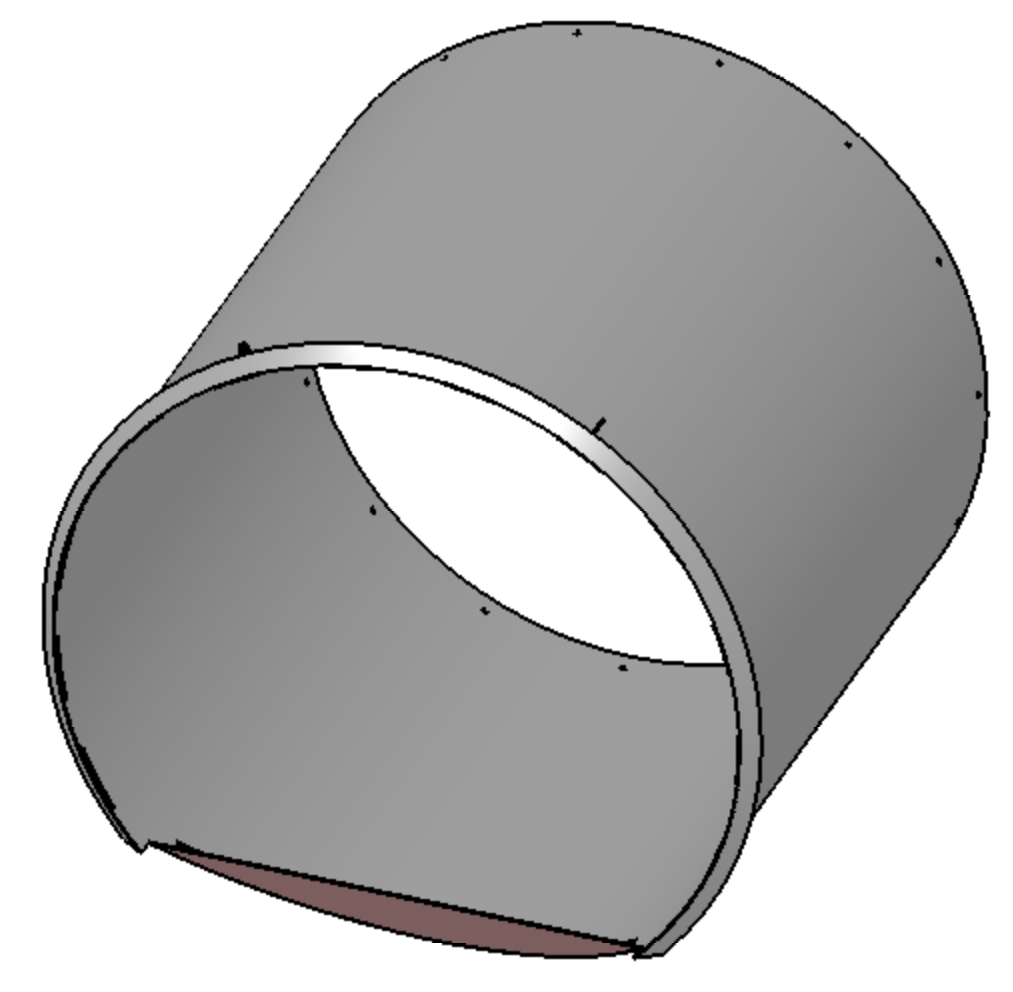
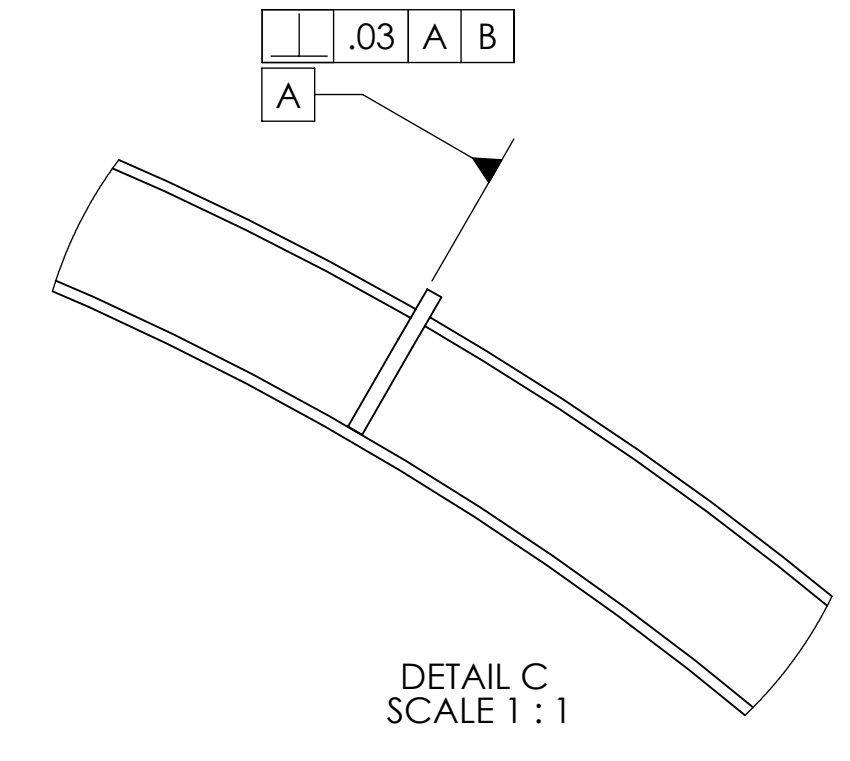
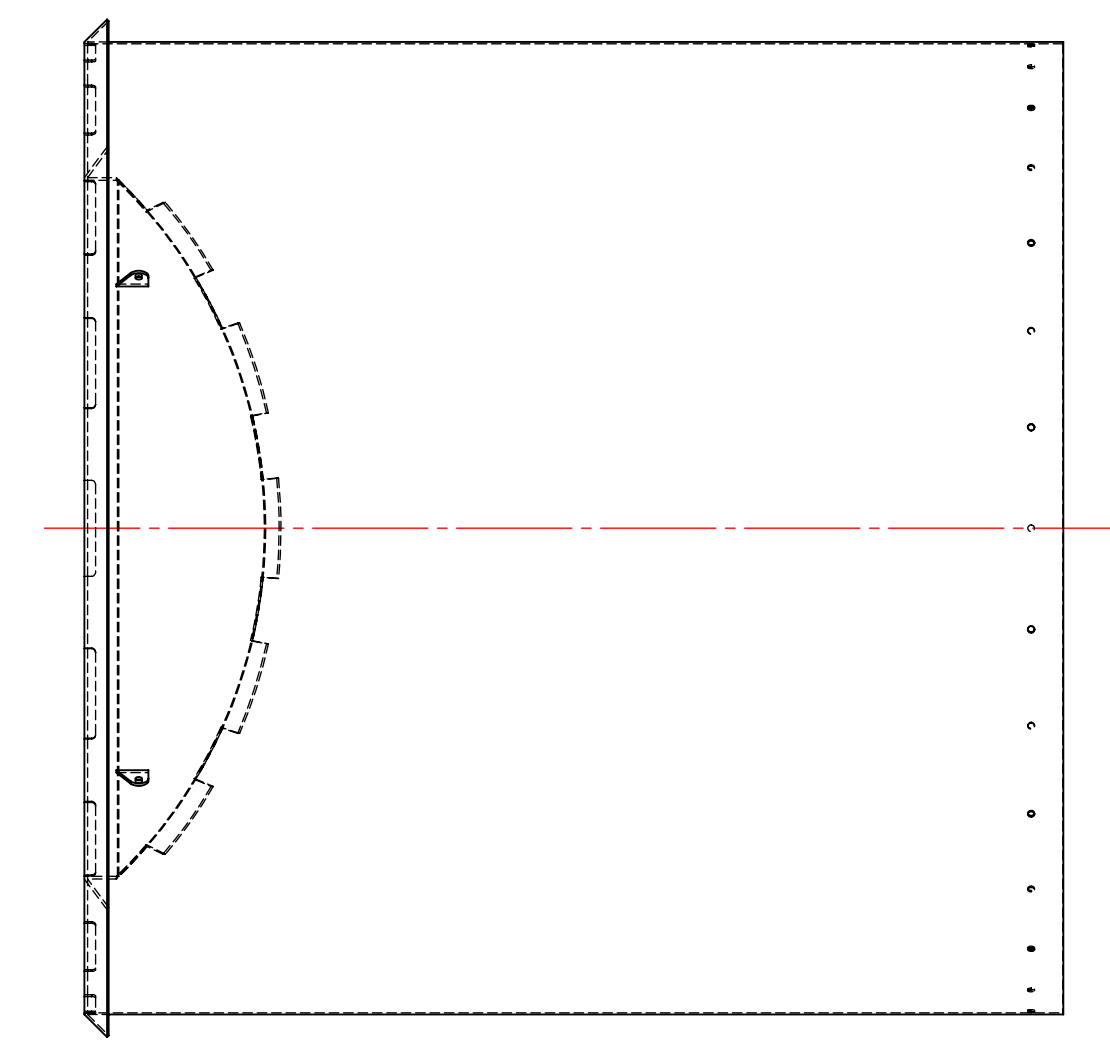
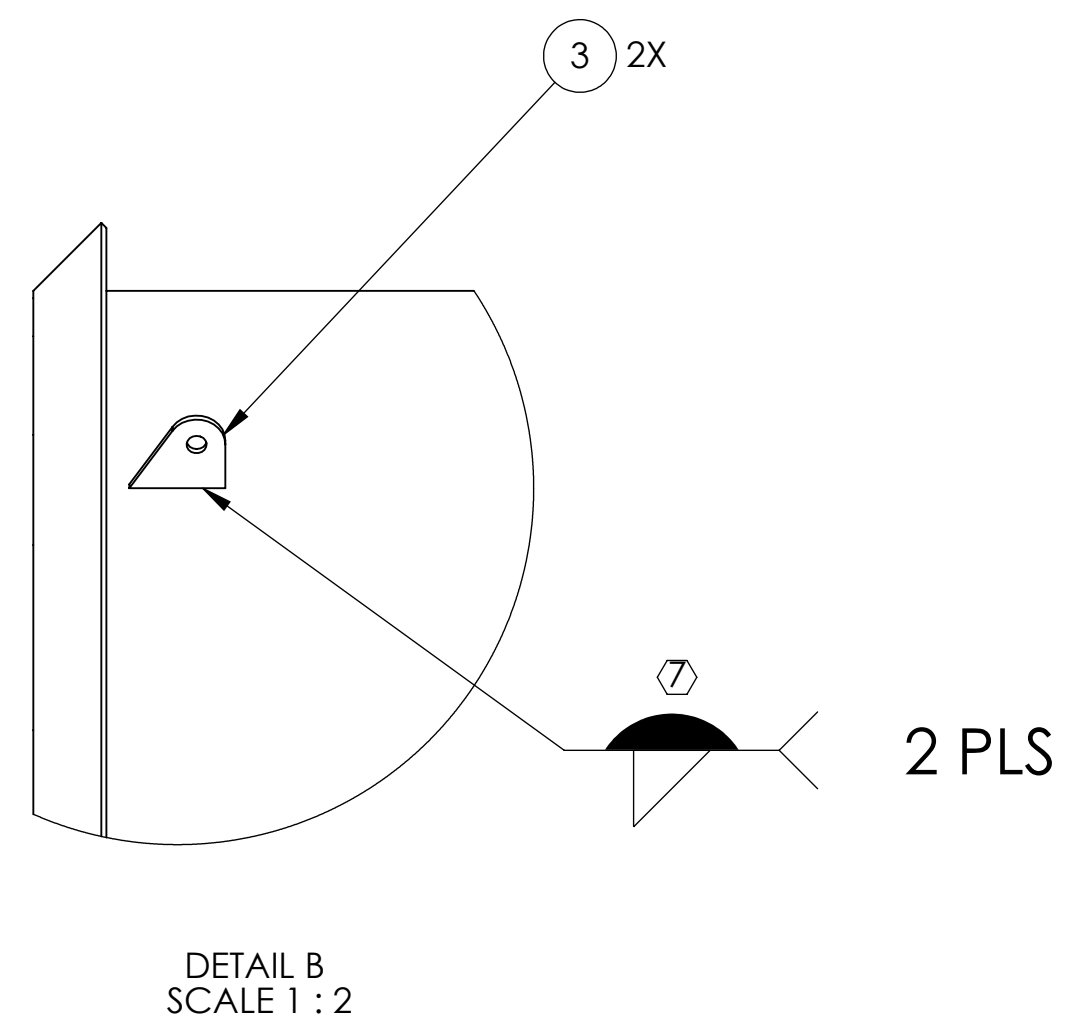


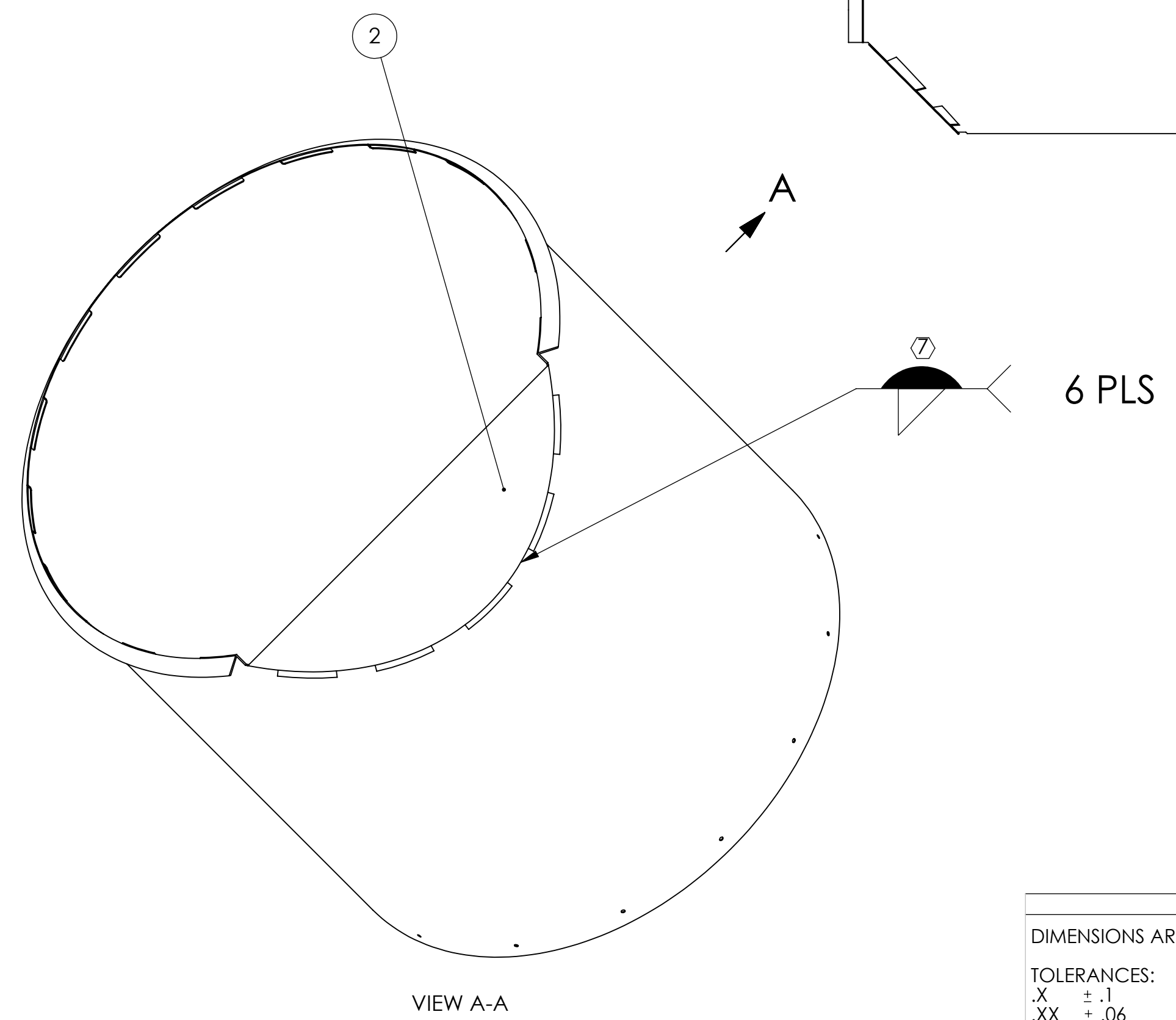
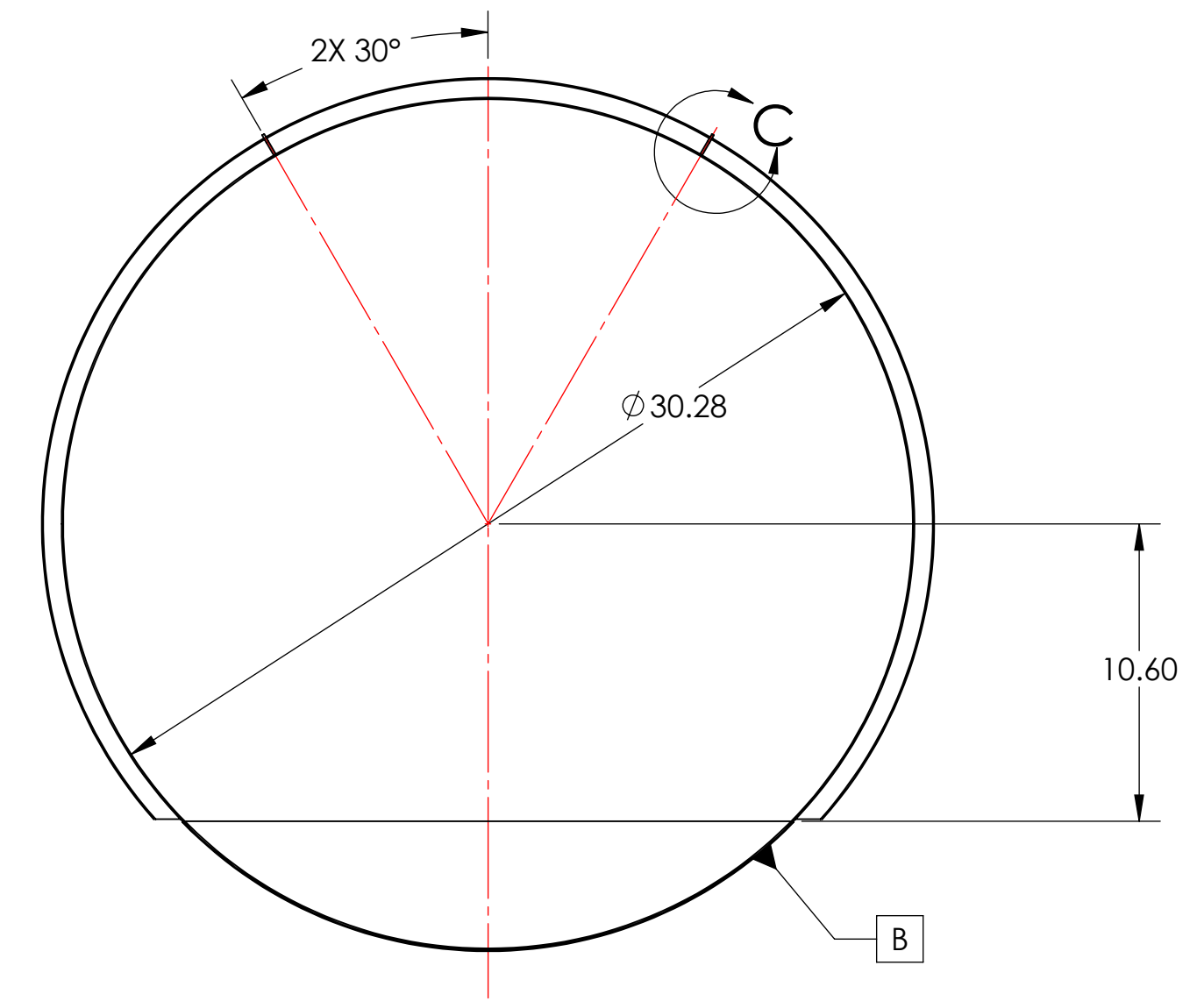
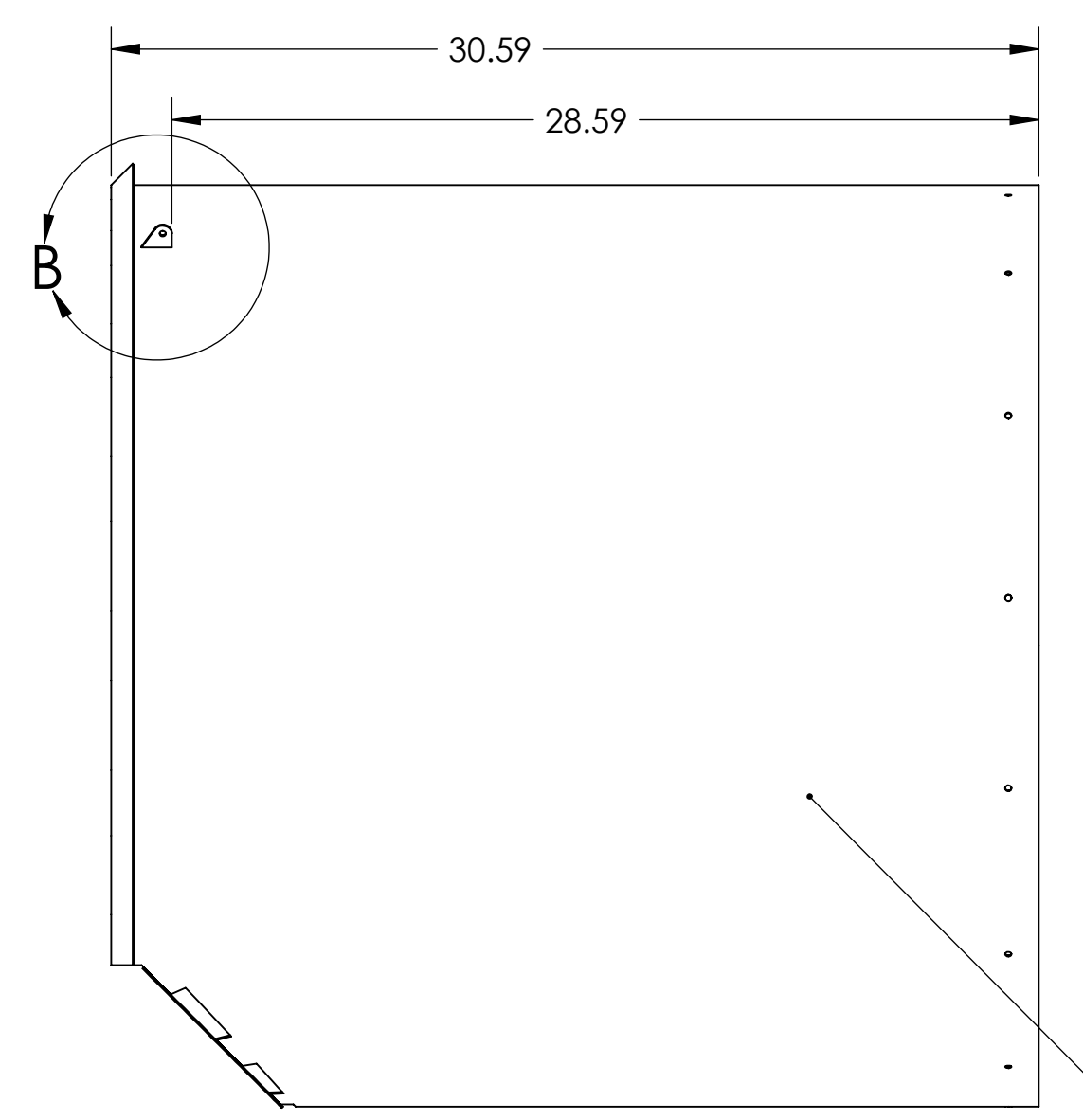
NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. 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. ASSEMBLY WILL BE PORCELAIN COATED AFTER WELDMENT IS COMPLETED.
 ⑦ FILLET WELD WHERE ITEMS ① & ③ AND ① & ② MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E 0900048

REV.	DATE	DCN #	DRAWING TREE #
V1	20 MAY 2010	E1000360	E1000367
-	-	-	-
-	-	-	-



GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
3	D1000536	Baffle Brace Bracket	14GA A424 TYPE I STEEL	2		2
2	D1001018	ELLIPSE SCRAPER BLADE	14GA A424 TYPE I STEEL	1		1
1	D1000570	MANIFOLD-CRYO BAFFLE CYLINDER	18GA A424 TYPE I STEEL	1		1

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		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	
ANGULAR ± 1.0°		MATERIAL N/A		FINISH N/A		PART NAME MANIFOLD-CRYO BAFFLE CYLINDER-SCRAPER ASSEMBLY	
		NEXT ASSY D1002061		DESIGNER H. KELMAN 25 MAY 2010		SIZE DWG. NO. D D1001348	
				DRAFTER TQ. NGUYEN 07 SEP 2010		REV. v1	
				CHECKER M. SMITH		SCALE: 1:6 PROJECTION:	
				APPROVAL D. COYNE		SHEET 1 OF 1	

D1001348.dwg: Manifold_Cryo_Baffle_Cyl_Scraper Assy: PART PDM REV: X-017: DRAWING PDM REV: X-005