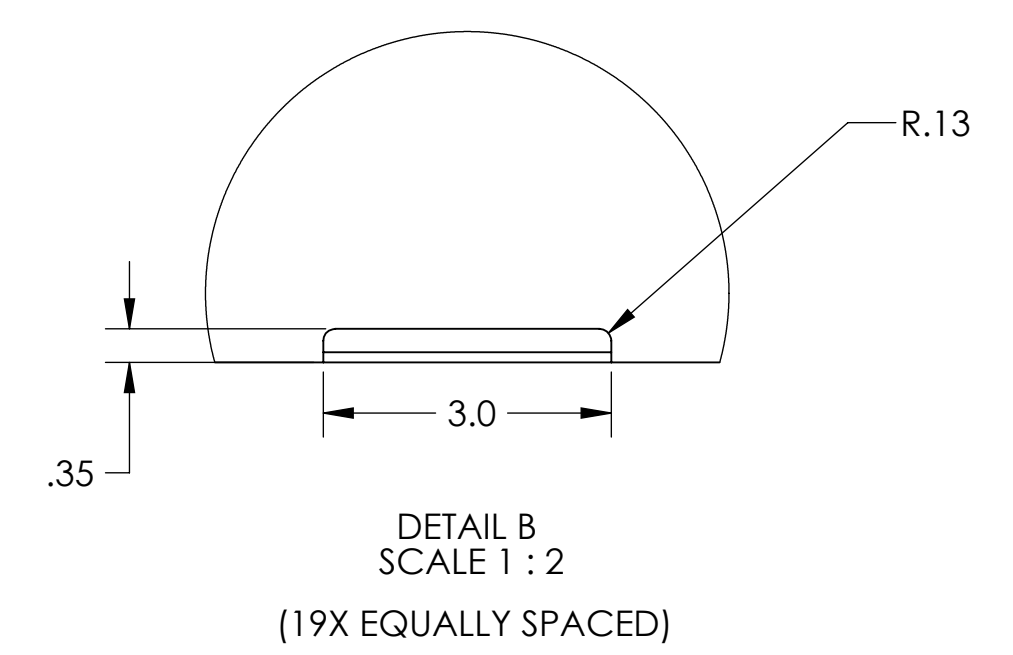
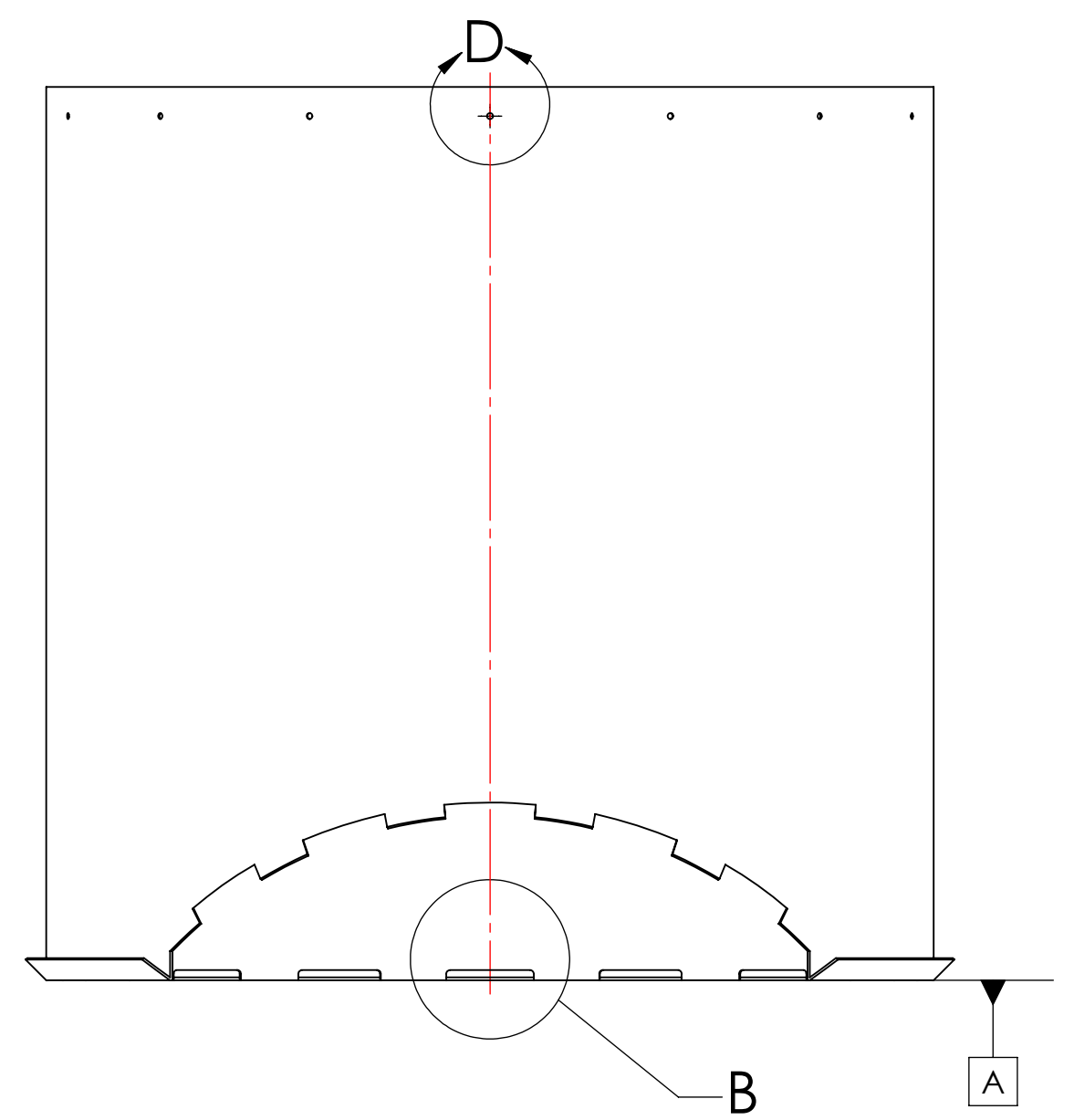
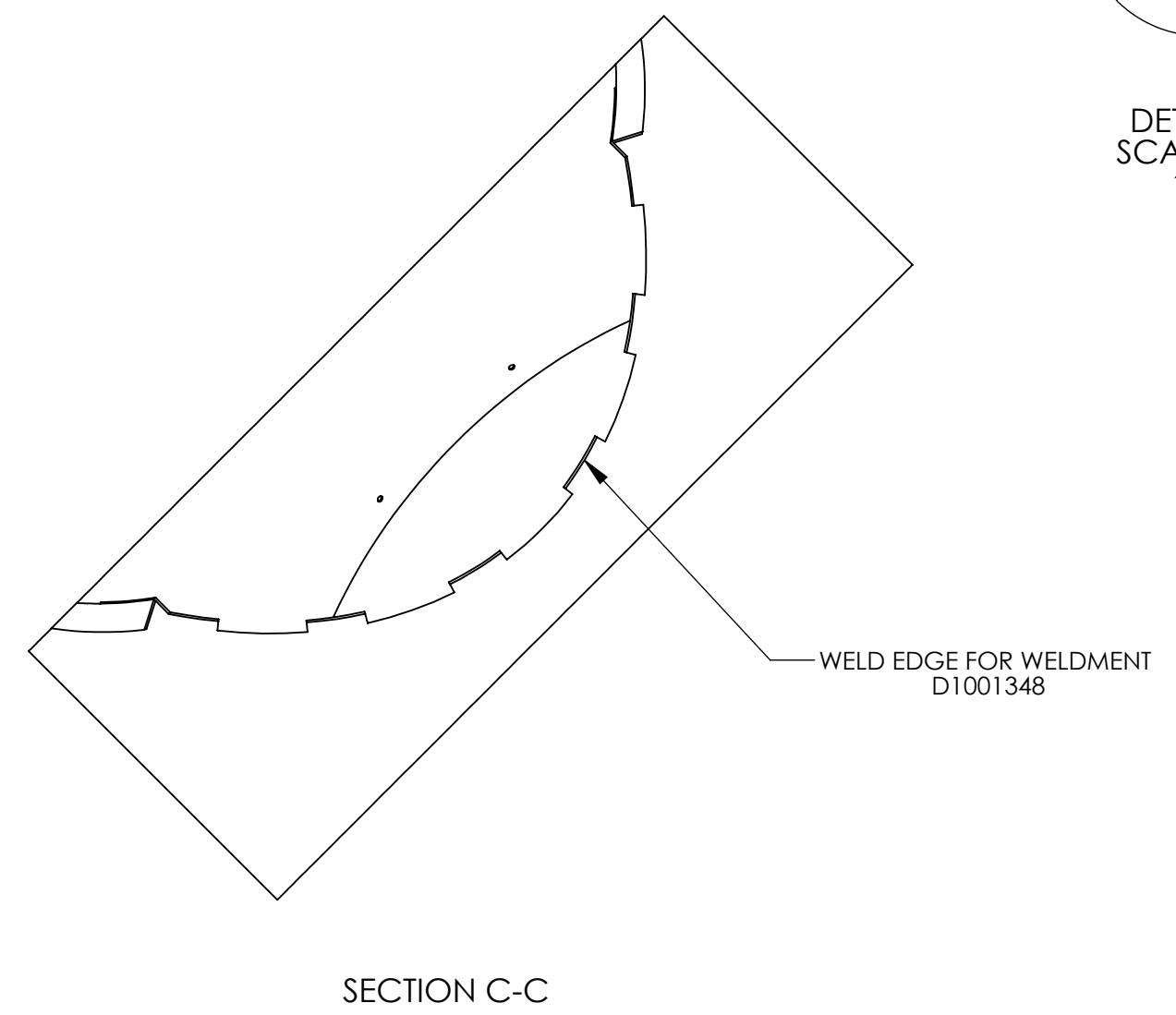
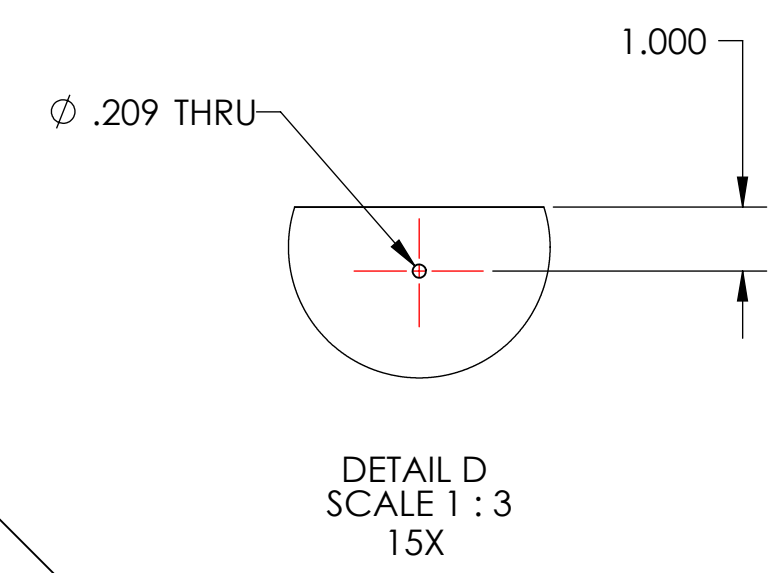
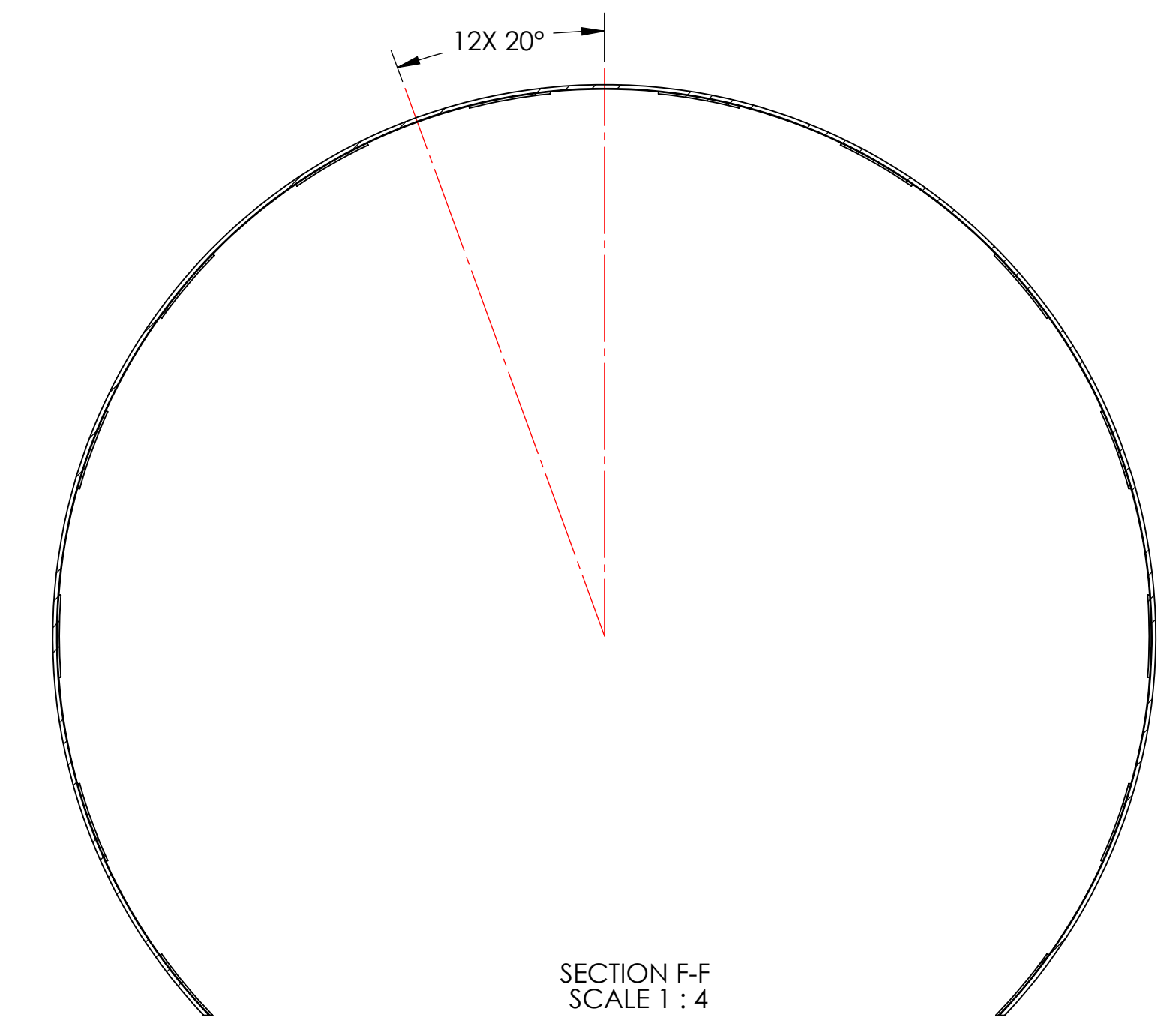
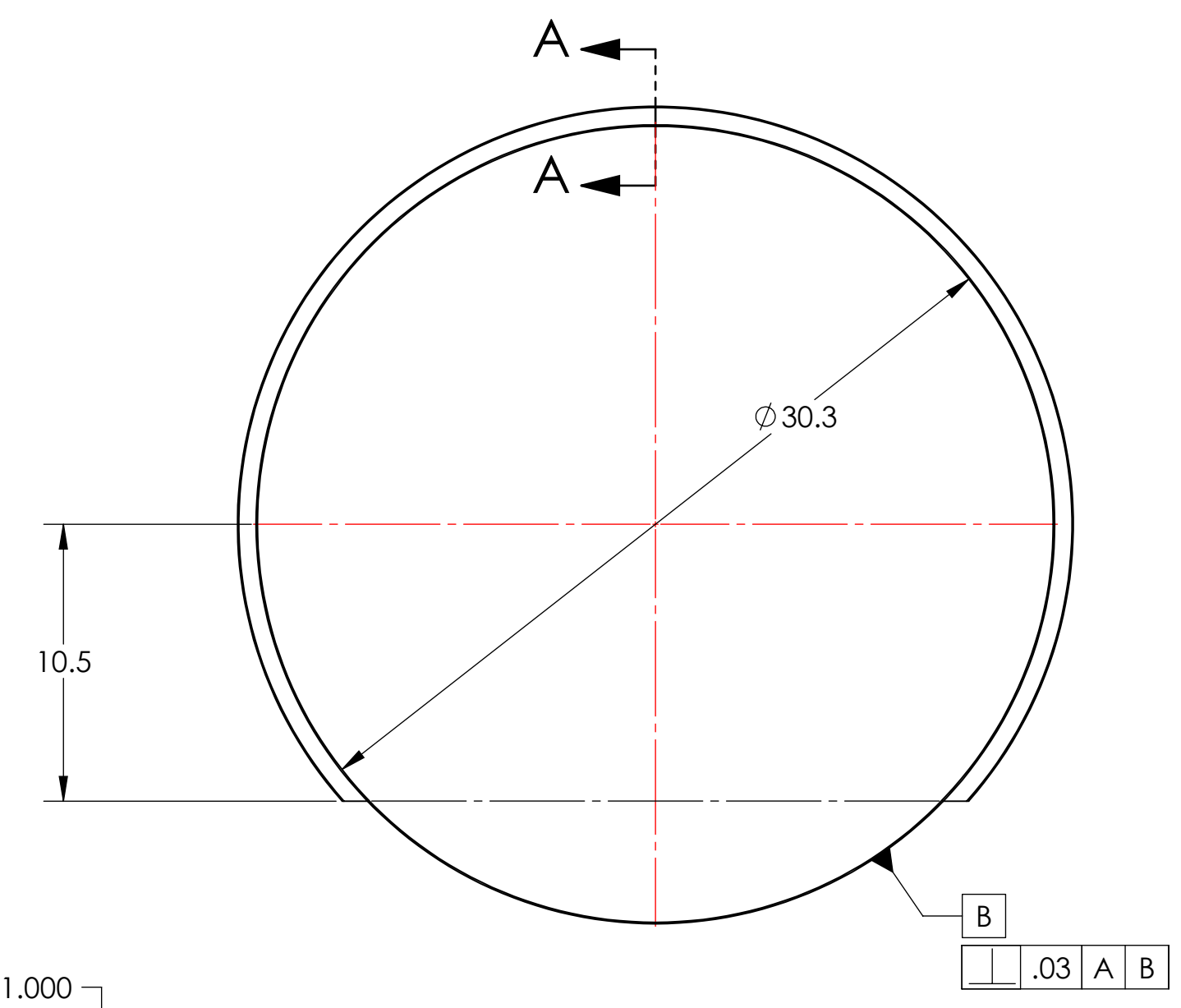
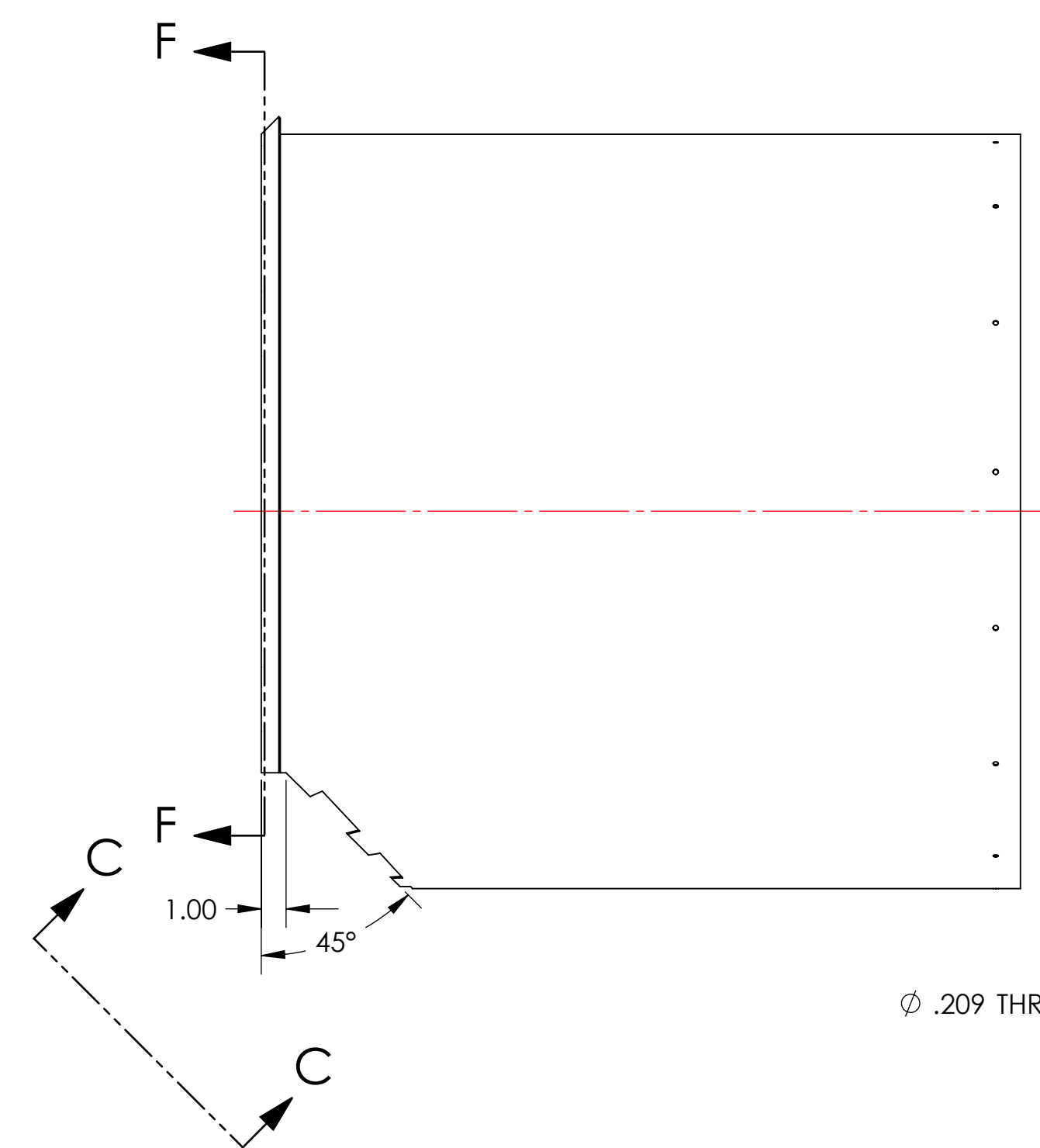
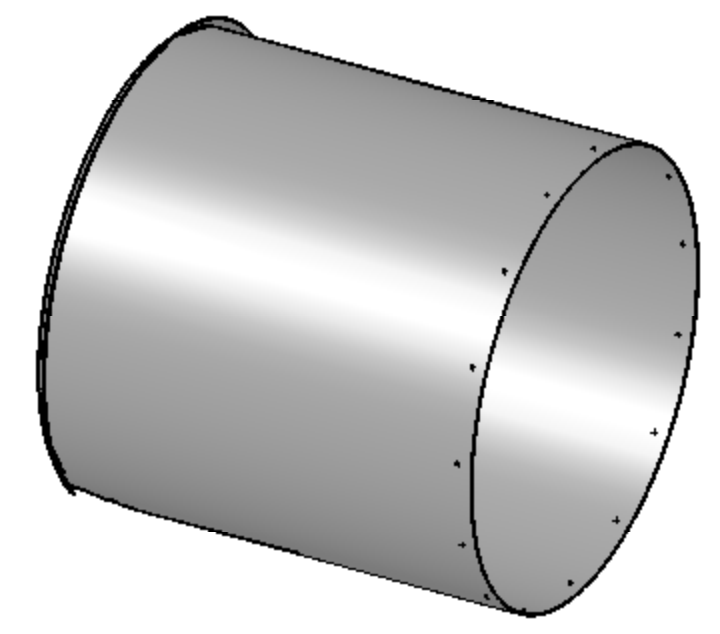
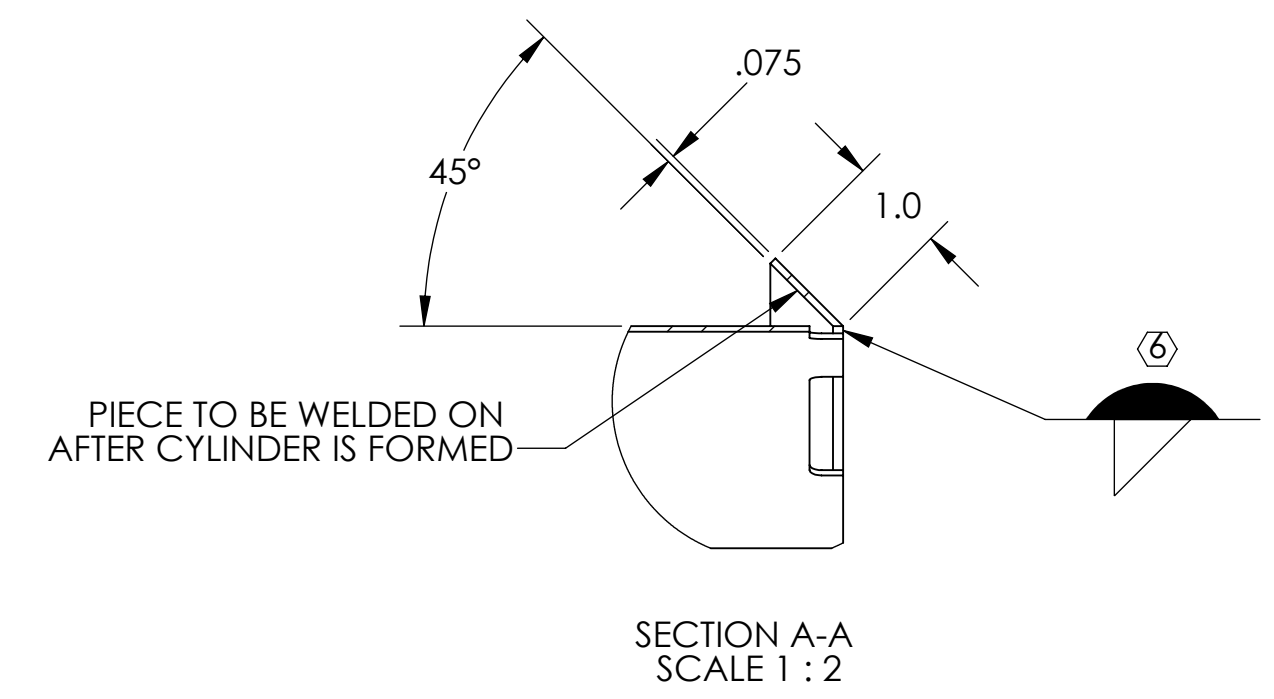


NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
 EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

⑥ FILLET WELD WHERE RING AND CYLINDER MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048

⑦ AS RECEIVED MACHINE FINISH

REV.	DATE	DCN #	DRAWING TREE #
V1	07 SEP 2010	E1000360	E1000367



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.

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME			
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010		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.		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS		MANIFOLD-CRYO BAFFLE CYLINDER	
ANGULAR ± 1.0°		MATERIAL 18GA A424 TYPE I STEEL		FINISH ⑦		NEXT ASSY D1001348		DESIGNER H. KELMAN	
						DESIGNER TQ. NGUYEN		DATE 5 APR 2010	
						CHECKER M. SMITH		DATE 07 SEP 2010	
						APPROVAL D. COYNE		SIZE D	
								DWG. NO. D1000570	
								REV. v1	
								SCALE: 1:6	
								PROJECTION:	
								SHEET 1 OF 1	

D1000570.dwg - Manifold_Cryo_Baffle_Cylinder_Parts - PART FDM REV: X014 - DRAWING FDM REV: X005