NOTES CONTINUED:

Ⓢ 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: DXXXXXXX-VY, TYPE-XX, S/N XXX

6. APPROXIMATE WEGHT: 26.750 LBS.

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

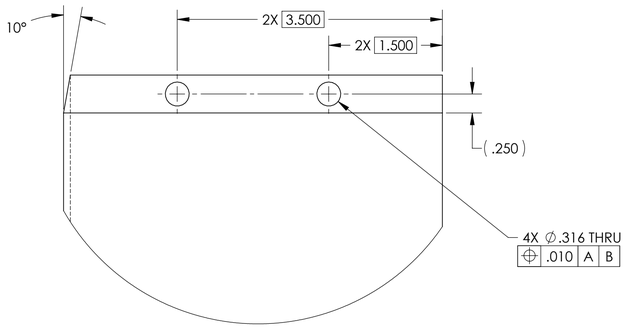
8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

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

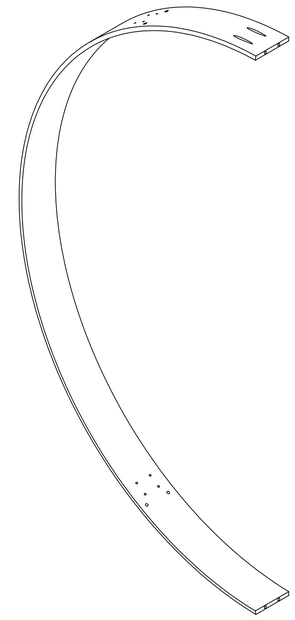
10. BEND RADIUS: UNLESS OTHERWISE NOTED, THE BEND RADIUS SHOULD BE THE MINIMUM REQUIRED TO FORM WITHOUT CRACKING OR REQUIRING ADDITIONAL WORK WHEN FORMING.

11. ELECTRO POLISH TO REMOVE .0005-.001 PER SIDE.

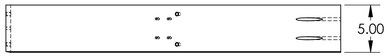
REV.	DATE	DCN #	DRAWING TREE #
v1	5 OCT 2010	E1000185	E1000358
v2	11 MAY 2011	E1000360-v2	-
v3	29 AUG 2012	E1000360	-

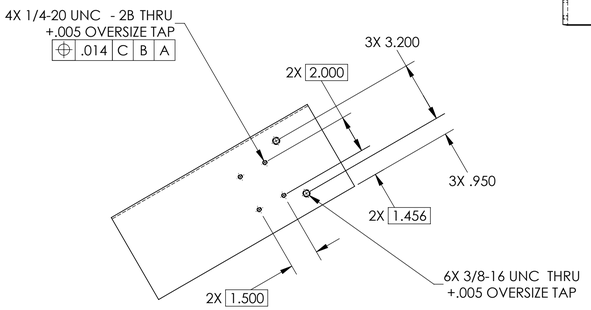


DETAIL A
SCALE 1 : 1

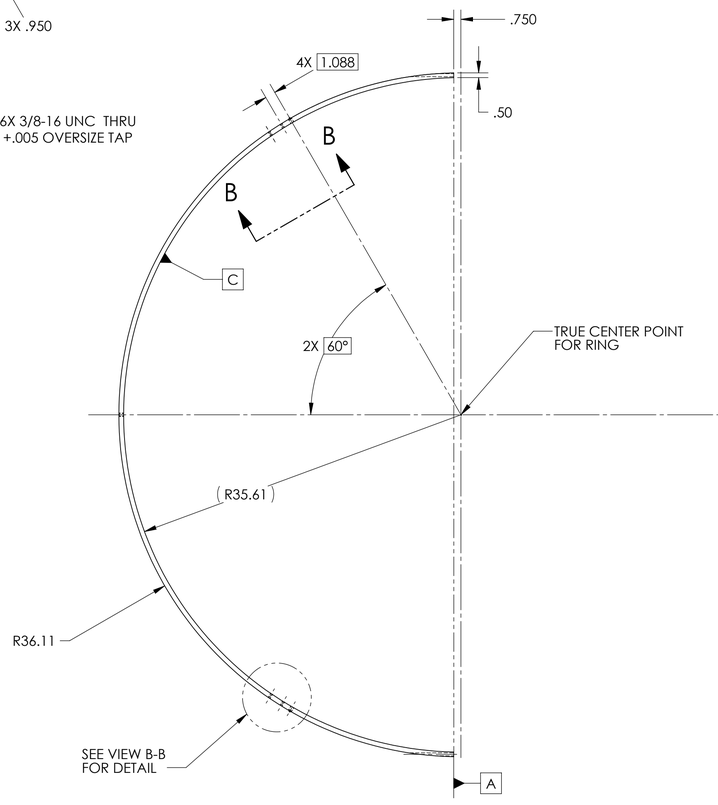


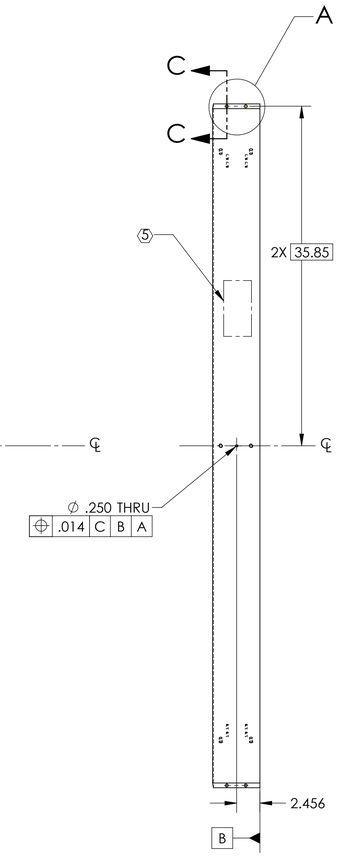
GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE

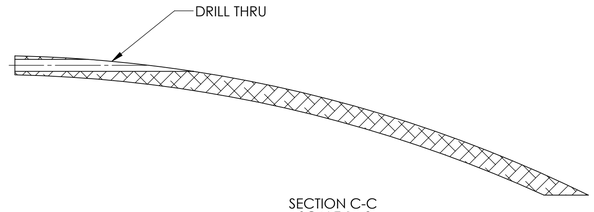




SECTION B-B
SCALE 1 : 4
2 PLACES







SECTION C-C
SCALE 1 : 2
4 PLACES

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)									
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .02 .XXX ± .005 ANGULAR ± 0.5°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	MANIFOLD-CRYO BAFFLE SUSPENSION RING, BOTTOM			
	MATERIAL: 6061-T6 Al	FINISH: 63 µinch	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	DESIGNER	H. KELMAN	08 JUNE 2010	SIZE: D	DWG. NO.: D0902816 REV.: v3
			NEXT ASSY: D1002084		DRAFTER	TQ. NGUYEN	19 AUG 2010		
					CHECKER	M. SMITH	27 JAN 2012		
					APPROVAL	D. COYNE	27 JAN 2012	SCALE: 1:8	PROJECTION: SHEET 1 OF 1

D0902816_aLIGO_Manifold_Cryo_Baffle_Suspension_Ring_Bottom, PART FDM REV: X-056, DRAWING FDM REV: X-023