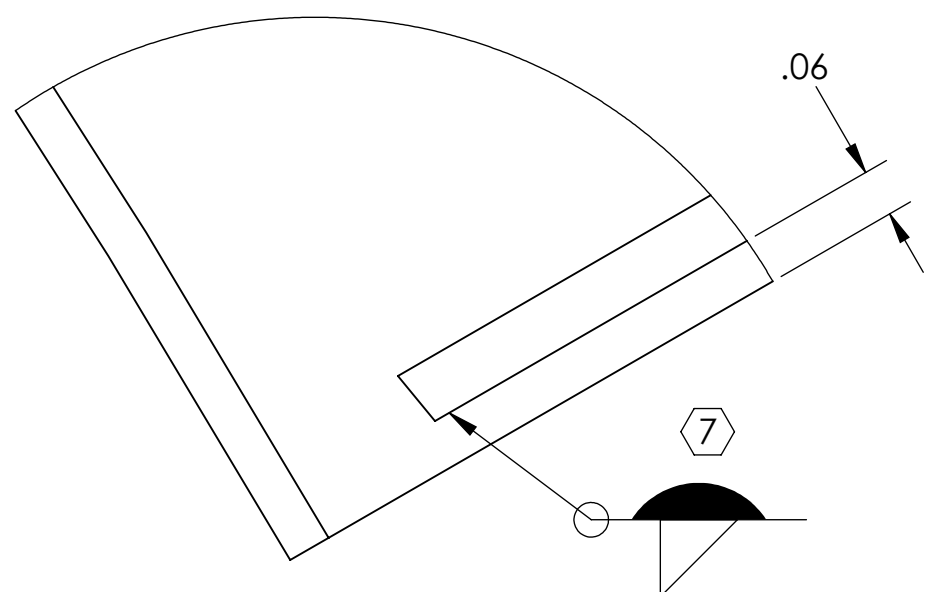
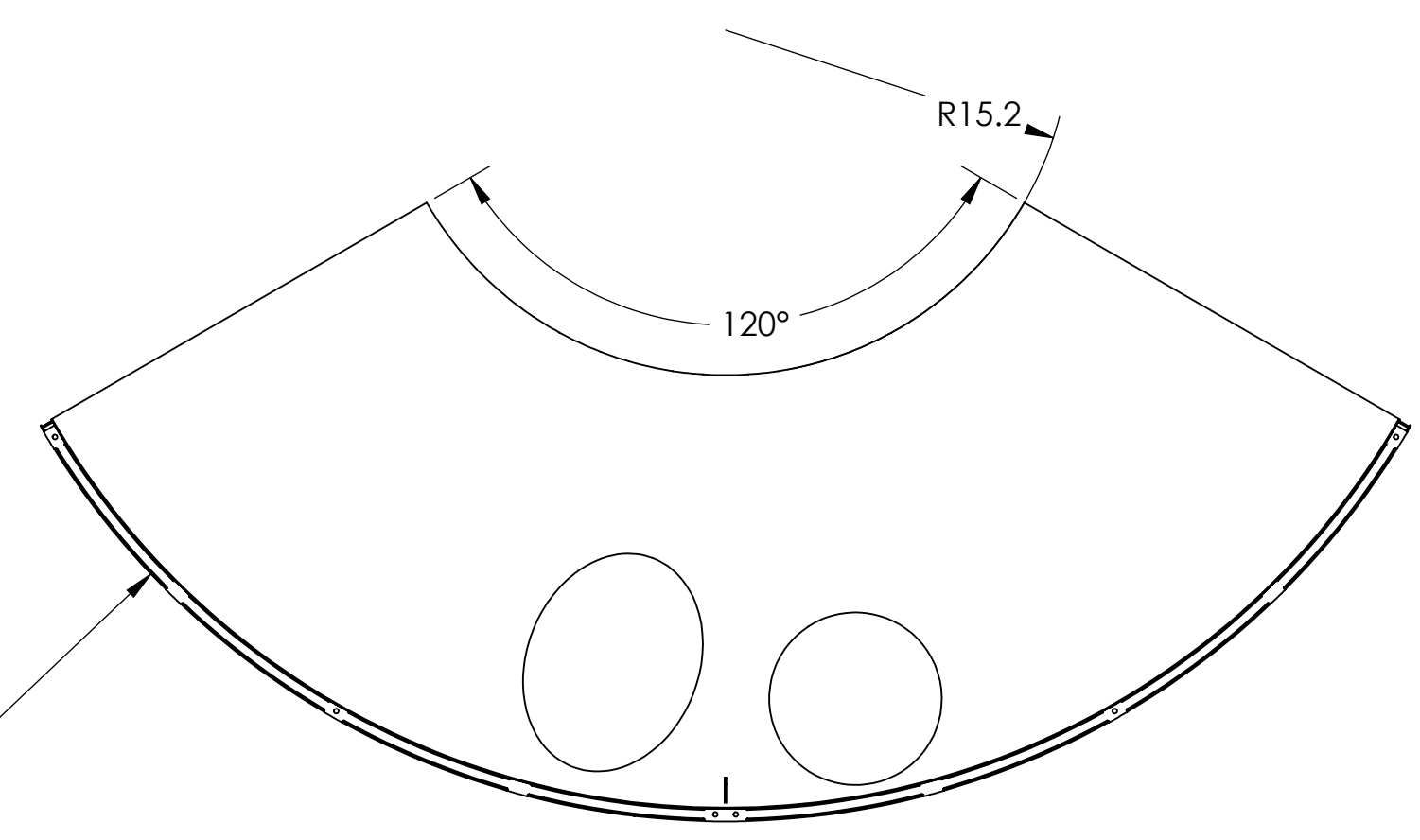
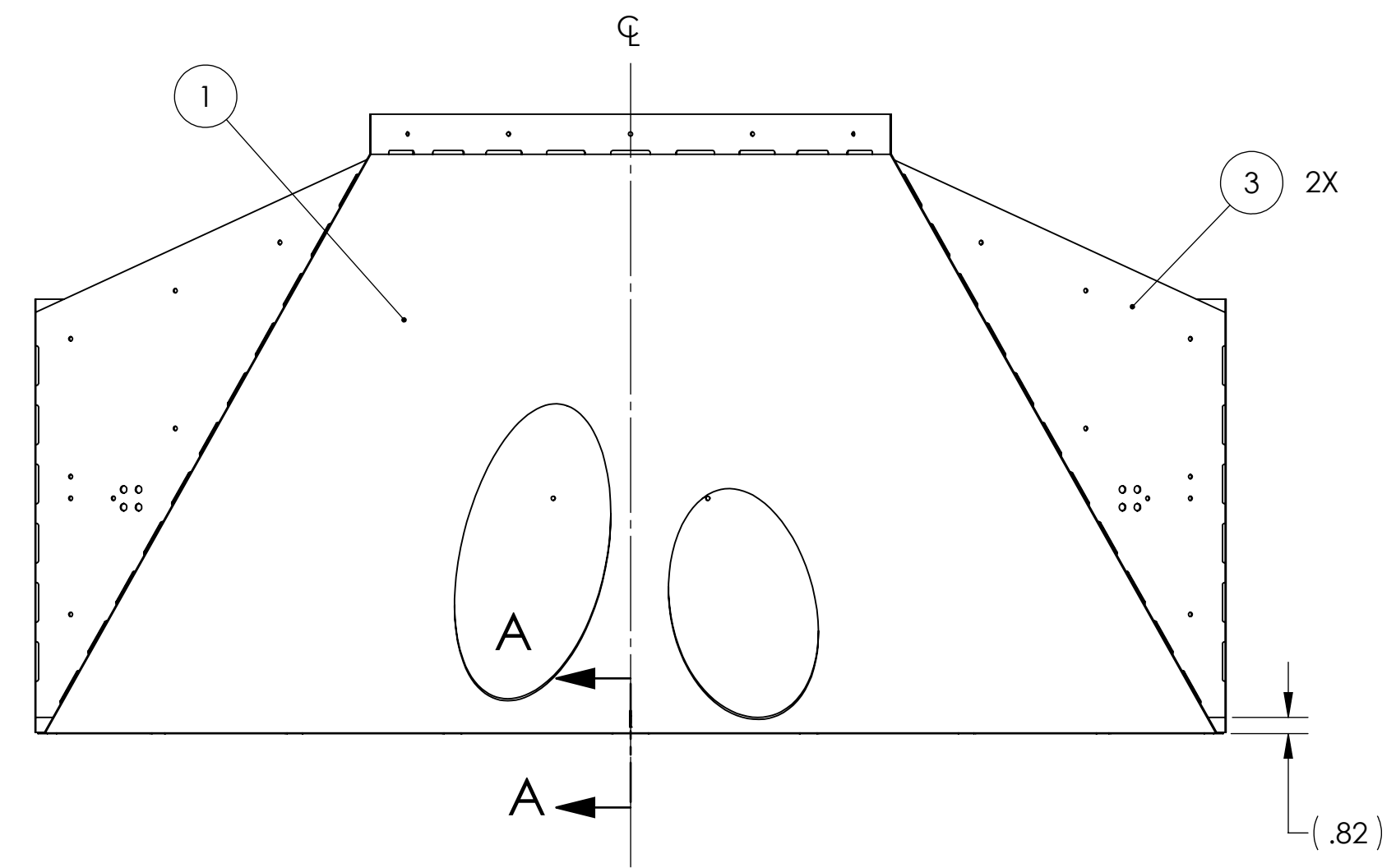
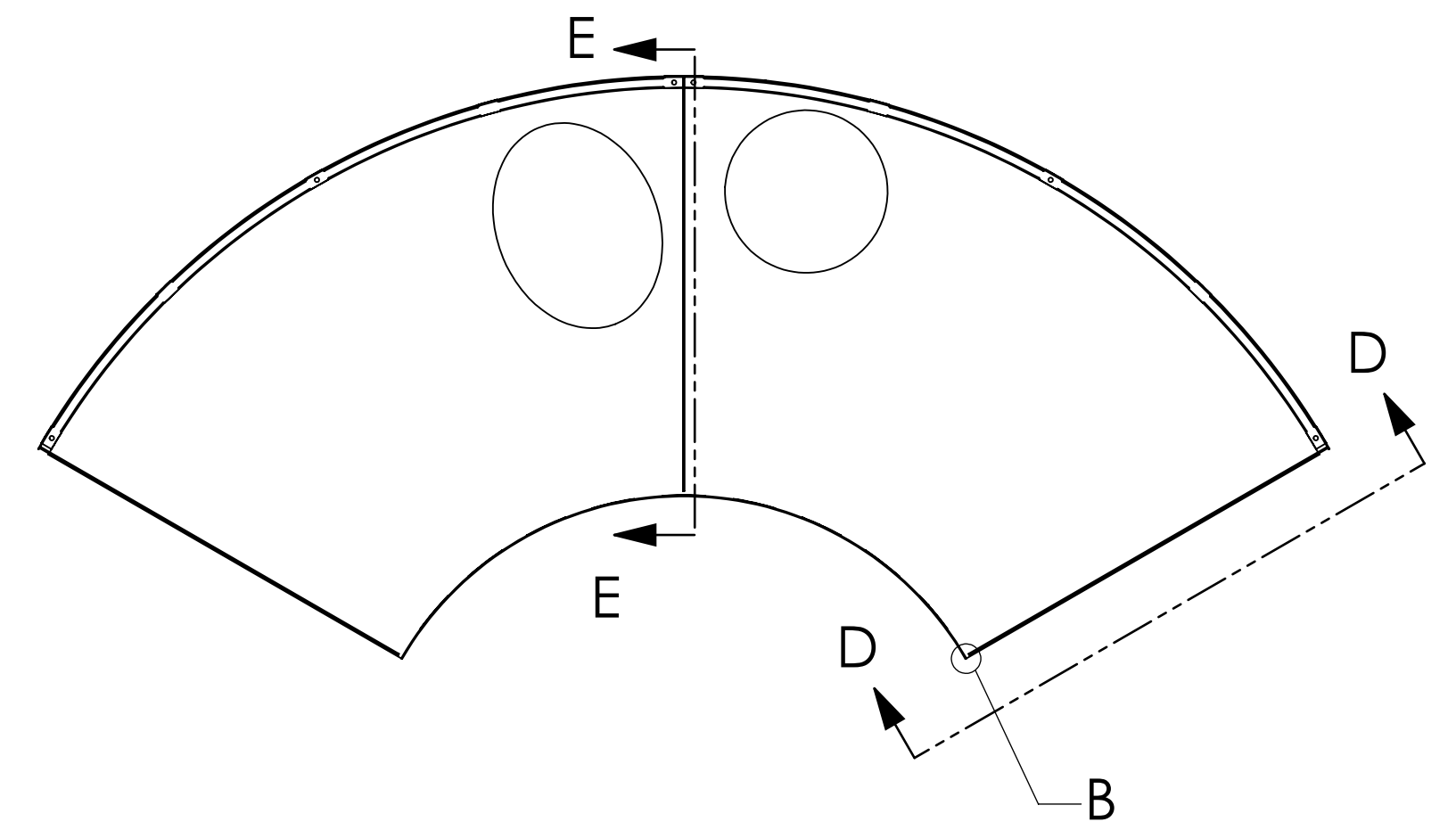


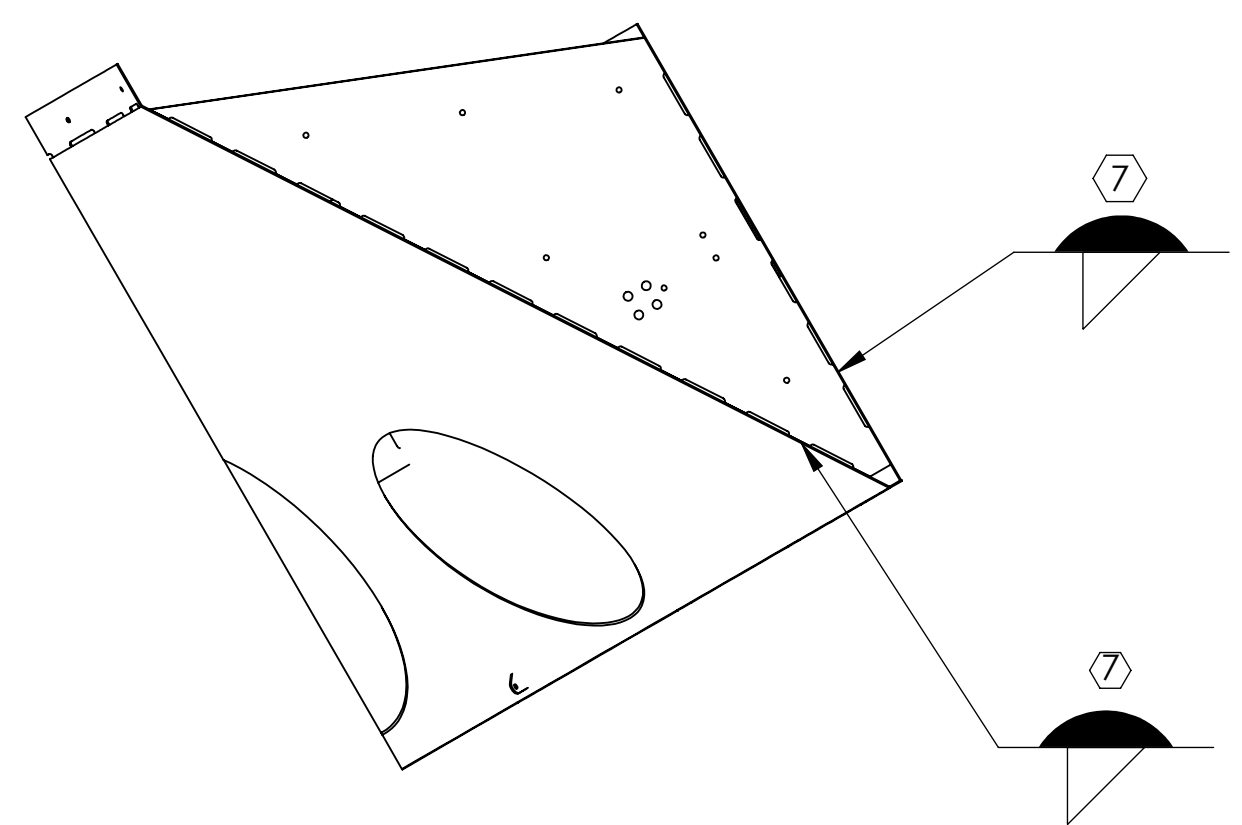
NOTES CONTINUED:  
 ⑤ SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), DO NOT STAMP OR LASER MARK (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE 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 DO NOT APPLY MARK ON SUPER #8 SIDE

6. ASSEMBLY TO BE OXIDIZED AFTER WELDMENT IS COMPLETED PER SPECIFICATION E1100842.

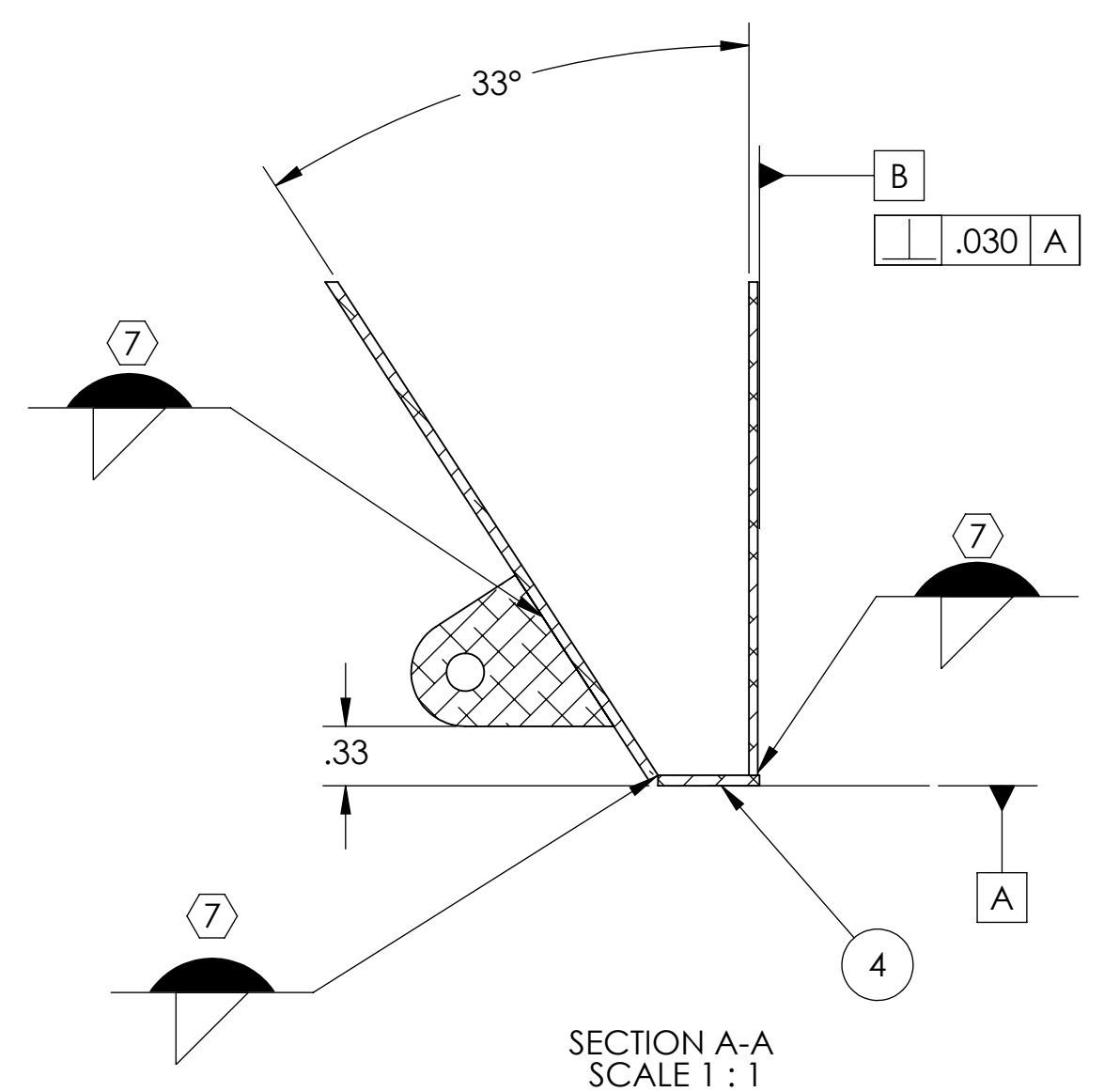
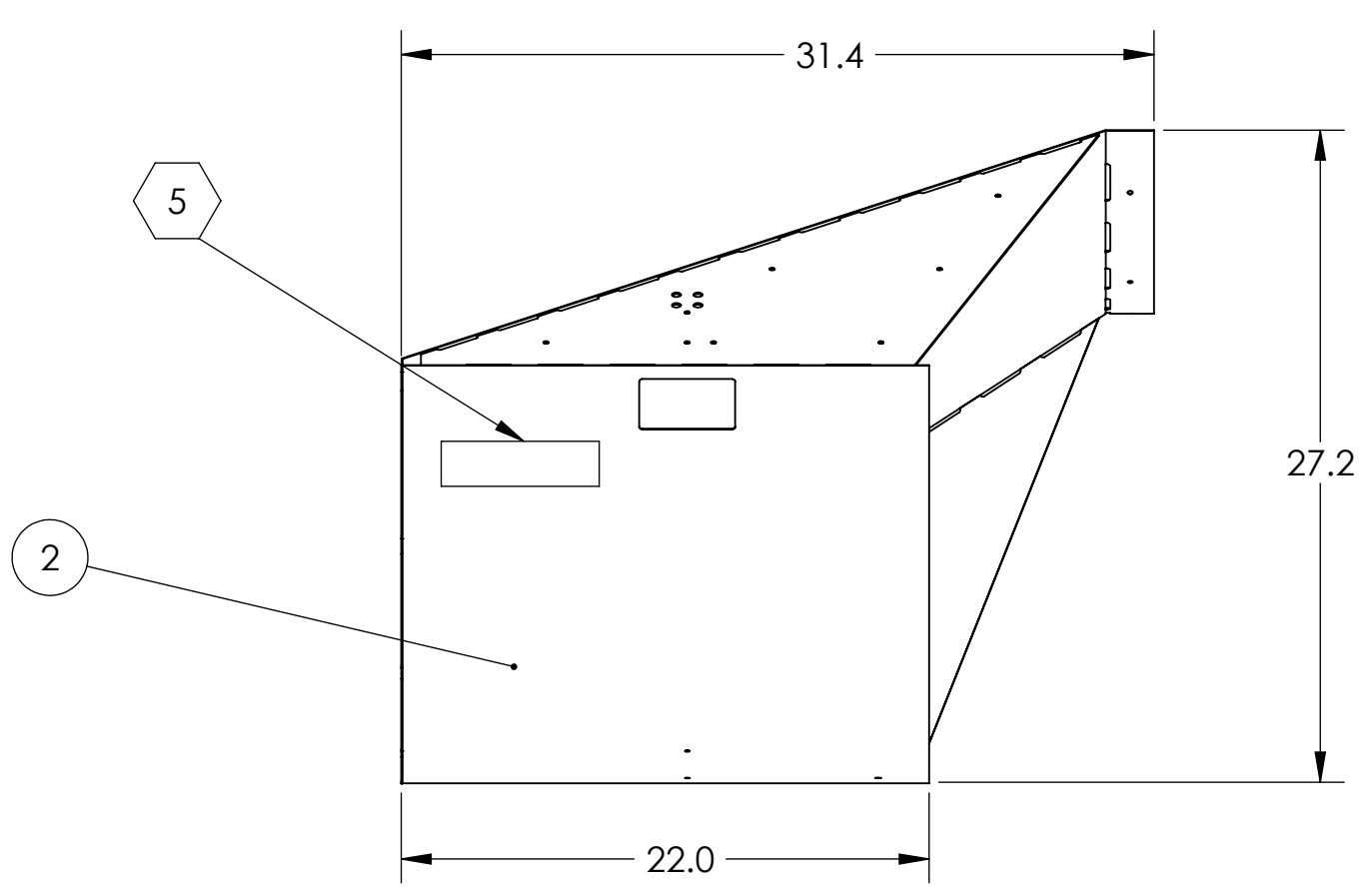
⑦ FILLET WELDS WHERE ITEMS ① & ③, ① & ⑤, ② & ③, ① & ④ MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048



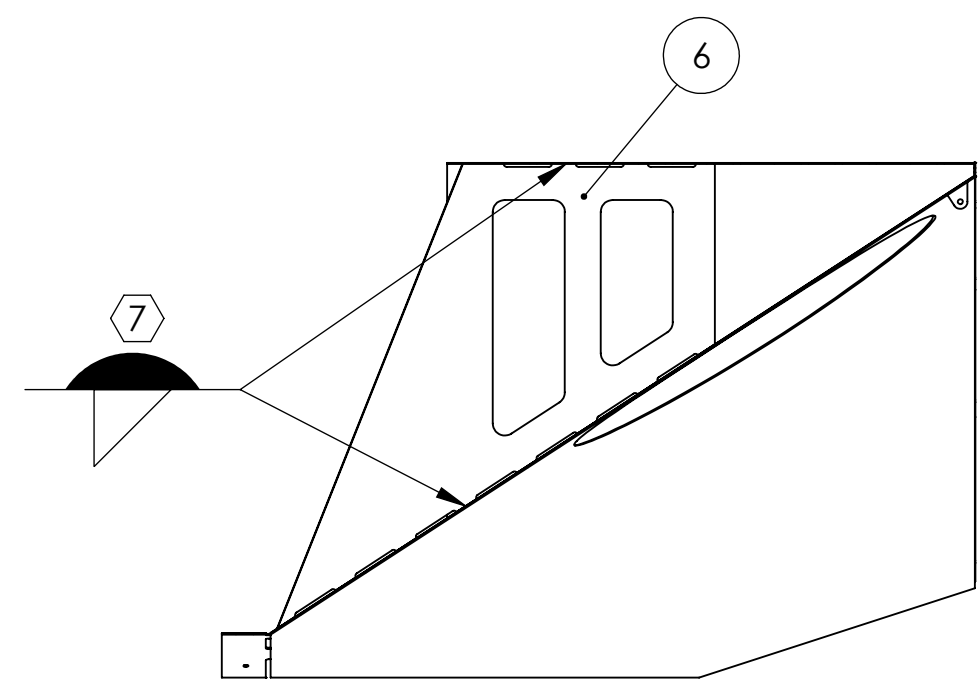
DETAIL B  
SCALE 4 : 1



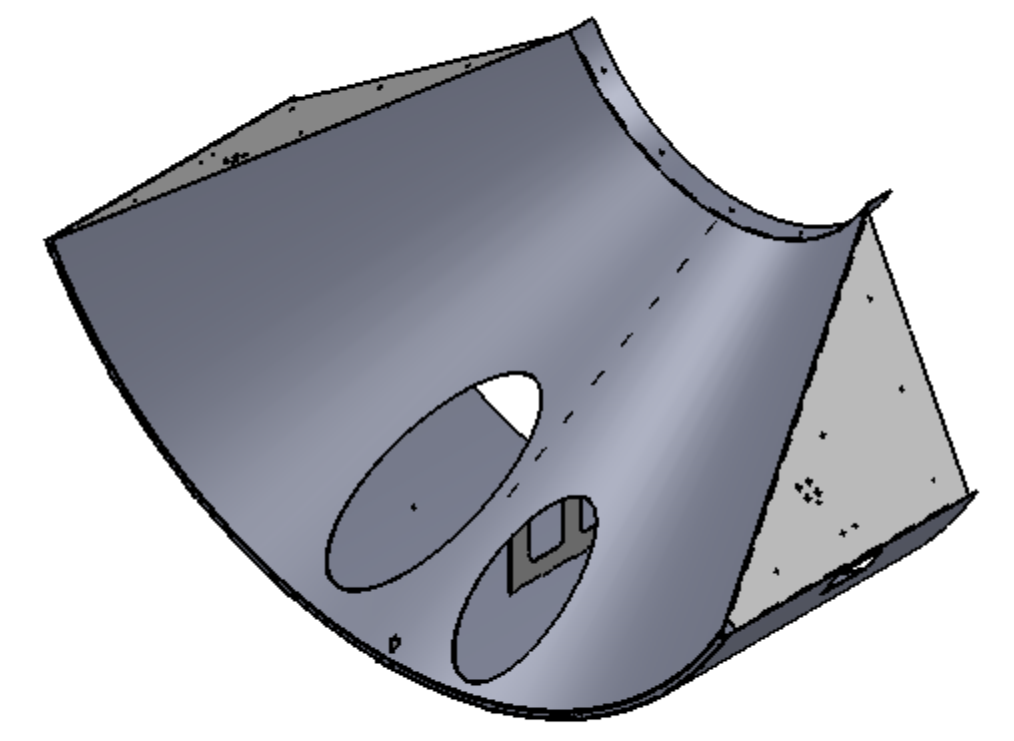
SECTION D-D



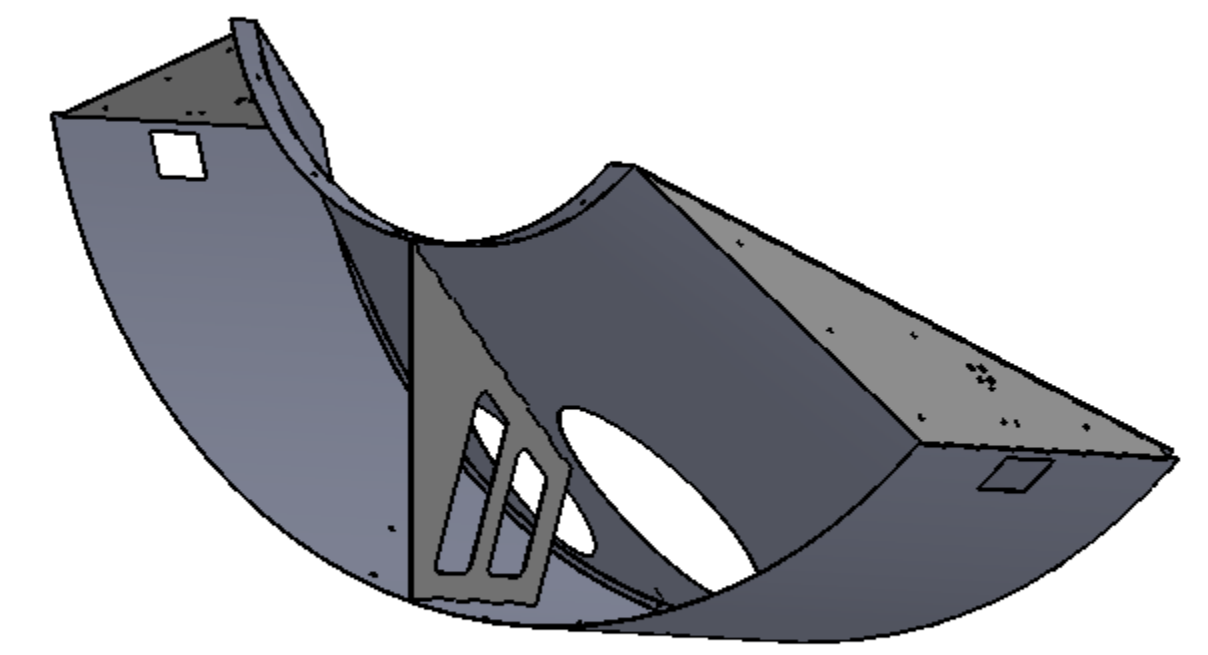
SECTION A-A  
SCALE 1 : 1



SECTION E-E



GENERAL VIEW  
FOR REFERENCE ONLY  
NO SCALE



REV.	DATE	DCN #	DRAWING TREE #
v1	26 OCT 2010	E1000360-v2	E1000085
v2	20 OCT 2011	E1000360-v3	-
-	-	-	-

ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
6	D1002849	MANIFOLD CRYO BAFFLE WELDMENT BRACE	14 GAUGE 304 SSSL	1		1
5	D1000536	BAFFLE BRACE BRACKET	14 GAUGE 304 SSSL	1		1
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14 GAUGE 304 SSSL	1		1
3	D0902621	MANIFOLD CRYO BAFFLE BRACKET	14 GAUGE 304 SSSL	2		2
2	D0902620	RADIAL SEGMENT, BOTTOM	18 GAUGE 304 SSSL	1		1
1	D1003185	MANIFOLD-CRYO BAFFLE INNER SEGMENT, ETMX H1 BOTTOM	18 GAUGE 304 SSSL	1		1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)  
 1. INTERPRET DRAWING PER ASME Y14.5-1994.  
 2. REMOVE ALL SHARP EDGES, .005-.015 ON ALL EDGES AND HOLES.  
 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: N/A  
 FINISH: N/A

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

SYSTEM: ADVANCED LIGO  
 SUB-SYSTEM: AOS  
 NEXT ASSY: D1003183

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

DESIGNER: H. KELMAN (17 MAR 2010)  
 DRAFTER: TQ. NGUYEN (3 SEP 2010)  
 CHECKER: M. SMITH  
 APPROVAL: D. COYNE

SIZE: D  
 DWG. NO.: D1003184  
 REV.: v2

SCALE: 1:8  
 PROJECTION:

SHEET 1 OF 1

D1003184.dwg: Manifold\_Cryo\_Baffle\_Segment\_Subassembly\_Weldment - PART PDM REV: X-026, DRAWING PDM REV: X-005