



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-V1, TYPE-XX, S/N XXX

6. ASSEMBLY TO BE PORCELAIN COATED AFTER WELDMENT IS COMPLETED PER SPECIFICATION E1000083  
 7. FILLET WELDS WHERE ITEMS 1 & 3, 1 & 5, 2 & 3, 1 & 4 MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048

REV.	DATE	DCN #	DRAWING TREE #
v1	17 MAR 2010	E1000360	E1000085
v2	9 MAY 2011	E1000360-v2	-
-	-	-	-

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
6	D1002849	MANIFOLD CRYO BAFFLE WELDMENT BRACE	14GA A424 TYPE I STEEL	1		1
5	D1000536	BAFFLE BRACE BRACKET	14GA A424 TYPE I STEEL	1		1
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14GA A424 TYPE I STEEL	1		1
3	D0902621	MANIFOLD CRYO BAFFLE BRACKET	14GA A424 TYPE I STEEL	2		2
2	D0902620	RADIAL SEGMENT, BOTTOM	18GA A424 TYPE I STEEL	1		1
1	D0902623	MANIFOLD-CRYO BAFFLE INNER SEGMENT, ITMX H1, BOTTOM	18GA A424 TYPE I STEEL	1		1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)  
 1. INTERPRET DRAWING PER ASME Y14.5-1994.  
 2. REMOVE ALL SHARP EDGES, R.02 MIN.  
 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:  
 .X ± .1  
 .XX ± .06  
 .XXX ± .010  
 ANGULAR ± 1.0°

MATERIAL: A424 TYPE I STEEL  
 FINISH: N/A

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

SYSTEM: ADVANCED LIGO  
 SUB-SYSTEM: AOS  
 NEXT ASSY: D0902061

PART NAME: MANIFOLD -CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ITMX H1-H2, BOTTOM

DESIGNER: H. KELMAN  
 DRAFTER: TQ. NGUYEN  
 CHECKER: M. SMITH  
 APPROVAL: D. COYNE

DATE: 17 MAR 2010  
 SIZE: D  
 DWG. NO.: D0902655  
 SCALE: 1:8  
 PROJECTION: 1st Angle  
 SHEET 1 OF 1

D0902655 at LIGO\_Monfield\_Cryo\_Baffle\_Segment\_Subassembly\_Weldment\_ITMX\_H1-H2\_Bottom\_PART\_PDM\_REV-X-080\_DRAWING\_PDM\_REV-X-025