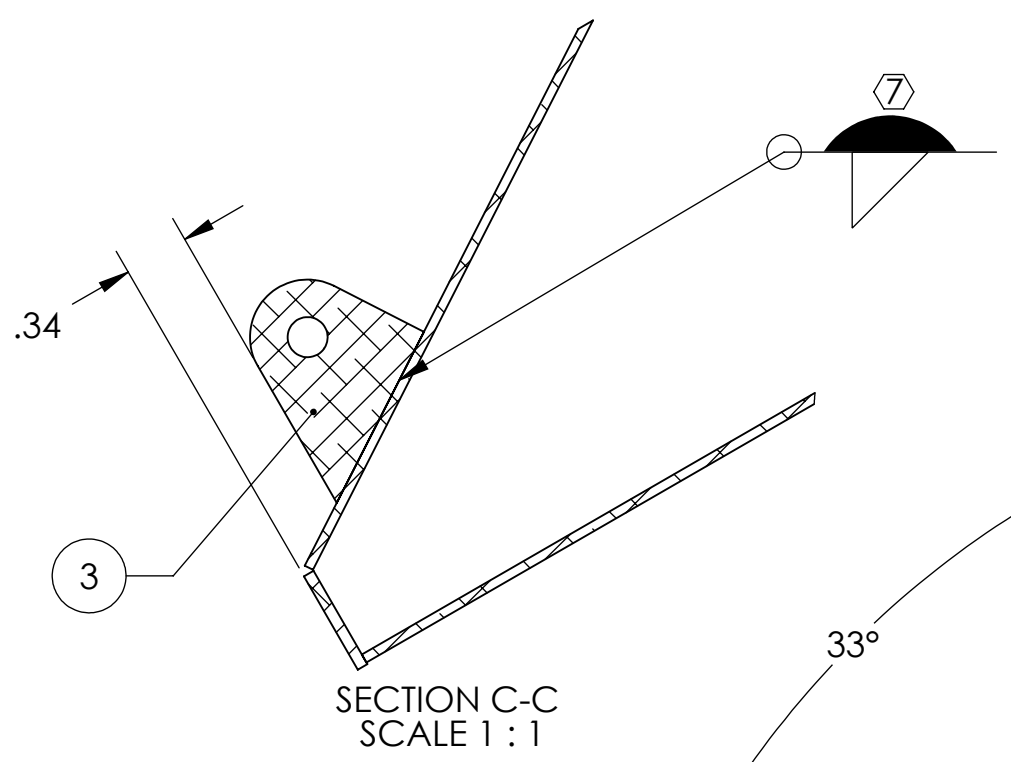
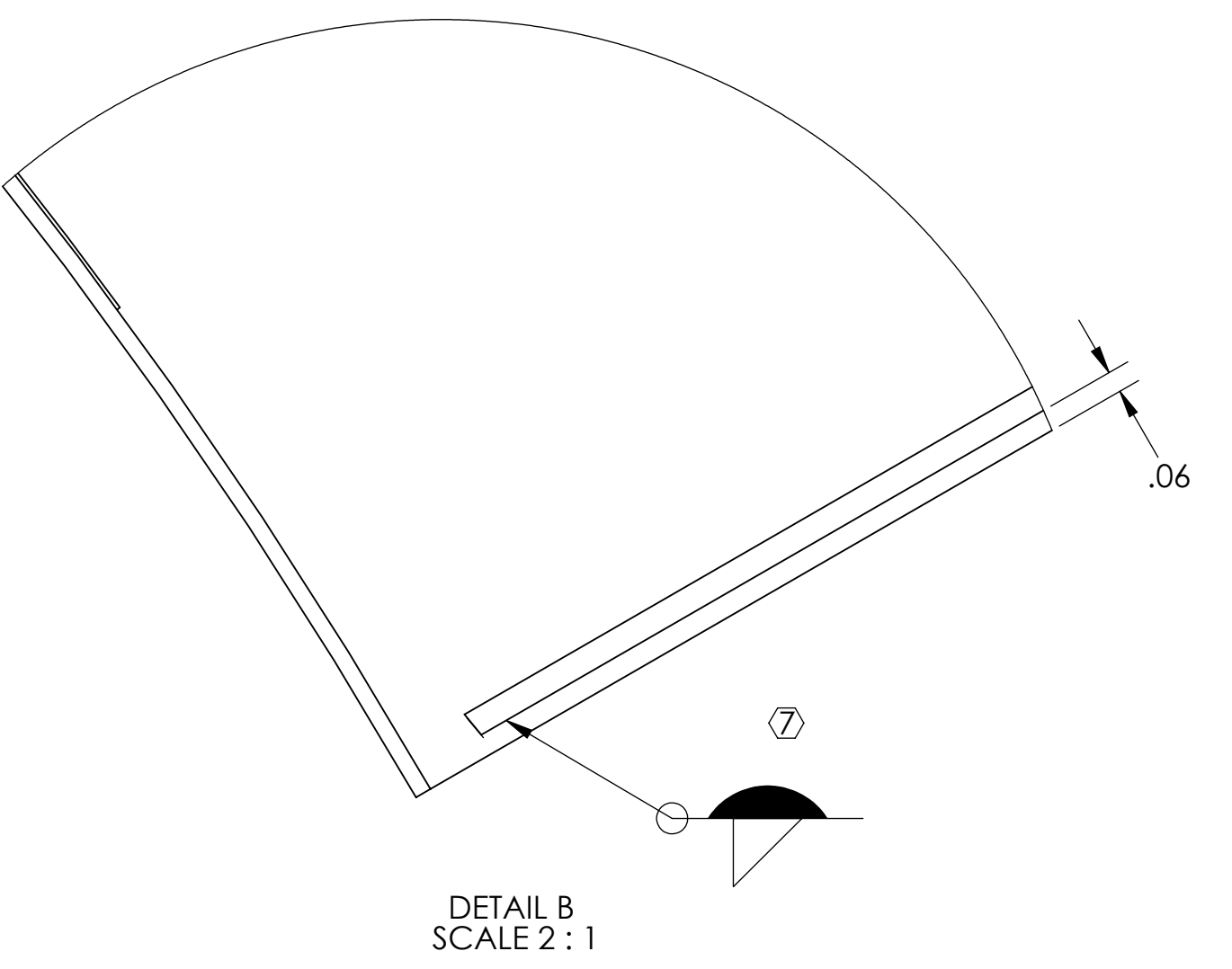
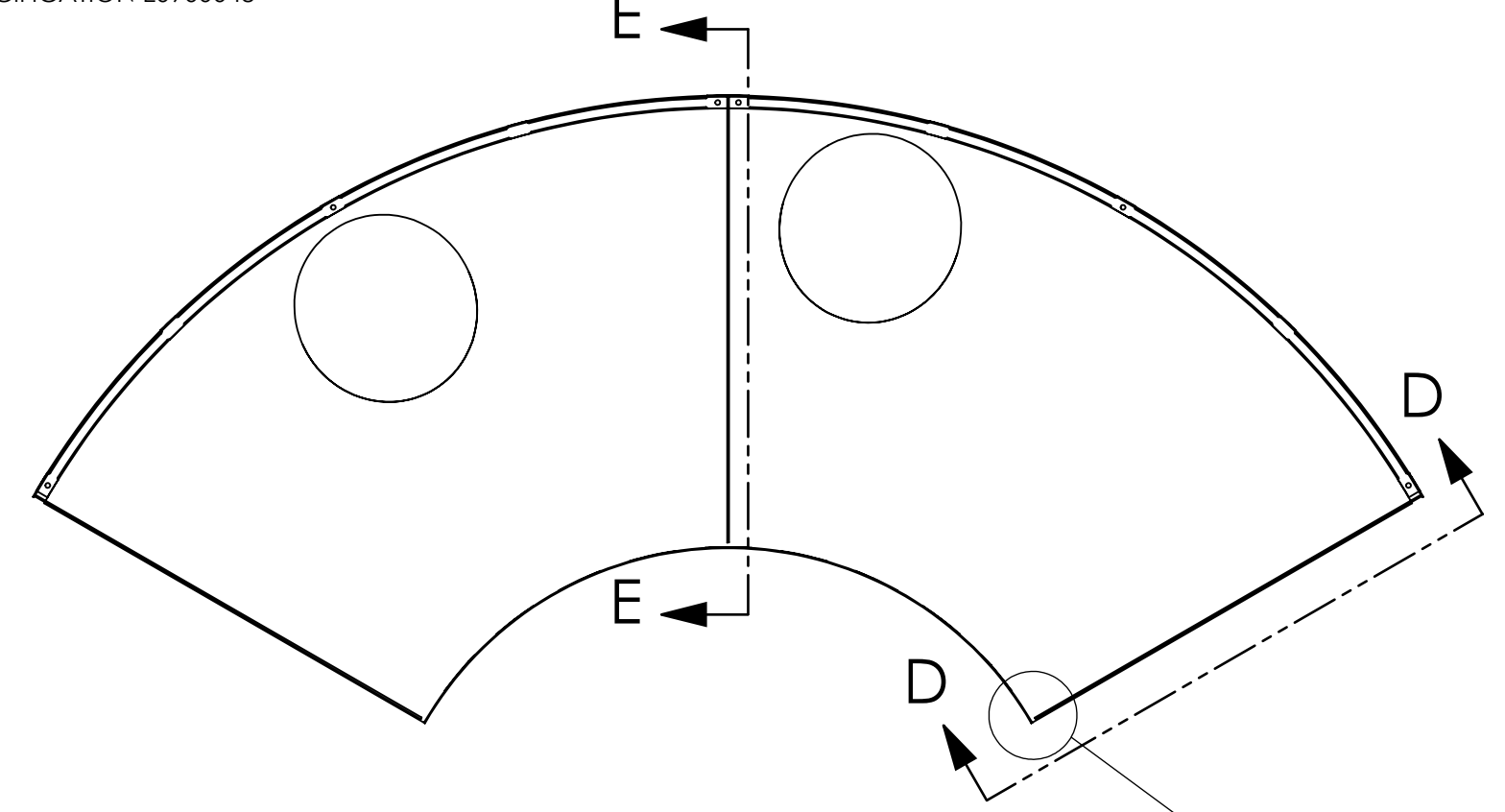
NOTES CONTINUED:

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

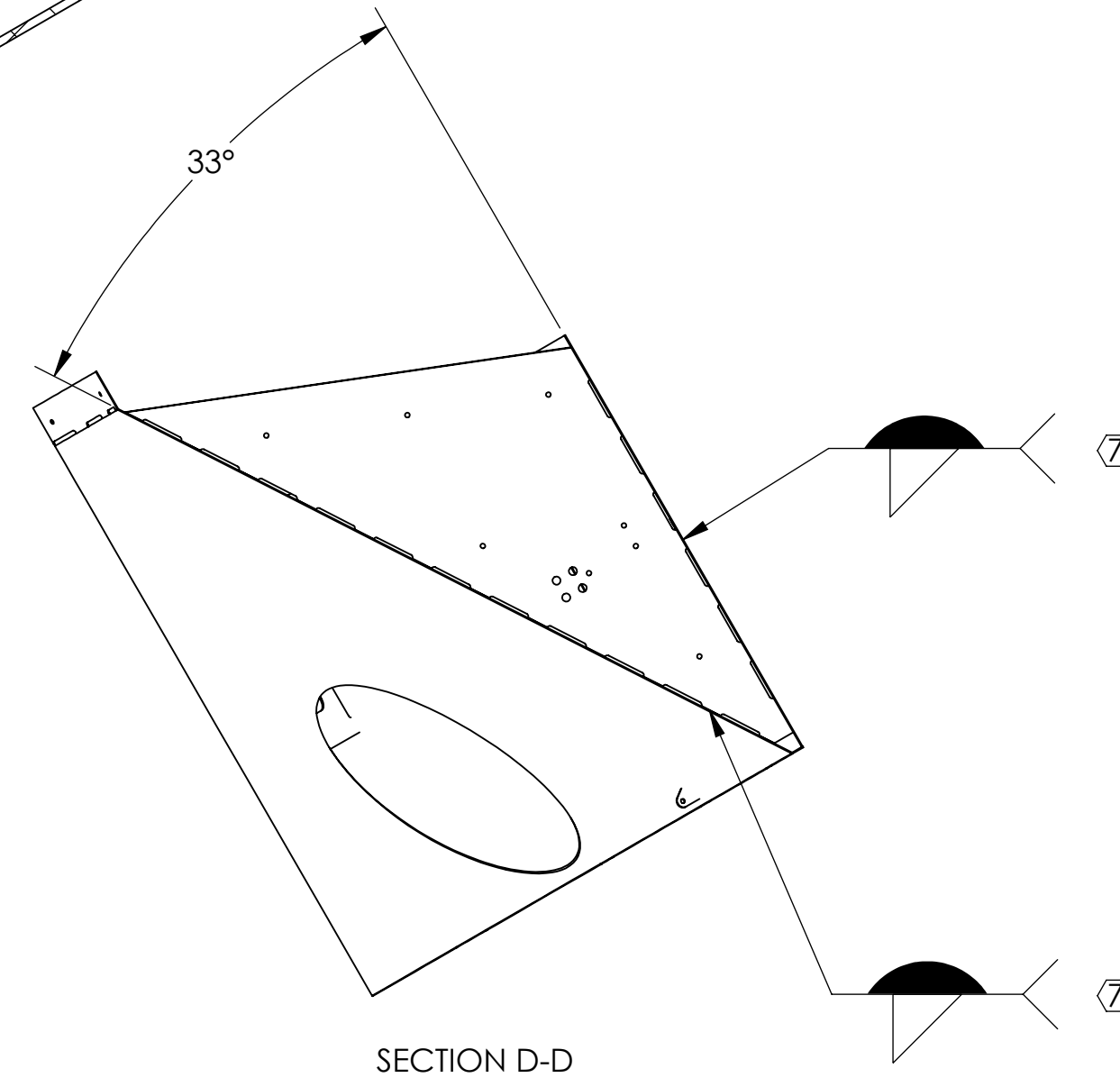
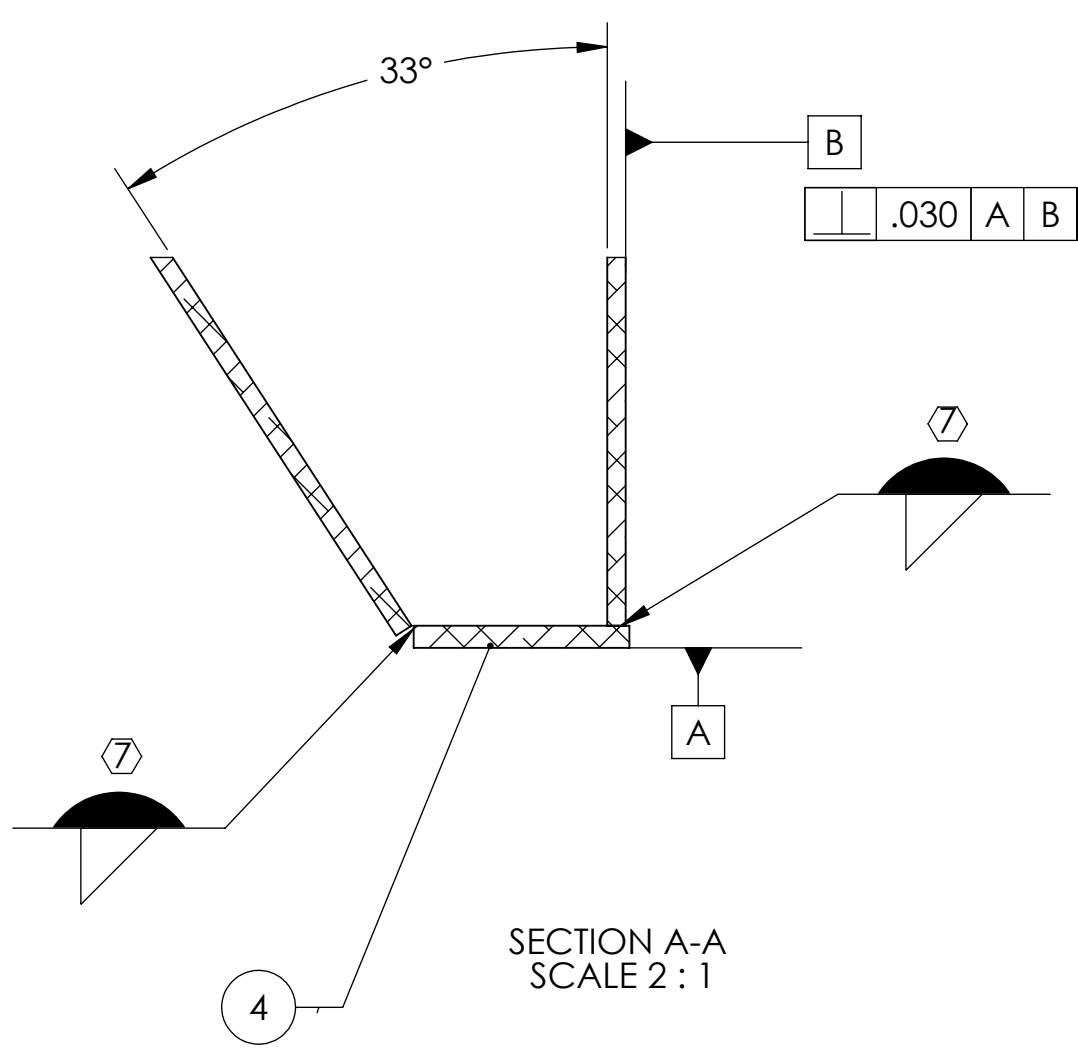
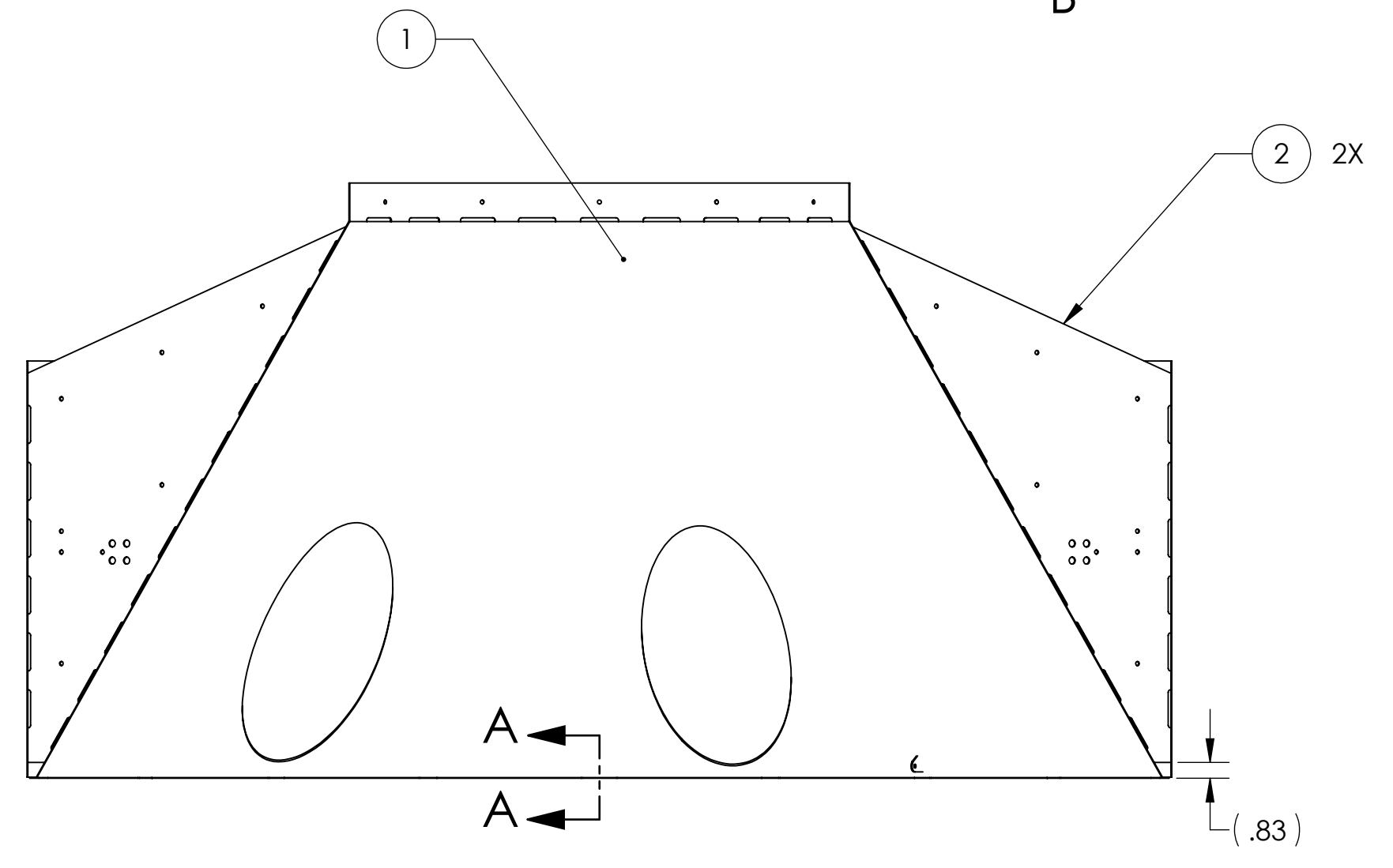
6. ASSEMBLY TO BE OXIDIZED AFTER WELDMENT IS COMPLETED PER SPECIFICATION E1100842.

⑦ FILLET WELDS WHERE ITEMS ① & ③, ① & ⑤, & ① & ④ MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048

REV.	DATE	DCN #	DRAWING TREE #
v1	20 MAY 2010	E1000360	E1000091
v2	9 MAY 2011	E1000360-v2	
v3	6 OCT 2011	E1000360-v3	

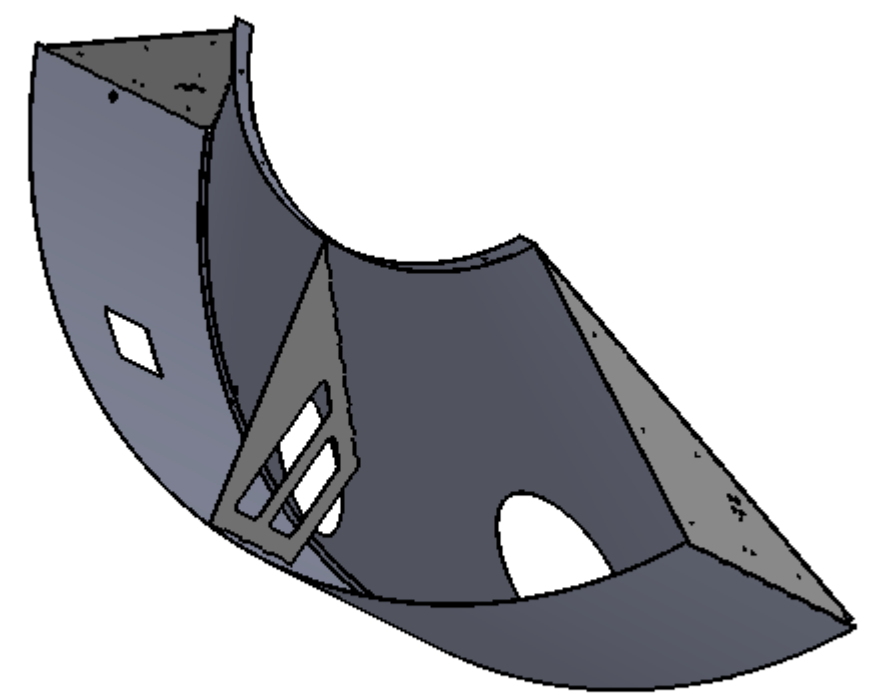


GENERAL VIEW FOR REFERENCE ONLY NO SCALE

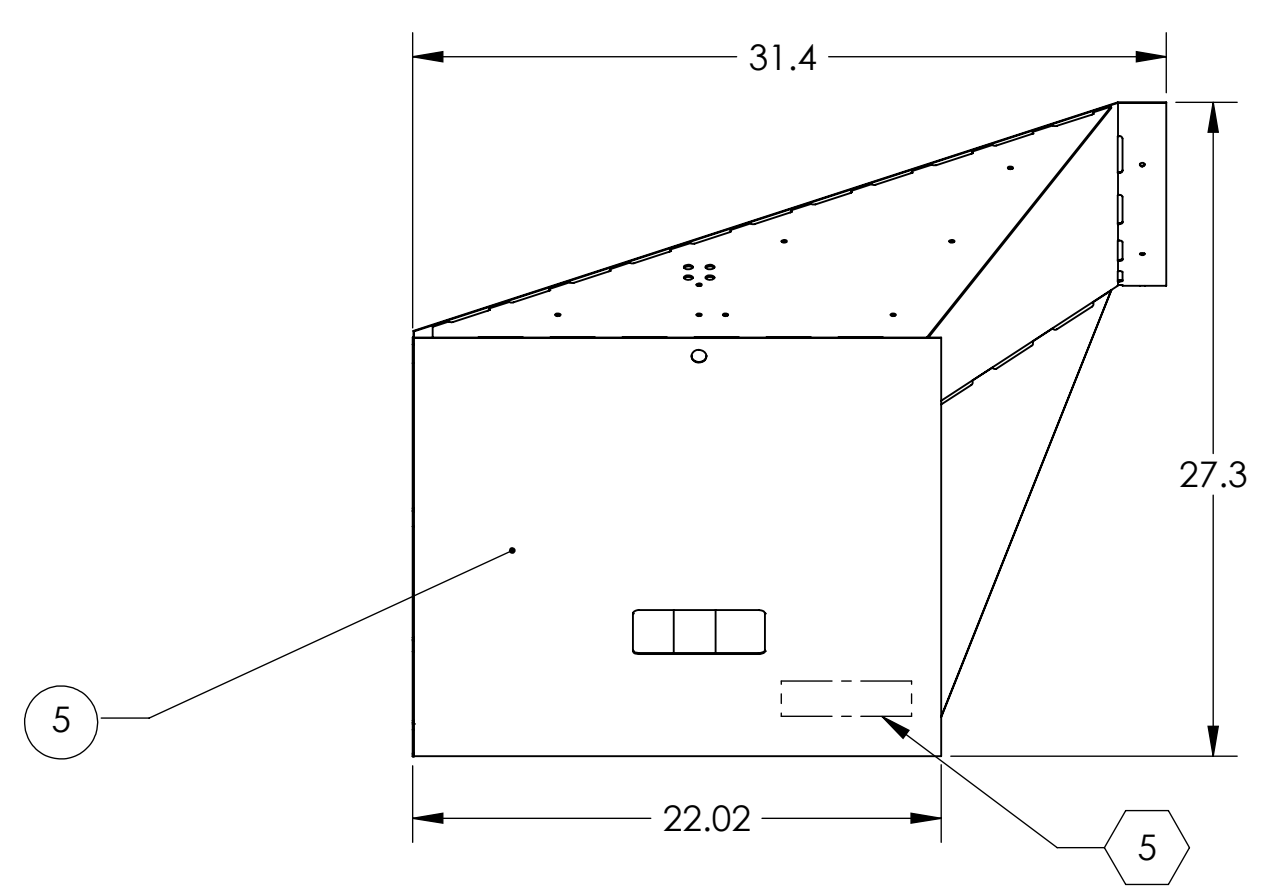
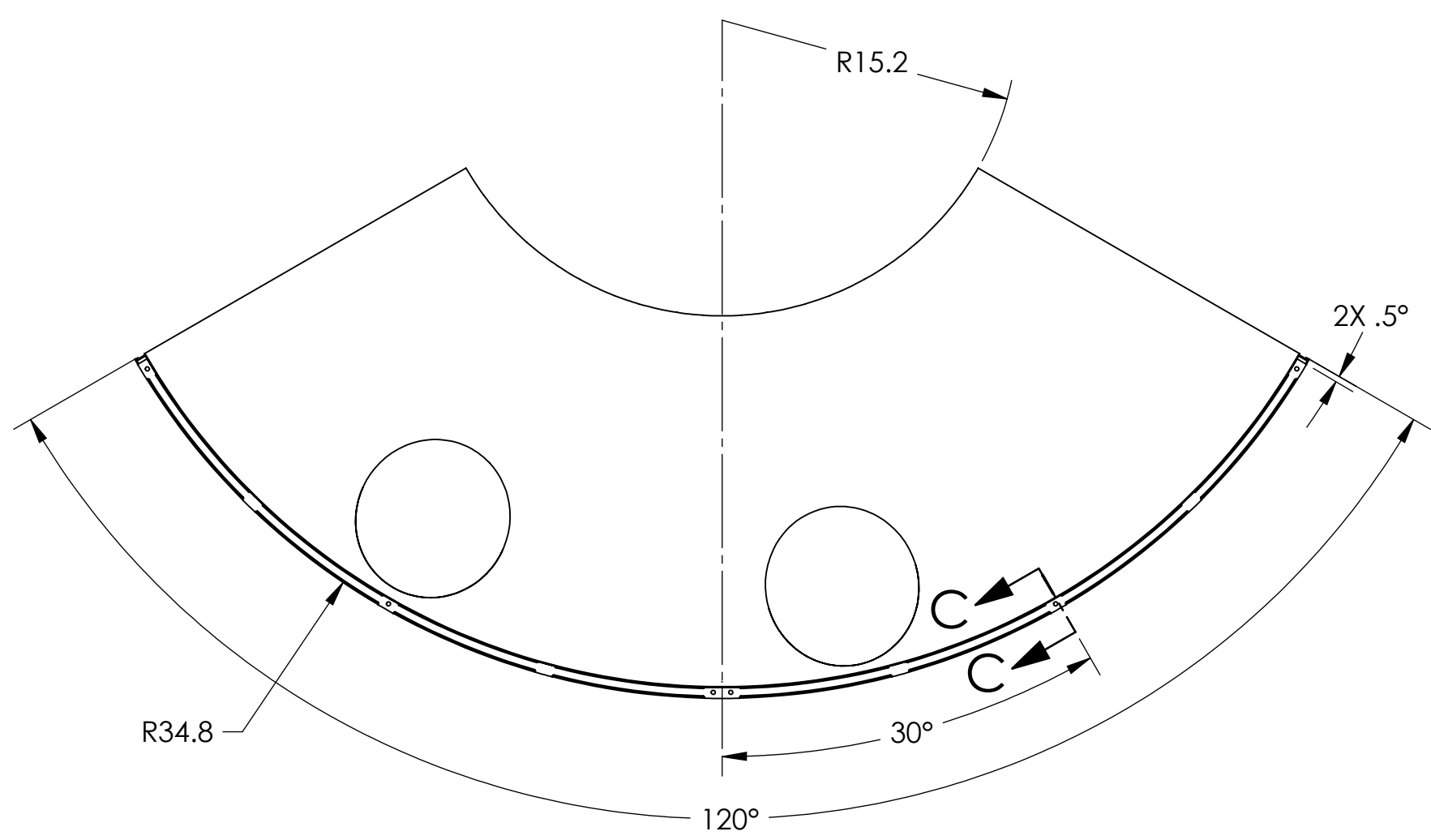


⑦7 PLS

⑦12 PLS



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
6	D1002849	MANIFOLD CRYO BAFFLE WELDMENT BRACE	14 GAUGE 304 SSSL	1		1
5	D1000559	RADIAL SEGMENT, RIGHT	18 GAUGE 304 SSSL	1		1
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14 GAUGE 304 SSSL	1		1
3	D1000536	BAFFLE BRACE BRACKET	14 GAUGE 304 SSSL	1		1
2	D0902621	MANIFOLD CRYO BAFFLE BRACKET	14 GAUGE 304 SSSL	2		2
1	D0902619	MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ITM XY, RIGHT	18 GAUGE 304 SSSL	1		1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010 ANGULAR ± 1.0°	
MATERIAL	N/A
FINISH	N/A

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	ADVANCED LIGO
SUB-SYSTEM	AOS
NEXT ASSY	D1101398

PARTS LIST					
PART NAME					
MANIFOLD CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ITM XY, RIGHT					
DESIGNER	H. KELMAN	20 MAY 2010	SIZE	DWG. NO.	REV.
DRAFTER	TQ. NGUYEN	07 SEP 2010	D	D0902654	v3
CHECKER	M. SMITH		SCALE: 1:8	PROJECTION:	SHEET 1 OF 1
APPROVAL	D. COYNE				

D0902654.dwg; Manifold_Cryo_Baffle_Segment_Subassembly_Weldment; ITM XY, RIGHT; PART PDM REV: X-070; DRAWING PDM REV: X-021