

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-VY, TYPE-XX, S/N XXX

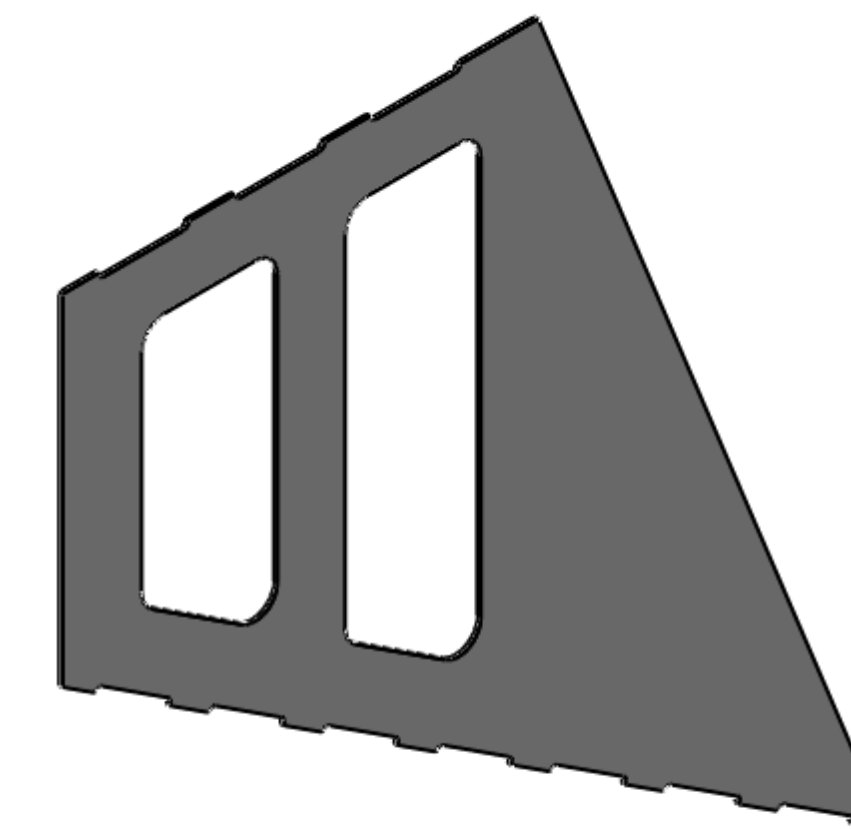
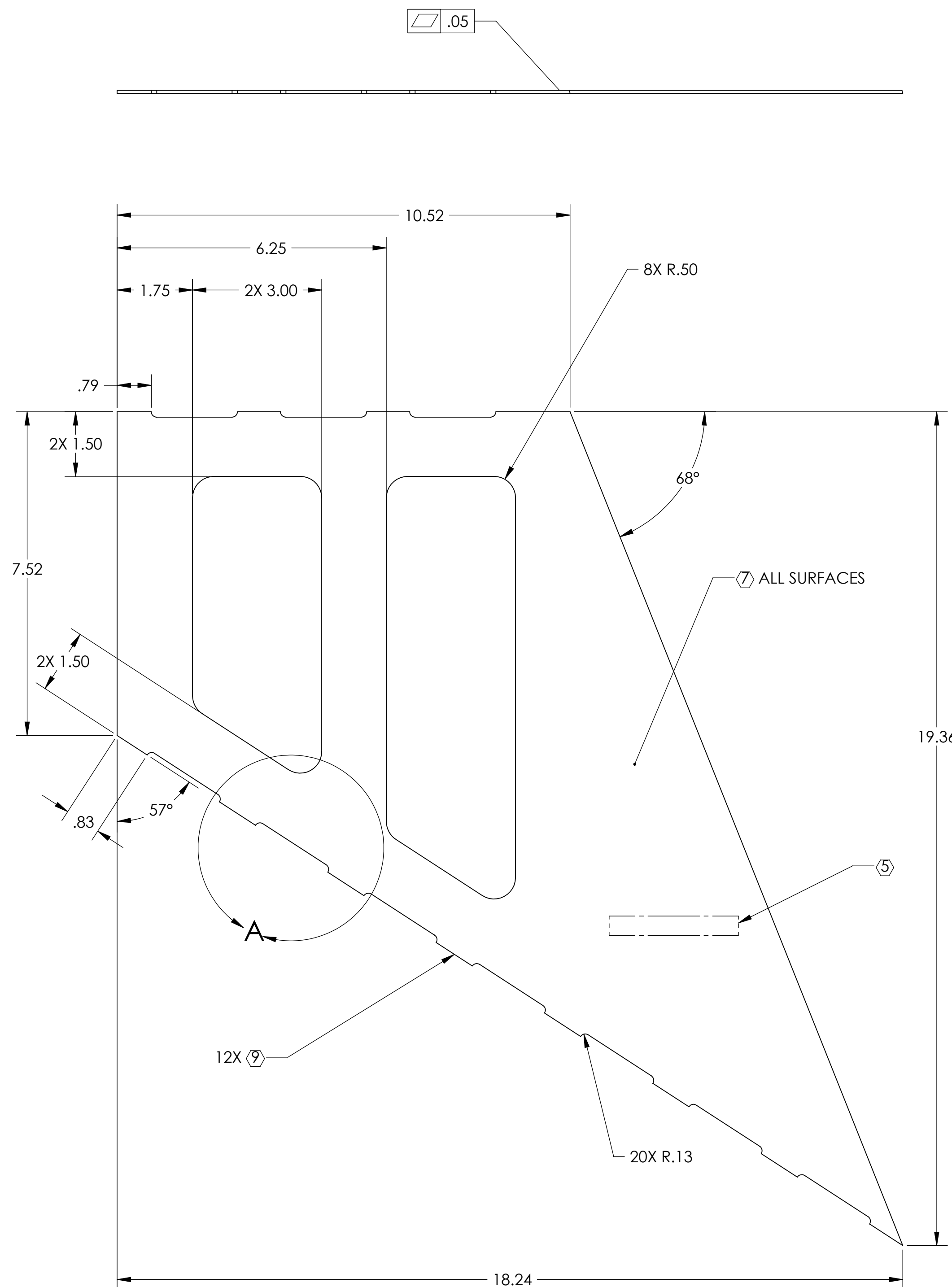
6. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.

7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364 AND E1100842.

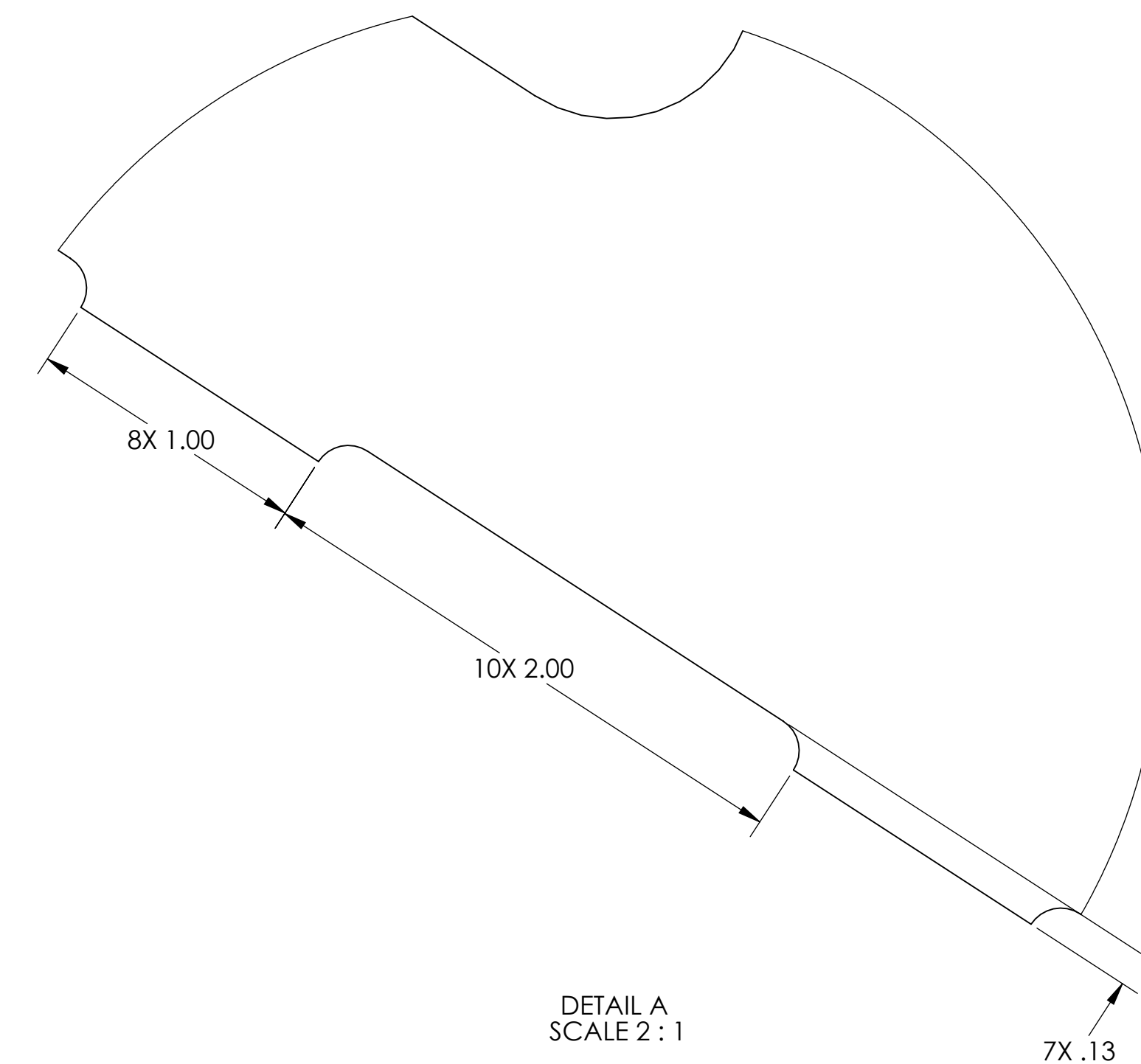
8. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.

9. CASTELLATION ON MATERIAL EDGES ARE FOR WELD PURPOSES IN ASSEMBLIES (D0902654, D0902655, D0902656).

REV.	DATE	DCN #	DRAWING TREE #
v1	2 OCT 2010	E1000360	E1000085-v1
v2	12 MAY 2011	E1000360-v2	E1000090-v1
v3	4 OCT 2011	E1000360-v3	E1000091-v1



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



DETAIL A SCALE 2:1

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 NEXT ASSEMBLY FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDING.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME						
DIMENSIONS ARE IN INCHES		SYSTEM <b>ADVANCED LIGO</b>		SUB-SYSTEM <b>AOS</b>		<b>MANIFOLD CRYO BAFFLE WELDMENT BRACE</b>				
TOLERANCES: .XX ± .06 .XXX ± .010 ANGULAR ± 1.0°						DESIGNER H. KELMAN	DATE 27 OCT 2010	SIZE <b>D</b>	DWG. NO. <b>D1002849</b>	REV. <b>v3</b>
MATERIAL <b>14 GAUGE 304 SSSL</b>		FINISH <b>8</b>		NEXT ASSY <b>VARIOUS</b>		CHECKER M. SMITH	DATE 27 SEP 2011	SCALE: 1:2	PROJECTION:	SHEET 1 OF 1

D1002849.dwg; Manifold\_Cryo\_Baffle\_Weldment\_Brace; PART PDM REV: X-024; DRAWING PDM REV: X-016